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(54) **Apparatus for producing a spherical element for the head of a ball joint**

(57) Apparatus (1) for producing a ball element (2) for a ball joint head, the said ball element (2) being provided with a central through hole (24), the apparatus (1) being characterised in that it comprises:

- a cutting station for producing substantially cylindrical metal workpiece blanks;
- at least one cold forming station (30, 40, 50, 60) for cold forming the said metal blanks;
- a shearing station (70) in which a central part (23) of the workpiece is sheared;
- means for displacing the workpiece to and from the cutting station, the cold forming stations (30, 40, 50, 60) and the shearing station (70); and
- a control unit (10) for controlling the operations.

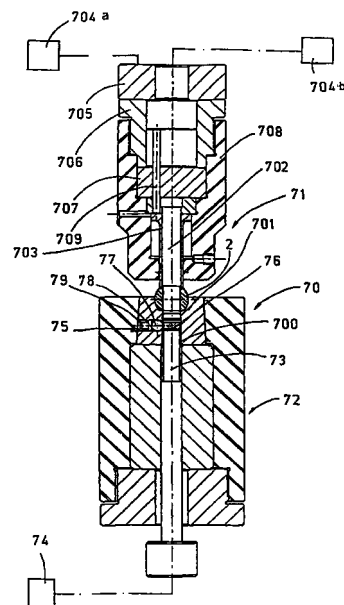


Fig.7

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EUROPEAN SEARCH REPORT

Application Number
EP 98 10 6366

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The present search report has been drawn up for all claims					
Place of search THE HAGUE		Date of completion of the search 15 April 1999	Examiner Gerard, O		
<table border="0"> <tr> <td> 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 </td> <td> 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 </td> </tr> </table>				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
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**ANNEX TO THE EUROPEAN SEARCH REPORT
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