

MOVABLE DIE COMPONENT FOR A PRESS DEVICE

[0001] The subject matter herein relates generally to movable die components for press devices. A press device includes die components used to form a work piece, such as a base assembly, a stripper plate and a punch assembly movable by a press ram toward the workpiece. The press device is configured for high speed stamping having many cycles per second. The workpiece, which is positioned between the base assembly and punch assembly, is formed during the pressing operation. A stripper plate is positioned between the base assembly and the punch assembly to pin the workpiece against the base assembly as the punch assembly is retracted. The stripper plate is spring actuated away from the base assembly to allow the stripper plate to move.

[0002] The spring actuated die components vibrate and rebound when moving and stamping the workpiece. The effects of the vibration and rebound intensifies as the speed of the pressing operation increases leading to accelerated wear and possibly die jams and product quality issues with the components formed from the workpiece. The vibration and rebound momentum of the movable die component is affected by the weight of the object. Heavier die components have more momentum and are affected by vibration and rebound.

[0003] The solution is provided by a press device as disclosed herein having reduced vibration and rebound effects on the movable die components during operation of the press device. A movable die component for a press device is provided that includes a plate body having a workpiece engagement surface configured to engage a workpiece formed by the press device. The plate body has a plurality of internal pockets completely enclosed by the plate body. Optionally, the plate body may be formed by an additive manufacturing process, such as by forming a plurality of direct metal laser sintering layers. The direct metal laser sintering layers may include a lower layer, a plurality of middle layers, and an upper layer with the internal pockets being provided in the middle layers, and with the lower layer

covering a bottom of each internal pocket and the upper layer coving a top of each internal pocket.

[0004] The invention will now be described by way of example with reference to the accompanying drawings in which:

[0005] Figure 1 illustrates a press device formed in accordance with an exemplary embodiment.

[0006] Figure 2 is an exploded view of a portion of the press device showing a base assembly, punch assembly and stripper plate.

[0007] Figure 3 illustrates a portion of the press device in a fully open position.

[0008] Figure 4 illustrates a portion of the press device in a fully closed position.

[0009] Figure 5 is a top view of a movable die component of the press device.

[0010] Figure 6 is a side view of the movable die component.

[0011] Figure 7 is a partial sectional view of a portion of the movable die component.

[0012] Figure 8 illustrates another movable die component.

[0013] Figure 9 illustrates a machine used to manufacture the stripper plate.

[0014] Figure 1 illustrates a press device 100 formed in accordance with an exemplary embodiment. The press device 100 is used to form a workpiece 102 from a metal sheet, such as by punching, stamping, bending or otherwise manipulating the shape and/or profile of the workpiece 102. The press device 100 may be used to form any type of component from the workpiece 102, such as

terminals or contacts. The press device 100 may include a feed mechanism 104 used to feed the workpiece 102 to a work zone 106. The press device 100 may include a frame or press bed 108 that supports other components of the press device 100.

[0015] A base assembly 110 is supported on the press bed 108. The base assembly 110 supports the workpiece 102 from below during the pressing operation. The press device 100 includes a punch assembly 112 above the base assembly 110. The punch assembly 112 is driven by a press ram 114 during a press operation toward and/or away from the base assembly 110 to press the workpiece 102 to form the component. Optionally, the punch assembly 112 may be spring biased away from the base assembly 110 rather than being pulled away by the press ram 114. In an exemplary embodiment, both the base assembly 110 and the punch assembly 112 include movable die components, generally shown at 116, that are used to form the workpiece 102.

[0016] In an exemplary embodiment, the base assembly 110 includes a base shoe 120 supported by the press bed 108 and a base block 122 mounted to the base shoe 120. Optionally, the base block 122 may have a predefined profile for forming a certain type of component from the workpiece 102. The base block 122 may be replaced by a different base block having a different profile to change the type of component manufactured by the press device 100. In an exemplary embodiment, the base block 122 is a movable die component 116. The base block 122 may be cam driven, spring driven or movable by other means. Optionally, the base shoe 120 may be a movable die component 116.

[0017] In an exemplary embodiment, the punch assembly 112 includes a punch shoe 124 and a punch block 126 coupled to the punch shoe 124. The punch shoe 124 has a predefined profile to form a certain type of component from the workpiece 102. The punch block 126 may be replaced by a different punch block having a different profile to form a different type of component from the workpiece 102. In an exemplary embodiment, the punch block 126 and the punch shoe 124 are movable die components 116. The punch block 126 and/or the punch shoe 124 may be cam driven, spring driven or movable by other means.

[0018] During operation, the workpiece 102 is formed between the base block 122 and the punch block 126. The punch shoe 124 is engaged by the press ram 114 and is driven toward the base assembly 110 during the pressing operation of the press device 100. The die components 116 may be subjected to many pressing cycles per second. The die components 116 may rebound and vibrate as the die components 116 are used. Other types of die components 116 may be used in alternative embodiments.

[0019] In an exemplary embodiment, the base assembly 110 includes a stripper plate 130 between the base block 122 and the punch assembly 112. The stripper plate 130 is a movable die component 116. The stripper plate 130 is located between the base block 122 and the punch block 126. The workpiece 102 is feed between the stripper plate 130 and the base block 122. The stripper plate 130 pins the workpiece 102 in position during the pressing operation. The stripper plate 130 is positioned to engage the workpiece 102 during withdrawal of the punch block 126 to prevent distortion of the component and or workpiece 102 and/or to release the workpiece 102 from the punch block 126. The stripper plate 130 pins the workpiece 102 against the base block 122 to strip the workpiece 102 from the punch assembly 112. During operation, the stripper plate 130, in addition to the other components of the press device 100, are subjected to many pressing operations per second. The vibration causes much wear and tear on the components.

[0020] In an exemplary embodiment, the movable die components 116 have weight reducing features to reduce wear and tear on the die components 116. For example, material of the die component(s) 116 is removed to reduce the weight of the die component(s) 116. The die component(s) 116 includes internal pockets (shown in Figure 7) in areas that do not require as much mechanical strength or stability to reduce the overall weight. Vibration and rebound effects are reduced.

[0021] Figure 2 is an exploded view of a portion of the press device 100 showing the base assembly 110, punch assembly 112 and stripper plate 130. The press device 100 includes biasing elements 140 that are used to press the die components 116 away from each other. For example, the biasing elements 140 may

include springs. Force from the press ram 114 (shown in Figure 1) may overcome the spring forces of the biasing elements 140 during the pressing operation to press the die components 116 together. Once the pressing forces are removed, the biasing elements 140 again press the components apart. Such movement of the die components 116 causes rebound and vibration, which may be mitigated by reducing the weight of the die components 116.

[0022] Figure 3 illustrates a portion of the press device 100 showing the base assembly 110, punch assembly 112 and stripper plate 130 assembled and in a fully open position. Figure 4 illustrates a portion of the press device 100 showing the base assembly 110, punch assembly 112 and stripper plate 130 assembled and in a fully closed position. In operation, the press ram 114 (shown in Figure 1) applies a pressing force 154 against the punch shoe 124 to drive the punch shoe 124 and punch block 126 downward toward the stripper plate 130 and base assembly 110. The workpiece 102, which is positioned between the base assembly 110 and punch assembly 112 is pressed and formed during the pressing operation. When the pressing force 154 of the press ram 114 is released, the punch assembly 112 is forced away from the base assembly 110. The stripper plate 130 holds the workpiece 102 against the base block 122 as the punch assembly 112 is retracted. The biasing elements 140 operate to press the die components 116 away from one another when the pressing force 154 of the press ram 114 is removed or unloaded from the punch shoe 124 allowing some separation between the base assembly 110 and punch assembly 112 to allow the workpiece 102 to advance for the next pressing operation. The press device 100 may be configured for high speed stamping having many cycles per second.

[0023] Figure 5 is a top view of a movable die component 116. Figure 6 is a side view of the movable die component 116. Figure 7 is a partial sectional view of the movable die component 116. The weight reducing features, such as the internal pockets, are shown in Figure 7.

[0024] The die component 116 includes a plate body 200 extending between a top 202, a bottom 204, a front edge 206, a rear edge 208, a first side 210 and a second side 212. The die component 116 includes at least one workpiece

engagement surface 214 configured to engage the workpiece 102. In an exemplary embodiment, the workpiece engagement surface 214 is defined by either the top 202 or the bottom 204. The workpiece engagement surface 214 may be used to form the workpiece 102 or may be used to hold the workpiece 102. For example, the die block 122 (shown in Figure 1) may have a workpiece engagement surface 214 on the top of the die block 122 that is used to form the workpiece 102 during the pressing operation; the punch block 126 (shown in Figure 1) may have a workpiece engagement surface 214 on the bottom of the punch block 126 that is used to form the workpiece 102 during the pressing operation; and the stripper plate 130 (shown in Figure 1) may have a workpiece engagement surface 214 on the bottom of the stripper plate 130 that is used to hold and pin the workpiece 102 against the die block 122 as the punch block 126 is withdrawn. Optionally, the workpiece 102 may be fed in a feed direction 216 generally from the front edge 206 toward the rear edge 208. In the illustrated embodiment, the weight reducing features are completely enclosed by the plate body 200 and thus are shown in phantom in Figures 5-6.

[0025] The plate body 200 may have any size or shape depending on the particular application. In an exemplary embodiment, the thinnest dimension of the plate body 200 is the height of the plate body 200 measured between the top 202 and the bottom 204. In an exemplary embodiment, the top 202 and bottom 204 are generally planer and parallel to one another. The top and bottom 202, 204 may include slots, grooves, channels, indentations, projections, tabs and the like that are used to form the workpiece 102, align the die component 116 with another component, guide movement of the die component 116, and the like.

[0026] In an exemplary embodiment, the plate body 200 may include one or more cavities that hold inserts (not shown) therein. The inserts may include features used to form the workpiece 102. The inserts may be removable and replaceable, such as when the inserts are worn or to change the shape of the forming surface for the workpiece 102.

[0027] In an exemplary embodiment, the plate body 200 includes openings 222. In the illustrated embodiment, the openings 222 are provided at the

sides 210, 212 near the front and rear edges 206, 208, however the openings 222 may be positioned at other locations in alternative embodiments. The openings 222 extend entirely through the plate body 200. Guide posts, fasteners or other components may be loaded into and/or through the openings 222, such as to tie the die component 116 to another component.

[0028] In an exemplary embodiment, the plate body 200 is a layered structure having one or more upper layers 230, one or more middle layers 232 and one or more lower layers 234. Internal pockets 236 (shown in Figure 7) are provided in the middle layers 232. The upper and lower layers 230, 234 cover the internal pockets 236. The upper layer 230 includes upper caps 238 covering the internal pockets 236. The lower layer 234 includes lower caps 240 covering the internal pockets 236. The upper and lower caps 238, 240 may be integral with the upper and lower layers 230, 234, respectively. Optionally, the internal pockets 236 may be at least partially filled with damping material having a lower specific weight than a specific weight of the metal powder material used to form the lower layer, middle layers and upper layer.

[0029] In an exemplary embodiment, the plate body 200 is manufactured by an additive manufacturing process. For example, the plate body 200 may be manufactured using a direct metal laser sintering process where the layers of the layered structure are built up by an additive process using a laser to form the layers from metal powder. The plate body 200 may be formed by other additive manufacturing processes, such as using an electron beam forming process. The plate body 200 is thus manufactured into a unitary body where the upper layers 230, the middle layers 232 and the lower layers 234 are all integrally formed and indivisible. The internal pockets 236 are provided and formed during the build-up process in predetermined areas of the plate body 200, as opposed to a subtractive process where portions of a metal block are milled or grinded out to form internal pockets.

[0030] In an alternative embodiment, the plate body 200 may be formed from separate pieces, such as an upper piece, a middle piece and a lower piece that are fastened or otherwise affixed together to form the plate body 200. The middle

piece includes the internal pockets 236 and the upper and lower pieces act as caps or covers to cover the internal pockets 236. The separate pieces are not formed together but rather are later assembled together to form the plate body. The different pieces may be formed by any method, including an additive process to build up layers to form the individual piece. The internal pockets 236 may be formed during the build-up process. Alternatively, the pieces may be formed by a subtractive process, such as where a block or material is milled, grinded, drilled or otherwise subjected to a process that removes material, such as to form the internal pockets 236.

[0031] In an exemplary embodiment, the internal pockets 236 are completely enclosed by the plate body 200. The internal pockets 236 reduce the overall weight of the die component 116 by removing material of the plate body 200 in areas of the plate body 200 that do not require as much mechanical strength and stability. For example, the internal pockets 236 may be positioned near corners 242 of the plate body 200. The internal pockets 236 may be positioned away from the areas of the plate body 200 that engage the workpiece 102 and are used to form the workpiece 102.

[0032] Reducing the weight of the plate body 200 reduces the dynamic effect of the rebound of the die component 116 during the pressing operation. Optionally, the internal pockets 236 may reduce the overall weight of the plate body 200 by between approximately 10% and 30%. In an exemplary embodiment, the internal pockets 236 are separated by support ribs 244 that extend vertical through the plate body 200. The internal pockets 236 are bounded by side walls 246. The support ribs 244 extend between the side walls 246 and between the upper and lower caps 238, 240.

[0033] Optionally, openings 248 may extend through the support ribs 244 to open adjacent internal pockets 236 to one another. The openings 248 may reduce the overall weight of the support ribs 244, thus reducing the overall weight of the plate body 200. In the illustrated embodiment, the openings 248 are cylindrical; however the openings 248 may have other shapes in alternative embodiments. Optionally, the support ribs 244 may each include multiple openings 248.

[0034] The internal pockets 236 are provided in the middle layers 232 of the plate body 200. The upper and lower layers 230, 234 of the plate body 200 define the caps 238, 240 that cover the internal pockets 236 such that the internal pockets 236 are completely enclosed. The upper and lower layers 230, 234 cover the internal pockets 236 to prevent debris and other contaminants from entering the internal pockets 236.

[0035] In an exemplary embodiment, the plate body 200 is manufactured by an additive process, such as a direct metal laser sintering process. During the direct metal laser sintering process, metal powder layers are sequentially built up. Metal powder material is layered on top of the object being formed and a laser is used to melt the powder into a solid. The structure of the solid object can be controlled by controlling the laser. Different layers of the solid object may have different geometry. For example, the lower layer or layers may have a different geometry from the middle layers which may have a different geometry from the upper layer or layers. For example, the middle layers may include gaps in certain areas that when the layers are stacked up form the internal pockets 236. However the upper and lower layers 230, 234 may not include such gaps but rather cover the gaps or internal pockets 236 with the caps 238, 240.

[0036] The direct metal laser sintering process is an additive process where the solid object is manufactured by adding layers upon layers to form the solid object. Complex geometries for the layers may be formed by the direct metal laser sintering process. The geometry of the layers may be more complex than a subtractive process such as milling or grinding where the size, shape, and location of the openings through the solid object are limited. Additionally, using the subtractive process such as milling or grinding leaves an exterior opening where debris or other contaminants can enter the opening. In contrast, the die component 116 includes the internal pockets 236, which are closed off at the top, bottom and along the sides of the internal pockets 236 such that the internal pockets 236 are completely enclosed.

[0037] Figure 8 is a perspective view of another movable die component 270. The movable die component 270 has a plate body 272 having

internal pockets (not shown) similar to the internal pockets 236 (shown in Figure 7) and external pockets 274 in addition to the internal pockets. The external pockets 274 are open to the exterior of the plate body 272, such as along front and rear edges 276, 278 and/or sides 280, 282. The external pockets 274 help to further reduce the weight of the plate body 272.

[0038] Figure 9 illustrates an exemplary machine 300 used to manufacture the die component 116. The machine 300 includes a computer 302, a laser 304 operatively coupled to the computer 302, a mirror system 306 for directing a laser beam from the laser 304 and a bath 308 holding powder material 310 used to form the die component 116 on a platform 312. The laser 304 is operated to build-up layers of the die component 116. The laser sinters the material 310 to solidify the material in a predetermined form.

[0039] In an exemplary embodiment, the machine 300 forms a lower layer by direct metal laser sintering the metal powder material 310. The machine 300 forms a plurality of middle layers on the lower layer by direct metal laser sintering the metal powder material 310, where the middle layers having one or more gaps 314 above the lower layer. The machine 300 forms an upper layer on the middle layers by direct metal laser sintering the metal powder material 310 on the middle layers. The upper layer has an upper cap covering the one or more gaps 314 such that the gaps 314 are completely enclosed to form the internal pockets 236 (shown in Figure 8) in the die component 116. The machine 300 may form support ribs 316 between corresponding gaps 314 that separating the internal pockets from one another. The support ribs 316 may extend between the upper cap and corresponding lower cap of the lower layer defined below the internal pockets. Optionally, the gaps 314 may be at least partially filled with damping material having a lower specific weight than a specific weight of the metal powder material used to form the lower layer, middle layers and upper layer. Other types of machines or machines having other components may be used to form the die component 116 by a direct metal laser sintering process or by another additive process.

[0040] It is to be understood that the above description is intended to be illustrative, and not restrictive. For example, the above-described embodiments (and/or aspects thereof) may be used in combination with each other. In addition, many modifications may be made to adapt a particular situation or material to the teachings of the invention without departing from its scope. Dimensions, types of materials, orientations of the various components, and the number and positions of the various components described herein are intended to define parameters of certain embodiments, and are by no means limiting and are merely exemplary embodiments. Many other embodiments and modifications within the spirit and scope of the claims will be apparent to those of skill in the art upon reviewing the above description. The scope of the invention should, therefore, be determined with reference to the appended claims, along with the full scope of equivalents to which such claims are entitled.

WHAT IS CLAIMED IS:

1. A movable die component (116) for a press device (100), the die component comprising:

a plate body (200) having a workpiece engagement surface (214) configured to engage a workpiece (102) formed by the press device, the plate body having a plurality of internal pockets (236) completely enclosed by the plate body.

2. The movable die component (116) of claim 1, wherein the plate body (200) includes an upper cap (238) and a lower cap (240) covering the internal pockets (236).

3. The movable die component (116) of claim 1, wherein the plate body (200) includes support ribs (244) extending between an upper cap (238) and a lower cap (240), the support ribs separating the internal pockets (236) from one another, the upper cap and the lower cap covering the internal pockets.

4. The movable die component (116) of claim 1, wherein the plate body (200) is formed by a plurality of layers (230, 232, 234) built-up on each other and being integral to form a unitary plate body (200).

5. The movable die component (116) of claim 4, wherein the layers comprise a lower layer (234), a plurality of middle layers (232), and an upper layer (230), the internal pockets (236) being provided in the middle layers, the lower layer covering a bottom of each internal pocket, the upper layer covering a top of each internal pocket.

6. The movable die component (116) of claim 1, further comprising damping material at least partially filling the internal pockets (236), the damping material having a lower specific weight than a specific weight of a material of the plate body (200).

7. The movable die component (116) of claim 1, wherein the plate body (200) is formed by a plurality of direct metal laser sintering layers comprising a

lower layer (234), a plurality of middle layers (232), and an upper layer (230), the internal pockets (236) being provided in the middle layers, the lower layer covering a bottom of each internal pocket, the upper layer coving a top of each internal pocket.