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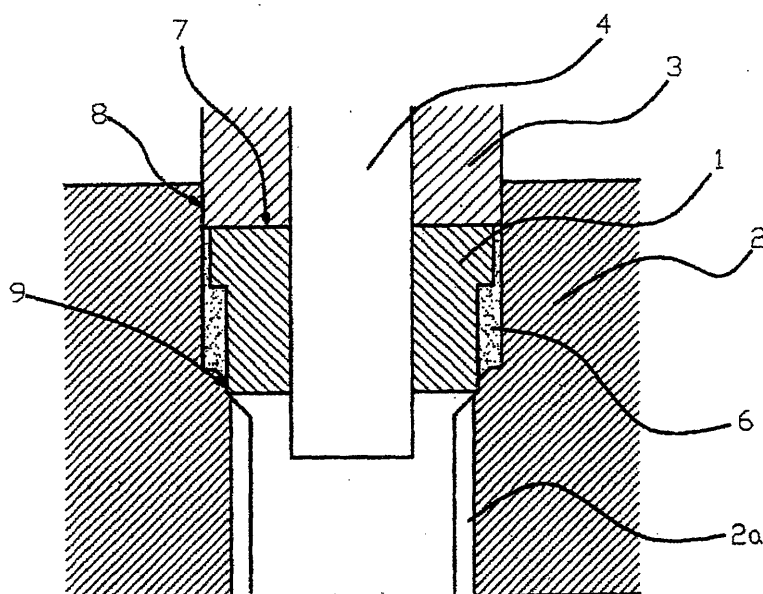
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(54) **Pressure controlled fluid pressure extrusion method**

(57) The lower part of a material blank to be molded forms a lower seal (9) with a die (2). A punch (3) applying a molding force to the material forms an upper seal (7) with the perimeter of the die. The space between the upper and lower seals (9) forms a pressure chamber (6) that is filled with a fluid. As the punch descends into the

die, the fluid is pressurized. The lower seal (9) is a complete seal to prevent leakage of fluid into the die. The upper seal is given a clearance with the die that permits controlled leakage of fluid therepast at a rate that limits the maximum pressure in the pressure chamber while permitting the development of an adequate pressure on the material being molded.

Fig. 2





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EUROPEAN SEARCH REPORT

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X	US 3 382 691 A (DEREK GREEN) 14 May 1968 (1968-05-14) * column 1, line 13-28 * * column 3, line 9-25; figure 1 *	1-7	B21J5/12 B21J5/04 B21C23/00 B21C23/10 B21K1/12 B21K1/30
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			TECHNICAL FIELDS SEARCHED (Int.Cl.7)
			B21C B21K B21J
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 4 June 2002	Examiner Marc Augé
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
ON EUROPEAN PATENT APPLICATION NO.**

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