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Description

The present invention relates to cut-off style, roll thread flat dies which are used to produce gimlet point screws and the like. State of the art cut-off style, roll thread flat dies are disclosed in U.S. Patent No. 3,789,643, which names Joseph F. Dickson (the inventor herein) as the sole inventor and in U.S. Patent No. 3,405,545 (Both are manufactured by the assignee of this application).

It is an object of the present invention to provide a cut-off style, roll thread flat die which will improve the quality of the formed fastener.

An advantage of the present invention is the achievement of a substantial improvement in the noise level attendant the use of these dies.

Other objects and advantages of the present invention will become apparent from the following portion of the specification and from the accompanying drawings which illustrate, in accordance with the mandate of the patent statutes, a presently preferred embodiment incorporating the principles of the invention.

Referring to the drawings:

Figure 1 is a top view of a cut-off style, roll thread flat die made in accordance with the teachings of the present invention;

Figure 2 is a simplified oblique view of a portion of the die illustrated in Figure 1 showing five vertical slices taken at a—a, b—b, c—c, d—d and e—e of Figure 1 with the outer contours of the die being drawing in;

Figure 3 is a view of a portion of Figure 2 showing the slug extrusion taper and the slug traction ramp with continuously roughened surfaces;

Figure 4 is a view similar to that of Figure 3 showing a modification thereof;

Figure 5 is a view similar to that of Figure 3 showing another variation thereof; and

Figure 6 is a view similar to that of Figure 5 showing a modification thereof.

The stationary die of a pair of matched cut-off style, roll thread flat dies is illustrated in Figure 1. A stationary cut-off die (with its matched movable die—not shown) operates on a cylindrical blank to form a pointed threaded object, such as a gimlet point screw, and produces an extruded pointed slug in the process. The top or operating face of the die includes body threads 10, point threads 12, a slug extrusion taper 14 to form the pointed end, a slug traction ramp 16 to provide controlled rotation of the cut-off slug and a slug relief area 18. The body threads 10 and the point threads 12 are conventional, and the body threads may be cross-nicked 20 as shown.

The nature of and relationship between the slug extrusion taper and the slug traction ramp are illustrated in Figure 2, which is a simplified oblique view of a portion of the die shown in Figure 1. Five discrete vertical "slices" taken at a—a, b—b, c—c, d—d, and e—e of Figure 1 are shown in this sketch. The first or forwardmost vertical "slice" of the die shown in Figure 2 was

taken at the start location (a—a) of the die illustrated in Figure 1. As can be seen from this slice, the horizontal slug traction ramp 16a is located below the crest of the body threads (represented by horizontal line 10a) and above the slug relief area 18a. This ramp 16a is laterally continuous with the slug extrusion taper 14a which defines a selected angle with the horizontal and which extends from the slug traction ramp 16a to the height of the crest of the body threads (10a). The angle of the slug extrusion taper 14a, 14b, 14c, 14d, 14e remains the same throughout its length as does the horizontal orientation of the slug traction ramp 16a, 16b, 16c, 16d, 16e.

In the second slice (b—b), the slug extrusion taper 14b and the slug traction ramp 16b continue to be laterally continuous. The slug extrusion taper 14b extends above the crest of the body threads 10b by a selected distance h_b forming a peak. The length of the slug extrusion taper 14b has also increased from its length 14a at the start location.

The third slice (c—c) shows the further lengthening of the slug extrusion taper 14c and its further increased height h_c , which can be seen by the increased size of the peak. From the start location (a—a) to this transition location (c—c), the slug extrusion taper 14 and the slug traction ramp 16 have a common edge and are accordingly laterally continuous. While the slug traction ramp 16 progressively decreases in width proceeding from the start location 16a to the transition location 16c, it remains constant in width from the transition location to the termination location 16e.

From the transition location (c—c) to the termination location (e—e), the slug extrusion taper 14 and the slug traction ramp 16 are laterally discontinuous being connected by a slightly inclined step 22. The length of this step, which is zero at the transition location (c—c), continuously increases proceeding through location d—d to the termination location (e—e).

The vertical height of the slug extrusion taper h_b , h_c , h_d , h_e continues to increase to a maximum at the termination location (e—e) and the lateral width of the slug extrusion taper 14c, 14d, 14e continuously decreases from the transition location to the termination location (e—e).

To enhance the traction of the slug, the entirety of the slug extrusion taper 14 and the slug traction ramp 16 may be roughened. In the embodiment illustrated in Figure 3, these surfaces have a continuously roughened character as a consequence of electric discharge machining (EDM). Surface roughness exceeds about 7.5 μm .

Figure 4 shows a variation of Figure 3 with threads 24 (the same configuration and height as the body threads 10) being cut into the slug extrusion taper 14 and slug traction ramp 16 from the start location (a—a) toward the transition location (c—c) with the threads 24 in the slug extrusion taper extending beyond the transition location.

Another variation of Figure 3 is shown in Figure

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5 where the portion of the slug traction ramp continuously roughened has constant width and direction (the width and direction of the slug traction ramp from the transition location to the termination location). In this variation, a triangular portion 26 of the slug traction ramp is not machined by an EDM process, and accordingly, has a height slightly above (approximately 0,04 mm) the portion which has been roughened. The slug extrusion taper and the slug traction ramp may additionally be threaded 24 (Figure 6) in the manner previously illustrated in Figure 4.

Claims

1. A cut-off style, roll thread flat die for use with a matched cut-off style, roll thread flat die to form a threaded, pointed fastener such as a gimlet point screw, said cut-off style, roll thread flat die having a top operating surface comprising body-threads, point threads, a slug traction ramp (16) to provide controlled rotation for the cut-off slug and a slug extrusion taper (14) to provide proper extrusion of the cut-off slug from the fastener, said slug traction ramp and said slug extrusion taper extending in side-by-side relation from a start location (a—a), past a transition location (c—c) to a termination location (e—e), characterized in that

said slug traction ramp (16) and said slug extrusion taper (14) having a common edge and thereby being laterally continuous from said start location to said transition location (c—c),

said slug extrusion taper (14) forming an obtuse angle with said slug traction ramp (16) from said start location (a—a) to said transition location (c—c),

the edge of said slug extrusion taper (14) adjacent said slug traction ramp (16) being substantially vertically spaced above the edge of said slug traction ramp adjacent said slug extrusion taper from said transition location (c—c) to said termination location (e—e), said spacing continuously increasing from said transition location to said termination location,

said slug extrusion taper (14) having a selected and constant angle of inclination, and

said slug traction ramp (16) having a selected and constant orientation.

2. A cut-off style, roll thread flat die according to claim 1, characterized in that said slug traction ramp (16) and said slug extrusion taper (14) have a roughened surface.

3. A cut-off style, roll thread flat die according to claim 2, characterized in that said roughened surfaces of said slug extrusion taper and said slug traction ramp are continuously roughened to at least a continuous roughness of about 7,5 µm.

4. A cut-off style, roll thread flat die according to claim 3, further characterized by threads (24) defined in said slug traction ramp from said start location (a—a) toward said transition location (c—c).

5. A cut-off style, roll thread flat die according to claim 1, characterized in that the surface of said

slug extrusion taper (14) and the surface of a constant width, constant direction portion of said slug traction ramp (16) extending from said start location to said termination location are roughened.

6. A cut-off style, roll thread flat die according to claim 5, characterized in that said roughened surfaces of said slug traction ramp (16) and slug extrusion taper (14) are continuously roughened to at least a continuous roughness of about 7,5 µm.

7. A cut-off style, roll thread flat die according to claim 6, further characterized by threads defined in said non-roughened portion of said slug traction ramp (16) from said start location toward said transition location (c—c).

8. A cut-off style, roll thread flat die according to claim 7, characterized in that threads (24) are defined in said roughened portion of said slug traction ramp (16) from said start location (a—a) toward said transition location (c—c).

Patentansprüche

1. Ein Schneidenteil einer flachen Gewinderollbacke für das Zusammenwirken mit einem angepaßten Schneidenteil einer Gewinderollbacke zum Formen eines mit Gewinde versehenen zugespitzten Befestigungselements, wie einer Holzschraube, welches flache Gewinderollbacken-Schneidenteil eine obere Arbeitsfläche aufweist mit Körpergewinde, Spitzgewinde, einer Rohling-Traktionsrampe (16) für das Bewirken gesteuerter Drehung für den Abtrennrohling und einer Rohlings-Extrusionsverjüngung (14) für das Bewirken der richtigen Extrusion des Abtrenn-Rohlings von dem Verbindungselement, welche Rohling-Traktionsrampe und Rohlings-Extrusionsverjüngung sich nebeneinander von einer Startstelle (a—a) über eine Übergangsstelle (c—c) zu einer Endstelle (e—e) erstrecken, dadurch gekennzeichnet, daß die Rohlings-Traktionsrampe (16) und die Rohlings-Extrusionsverjüngung (14) eine gemeinsame Kante aufweisen und dadurch seitlich durchgehend sind von der Startstelle zu der Übergangsstelle (c—c), daß die Rohlings-Extrusionsverjüngung (14) mit der Rohlings-Traktionsrampe (16) einen stumpfen Winkel von der Startstelle (a—a) zu der Übergangsstelle (c—c) bildet, daß die Kante der Rohlings-Extrusionsverjüngung (14) nahe der Rohlings-Traktionsrampe (16) im wesentlichen vertikal im Abstand oberhalb der Kante der Rohlings-Traktionsrampe nahe der Rohlings-Extrusionsverjüngung von der Übergangsstelle (c—c) zur Endstelle (e—e) verläuft, wobei dieser Abstand kontinuierlich von der Übergangsstelle zu der Endstelle zunimmt, daß die Rohlings-Extrusionsverjüngung (14) einen ausgewählten und konstanten Neigungswinkel hat, und daß die Rohlings-Traktionsrampe (16) eine ausgewählte und konstante Orientierung aufweist.

2. Ein flaches Gewinderollbacken-Schneidenteil nach Anspruch 1, dadurch gekennzeichnet, daß die Rohlings-Traktionsrampe (16) und die Roh-

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5 where the portion of the slug traction ramp continuously roughened has constant width and direction (the width and direction of the slug traction ramp from the transition location to the termination location). In this variation, a triangular portion 26 of the slug traction ramp is not machined by an EDM process, and accordingly, has a height slightly above (approximately 0,04 mm) the portion which has been roughened. The slug extrusion taper and the slug traction ramp may additionally be threaded 24 (Figure 6) in the manner previously illustrated in Figure 4.

Claims

1. A cut-off style, roll thread flat die for use with a matched cut-off style, roll thread flat die to form a threaded, pointed fastener such as a gimlet point screw, said cut-off style, roll thread flat die having a top operating surface comprising body-threads, point threads, a slug traction ramp (16) to provide controlled rotation for the cut-off slug and a slug extrusion taper (14) to provide proper extrusion of the cut-off slug from the fastener, said slug traction ramp and said slug extrusion taper extending in side-by-side relation from a start location (a—a), past a transition location (c—c) to a termination location (e—e), characterized in that

said slug traction ramp (16) and said slug extrusion taper (14) having a common edge and thereby being laterally continuous from said start location to said transition location (c—c),

said slug extrusion taper (14) forming an obtuse angle with said slug traction ramp (16) from said start location (a—a) to said transition location (c—c),

the edge of said slug extrusion taper (14) adjacent said slug traction ramp (16) being substantially vertically spaced above the edge of said slug traction ramp adjacent said slug extrusion taper from said transition location (c—c) to said termination location (e—e), said spacing continuously increasing from said transition location to said termination location,

said slug extrusion taper (14) having a selected and constant angle of inclination, and

said slug traction ramp (16) having a selected and constant orientation.

2. A cut-off style, roll thread flat die according to claim 1, characterized in that said slug traction ramp (16) and said slug extrusion taper (14) have a roughened surface.

3. A cut-off style, roll thread flat die according to claim 2, characterized in that said roughened surfaces of said slug extrusion taper and said slug traction ramp are continuously roughened to at least a continuous roughness of about 7,5 µm.

4. A cut-off style, roll thread flat die according to claim 3, further characterized by threads (24) defined in said slug traction ramp from said start location (a—a) toward said transition location (c—c).

5. A cut-off style, roll thread flat die according to claim 1, characterized in that the surface of said

slug extrusion taper (14) and the surface of a constant width, constant direction portion of said slug traction ramp (16) extending from said start location to said termination location are roughened.

6. A cut-off style, roll thread flat die according to claim 5, characterized in that said roughened surfaces of said slug traction ramp (16) and slug extrusion taper (14) are continuously roughened to at least a continuous roughness of about 7,5 µm.

7. A cut-off style, roll thread flat die according to claim 6, further characterized by threads defined in said non-roughened portion of said slug traction ramp (16) from said start location toward said transition location (c—c).

8. A cut-off style, roll thread flat die according to claim 7, characterized in that threads (24) are defined in said roughened portion of said slug traction ramp (16) from said start location (a—a) toward said transition location (c—c).

Patentansprüche

1. Ein Schneidenteil einer flachen Gewinderollbacke für das Zusammenwirken mit einem angepaßten Schneidenteil einer Gewinderollbacke zum Formen eines mit Gewinde versehenen zugespitzten Befestigungselements, wie einer Holzschraube, welches flache Gewinderollbacken-Schneidenteil eine obere Arbeitsfläche aufweist mit Körpergewinde, Spitzgewinde, einer Rohlings-Traktionsrampe (16) für das Bewirken gesteuerter Drehung für den Abtrennrohling und einer Rohlings-Extrusionsverjüngung (14) für das Bewirken der richtigen Extrusion des Abtrenn-Rohlings von dem Verbindungselement, welche Rohling-Traktionsrampe und Rohlings-Extrusionsverjüngung sich nebeneinander von einer Startstelle (a—a) über eine Übergangsstelle (c—c) zu einer Endstelle (e—e) erstrecken, dadurch gekennzeichnet, daß die Rohlings-Traktionsrampe (16) und die Rohlings-Extrusionsverjüngung (14) eine gemeinsame Kante aufweisen und dadurch seitlich durchgehend sind von der Startstelle zu der Übergangsstelle (c—c), daß die Rohlings-Extrusionsverjüngung (14) mit der Rohlings-Traktionsrampe (16) einen stumpfen Winkel von der Startstelle (a—a) zu der Übergangsstelle (c—c) bildet, daß die Kante der Rohlings-Extrusionsverjüngung (14) nahe der Rohlings-Traktionsrampe (16) im wesentlichen vertikal im Abstand oberhalb der Kante der Rohlings-Traktionsrampe nahe der Rohlings-Extrusionsverjüngung von der Übergangsstelle (c—c) zur Endstelle (e—e) verläuft, wobei dieser Abstand kontinuierlich von der Übergangsstelle zu der Endstelle zunimmt, daß die Rohlings-Extrusionsverjüngung (14) einen ausgewählten und konstanten Neigungswinkel hat, und daß die Rohlings-Traktionsrampe (16) eine ausgewählte und konstante Orientierung aufweist.

2. Ein flaches Gewinderollbacken-Schneidenteil nach Anspruch 1, dadurch gekennzeichnet, daß die Rohlings-Traktionsrampe (16) und die Roh-



lings-Extrusionsverjüngung (14) eine aufgeraute Oberfläche aufweisen.

3. Ein flaches Gewinderollbacken-Schneidenteil nach Anspruch 2, dadurch gekennzeichnet, daß die aufgerauten Oberflächen der Rohlings-Extrusionsverjüngung und der Rohlings-Traktionsrampe durchgehend bis mindestens zu einer kontinuierlichen Rauhtiefe von etwa 7,5 µm aufgeraut sind.

4. Ein flaches Gewinderollbacken-Schneidenteil nach Anspruch 3, weiter gekennzeichnet durch Gewindegänge (24), die in der Rohlings-Traktionsrampe von der Startstelle (a—a) zu der Übergangsstelle (c—c) definiert sind.

5. Ein flaches Gewinderollbacken-Schneidenteil nach Anspruch 1, dadurch gekennzeichnet, daß die Oberfläche der Rohlings-Extrusionsverjüngung (14) und die Oberfläche eines Abschnitts konstanter Breite und konstanter Richtung der Rohlings-Traktionsrampe (16), sich von der Startstelle zu der Endstelle erstreckend, aufgeraut sind.

6. Ein Gewinderollbacken-Schneidenteil nach Anspruch 5, dadurch gekennzeichnet, daß die aufgerauten Oberflächen der Rohlings-Traktionsrampe (16) und der Rohlings-Extrusionsverjüngung (14) durchgehend bis mindestens zu einer kontinuierlichen Rauhtiefe von etwa 7,5 µm aufgeraut sind.

7. Ein flaches Gewinderollbacken-Schneidenteil nach Anspruch 6, weiter gekennzeichnet durch Gewindegänge, die in dem nicht-aufgerauten Abschnitt der Rohlings-Traktionsrampe (16) von der Startstelle zu der Übergangsstelle (c—c) definiert sind.

8. Ein Gewinderollbacken-Schneidenteil nach Anspruch 7, dadurch gekennzeichnet, daß Gewindegänge (24) in dem aufgerauten Abschnitt der Rohlings-Traktionsrampe (16) von der Startstelle (a—a) zu der Übergangsstelle (c—c) definiert sind.

Revendications

1. Mâchoire aplatie d'une partie de découpage pour rouler les filets, destinée à être utilisée avec une mâchoire complémentaire aplatie d'une partie de découpage pour rouler les filets, de manière à former un élément de fixation pointu et fileté tel qu'une vis à bois, ladite mâchoire aplatie de la partie de découpage pour rouler les filets présentant une surface supérieure active qui comprend des filets de corps, des filets de pointe, une rampe (16) de traction du flan pour assurer une rotation contrôlée du flan découpé, ainsi qu'un cône (14) d'extrusion du flan, destiné à assurer une extrusion adéquate du flan découpé à partir de l'élément de fixation, ladite rampe de traction du flan et ledit cône d'extrusion du flan s'étendant côte à côte d'une zone initiale (a—a) jusqu'à une zone finale (e—e), en passant par une zone de transition (c—c), caractérisée par le fait que

ladite rampe (16) de traction du flan et ledit cône (14) d'extrusion du flan présentent une arête commune et s'étendent, de ce fait, dans le prolongement latéral continu l'un de l'autre, de ladite

zone initiale jusqu'à ladite zone de transition (c—c),

ledit cône (14) d'extrusion du flan forme un angle obtus avec ladite rampe (16) de traction du flan, de ladite zone initiale (a—a) jusqu'à ladite zone de transition (c—c),

l'arête dudit cône (14) d'extrusion du flan qui est adjacente à ladite rampe (16) de traction du flan est sensiblement espacée, dans le sens vertical, au-dessus de l'arête de ladite rampe de traction du flan qui est adjacente audit cône d'extrusion du flan, de ladite zone de transition (c—c) jusqu'à ladite zone finale (e—e), ledit espacement augmentant continûment de ladite zone de transition jusqu'à ladite zone finale,

ledit cône (14) d'extrusion du flan présente un angle d'inclinaison sélectionné et constant, et

ladite rampe (16) de traction du flan présente une orientation sélectionnée et constante.

2. Mâchoire aplatie d'une partie de découpage pour rouler les filets, selon la revendication 1, caractérisée par le fait que ladite rampe (16) de traction du flan et ledit cône (14) d'extrusion du flan possédant une surface rendue rugueuse.

3. Mâchoire aplatie d'une partie de découpage pour rouler les filets, selon la revendication 2, caractérisée par le fait que lesdites surfaces rugueuses dudit cône d'extrusion du flan et de ladite rampe de traction du flan sont rendues rugueuses de manière continue, jusqu'à au moins une rugosité continue d'environ 7,5 µm.

4. Mâchoire aplatie d'une partie de découpage pour rouler les filets, selon la revendication 3, caractérisée en outre par des filets (24) taillés, dans ladite rampe de traction du flan, de ladite zone initiale (a—a) vers ladite zone de transition (c—c).

5. Mâchoire aplatie d'une partie de découpage pour rouler les filets, selon la revendication 1, caractérisée par le fait que la surface dudit cône (14) d'extrusion du flan et la surface d'une partie à largeur constante et à orientation constante de ladite rampe (16) de traction du flan, qui s'étendent de ladite zone initiale jusqu'à ladite zone finale, présentent une rugosité.

6. Mâchoire aplatie d'une partie de découpage pour rouler les filets, selon la revendication 5, caractérisée par le fait que lesdites surfaces rugueuses de ladite rampe (16) de traction du flan et dudit cône (14) d'extrusion du flan sont rendues rugueuses de manière continue, jusqu'à au moins une rugosité continue d'environ 7,5 µm.

7. Mâchoire aplatie d'une partie de découpage pour rouler les filets, selon la revendication 6, caractérisée en outre par des filets taillés, dans ladite partie non rendue rugueuse de ladite rampe (16) de traction du flan, de ladite zone initiale vers ladite zone de transition (c—c).

8. Mâchoire aplatie d'une partie de découpage pour rouler les filets, selon la revendication 7, caractérisée par le fait que des filets (24) sont taillés, dans ladite partie rendue rugueuse de ladite rampe (16) de traction du flan, de ladite zone initiale (a—a) vers ladite zone de transition (c—c).

