

ABSTRACT

When starting up, the eccentric shaft (5) must accelerate through a start-up angle (α_s) due to the forces of inertia. When stopping the punch press the eccentric shaft (5) is rotated in the direction (13) of normal operation into a position between the upper dead center (OT) and the lower dead center (UT) position, in which position no contacting between the upper tool (8) and the metal strip (12) to be worked upon takes place. From this position the eccentric shaft (5) is rotated backwards by the start-up angle (α_s) into a start-up angle position (D). In the start-up angle position (D) again no contact between the upper tool (8) and the strip (12) takes place. Accordingly, an enlarged start-up angle (α_s) which has been increased backwards over the upper dead center position (OT) is available for the start-up of the punch press, such that the first punching is executed at the same dynamic conditions of the punch press as the next subsequent punching operations, such that when starting the punch press up precise products are produced already by the first stroke.

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(Figure 4)

