

Method and arrangement for changing the shape of a sheet-like workpiece

Abstract

5 The present invention relates to a method for changing the shape of a sheet-like workpiece (10), which has a mould recess formed by reducing the thickness of the material, comprising arranging the workpiece (10) on at least two spaced-apart supporting elements (12) of a machine bed (13), forming the workpiece (10) into a final shape by step-by-step free bending, in that the steps of bending a part of the workpiece (10) by lowering an upper die 10 (14) between the supporting elements from a waiting position into a forming position (15), raising the upper die (14) into the waiting position and moving the position of the workpiece (10) relative to the machine bed (13) in at least one infeed direction are performed repetitively, and is characterised in that, before the workpiece (10) is formed into the final shape, a filling element (18), which is adapted to the mould recess and designed to make up 15 the material thickness, is produced and is arranged in the region of the mould recess. The invention also relates to such an arrangement.

Figure 1