

Title (en)
PRESS FOR DRAWING SHEET COMPONENTS

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EP 0312808 A3 19891018 (DE)

Application
EP 88115855 A 19880927

Priority
DE 3735581 A 19871021

Abstract (en)
[origin: EP0312808A2] The invention relates to a press for drawing sheet components, in which the hold-down force during the drawing operation is applied to the hold down of the tool by a drawing apparatus of the forming machine. In order to be able to set the hold-down force individually, preferably zone by zone, with accuracy of reproduction and low inertia and hold it at the preset value, the drawing apparatus (es) is (are) designed in such a way that a hydraulically controlled die cushion is used during the drawing operation. A hydraulic hold-down force control is provided for the (each) die cushion of a press. Via a pressure or force sensor assigned to each die cushion, it is possible to measure the associated hold-down force. Via a forward path formed by a controller and a throttle valve under electrohydraulic pilot control, the force-determining pressure space of the die cushion can in each case be adjusted individually to the required pressure. This forward path operates with a low inertia and substantially without hysteresis, allowing the desired value for the hold-down force to be changed in accordance with a recurring functional sequence, even during a pressing cycle. <IMAGE>

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Citation (search report)
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