

Title (en)  
PRODUCTION SYSTEM FOR PRODUCING WORKPIECES FROM SHEET METAL AND METHOD THEREFOR

Title (de)  
FERTIGUNGSANLAGE ZUR FERTIGUNG VON WERKSTÜCKEN AUS BLECH SOWIE VERFAHREN DAZU

Title (fr)  
INSTALLATION DE FABRICATION POUR LA FABRICATION DE PIÈCES EN TÔLE ET PROCÉDÉ À CET EFFET

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Application  
**EP 16735977 A 20160602**

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Abstract (en)  
[origin: WO2016191786A1] The invention relates to a production system (1) for producing workpieces (2) from sheet metal, comprising a bending machine (3) having clamping jaws (5, 6) held on clamping bars (13, 16), a support table (32), and a manipulation device (42) having a first and a second manipulator (43, 45). The second manipulator (45) is flat, wherein a supporting surface (47) having a retaining element (48) is arranged on the side of the second manipulator that can be turned toward the sheet metal. In one of the clamping jaws (5, 6), a cut-out (39) is arranged in the clamping surface (30, 31) of the clamping jaw, which cut-out extends from the clamping surface (30, 31) into the clamping jaw (5, 6), in such a way that the cut-out is recessed over a height (46), and extends in the direction of a bending region (34). The second manipulator (45) has a thickness (49) that is at most equal to the height (46) of the cut-out (39). The second manipulator (45) is at least partially accommodated in the cut-out (39) in order to manipulate the sheet metal. The invention further relates to a method for producing workpieces (2) from sheet metal by shaping the sheet metal.

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Opponent : Ulrich Neymeyr  
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