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(54) Title: METHOD OF MONITORING A CRIMPING PROCESS, CRIMPING PRESS AND COMPUTER PROGRAM
PRODUCT

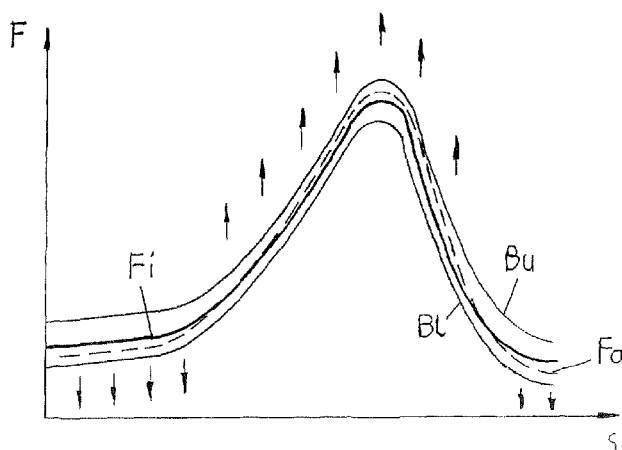


Fig. 1

(57) Abstract: A method of monitoring a crimping process is disclosed, which determines whether an actual force stroke progres-
sion (Fa) / force time progression is, a) above, or, b) below an ideal force stroke progression (Fi) / force time progression in at
least one point. The method shifts an upper border (Bu) and/or the lower border (Bl) of a tolerance band upwards in case a) and
downwards in case b). Additionally, there is an absolute upper limit (Lu), at which an upward shifting of the upper border (Bu) is
inhibited, and an absolute lower limit (Ll), at which a downward shifting of the lower border (Bl) is inhibited. Moreover, a
crimping press and a computer program product for employing the inventive method are disclosed.