

Abstract

The invention relates to a method for operating a stamping press (1) with a ram (2) which acts
5 against a bolster plate (3), in particular a fixed bolster plate (3), and whose ram position relative to the bolster plate (3) can be adjusted in the intended use, wherein the ram (2) carries a first die part (4) and the bolster plate (3) carries a second die part (5), wherein
10 the two die parts (4, 5) provide associated stop faces (6a, 7a) which, when the die is completely closed, form one or more fixed stops within the die for limiting the closing dimension of the die (4, 5).

In accordance with a first method according
15 to the invention, the distance (a, a1, a2, a3) between the two die parts (4, 5) or a parameter (b1, b2, b3, c) representing said distance is monitored at a certain point (P1, P2, P3) of the ram movement in which the die (4, 5) is not fully closed, and the ram movement is
20 changed as a function of the monitoring result.

In accordance with a second method according to the invention, at least one of the fixed stops is monitored for stop contact in the intended use of the stamping press, and the ram position is changed as a
25 function of the monitoring result.

With the methods according to the invention, energy-efficient and low-wear process control is possible also for dies (4, 5) with fixed stops, regardless of the skill and experience of the operator.

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Fig. 1