

Title (en)
METHOD FOR PRODUCING A WORKPIECE BY FORMING UNDER BENDING CONDITIONS

Title (de)
VERFAHREN ZUR HERSTELLUNG EINES WERKTEILS DURCH BIEGEUMFORMUNG

Title (fr)
PROCEDE POUR REALISER UNE PIECE PAR CINTRAGE

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Application
EP 05773976 A 20050830

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Abstract (en)
[origin: WO2006026797A1] The invention relates to a method for producing a workpiece (24) by bending a sheet bar (25) in a bending press, particularly a folding press (1) with measures for compensating for stress-dependent deformations of the folding press (1), particularly the bending deformation of the press bars (5, 8). The measures provide a detection of adjusting forces of drive means (9, 10) during a bending of the sheet bar (25) with an action depth (70) of the bending tools (21, 22) slightly less than a required bending action (72) for forming a specified deformation angle (65). Based on the established adjusting forces, the bending deformation of the press bars (5, 8) that corresponds to the adjusting forces is determined according to machine data in the computer (35) or from data stored in the data memory (36), and the adjusting force of the drive means (9, 10) is reduced and, afterwards, by adjusting a compensating device (54), a counter bulging (65) of supporting surfaces (18, 19) for the bending tools (21, 22) or tool holding figures is set, and the sheet bar (25) is formed into its final shape by displacing the press bar (8) into the bending action (72) corresponding to the preset deformation angle (65).

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