



Europäisches Patentamt
European Patent Office
Office européen des brevets

⑪ Publication number:

0 326 008
A3

⑫

EUROPEAN PATENT APPLICATION

⑬ Application number: 89100817.9

⑮ Int. Cl.5: **B21C 23/20, B21C 23/21**

⑯ Date of filing: **18.01.89**

⑭ Priority: **26.01.88 IT 1921588**

⑮ Date of publication of application:
02.08.89 Bulletin 89/31

⑯ Designated Contracting States:
AT BE CH DE ES FR GB GR IT LI LU NL SE

⑰ Date of deferred publication of the search report:
03.10.90 Bulletin 90/40

⑰ Applicant: **INNSE INNOCENTI
SANTEUSTACCHIO S.p.A.
20, Via A. Franchi
I-25100 Brescia(IT)**

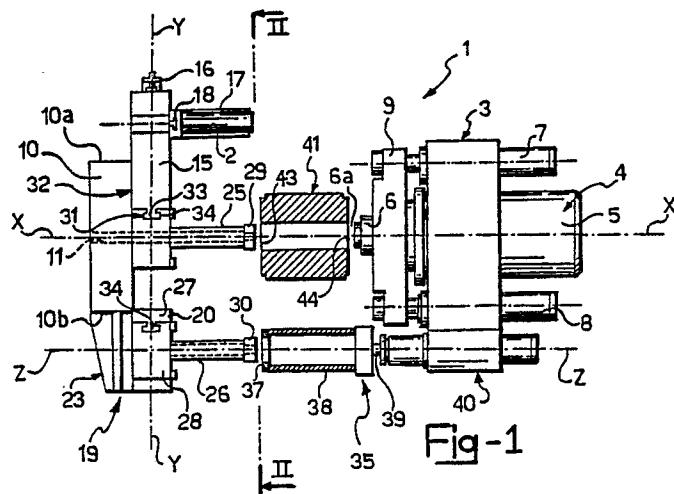
⑰ Inventor: **Zurru, Sergio
Via Martiri di Cefalonia 42/B
I-20097 San Donato Milanese Milan(IT)**

⑰ Representative: **Vannini, Torquato et al
JACOBACCI-CASETTA & PERANI S.p.A. 7 Via
Visconti di Modrone
I-20122 Milan(IT)**

⑲ **A method for improving the backward extrusion rate of brass billets and the like, and an apparatus for the implementation thereof.**

⑲ To improve the rate of backward extrusion of brass billets and the like, a horizontal extrusion press is provided with two parallel tubular headers (25,26) to which respective extrusion dies (29,30) are affixed permanently and which are mounted on slides (27,28) adapted to be driven in a guided fashion perpendicularly to the extrusion axis (X-X) of the press; one header (25) is set at an operative position for extrusion aligned to the extrusion axis (X-X), and

the other header (26) set at an inoperative position laterally of the axis (X-X), and a billet is extruded with said one header (25) to form a residual brass jacket (36) around the header; on completion of the extrusion step, the positions of the headers (25,26) are reversed, and said one header (25) is cleared of the residual brass jacket (36) in the inoperative position, while another billet is simultaneously extruded with said other header (26).





European Patent
Office

EUROPEAN SEARCH REPORT

Application Number

EP 89 10 0817

DOCUMENTS CONSIDERED TO BE RELEVANT			CLASSIFICATION OF THE APPLICATION (Int. Cl.4)						
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim							
Y	US-A-4459837 (HIROMASA HAYASHI) * column 5, line 36 - column 5, line 49; figures * ---	1, 2	B21C23/20 B21C23/21						
Y	US-A-3182478 (AKIRA ASARI) * column 2, line 52 - column 2, line 60 *	1, 2							
A	* claim 1; figures 8-13 *	6, 7							
A	GB-A-897040 (HYDRAULIK GMBH) * page 1, line 83 - page 2, line 11; claims 1, 2; figures 1-5 *	1, 5, 7-9							
A	FR-A-2148704 (TREFIMETAUX) -----	-							
			TECHNICAL FIELDS SEARCHED (Int. Cl.4)						
			B21C						
<p>The present search report has been drawn up for all claims</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 33%;">Place of search</td> <td style="width: 33%;">Date of completion of the search</td> <td style="width: 34%;">Examiner</td> </tr> <tr> <td>THE HAGUE</td> <td>07 AUGUST 1990</td> <td>BARROW J.</td> </tr> </table>				Place of search	Date of completion of the search	Examiner	THE HAGUE	07 AUGUST 1990	BARROW J.
Place of search	Date of completion of the search	Examiner							
THE HAGUE	07 AUGUST 1990	BARROW J.							
CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document							