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United States Patent [19][11] **Patent Number:** 5,918,498**Robbins**[45] **Date of Patent:** Jul. 6, 1999**[54] DUMMY BLOCK CONSTRUCTION****FOREIGN PATENT DOCUMENTS**

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[21] **Appl. No.:** 08/863,100[22] **Filed:** May 23, 1997**Related U.S. Application Data**

[63] **Continuation-in-part of application No. 08/683,268, Jul. 18, 1996, Pat. No. 5,771,734.**

[51] **Int. Cl.⁶** B21C 25/00[52] **U.S. Cl.** 72/273[58] **Field of Search** 72/273, 273.5, 72/272, 253.1, 478**[56] References Cited****U.S. PATENT DOCUMENTS**

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In a dummy block construction for use in extruding an extrudable metal, the dummy block having a dummy block base; a connector for connecting said dummy block base to a stem of an extruder; a replaceable wear ring connected to a forward circumferential portion of said dummy block base; a device for releasably securing said wear ring to said dummy block base; a device for expanding said ring to engage a billet container inside wall of an extrusion press during extrusion of a billet of extrudable metal through such extrusion press, the improvement being characterized in the wear ring being a metal collar having a conical interior surface converging towards said dummy block base; and the device for expanding the ring comprising a metal plunger having a plunger head with a conical surface for engaging the collar conical surface to expand the collar as said plunger head is forced into the collar during extrusion; the converging surfaces of the collar and the plunger head extending a sufficient distance to permit telescoping of the plunger head into the collar to an extent whereby the collar is expanded to engage the billet container inside wall.

7 Claims, 9 Drawing Sheets