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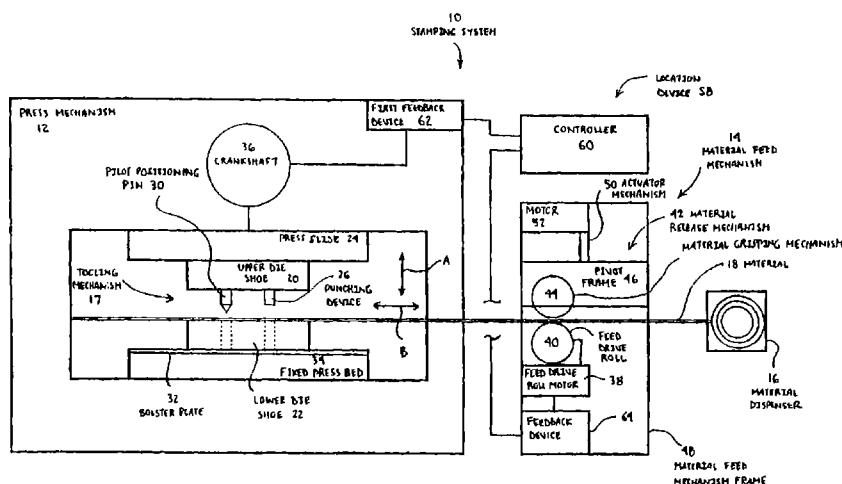
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(57) Abstract: This invention includes a method of determining the correct timing of a material release mechanism (42) of a material feed mechanism (14) and includes the steps of: cycling a press mechanism (12) through a working portion of a tooling mechanism (17); monitoring the press mechanism (12) position; determining, by a location device (58), the desired timing for the material release mechanism (42) to release contact with material (18); and correlating the desired material release mechanism (42) timing to the press mechanism (12) position. The present invention also is a stamping system (10) for working the material (18). This stamping system (10) includes a press mechanism (12) having a tooling mechanism (17) configured to punch holes (66) in the material (18). The stamping system (10) also includes a material feed mechanism (14) to feed material (18) to the press mechanism (12), and this material feed mechanism (14) includes a material release mechanism (42). Finally, the stamping system (10) includes a location device (58) to monitor the press mechanism (12) position and determine desired material release mechanism (42) timing.

WO 02/045943 A3

WO 02/045943 A3

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