

Title (en)
METHODS FOR OPERATING A STAMPING PRESS AND STAMPING PRESSES FOR BEING OPERATED ACCORDING TO THE METHODS

Title (de)
VERFAHREN ZUM BETRIEB EINER STANZPRESSE UND STANZPRESSEN ZUM BETRIEB GEMÄSS DEN VERFAHREN

Title (fr)
PROCÉDÉ DE FONCTIONNEMENT D'UNE POINÇONNEUSE ET POINÇONNEUSE POUR LE FONCTIONNEMENT SELON CE PROCÉDÉ

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Abstract (en)
[origin: WO2020015815A1] The invention relates to methods for operating a stamping press (1), comprising a ram (2), which operates against a (in particular fixed) bolster plate (3) and the position of which can be set with respect to the bolster plate (3) during operation as intended, wherein the ram (2) bears a first die part (4) and the bolster plate (3) bears a second die part (5), wherein the two die parts (4, 5) provide stop faces (6a, 7a), which are assigned to one another and, when the die is completely closed, form one or more fixed stops for delimiting the closing clearance of the die (4, 5) internally within the die. According to a first method according to the invention, during operation of the stamping press (1) as intended, the distance (a, a1, a2, a3) of the two die parts (4, 5) from one another or a parameter (b1, b2, b3, c) representing this distance at a specific point (P1, P2, P3) of the ram movement at which the die (4, 5) is not completely closed is monitored and the position of the ram is changed in dependence on the result of the monitoring. According to a second method according to the invention, during operation of the stamping press as intended, at least one of the fixed stops is monitored for contact between the stops and the position of the ram is changed in dependence on the result of the monitoring. With the methods according to the invention, it is possible even in the case of dies (4, 5) with fixed stops and irrespective of the skill and experience of the operator for the process to be conducted energy-efficiently and with little wear.

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