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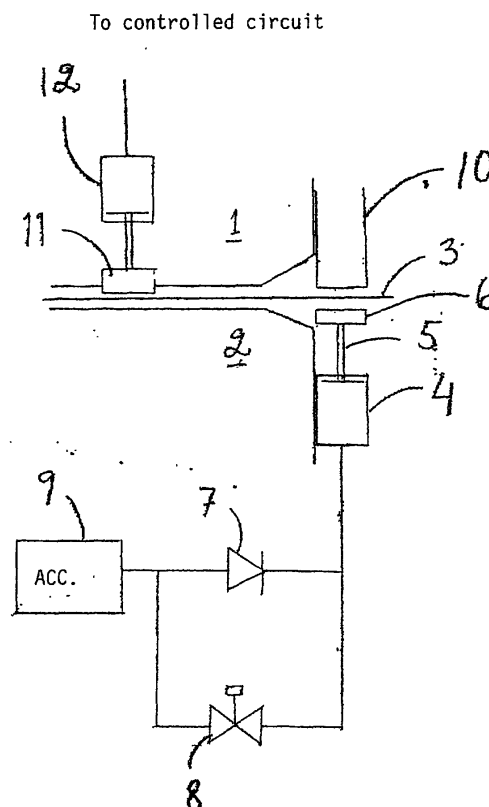
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(54) **Machine with hydraulically controlled counterpressure holding element**

(57) The invention relates to a machine with a hydraulically controlled counterpressure element. The machine comprises a frame and top and lower machine parts (1, 2) in a conventional way for performing the embossing. According to the invention the counterpressure element (6, 11) is connected to a hydraulic cylinder (4, 12), said counterpressure element engaging the plate (3). The hydraulic cylinder (4, 12) is connected to a hydraulic circuit having a controllable hydraulic pressure, so that the counterpressure element is pressed back at the controlled pressure during an embossing operation. The counterpressure element may be included in a holding means to hold the plate securely during the embossing. According to the invention a machine part (1) is then connected to a positive counterpressure element (10) and another machine part (2) is connected to a hydraulic cylinder (4), said hydraulic cylinder (4) having a plunger and a stem (5) connected to a gripping means (6) holding the plate (3) together with the positive counterpressure element (10), such that the plunger during an embossing operation is pressed back at a controlled pressure. The holding means provides a secure holding through the whole press operation. The counterpressure element may also be included in an embossing counterpressure element, in which the counterpressure may be set in order to achieve a pre-embossing or a pressure controlled embossing. The invention may be applied to all types of machines in which counterpressure elements are required.



FIG

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EUROPEAN SEARCH REPORT

Application Number
EP 99 85 0120

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The present search report has been drawn up for all claims			TECHNICAL FIELDS SEARCHED (Int.Cl.7)
			B21D
Place of search MUNICH		Date of completion of the search 26 February 2003	Examiner Vinci, V
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**ANNEX TO THE EUROPEAN SEARCH REPORT
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