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United States Patent [19]

Robbins

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[54] METAL EXTRUSION DUMMY BLOCK HAVING A SPRING LOADED VALVE

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[52] U.S. Cl. 72/273

[58] Field of Search 72/273, 273.5, 272, 72/253.1

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[57] ABSTRACT

An extrusion press for extruding extrudable metals through a die by use of a dummy block, the addition of a mechanical venting device to vent gases from the container. The venting device has:

i) a circular shaped valve member provided in a front face of the dummy block, the valve member is moveable inwardly and outwardly of the dummy block from an open venting position to a closed position,

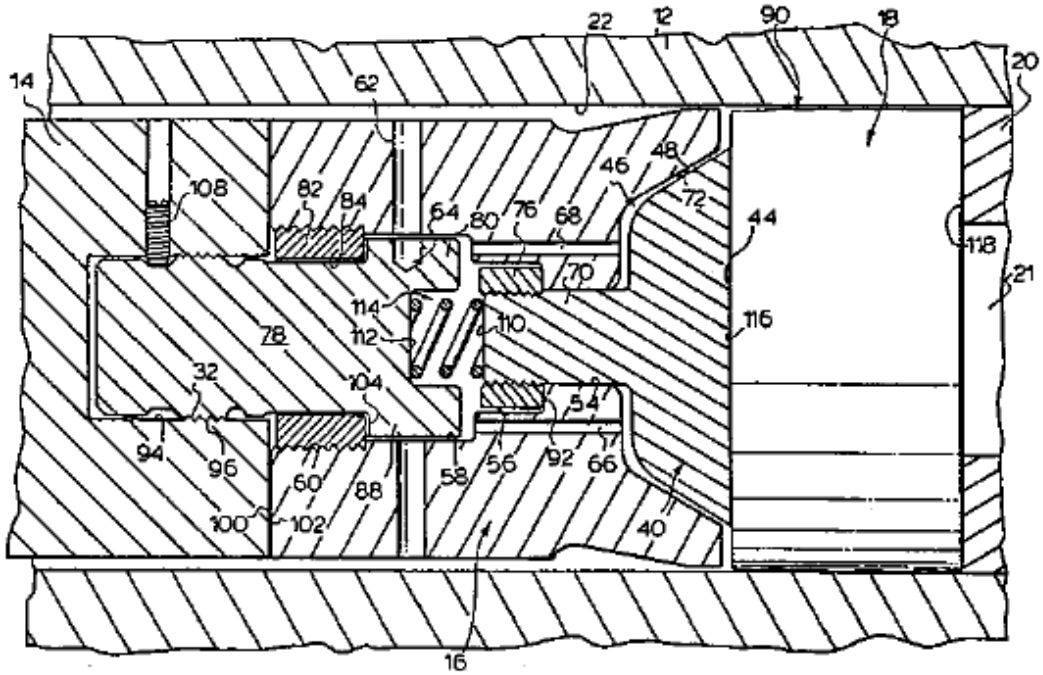
ii) a channel is provided in the dummy block and leads away therefrom to vent gases away from the valve in the open position,

iii) a spring is provided for biasing the valve member to the open position,

iv) the spring resists movement of the valve member toward the closed position by virtue of the dummy block moving into the container and the valve member contacts a metal billet in the container and is thereby urged toward the closed position,

v) the spring has a present resistance value which resists movement of the valve member to the closed position at least until a metal billet in the container commences to upset and flow within the container at which moment force on the valve member due to the dummy block advancing into the container exceeds the resistance value of the biasing means. In this manner the valve is retained in the open position until the last possible moment to vent gases from the container.

7 Claims, 5 Drawing Sheets



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