

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

Publication
EP 1793946 B1 20080326 (DE)

Application
EP 05773976 A 20050830

Priority
• AT 2005000346 W 20050830
• AT 15122004 A 20040910

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).

IPC 8 full level
B21D 5/02 (2006.01)

CPC (source: EP US)
B21D 5/0272 (2013.01 - EP US); **B30B 15/044** (2013.01 - EP US)

Cited by
CN108637051A

Designated contracting state (EPC)
AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HU IE IS IT LI LT LU LV MC NL PL PT RO SE SI SK TR

DOCDB simple family (publication)
WO 2006026797 A1 20060316; AT 501264 A4 20060815; AT 501264 B1 20060815; AT 501264 B8 20070215; AT E390220 T1 20080415; DE 502005003499 D1 20080508; EP 1793946 A1 20070613; EP 1793946 B1 20080326; US 2008066520 A1 20080320

DOCDB simple family (application)
AT 2005000346 W 20050830; AT 05773976 T 20050830; AT 15122004 A 20040910; DE 502005003499 T 20050830; EP 05773976 A 20050830; US 66242005 A 20050830