

Title (en)

DEVICE FOR CONTROLLING THE DRAWING PROCESS IN A TRANSFER PRESS

Title (de)

EINRICHTUNG ZUR STEUERUNG DES ZIEHVORGANGS BEI EINER TRANSFERPRESSE

Title (fr)

SYSTEME POUR COMMANDER LE PROCESSUS D'ETIRAGE DANS UNE PRESSE DE TRANSFERT

Publication

**EP 1656224 A1 20060517 (DE)**

Application

**EP 04741376 A 20040806**

Priority

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Abstract (en)

[origin: WO2005016571A1] The invention relates to a device for controlling the drawing process in a transfer press, said device comprising two antagonistic tool parts (11, 12) between which a workpiece (10) to be formed is held. One tool part (11) can be displaced between two stop points (OT, UT) by a mechanical crank mechanism (13) driven at a constant rotational speed. The second tool part (12) is connected to the piston (16) of a hydraulic differential cylinder (15) by means of a piston rod (17). During a first time interval, inside a region defined by the first and the second stop point, the rod-side surface (Ar) of the piston is subjected to a pressure that is sufficiently high to accelerate the second tool part (12) in such a way that when the two tool parts meet, they both move at practically the same speed. A controllable throttle (35) is arranged between a bottom-side chamber (15b) and a tank (26). In order to save energy during the operation of one such transfer press, in a second time interval following the first time interval and lasting until the second stop point (UT), the rod-side surface (Ar) of the piston is subjected to a second pressure that is smaller than the pressure subjected thereon during the first time interval.

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