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(54) **Tool for cold rolling sheet material**

Werkzeug zum Kaltwalzen eines Bleches

Outil pour le laminage à froid d'une tôle

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Description

[0001] The present invention relates generally to a tool for cold rolling sheet material to form projections on its surfaces, according to the preamble of claim 1.

[0002] As referred to herein, sheet material of the kind specified refers to sheet material having on both of its faces a plurality of rows of projections, each projection having been formed by deforming the sheet material locally to leave a corresponding depression at the opposite face of the material. This deformation is effected by a forming tool and results in both plastic strain hardening and in an increase of the effective thickness thereof. Sheet material of the kind specified is stiffer than the plain sheet material from which it is formed and the mass of material required for a particular duty can be reduced by using sheet material of the kind specified in place of plain sheet material.

[0003] The magnitude and distribution of plastic strain exerted on the sheet material depends on a number of factors including, *inter alia*, the depth of penetration of the forming portions of the tool and the geometry of the forming portions.

[0004] An example of sheet material of the kind specified is disclosed in EP0674551, which is owned by the current applicant, wherein the sheet material is provided with the relative positions of the projections and depressions such that lines drawn on a surface of the material between adjacent rows of projections and depressions are non-linear. The projections are formed by forming tools having teeth with four flanks, wherein each flank faces a direction between the axial and circumferential directions of the rolls.

[0005] A further factor which affects the magnitude and distribution of plastic strain in such an arrangement is the layout or concentration of teeth in the forming tool.

[0006] According to a first aspect there is provided a tool in accordance with Claim 1 for cold rolling sheet material. Preferred embodiments of the tool according to the invention are defined in the dependent claims. Claim 12 relates to an apparatus for cold rolling sheet material comprising a pair of tools according to the invention.

[0007] Preferably, there is provided an apparatus for cold forming sheet material, the apparatus comprising a pair of opposed tools according to the invention having rows of teeth on their outer surface and being movable relative to one another, the geometry and position of the teeth and the spacing of the tools being such that the teeth on one tool extend, in use, into gaps between the teeth on the other tool with a minimum clearance between adjacent teeth which is at least equal to base gauge G of the material to be passed through the apparatus, each tooth comprising a rounded sheet engaging surface free of sharp corners.

[0008] Preferably, there is also a minimum clearance, in use, between the peak of each tooth on the one tool and the root surface of the other tool, for example to ensure material to be formed is not pinched therebetween.

[0009] The apparatus may further comprise shaping means for shaping the sheet material. The shaping means may comprise a further pair of rollers and may be arranged to shape the formed sheet material, for example into a channel section.

[0010] Preferably, the pitch P is between 3 and 3.5, for example 3.32, times the radius of curvature R.

[0011] The radius of curvature R is preferably at least equal to the base gauge G of a sheet material to be formed and more preferably at least 1.1 times the base gauge G, for example at least 2 times the base gauge G and/or less than 3.33 times the base gauge. Thus, the pitch is preferably between 2.5 and 13 times the base gauge G, for example between 2.75 and 7.8 times the base gauge and more preferably at least 3.65 times the base gauge G.

[0012] The second radius r_2 may be less than or equal to the first radius r_1 .

[0013] As used herein, the term "radius" refers to the distance between the centre of the tooth base plane and the tooth face as measured along an imaginary plane extending in the direction of the radius r_1 , r_2 , r_3 , r_4 whilst the term "radius of curvature" refers to the actual surface radius at a specific point on the surface of the tooth forming portion. Thus a "radius" r_1 , r_2 , r_3 , r_4 may be a compound radius of curvature having two or more radii of curvature blended together.

[0014] For the avoidance of doubt, the "direction" of a radius r_1 , r_2 , r_3 , r_4 refers to the direction in which the plane of that radius r_1 , r_2 , r_3 , r_4 extends.

[0015] The pitch P between adjacent teeth in a row may be at least 3.3, for example at least 3.32, times the first and/or second radii r_1 , r_2 . Preferably, the pitch P between adjacent teeth in a row is at least 3.3, for example at least 3.32, times the second radius r_2 measured at the point of the tooth nearest the adjacent tooth from the other tool. It is postulated that this arrangement provides sufficient clearance to avoid material pinching in use.

[0016] The tool may be for cold forming sheet material having a base gauge G of 2mm or greater, the tool comprising rows of teeth on its outer surface, each tooth having a rounded sheet engaging surface with a radius of curvature R greater than or equal to 2mm and a pitch of less than 26 mm.

[0017] Preferably, the radius of curvature R is less than or equal to 6.7mm and/or the pitch is less than 15.6mm such as between 5mm and 15.6mm, for example between 5mm and 7.8mm.

[0018] The tool or tools may comprise a first dimension and a second dimension, for example where the second dimension is orthogonal to the first dimension. The rows may extend in the direction of the first and/or the second dimensions. Alternatively, the rows may extend in a direction between the first and second dimensions.

[0019] The tool or tools may comprise cylindrical rolls, for example which are rotatable about respective axes, which axes may be parallel to one another. The teeth may be arranged in helical rows. Each tooth may have

a sheet engaging forming portion which is substantially free of sharp corners and/or comprises the sheet engaging surface. The first dimension may comprise a circumferential dimension and/or the second dimension may comprise an axial dimension. In this embodiment there is preferably a minimum clearance, in use, between the peak of each tooth on the one tool and the root diameter of the other tool, for example to ensure material to be formed is not pinched therebetween.

[0020] The sheet engaging surface is preferably free of sharp corners. The teeth may comprise forming portions free of sharp corners.

[0021] The pitch P and/or the radii r_1 , r_2 , r_3 , r_4 and/or the spacing of the rolls are preferably selected such that the tooth forming portions cause a plastic strain preferably of 0.05 or more, and/or material thinning of no more than 25% of the base gauge G of the sheet material, in use.

[0022] Preferably, the clearance between the teeth on one tool and the teeth on the other tool, during forming, is at least equal to the base gauge G of the plain sheet material.

[0023] Preferably, the clearance is at least 1.1 times the base gauge G of the plain sheet material.

[0024] One embodiment of the invention will now be described, by way of example only, with reference to the accompanying drawings, in which:

Figure 1 is a perspective view of a tooth according to the prior art;

Figure 2 is a representation of the strain distribution across a projection formed in sheet material using the tooth of Figure 1;

Figure 3 is a plan view of a fragment of one embodiment of sheet material formed using a tool according to the invention;

Figure 4 is a diagrammatical illustration of the forming of sheet material using one embodiment of apparatus according to the invention;

Figure 5 is a perspective view of the cooperation of a group of teeth having a first embodiment of tooth forming portions;

Figure 6 is a side view of the tooth forming portions of Figure 5 from direction X;

Figure 7 is a plan view of the tooth forming portions of Figure 5;

Figure 8 is a cross-section view along line B-B of Figure 7 showing sheet material being formed between the tooth forming portions;

Figure 8A is a representation of the strain distribution across a projection formed in sheet material using the tooth of Figure 8;

Figure 9 shows a second embodiment of tooth forming portions;

Figure 10 shows a third embodiment of tooth forming portions;

Figure 11 shows a fourth embodiment of tooth forming portions;

Figure 12 shows a fifth embodiment of tooth forming portions;

Figure 13 shows a sixth embodiment of tooth forming portions;

Figure 14A is a cross-sectional view of one of the tooth forming portions of Figure 13;

Figure 14B is a top view of one of the tooth forming portions of Figure 13;

Figure 15 is a perspective view of sheet material shaped into a first embodiment of channel section; and

Figure 16 is a perspective view of sheet material shaped into a second embodiment of channel section.

[0025] Figures 1 illustrates a prior art roll tooth 1 of the kind disclosed in EP0891234 (which is owned by the current applicant) for forming a projection 2 in sheet material 3 as shown in Figure 2. The roll tooth 1 is a cross cut involute gear form having four flanks 4 merging to a substantially flat peak 5. The forming rolls (not shown) will include a plurality of such teeth 1, wherein the teeth 1 on adjacent rolls (not shown) intermesh to deform the sheet material 3.

[0026] The geometry and density of the teeth 1 across the surface of the rolls (not shown) is dependent upon specific requirements of the application. For example, an increase in the depth of intermeshing and/or an increase in the density of teeth 1 will result in a greater degree of work hardening as well as a greater reduction in overall length of the material.

[0027] We have observed through extensive experimentation that the practical range of depth and/or density of teeth 1 on the roll (not shown) for producing useful sheet material of the kind specified is also limited by the resulting degree of material thinning, which worsen the mechanical properties of the material. The equipment and methods of producing sheet material of the kind specified therefore requires a balance between the density and intermeshing of the teeth versus the degree of material thinning in order to optimise the forming process.

[0028] On further investigation, we have surprisingly determined that the sharp corners 6 between the flanks 4, which are formed as a result of the manufacturing process, cause areas 7 of peak plastic strain.

[0029] As a result, a higher degree of work hardening and thinning of the material is experienced in these areas 7. The resulting strain distribution is illustrated in Figure 2. Without wishing to be limited by any particular theory we now postulate that difficulties in forming sheet material of the kind specified using a relatively thick sheet material, for example having a thickness above 1.5mm, may be attributed to this phenomenon.

[0030] It is from these surprising realisations that we have conceived and developed the present invention.

[0031] Referring now to Figure 3, there is shown a fragment of formed sheet material 10 comprising mild steel having on both of its faces a large number of projections

11 and depressions 12 each projection 11 at one face corresponding to a depression 12 at the other face. The projections 11 and depressions 12 are substantially square in shape with rounded corners.

[0032] The projections 11 and depressions 12 at one face are arranged in rectilinear rows R11 and columns C11, wherein each row R11 and each column C11 comprises alternating projections 11 and depressions 12. There are also alternating respective rows R12, R13 of projections 11 and depressions 12 which extend along a line between the directions of the rows R11 and columns C11. The rows R12, R13 extend at 45° to the rows R11 and the columns C11 in this embodiment. These rows are referred to hereinafter as helical rows R12, R13. The angle can range from 0° to 180°.

[0033] Adjacent projections 11 and depressions 12 are sufficiently close to one another for there to be no substantially flat areas of sheet material between them. Thus, the sheet material 10 as viewed in any cross-section which is generally perpendicular to the nominal or actual plane of the sheet material 10 is undulatory, thereby resulting in an effective thickness, or amplitude A, which is greater than the base gauge G of the material.

[0034] The formed sheet material 10 illustrated in Figure 3 is formed by the process illustrated in Figure 4. In this process, plain or base sheet material 17 having a base gauge G is drawn from a coil (not shown) and passes between a pair of rolls 18 and 19, each of which has at its periphery a number of teeth 30. The rolls 18, 19 are rotated about respective parallel axes 20 and 21 and the base sheet material 17 is engaged and deformed by the teeth 30 of the rolls 18, 19. Each tooth 30 pushes a part of the base sheet material 17 into a gap between teeth 30 on the other roll 18, 19 to form a projection 11 facing that other roll 18, 19 and a corresponding depression 12 facing the one roll 18, 19, thereby providing the formed sheet material 10. Thus, the overall thickness of the base sheet material 17 is increased by the presence of projections 11 on both of its faces and providing an effective thickness, or amplitude A, in the formed sheet material 10.

[0035] From the roll pair 18 and 19, the sheet material 10 may then pass between further roll pairs 22, 23 and 24 to shape the formed sheet material 10 into a channel section 27 in this embodiment. Other elongate shaped members (not shown) may also be formed.

[0036] The roll pair 18 and 19 and the further roll pairs 22, 23 and 24 are all driven by common drive means 25 of known form and preferably including an electric motor 26. The roll pairs 18 and 19, 22, 23, 24 are driven at substantially the same peripheral speed so that the base sheet material 17 passes continuously and at the same speed between the rolls 18 and 19 as the formed sheet material 10 passes between the subsequent further roll pairs 22, 23, 24.

[0037] After the formed sheet material 10 has been shaped into a channel or other section 27, it may be cut into lengths (not shown) for transportation and use.

[0038] Both of the rolls 18, 19 have substantially the same form with a first dimension, or axial length in this embodiment, and a second dimension orthogonal to the first, or circumferential dimension in this embodiment. Each roll 18, 19 includes a plurality of identical teeth 30 on its periphery, each of which teeth 30 includes a tooth forming portion 30a as shown in Figure 5. The teeth 30 are arranged in a plurality of rows which correspond to the rows R11, R12, R13 and columns C11 of the formed sheet material. It will be appreciated that the helical rows R12, R13 of teeth 30 extend along lines which extend between lines lying along the first and second dimensions. In this embodiment, the helical rows (not shown) are inclined to the axis 20, 21 of the roll 18, 19 at an angle of 45°.

[0039] Each tooth forming portion 30 is formed integrally with a tooth base portion (not shown) which in turn is formed integrally or otherwise secured to the periphery of one of the rolls 18, 19. It will be appreciated that the tooth base portions (not shown) are sized and dimensioned such that they do not impede deformation of the material in use.

[0040] The first embodiment of tooth forming portions 30a have a geometry and cooperating layout as illustrated in part in Figures 5 to 8. Each tooth forming portion 30a includes a base plane 31 which is substantially square in shape having rounded corners 32 and a smoothed depression 33 at the mid point of each side edge 34, thereby forming a four lobed shape. The side surfaces 35 of the tooth forming portion 30 project upward from the side edges 34 of the base 31 and curve toward a common smoothed apex 36, thus forming a rounded sheet engaging surface. It will be appreciated that there are no sharp corners present on the tooth forming portions 30a.

[0041] The features of the shape of the tooth forming portion 30a are defined by a series of radii r_1, r_2, r_3, r_4 , each of which has a constant radius of curvature in this embodiment. However, the first and third radii r_1, r_3 are different from the second and fourth radii r_2, r_4 in this embodiment.

[0042] As used herein, the term "radius" refers to the distance between the centre of the tooth base plane 31 and the tooth face 35 as measured along an imaginary plane extending in the direction of the radius r_1, r_2, r_3, r_4 (as shown more clearly in Figure 6) whilst the term "radius of curvature" refers to the actual surface radius at a specific point on the surface of the tooth forming portion 30a. Thus, a "radius" r_1, r_2, r_3, r_4 may be a compound radius of curvature having two or more radii of curvature blended together.

[0043] For the avoidance of doubt, the "direction" of a radius r_1, r_2, r_3, r_4 refers to the direction in which the plane of that radius r_1, r_2, r_3, r_4 extends.

[0044] The first and third radii r_1, r_3 are orthogonal to one another and each extends in a direction between the first and second directions (i.e. between the axial and circumferential directions of the rolls 18, 19). As is shown,

r_1 , r_3 both extend at 45° to the first direction in this embodiment. The second and fourth radii r_2 , r_4 extend respectively along the axial direction and circumferential (i.e. rolling) direction. The pitch P between adjacent teeth 30 is equal in this embodiment along both the rectilinear rows R11 and columns C11.

[0045] In use, the sheet material 10 is passed through the rolls 18, 19 in the rolling direction RD (shown in Figure 7). Each tooth forming portion 30 from one of the rolls 18, 19 moves into and out of alignment with the space between adjacent tooth forming portions 30 in the other of the rolls 18, 19 as shown more clearly in Figures 5 to 8. As can be seen from Figure 8, the amplitude A of the formed sheet material 10 is a function of the depth D of penetration, or overlap, between the forming portions 30a, which in turn is a function of the separation of the rolls 18, 19.

[0046] The spacing and geometry of the teeth 30 in this embodiment are such that the apex or peak of a projection 11 being formed by one of the teeth 30 on one of the rolls 18, 19 is free from contact with other the roll 18, 19. This can be seen, for example, in Figure 8.

[0047] The amplitude A of the sheet material leaving the rolls 18 and 19 is preferably between 1.5 to 4, say 2 and 3, times the base gauge G of the sheet material. However, it will be appreciated that subsequent shaping of the sheet material by the roll pairs 22, 23 and 24 can reduce the amplitude A of the formed sheet material 10.

[0048] As mentioned above, the improvements in physical properties of sheet material of the kind specified are mainly attributed to the increase in effective thickness of the sheet material and the strain hardening effect which is a consequence of the plastic deformation of the material. It is therefore desirable to maximise the effective thickness or amplitude A of the formed material 10 and to maximise both the magnitude and area of plastic strain. Increasing the amplitude A will increase the magnitude of plastic strain and decreasing the pitch P will increase the area of plastic strain because of an increase in projection density.

[0049] However, the greater the magnitude of plastic strain, the greater the extent of material thinning, which adversely affects the physical properties of the sheet material.

[0050] We have determined that there is a preferable or optimum sheet engaging surface radius R which provides a balance between maximising work hardening and minimising the material thinning.

[0051] However, as mentioned above, it is desirable to minimise the pitch P in order to maximise the area of plastic strain. It has been observed that the sheet material is 'pinched' when the clearance between adjacent forming portions 30a approaches and is less than the base gauge G in use. Whilst material pinch is beneficial in terms of plastic strain and therefore strain hardening of the formed material, it can result in local thinning of the sheet material and it causes issues in manufacture due to excessive loads and roll wear issues. It is therefore

preferable to avoid material pinch.

[0052] The present invention provides a tooth form which enables a balance to be struck between these competing factors. This is achieved by providing a rounded sheet engaging surface having a radius of curvature equal to the preferable surface radius R in some areas while the radius of curvature in other areas is adjusted to prevent pinching

[0053] Material pinching occurs in the regions where there is the least distance between intermeshing teeth. In the case of the first embodiment of tooth forming portion 30a, this is in the direction of the rectilinear rows R11 and columns C11 (i.e. direction of r_2 and r_4).

[0054] Accordingly, in this embodiment the radii r_1 , r_3 of the sheet engaging surface have a radius of curvature equal to the preferable surface radius R , while the radii r_2 , r_4 gradually decrease from the peak to the base portion (not shown). This provides a profile which allows for a reduced pitch P to maximise the strained area, while providing a degree of extra clearance to avoid pinching the material.

[0055] We have determined that by ensuring that the pitch P is at least 2.5 times, preferably at least 3 times, for example 3.32 times, the preferable surface radius R (i.e. the first and third radii r_1 , r_3 in this embodiment) the level of strain can be maximised.

[0056] The surface radius along the radii r_1 , r_2 , r_3 and r_4 should be at least equal to the base gauge G , preferably 1.1 or more times the base gauge G , of the sheet material in order to ensure a relatively even strain distribution throughout the projection 11 and to minimise thinning.

[0057] Figure 8a shows a representation of the plastic strain of a part of the sheet material 10 formed using the tooth geometry shown in Figures 5 to 8. As shown in Figure 8a, there is a continuous area of peak plastic strain PP around the apex of the projection 11, while the plastic strain in the quaquaversal region QQ surrounding the area PP decreases moving away from that region. The sheet material is thinned by less than 25%.

[0058] The base of the depression 12 includes four radii dr_1 , dr_2 , dr_3 and dr_4 , which correspond generally to the four radii r_1 , r_2 , r_3 and r_4 of the sheet engaging surface of the tooth.

[0059] In order to further demonstrate the flexibility of the invention, reference is made to the further tooth forms shown in Figures 9 to 13.

[0060] Figure 9 shows a second embodiment of tooth 130 which includes a forming portion 130a of hemispherical form and a cylindrical base portion 130b formed integrally with the forming portion 130a. In this case, all radii r_1 , r_2 , r_3 and r_4 are equal to the preferable surface radius R and the pitch P_2 is such that no material pinching occurs. It will be appreciated that the pitch P_2 required to prevent material pinching will be greater for this embodiment since the second and fourth radii r_2 , r_4 are equal to the first and third radii r_1 , r_3 .

[0061] Figure 10 shows a third embodiment of tooth 230 which includes a forming portion 230a formed inte-

grally with a base portion 230b that is generally square in plan with rounded corners. The first and third radii r_1 , r_3 in this embodiment are both equal to the preferable surface radius R , whereas the second and fourth radii r_2 , r_4 each comprise a compound radius gradually decreasing toward the base portion 230b to provide suitable clearance and thereby reduce the potential for material pinch. This tooth form 230 allows for a reduced pitch P_3 with respect to the pitch P_2 of the second embodiment, thereby increasing the density of projections 11 and improving the proportion of the formed sheet material 10 which is strain hardened.

[0062] Figure 11 shows a fourth embodiment of tooth 330 which includes a forming portion 330a formed integrally with a base portion 330b that is also generally square in plan with rounded corners. The first and third radii r_1 , r_3 in this embodiment are both equal to the preferable surface radius R at or adjacent to the peak 311 a of the tooth 330 and comprise a compound radius gradually decreasing toward the base portion 330b. The second and fourth radii r_2 , r_4 have a single radius of curvature and are smaller than the first and third radii r_1 , r_3 to provide suitable clearance and thereby reduce the potential for material pinch. This tooth form 330 allows for a reduced pitch P_4 with respect to the pitch P_2 of the second embodiment since the size of the base portion 330b can be reduced for a given preferable surface radius R , thus increasing the worked area of the sheet material 10.

[0063] Figure 12 shows a fifth embodiment of tooth 430 which includes a forming portion 430a formed integrally with a base portion 430b that is also generally square in plan with rounded corners. The first and third radii r_1 , r_3 in this embodiment are both equal to the preferable surface radius R at or adjacent to the peak 411 a of the tooth 430 and comprise a compound radius gradually decreasing toward the base portion 430b. The second and fourth radii r_2 , r_4 each comprise a compound radius gradually decreasing toward the base portion 430b to provide a region having a suitable clearance and thereby reduce the potential for material pinch. The four compound radii r_1 , r_2 , r_3 , r_4 of the tooth form 430 provide maximum flexibility for optimising the balance between the degree of work hardening and avoiding material pinch.

[0064] Figures 13, 14A and 14B show a sixth embodiment of tooth 630 which includes a forming portion 630a formed integrally with a base portion 630b that is generally square in plan with rounded corners. All of the radii r_1 , r_2 , r_3 , r_4 in this embodiment are equal to the preferable surface radius R at and adjacent to the peak 611 a of the tooth 430 to provide a part spheroidal surface 631 and comprise a compound radius gradually decreasing toward the base portion 430b extending from and blended with the part spheroidal surface 631. The second and fourth radii r_2 , r_4 each comprise a compound radius which gradually decreases toward the base portion 430b by a steeper gradient than the first and third radii r_1 , r_3 , thereby providing a region having a suitable clearance to reduce the potential for material pinch.

[0065] As shown more clearly in Figures 14A and 14B, the part spheroidal surface 631 or tip area 631 is defined by a conical segment with an angle A between 0 and 180°. Clearly, if the angle A approaches 180° then the tooth form 160 will approach that of Figure 9.

[0066] The shaped sheet material 27 which results from the process illustrated in Figure 4 is suitable for use on its own or in the form of a structural member 27a, 27b as shown in Figures 15 and 16, for example a post or a beam. For these purposes, sheet material 10 of channel form 27a, 27b is particularly suitable, the channel 27a, 27b having flanges 270a, 271a, 270b and a web 272a, 272b which maintains the flanges 270a, 271a, 270b a predetermined distance apart.

[0067] The surfaces of the flanges 270a, 271 a, 270b and the web 272a, 272b include rows (R11, R12, R13) of projections 11 and depressions 12. In certain cases, projections 11 and depressions 12 may be required on only a part of the surface of the sheet material 10. The invention is applicable with especial advantage to studs 27a, 27b used in stud and panel partitions and to the channel lengths 27b in which end portions of the studs 27a, 27b are received.

[0068] For other purposes, generally flat material or section other than a channel 27 are useful, for example C-sections, U-sections, Z-sections, I sections and so on.

[0069] Sheet material of the kind specified formed in accordance with the present invention is much stiffer than the plain sheet material from which it is formed. In particular, the bending strength of such material increases dramatically.

Example 1

[0070] A specimen of sheet material having a base gauge G of 0.45mm was formed using a tool comprising the tooth form shown in Figure 10. The pitch of the teeth on the tool was 5.1 mm, the first and third radii r_1 , r_3 had a constant radius of curvature of 1.5mm, while the second and fourth radii r_2 , r_4 had a composite radius of curvature.

[0071] The sheet material was formed with an amplitude A of 2.5 times the base gauge G of the material 17 with a proportion of significant plastic strain of 70% and material thinning of 15%. The formed sheet material 10 resulted in a 33% increase in bending strength over the plain sheet material from which it was formed, as measured by a 5mm displacement three point bending test

Example 2

[0072] A further specimen of sheet material having a base gauge G of 0.45mm was formed using a tool comprising the same tooth form and having the same pitch as in Example 1.

[0073] The sheet material was formed with an amplitude A of 3 times the base gauge G of the material 17 with a proportion of significant plastic strain of 88% and material thinning of 23%. The formed sheet material 10

resulted in a 36% increase in bending strength over the plain sheet material from which it was formed, as measured by a 5mm displacement three point bending test.

Example 3

[0074] A specimen of sheet material having a base gauge G of 0.7mm was formed using a tool comprising the same tooth form and having the same pitch as in Example 1.

[0075] The sheet material was formed with an amplitude A of 2 times the base gauge G of the material 17 with a proportion of significant plastic strain of 88% and material thinning of 11%. The formed sheet material 10 resulted in a 48% increase in bending strength over the plain sheet material from which it was formed, as measured by a 5mm displacement three point bending test.

Example 4

[0076] A further specimen of sheet material having a base gauge G of 0.7mm was formed using a tool comprising the same tooth form and having the same pitch as in Example 1.

[0077] The sheet material was formed with an amplitude A of 2.5 times the base gauge G of the material 17 with a proportion of significant plastic strain of 96% and material thinning of 22%. The formed sheet material 10 resulted in a 62% increase in bending strength over the plain sheet material from which it was formed, as measured by a 5mm displacement three point bending test.

Example 5

[0078] A specimen of sheet material having a base gauge G of 2mm was formed using a tool comprising the tooth form shown in Figure 9. The pitch of the teeth on the tool was 9.5mm and the first, second, third and fourth radii r_1 , r_2 , r_3 , r_4 all had a constant radius of curvature of 2.5mm.

[0079] The sheet material was formed with an amplitude A of 1.8 times the base gauge G of the material 17 with a proportion of significant plastic strain of 76% and material thinning of 24%. The formed sheet material 10 resulted in a 35% increase in bending strength over the plain sheet material from which it was formed, as measured by a 5mm displacement three point bending test.

[0080] It will be appreciated that several variations to the embodiment disclosed are envisaged without departing from the scope of the invention as defined in the appended claims.

[0081] There may be a substituted for the roll pair 18, 19 a pair of rolls which are not identical, for example, one having square teeth (not shown) and the other having elongated teeth (not shown).

[0082] Whilst helical rows are inclined at 45 degrees relative to the axis of the rolls, they may be inclined at any angle and/or they need not be arranged in helical

rows. The tool need not be rolls, could be, for example, a block with a flat face and/or substantially planar

[0083] The sheet material is preferably mild steel, which may be galvanised or otherwise coated for protection against corrosion. Modification of initially plain, galvanised mild steel sheet in the manner hereinbefore described leaves the protective coating intact. The base gauge G of the plain sheet material is typically within the range 0.3 to 3mm.

[0084] It has been surprisingly found that the present invention can be used to form material with a base gauge G of 3mm whilst still showing improved strength and no noticeable material pinching.

[0085] As will be appreciated, many alternative radii r_1 , r_2 , r_3 , r_4 are envisaged which will result in a number of different forms of rounded sheet engaging surfaces which are consistent with the invention.

[0086] The pitch P between adjacent teeth 30 in rows R11 may be different from the pitch P in the columns C11.

[0087] As used herein, the term "sheet material" embraces generally flat material, for example such as that which is described in the aforesaid European patent applications and products made by bending or shaping generally flat sheet material, examples of which products are shown in Figures 9 and 10 and mentioned in our published International patent application published as WO82/03347.

[0088] By means of the tool according to the invention a sheet of cold rolled material may be manufactured having on both of its surfaces rows of projections and rows of depressions, the projections on one surface corresponding with the depressions on the other surface, the relative positions of the projections and depressions being such that lines drawn on a surface of the sheet between adjacent rows of projections are non-rectilinear, the sheet having a base gauge G, wherein each projection has a substantially continuous region of peak plastic strain at, toward or about its apex and/or is thinned by no more than 25% of its base gauge G.

[0089] Preferably, the peak of each projection is rounded and featureless.

[0090] Preferably, the peak of each projection is free of pinched regions.

[0091] Preferably, the base of each depression comprises two or more different radii of curvature.

[0092] Preferably, the base of each depression comprises a first radius dr_1 , in a first direction, a second radius dr_2 in a second direction along the length of the sheet material, the first direction being different from the second direction, wherein the radius of curvature along the first radius dr_1 , is different from the radius of curvature along the second radius dr_2 .

[0093] Preferably, the pitch P between adjacent depressions or between adjacent projections in each row is at least 2.5 times the or a radius of curvature along the or a first radius dr_1 .

[0094] Preferably, the pitch P is between 2.5 and 3.9 times the radius of curvature along the first radius dr_1 .

[0095] Preferably, the amplitude A of the sheet is between 1.5 and 4 times the base gauge G of the material from which the sheet was formed.

[0096] Preferably, the amplitude A is between 2 and 3 times the base gauge G.

[0097] Preferably, the proportion of sheet material which is subjected to plastic strain of 0.05 or more is at least 65%.

[0098] Preferably, the proportion of sheet material which is subjected to plastic strain of 0.05 or more is at least 80%.

[0099] Preferably, the proportion of sheet material which is subjected to plastic strain of 0.05 or more is between 90% and 100%.

[0100] Preferably, the sheet comprises steel.

[0101] Preferably, the base gauge G is between 0.2mm and 3.00mm.

[0102] Preferably, the base gauge G is 2mm or greater.

[0103] Preferably, the sheet comprises a shaped section or the like for use as a, or as part of a, partition or channel stud.

[0104] Preferably, the projections are formed over all or part of the shaped section.

[0105] The tool for cold forming sheet material according to the invention has rows of teeth on their outer surface, each tooth comprising a rounded sheet engaging surface.

[0106] Preferably, the teeth comprise forming portions free of sharp corners.

[0107] The rounded sheet engaging surface of each tooth has a radius of curvature R, the pitch P between adjacent teeth in a row being between 2.5 and 3.9 times the radius of curvature R.

[0108] Preferably, the pitch P is between 3 and 3.5 times the radius of curvature R.

[0109] Preferably, the radius of curvature R is at least 1.1 times the base gauge G of the sheet material to be formed.

[0110] Preferably, the radius of curvature is at least 2 times the base gauge G of the sheet material to be formed.

[0111] Preferably, the rounded sheet engaging surface of each tooth has a first radius r_1 in a first direction and a second radius r_2 in a second direction along the rows, the first direction being at an acute angle in relation to the second direction, wherein the second radius r_2 is less than the first radius r_1 .

[0112] Preferably, the pitch P between adjacent teeth in a row is at least 3.3 times the first and/or second radii r_1 , r_2 .

[0113] Preferably, the tool is for cold forming sheet material having a base gauge G of 2mm or greater, each tooth having a rounded sheet engaging surface with a radius of curvature greater than or equal to 2mm and a pitch P of less than 26mm.

[0114] Preferably, the pitch P is less than 15.6mm.

[0115] Preferably, the pitch P is between 5mm and 15.6mm

[0116] Preferably, the pitch P is between 5mm and 7.8mm.

[0117] Preferably, the tool comprises a cylindrical roll rotatable about an axis.

5 [0118] The tooth of the tool may comprise one or more compound radii of curvature, wherein the radius of curvature on one part of the tooth's periphery may blend smoothly and continuously into a second radius of curvature on another part of the tooth's periphery.

10 [0119] The invention also relates to an apparatus for cold rolling sheet material comprising a pair of tools according to the invention.

15 [0120] The pair of tools may further comprise a pair of rollers arranged to shape the formed sheet material, for example into a channel section.

Claims

20 1. A tool (20) for cold rolling sheet material having a base gauge G, the tool being cylindrical having an axial dimension extending along an axis of rotation and a circumferential surface having a circumferential dimension extending orthogonally to the axial dimension, the tool having rows (R12, R13) of teeth (30, 130, 230, 330, 430, 630) extending from the circumferential surface, each tooth having a rounded sheet engaging surface, each tooth (30, 130, 230, 330, 430, 630) **characterized by:**

a radius r_1 extending along a first direction, a second radius r_2 extending along the axial dimension, a fourth radius r_4 extending along the circumferential dimension;
a third radius r_3 extending in a direction orthogonal to said first direction, said first and third directions extending between said axial and circumferential dimensions;
both the first radius, and the third radius r_3 being equal to a radius of curvature R at and adjacent the peak (11, 31a, 41a, 61a) of each tooth, and the pitch between adjacent teeth in a row being between 2.5R and 3.9R

35 2. A tool (20) according to Claim 1, wherein each tooth (30, 130, 230, 330, 430, 630) has a second radius of curvature extending in the axial direction.

3. A tool (20) according to Claim 2, wherein the second radius of curvature is the same or less than the radius of curvature R.

40 4. A tool (20) according to Claim 2 or 3, wherein each tooth (30, 130, 230, 330, 430, 630) has third and fourth radii of curvature, the third extending in a direction orthogonal to the first and the fourth extending in a direction orthogonal to the second.

5. A tool (20) according to Claim 4, wherein at least one of the four radii of curvature are different from the others.
6. A tool (20) according to any preceding Claim, wherein teeth (30,130,230,330,430,630) are arranged in helical rows.
7. A tool (20) according to any preceding Claim, wherein each tooth (30,130,230,330,430,630) has a substantially square base, in plan.
8. A tool (20) according to any of Claims 1 to 6 wherein each tooth (30,130,230,330,430,630) is a four lobed base, in plan.
9. A tool (20) according to any preceding Claim, wherein the tool is for cold forming sheet material having a base gauge G of 2mm or greater, each tooth (30,130,230,330,430,630) having a rounded sheet engaging surface with a radius of curvature greater than or equal to 2mm and a pitch P of less than 26mm.
10. A tool (20) as claimed in Claim 9, wherein the pitch P is less than 15.6mm.
11. A tool (20) as claimed in any preceding Claim, wherein the tool (20) comprises a cylindrical roll rotatable about an axis.
12. A tool (20) as claimed in any preceding Claim, wherein the four radii (r_1 , r_2 , r_3 , r_4) are equal or different.
13. An apparatus for cold rolling sheet material having a base gauge G and comprising a pair of tools (20) as claimed in any one of Claims 1 to 12.

Patentansprüche

1. Werkzeug (20) zum Kaltwalzen von Blechmaterial mit einer Basisstärke G, wobei das Werkzeug zylindrisch ist und eine axiale Abmessung aufweist, die sich entlang der Rotationsachse erstreckt sowie eine umfängliche Oberfläche mit einer umfänglichen Abmessung, die sich orthogonal zu der axialen Abmessung erstreckt, wobei das Werkzeug Reihen (R12, R13) von Zähnen (30, 130, 230, 330, 430, 630) aufweist, die sich von der umfänglichen Oberfläche erstrecken, wobei jeder Zahn eine abgerundete Blecheingriffsoberfläche aufweist, wobei jeder Zahn (30, 130, 230, 330, 430, 630) **gekennzeichnet ist durch:**

einen Radius r_1 , der sich entlang einer ersten Richtung erstreckt;
einen zweiten Radius r_2 , der sich entlang der

axialen Abmessung erstreckt, einen vierten Radius r_4 , der sich entlang der umfänglichen Abmessung erstreckt;
einen dritten Radius r_3 , der sich in eine zu der ersten Richtung orthogonale Richtung erstreckt, wobei sich die erste und die dritte Richtung zwischen den axialen und umfänglichen Abmessungen erstrecken;
wobei sowohl der erste Radius und als auch der dritte Radius r_3 einem Krümmungsradius R an und angrenzend an die Spitze (11, 31 a, 41 a, 61 a) jedes Zahns entsprechen, und wobei die Teilung zwischen benachbarten Zähnen in einer Reihe zwischen 2,5R und 3,5R liegt.

2. Werkzeug (20) nach Anspruch 1, wobei jeder Zahn (30, 130, 230, 330, 430, 630) einen zweiten Krümmungsradius aufweist, der sich in die axiale Richtung erstreckt.
3. Werkzeug (20) nach Anspruch 2, wobei der zweite Krümmungsradius kleiner oder gleich dem Krümmungsradius R ist.
4. Werkzeug (20) nach Anspruch 2 oder 3, wobei jeder Zahn (30, 130, 230, 330, 430, 630) dritte und vierte Krümmungsradien aufweist, wobei sich der dritte Radius in eine Richtung erstreckt, die orthogonal ist zu der ersten Richtung, und wobei sich der vierte Radius in eine Richtung erstreckt, die orthogonal ist zu der zweiten Richtung.
5. Werkzeug (20) nach Anspruch 4, wobei sich wenigstens einer der vier Krümmungsradien von den anderen Radien unterscheidet.
6. Werkzeug (20) nach einem der vorstehenden Ansprüche, wobei die Zähne (30, 130, 230, 330, 430, 630) in spiralförmigen Reihen angeordnet sind.
7. Werkzeug (20) nach einem der vorstehenden Ansprüche, wobei jeder Zahn (30, 130, 230, 330, 430, 630) in der Draufsicht eine im Wesentlichen rechteckige Basis aufweist.
8. Werkzeug (20) nach einem der Ansprüche 1 bis 6, wobei jeder Zahn (30, 130, 230, 330, 430, 630) in der Draufsicht eine Basis mit vier Nocken ist.
9. Werkzeug (20) nach einem der vorstehenden Ansprüche, wobei das Werkzeug vorgesehen ist zum Kaltformen von Blechmaterial mit einer Basisstärke G von 2 mm oder mehr, wobei jeder Zahn (30, 130, 230, 330, 430, 630) eine abgerundete Blecheingriffsoberfläche mit einem Krümmungsradius von größer oder gleich 2 mm aufweist und eine Teilung P von weniger als 26 mm.

10. Werkzeug (20) nach Anspruch 9, wobei die Teilung P kleiner ist als 15,6 mm.
11. Werkzeug (20) nach einem der vorstehenden Ansprüche, wobei das Werkzeug (20) eine zylindrische Walze umfasst, die um eine Achse drehbar ist.
12. Werkzeug (20) nach einem der vorstehenden Ansprüche, wobei die vier Radien (r_1 , r_2 , r_3 , r_4) gleich oder unterschiedlich sind.
13. Vorrichtung zum Kaltwalzen von Blechmaterial mit einer Basisstärke G und umfassend ein Paar von Werkzeugen (20) nach einem der Ansprüche 1 bis 12.

Revendications

1. Outil (20) pour le laminage à froid d'une tôle ayant une épaisseur de base G, l'outil étant cylindrique et ayant une dimension axiale s'étendant le long d'un axe de rotation et une surface circonférentielle ayant une dimension circonférentielle s'étendant perpendiculairement à la dimension axiale, l'outil ayant des rangées (R12, R13) de dents (30, 130, 230, 330, 430, 630) s'étendant de la surface circonférentielle, chaque dent ayant une surface venant en prise avec une tôle arrondie, chaque dent (30, 130, 230, 330, 430, 630) étant **caractérisée par** :
- un rayon r_1 s'étendant le long d'une première direction,
- un deuxième rayon r_2 s'étendant le long de la dimension axiale, un quatrième rayon r_4 s'étendant le long de la dimension circonférentielle ;
- un troisième rayon r_3 s'étendant dans une direction perpendiculaire à ladite première direction, lesdites première et troisième directions s'étendant entre lesdites dimensions axiales et circonférentielles ;
- le premier rayon et le troisième rayon r_3 étant égaux à un rayon de courbure R au niveau et à proximité du pic (11, 31, 41, 61 a) de chaque dent, et le pas entre les dents adjacentes d'une rangée étant compris entre 2,5 R et 3,9 R.
2. Outil (20) selon la revendication 1, chaque dent (30, 130, 230, 330, 430, 630) ayant un deuxième rayon de courbure s'étendant dans la direction axiale.
3. Outil (20) selon la revendication 2, le deuxième rayon de courbure étant égal ou inférieur au rayon de courbure R.
4. Outil (20) selon la revendication 2 ou 3, chaque dent (30, 130, 230, 330, 430, 630) ayant des troisième et quatrième rayons de courbure, le troisième s'étendant

dans une direction perpendiculaire au premier et le quatrième s'étendant dans une direction perpendiculaire au deuxième.

5. Outil (20) selon la revendication 4, au moins l'un des quatre rayons de courbure étant différent des autres.
6. Outil (20) selon l'une quelconque des revendications précédentes, les dents (30, 130, 230, 330, 430, 630) étant disposées en rangées hélicoïdales.
7. Outil (20) selon l'une quelconque des revendications précédentes, chaque dent (30, 130, 230, 330, 430, 630) ayant une base sensiblement carrée, en plan.
8. Outil (20) selon l'une quelconque des revendications 1 à 6, chaque dent (30, 130, 230, 330, 430, 630) étant une base à quatre arêtes, en plan.
9. Outil (20) selon l'une quelconque des revendications précédentes, l'outil étant destiné au laminage à froid d'une tôle ayant une épaisseur de base G de 2 mm ou plus, chaque dent (30, 130, 230, 330, 430, 630) ayant une surface venant en prise avec une tôle arrondie avec un rayon de courbure supérieur ou égal à 2 mm et un pas P inférieur à 26 mm.
10. Outil (20) selon la revendication 9, le pas P étant inférieur à 15,6 mm.
11. Outil (20) selon l'une quelconque des revendications précédentes, l'outil (20) comprenant un rouleau cylindrique apte à tourner autour d'un axe.
12. Outil (20) selon l'une quelconque des revendications précédentes, les quatre rayons (r_1 , r_2 , r_3 , r_4) étant égaux ou différents.
13. Appareil de laminage à froid d'une tôle ayant une épaisseur de base G et comprenant une paire d'outils (20) selon l'une quelconque des revendications 1 à 12.

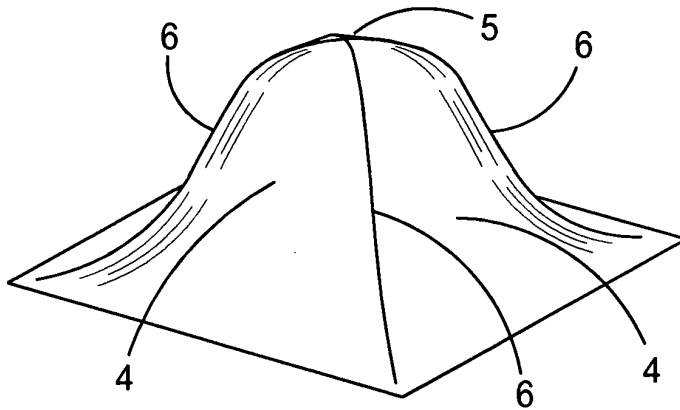


FIGURE 1 PRIOR ART

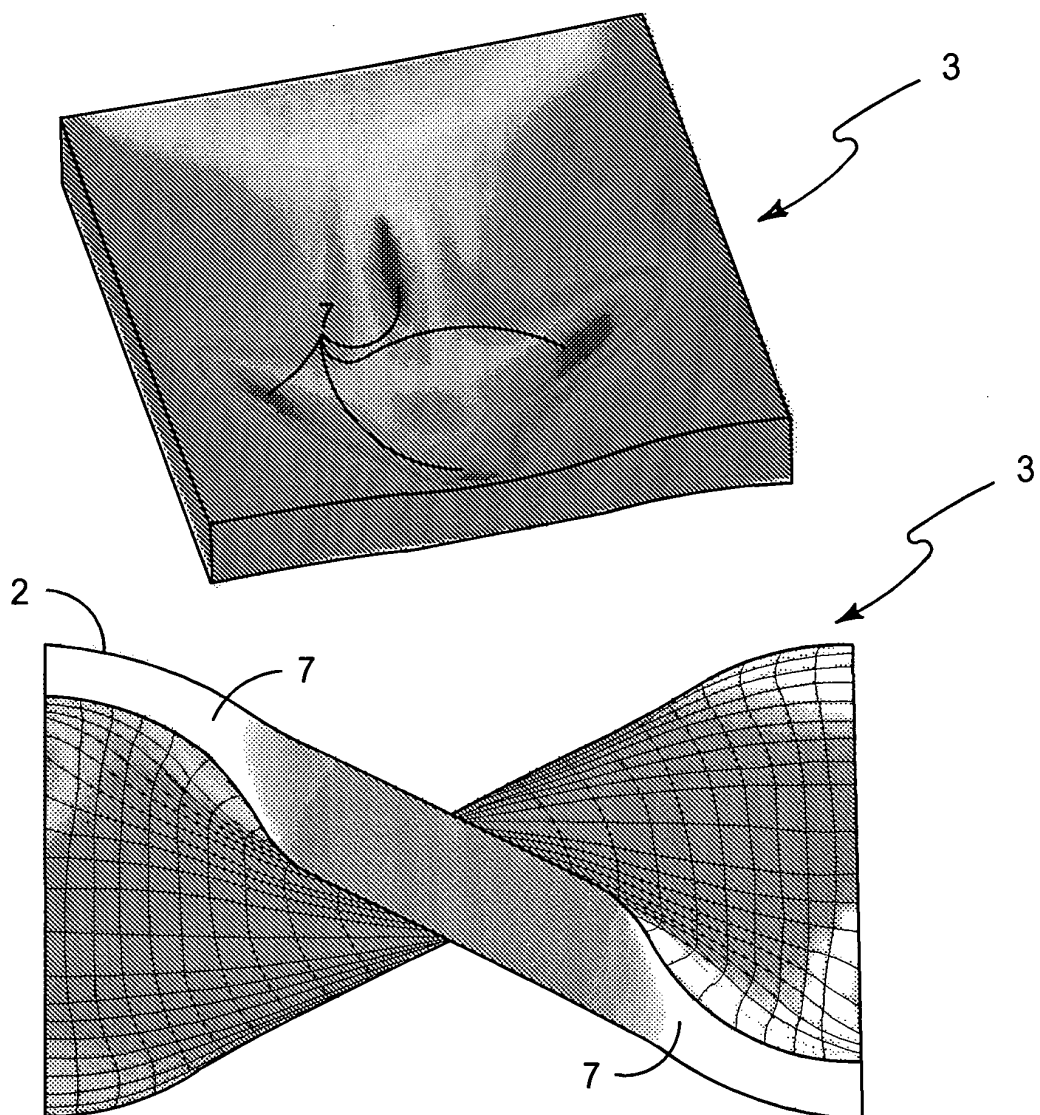
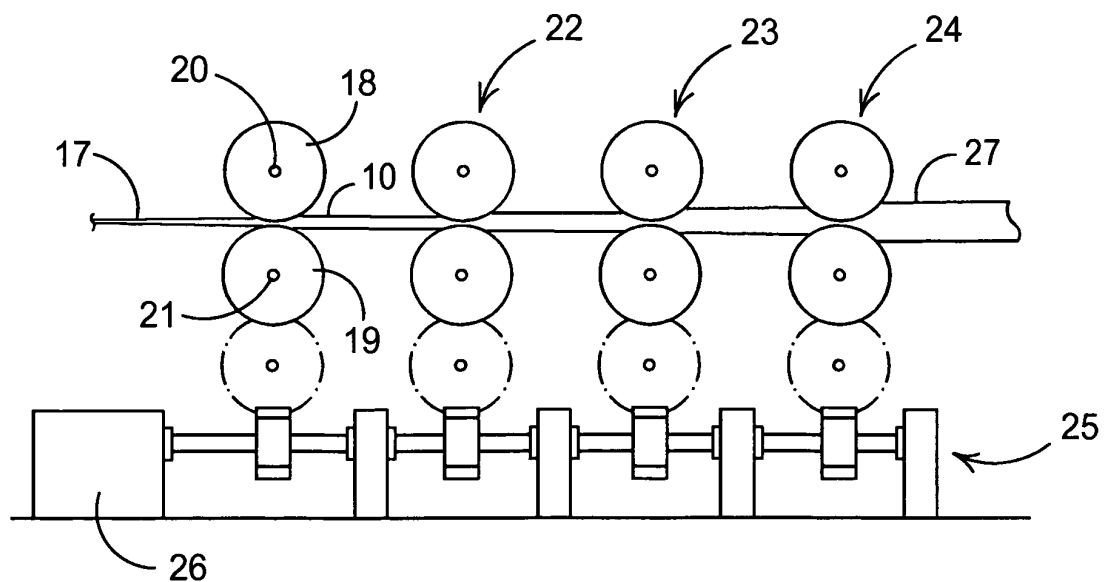
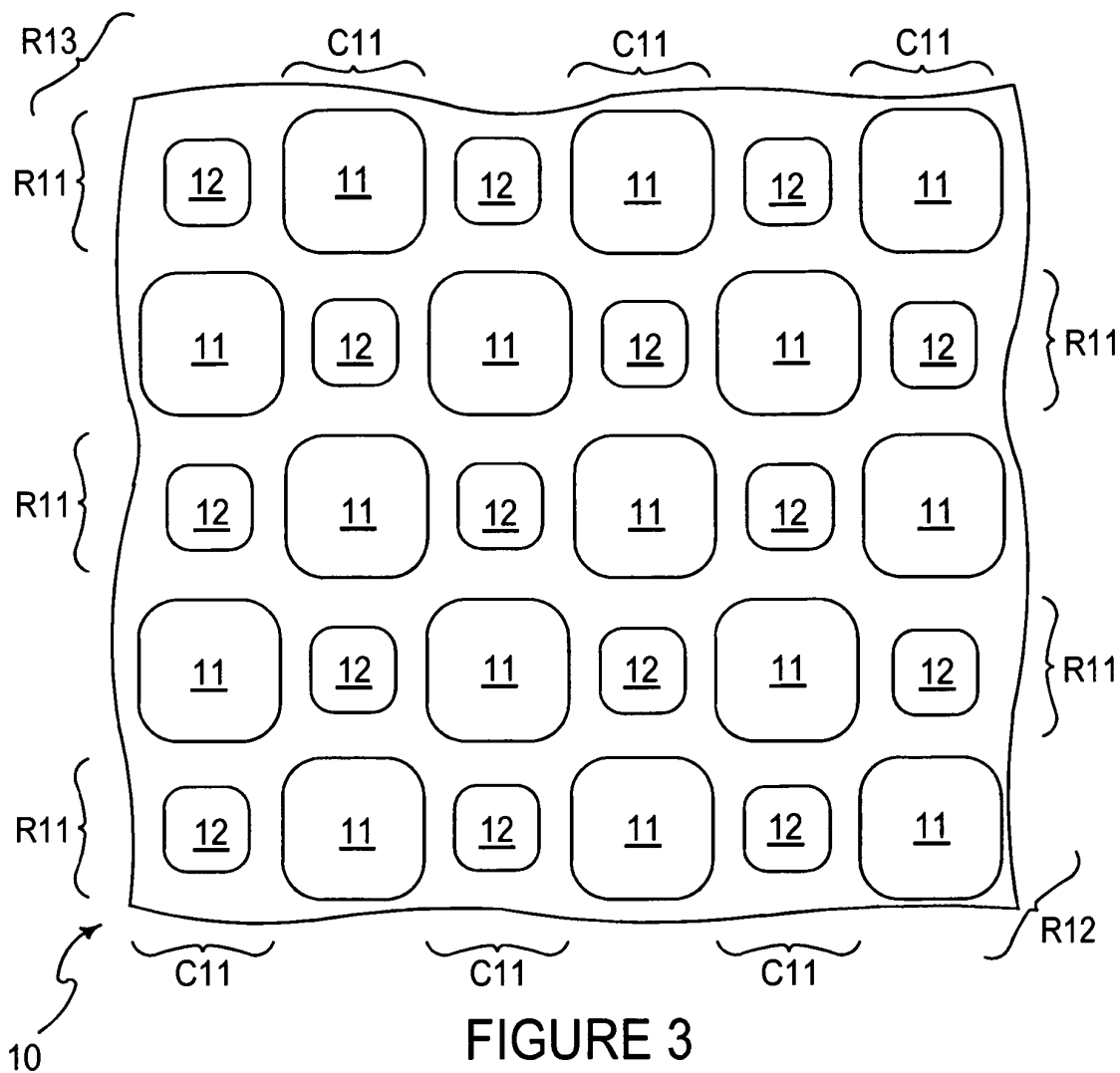


FIGURE 2 PRIOR ART



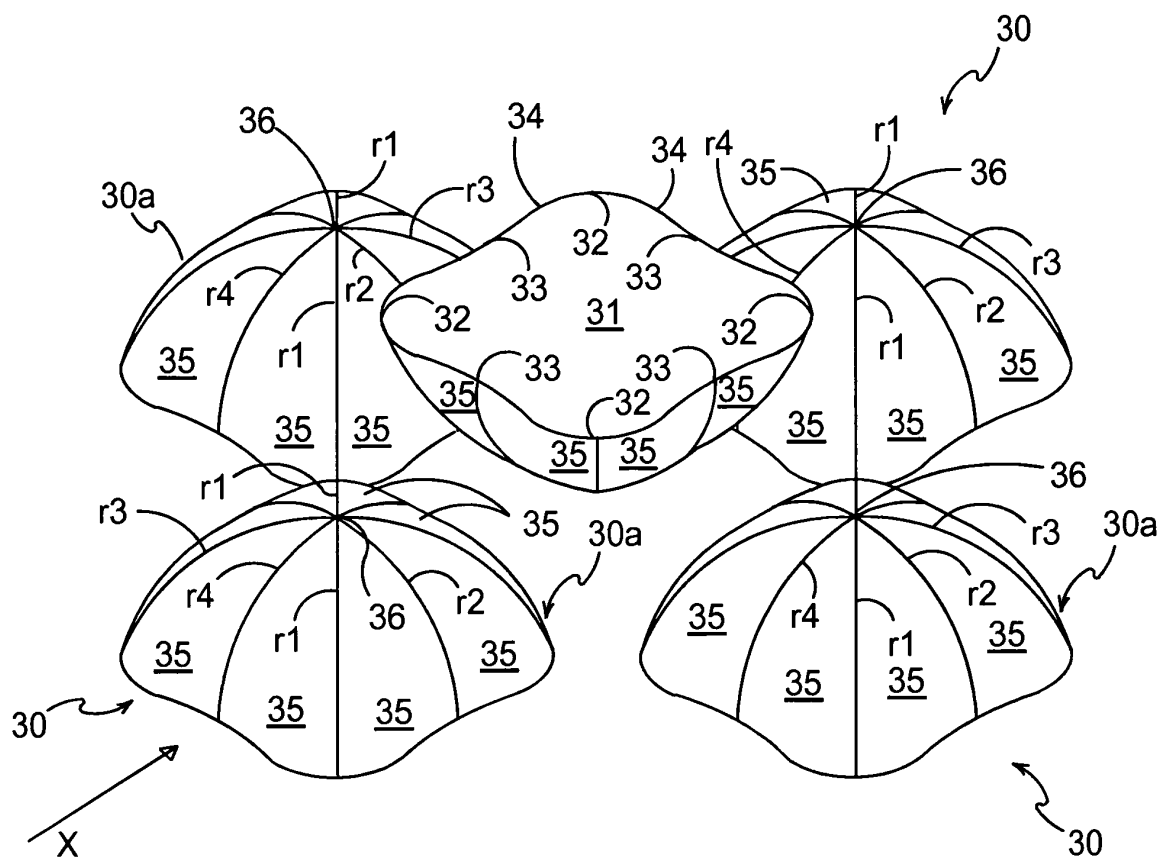


FIGURE 5

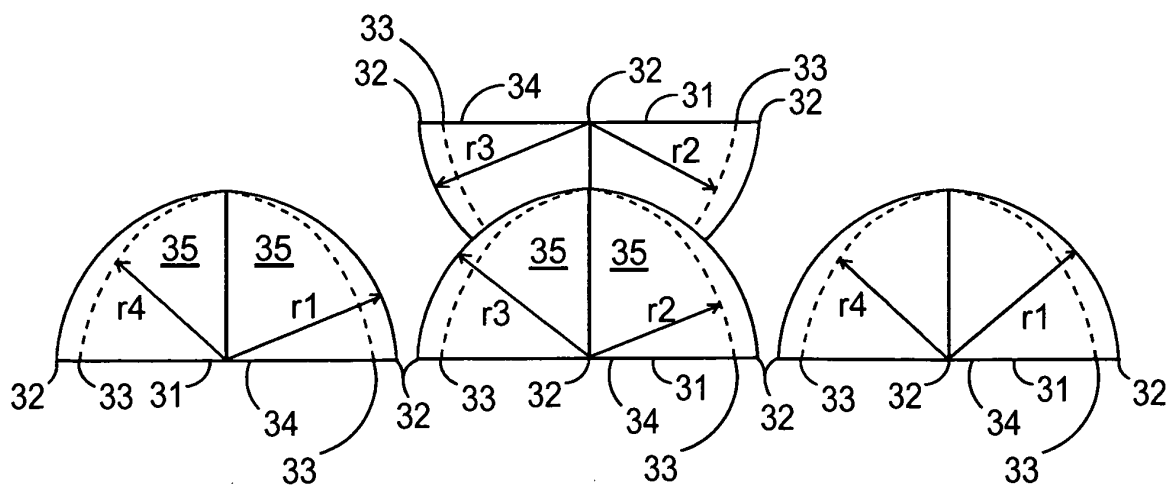


FIGURE 6

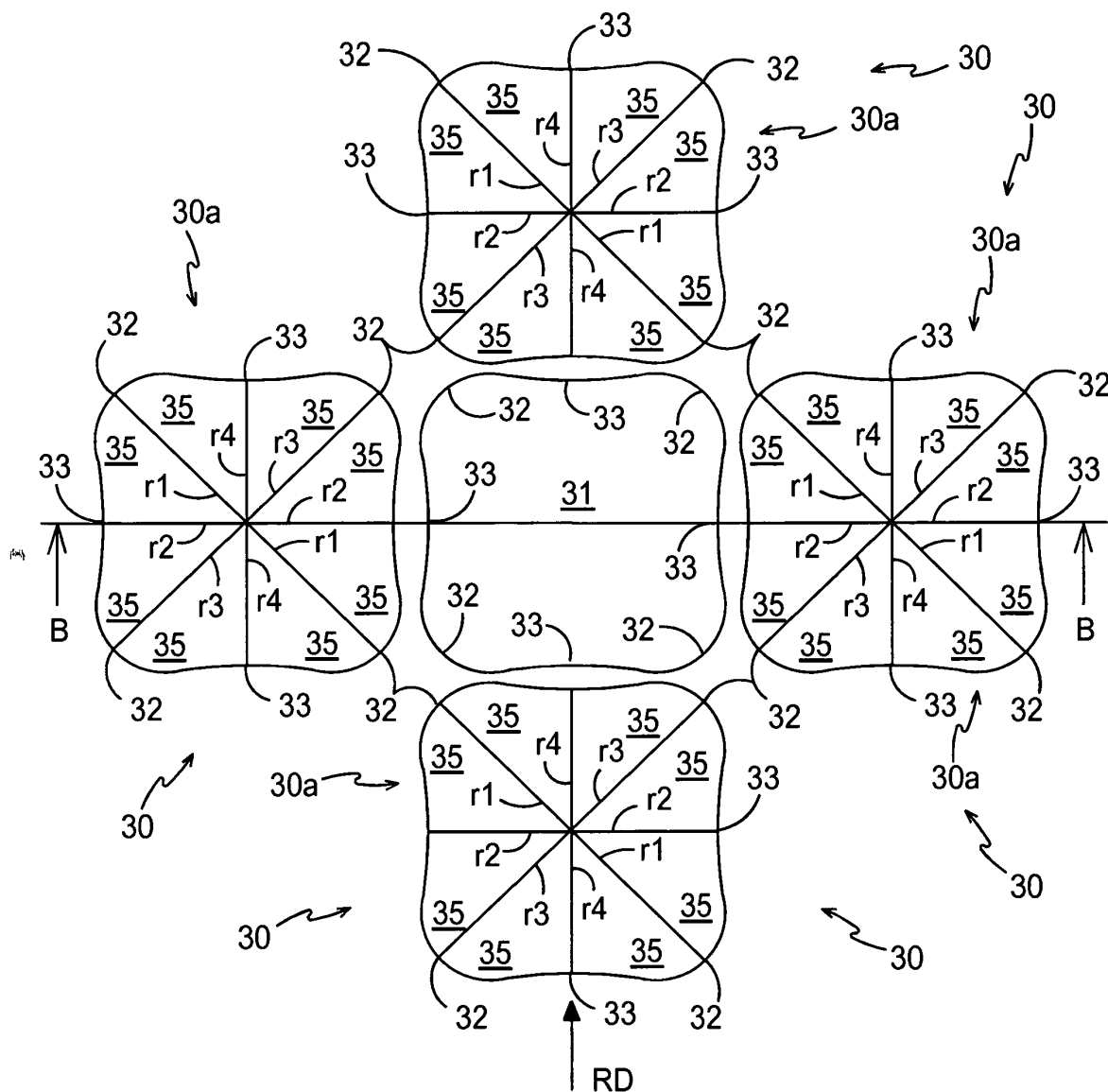


FIGURE 7

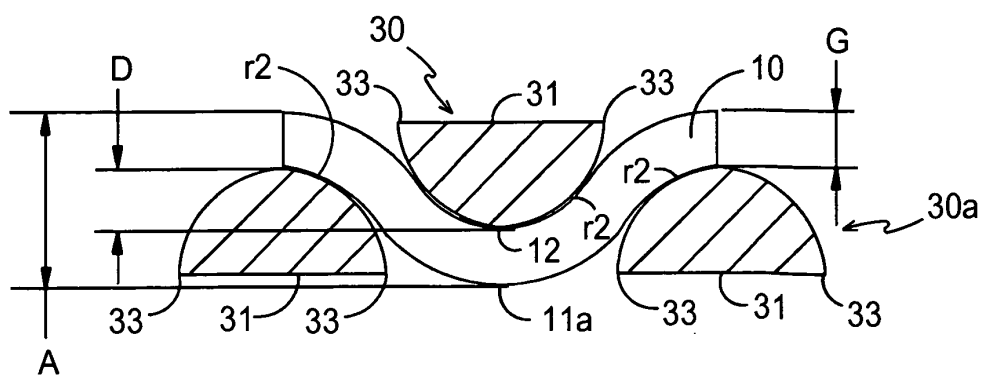


FIGURE 8

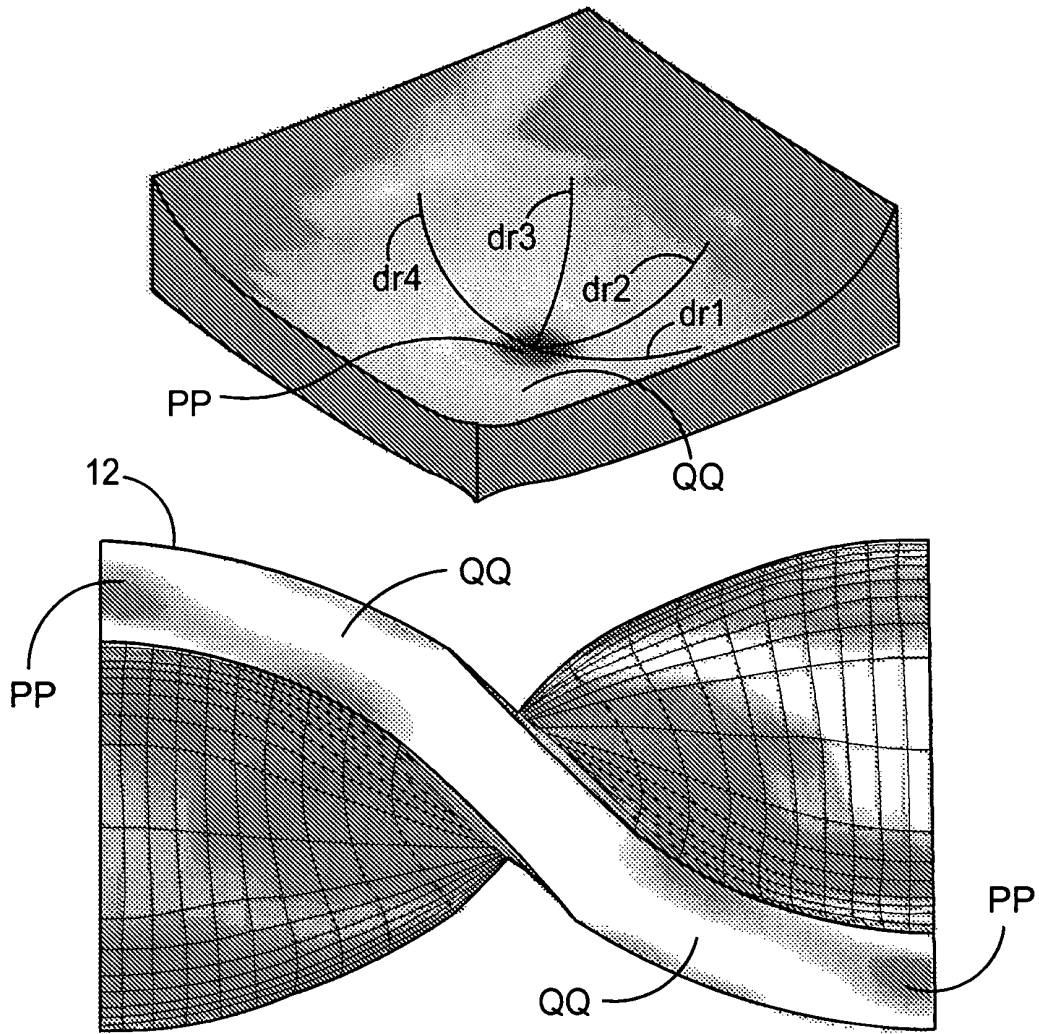


FIGURE 8A

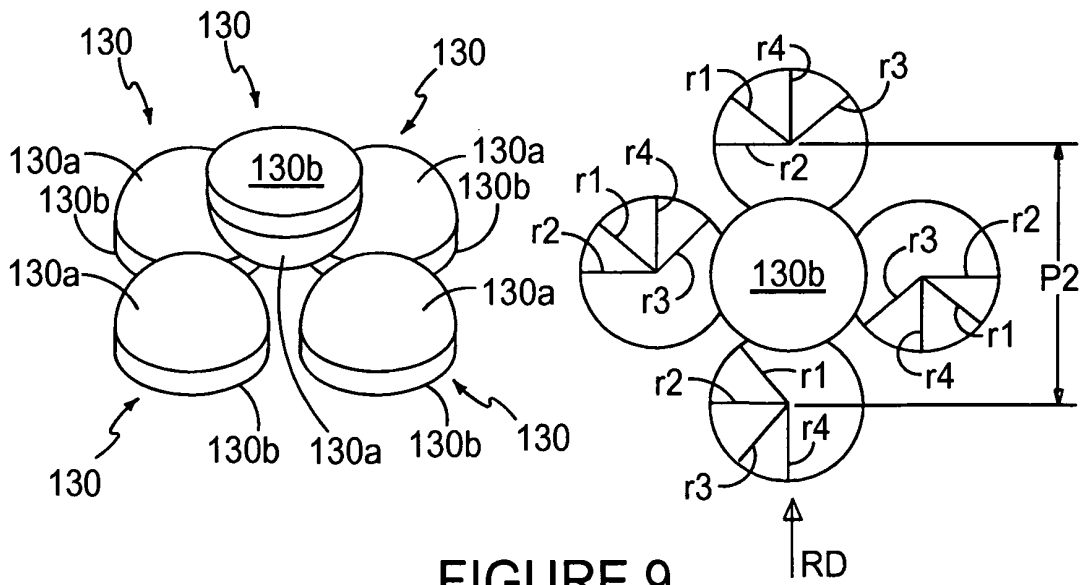


FIGURE 9

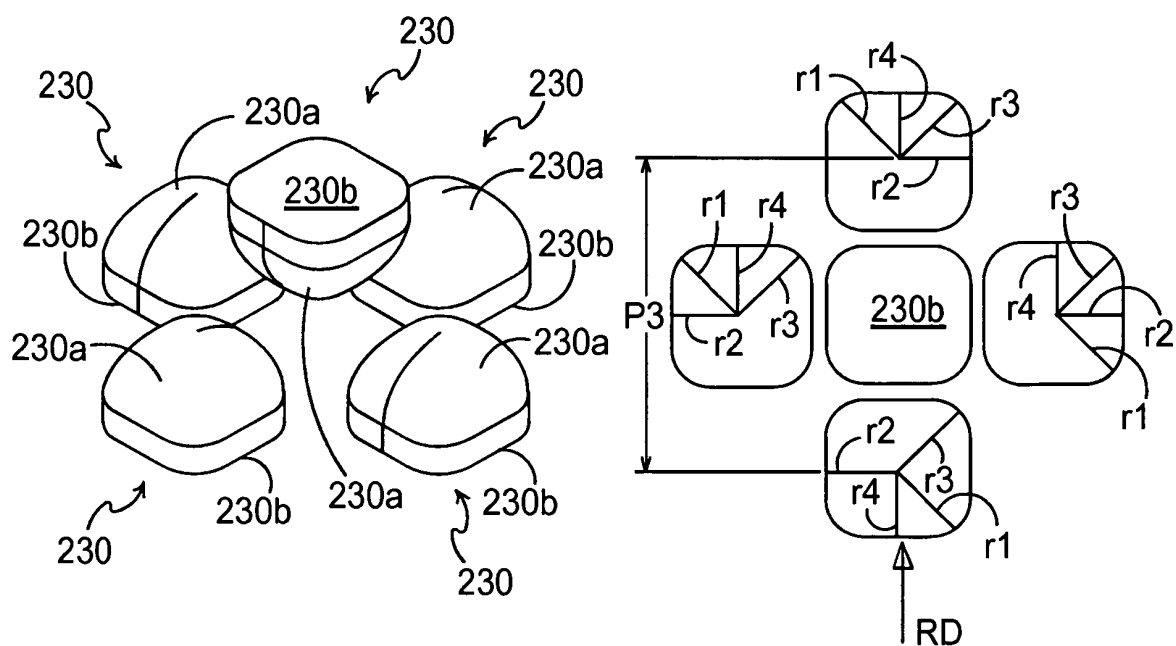


FIGURE 10

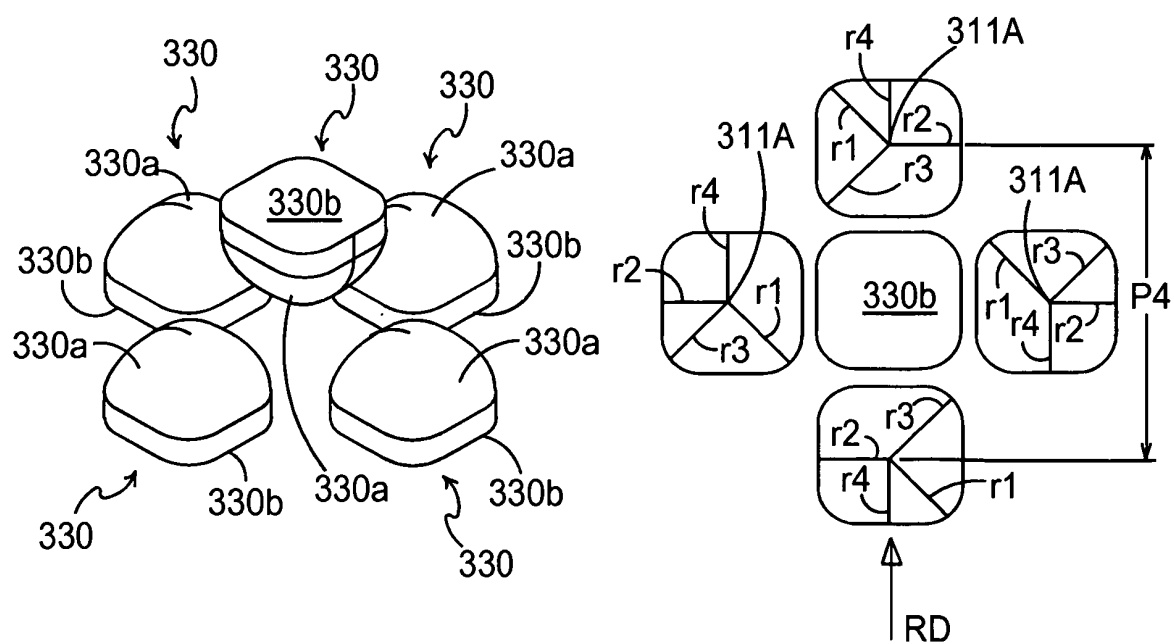


FIGURE 11

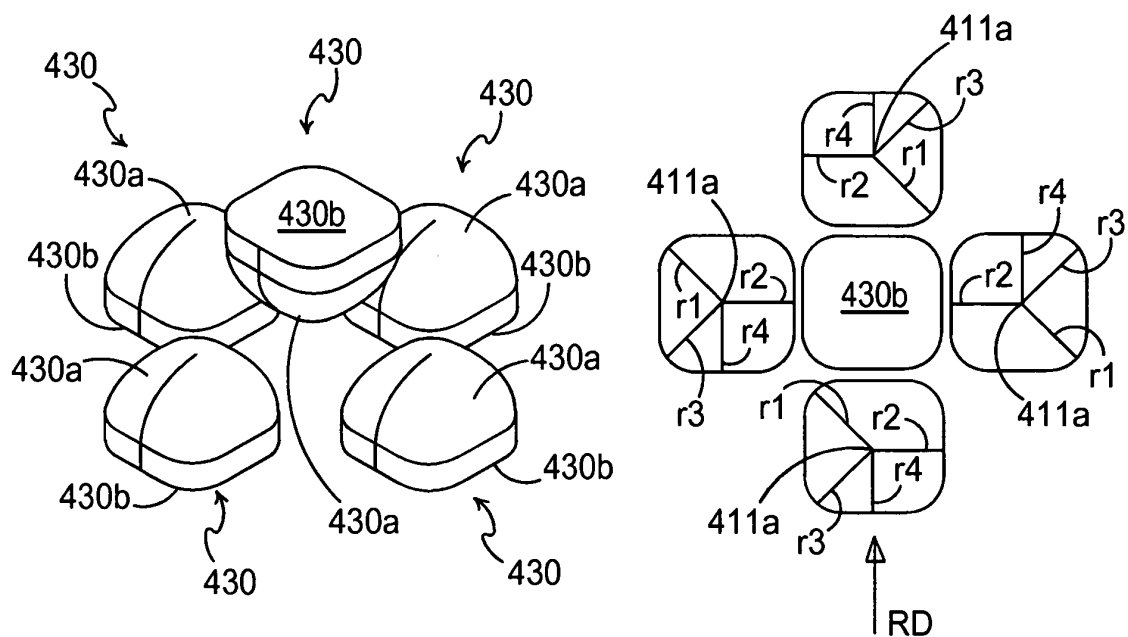


FIGURE 12

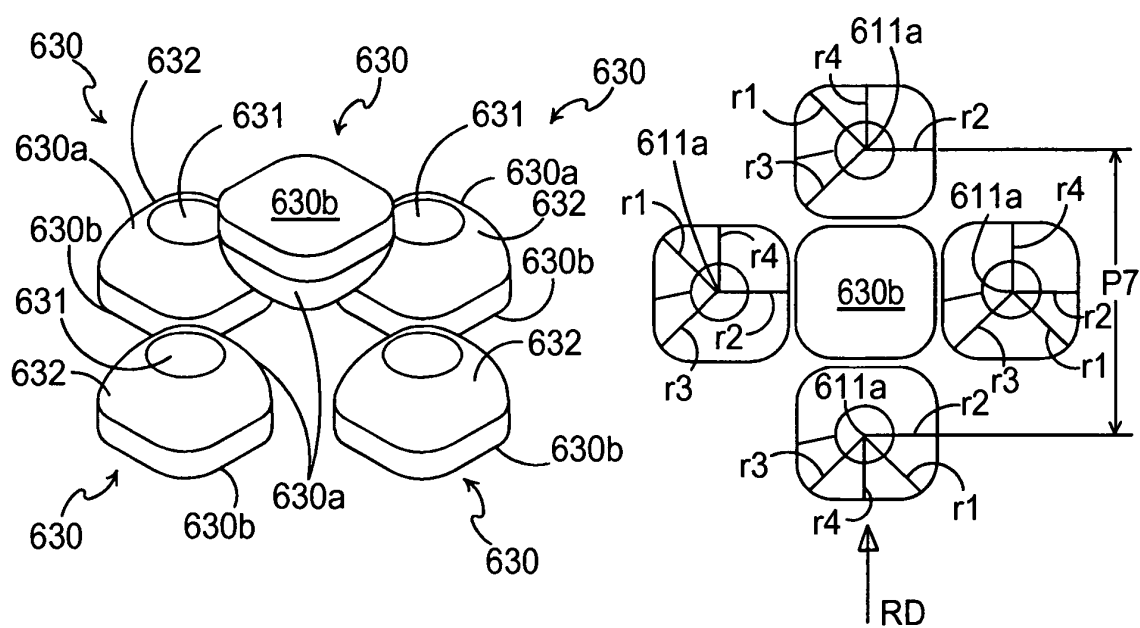


FIGURE 13

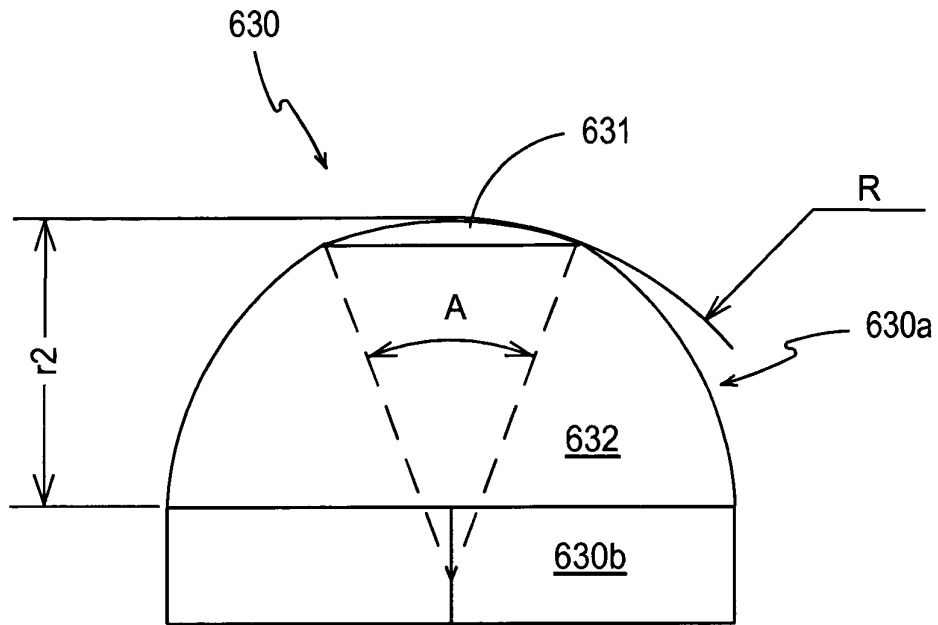


FIGURE 14A

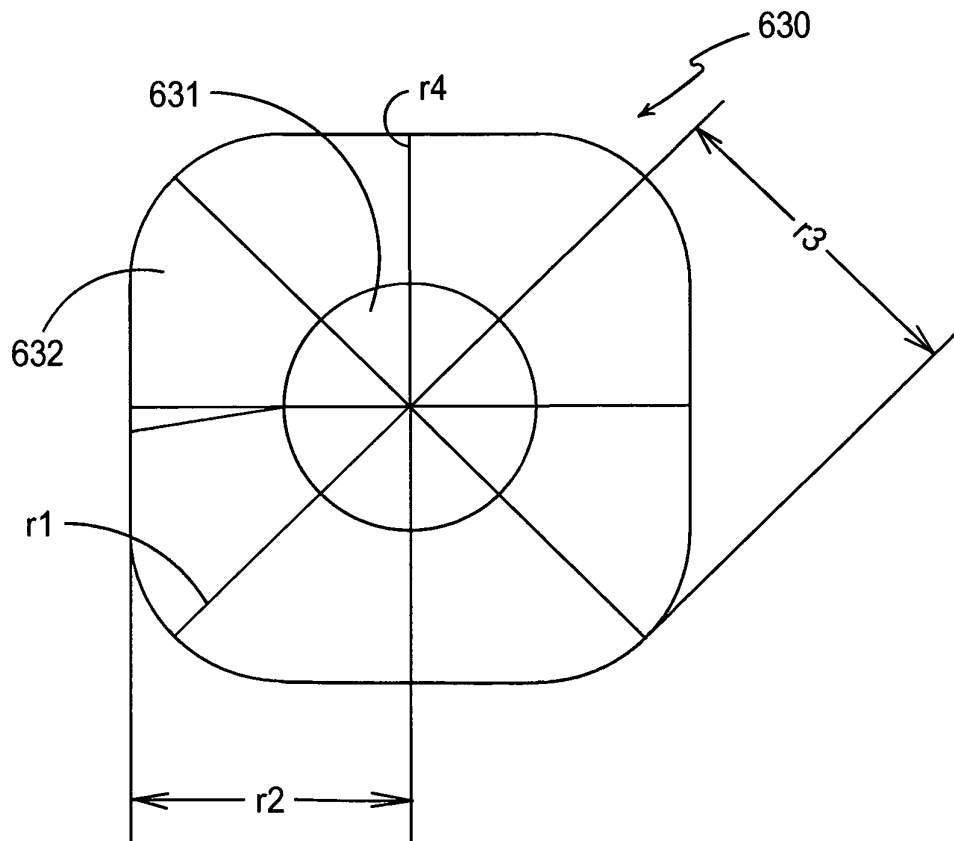


FIGURE 14B

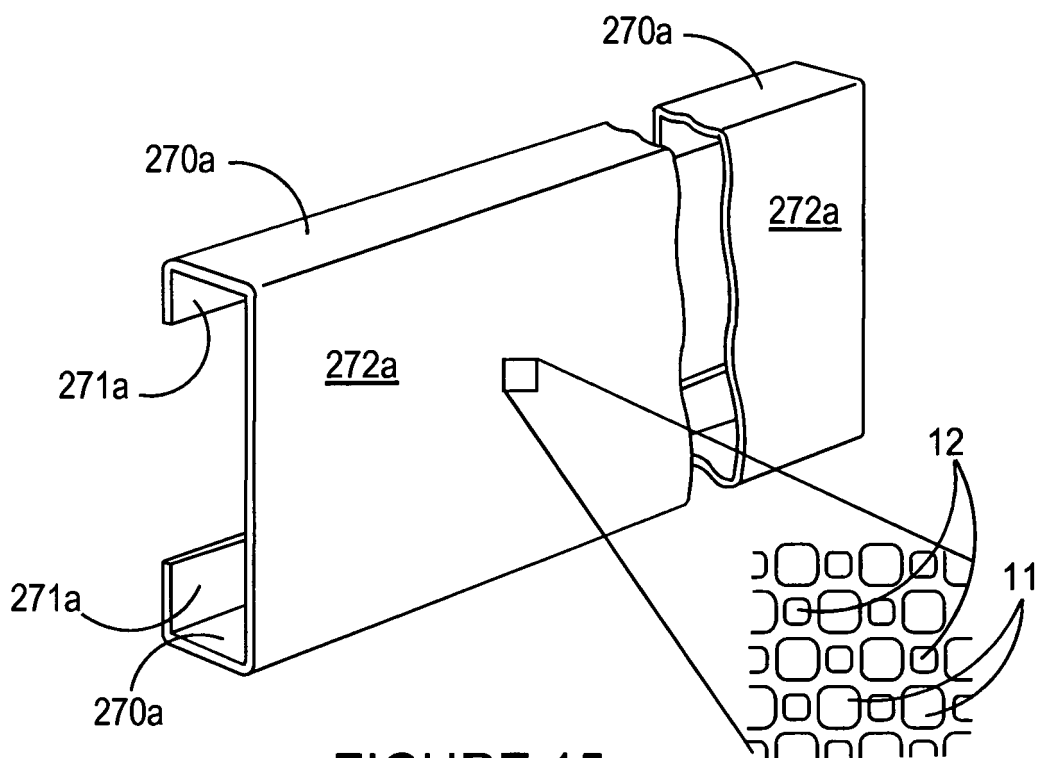


FIGURE 15

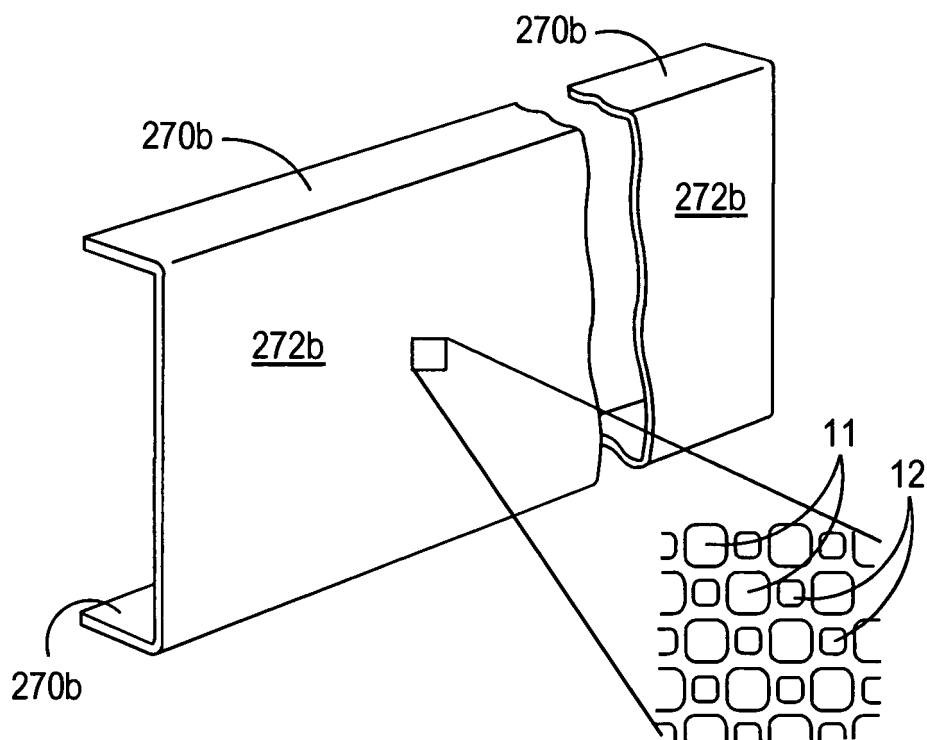


FIGURE 16

REFERENCES CITED IN THE DESCRIPTION

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- EP 0891234 A [0025]
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