

Description

Field of the Invention

The present invention relates generally to punch and die processes, and particularly to such a process that provides the combined advantages of high precision and low tool wear.

Description of the Prior Art

The prior art is replete with disclosures of various apparatus and methods intended to achieve precisely controlled positioning of a moving member. For example, U.S. Patent No. 3,903,993 to Vorrhees et al. discloses a press slide which is reciprocable in a press frame. Hydrostatic bearings guide the slide as it reciprocates, and they resist any lateral deflection thereof due to an unbalanced load. For another example, U.S. Patent No. 4,448,460 to Yamamoto discloses a hydrostatic bearing arrangement intended to achieve greater load bearing capacity and rigidity for a sliding member. Also, U.S. Patent No. 4,606,587 to Thompson discloses a precision air slide that includes a slide ram which is movable, with the aid of air bearings, inside a relatively stationary segmented housing. Published U.K. Patent Application 2 141 063A discloses a punch and die method comprising the steps of:

- a) providing a rigid mounting frame structure (61);
- b) mounting on said frame structure (61) a pair of pneumostatic bearings (3,66,67) in registered spaced-apart relation to each other;
- c) mounting on said frame structure (61) a die (5);
- e) positioning in said bearings (3,66) a punch (4) adapted for guided movement through said bearings (3,66) and said die (5);
- f) controllably supplying a pressurized gas (G) to said bearing surface (66); and
- g) effecting movement of said punch (4) through said bearings (3,66) and said die (5).

While such known apparatus and methods may have sufficed for their respective purposes, there has remained a persistent need for an effective and practical way to achieve both high precision and negligible tool wear in a punch and die process.

SUMMARY OF THE INVENTION

Accordingly, a primary object of this invention has been to meet the foregoing need, and to do so in a totally reliable, yet practical and economical, manner. That and other objects have been achieved by the invention herein disclosed and claimed.

This invention finds utility in a high-precision punch and die method comprising the steps of (a) providing a rigid mounting frame structure; (b) mounting on the frame structure a pair of pneumostatic bearings in registered spaced-apart relation to each other, the bearings each having a plurality of bearing journal segments provided with a pneumostatic bearing surface and adjustably mountable on said structure, the bearing mounting step including adjustably mounting the journal segments of both bearings on said structure; (c) mounting on the frame structure a segmented die in registered spaced-apart relation to the bearings, the die having a plurality of die segments provided with a cutting edge and adjustably mountable on said structure, the die mounting step including adjustably mounting the die segments on said structure; (d) adjusting the journal segments and the die segments so as to achieve required sizing and alignment of the bearings and the die; (e) positioning in the bearings a punch adapted for guided movement through the bearings and the die, the punch having integral pneumostatic bearing surfaces and at least one cutting edge, the punch positioning step including positioning the punch between the journal segments of each bearing so that the bearing surface on each journal segment is in close face-to-face relation to an opposing one of the bearing surfaces on the punch, and so that the cutting edge(s) on the punch is (are) disposed in coactable relation to the cutting edge on each of the die segments; (f) controllably supplying a pressurized gas to the bearing surface on each of the journal segments to provide required constraint and guidance to the punch; and (g) effecting movement of the punch through the bearings and the die so as to move the cutting edge(s) on the punch into coacting relation with the cutting edge on each of the die segments.

This invention, and its objects and advantages, will become more apparent in the detailed description of the illustrated embodiments thereof presented hereinbelow.

BRIEF DESCRIPTION OF THE DRAWINGS

In the detailed description of the embodiments of this invention presented below, reference is made to the accompanying drawings, wherein like reference characters denote like elements, and wherein:

Fig. 1 is a perspective view of a punch as configured in accordance with an embodiment of this invention;

Fig. 2 is a perspective view of the punch shown in Fig. 1 together with a segmented die configured in accordance with an embodiment of this invention;

Fig. 3 is a perspective view of the punch and die shown in Fig. 2 together with a pair of pneumostatic bearings configured in accordance with an embodiment of this invention;

Fig. 4 is a perspective view similar to Fig. 3 but with additional structure for mounting the die and pneumostatic bearings, and with schematic depiction of respective means for pressurizing the bearings and moving the punch therethrough;

Fig. 5 is a perspective view similar to Fig. 4 but showing an exemplary work piece still in place after being notched by the punch and die;

Fig. 6 is a perspective view of a set-up bar useful in correctly sizing and aligning the bearings and die shown in Figs. 3-5; and

Figs. 7-10 are perspective views illustrating alternative embodiments of the present invention.

DESCRIPTION OF THE ILLUSTRATED EMBODIMENTS

Because certain parts of, and practices relating to, punch and die apparatus and methods are well known, the following description is directed in particular to those elements and steps forming or cooperating directly with this invention. Elements and steps not specifically shown or described herein are selectable from those known in the relevant art.

Fig. 1 illustrates a punch 10 configured in accordance with one embodiment of this invention. Punch 10 is an elongate one-piece member made of air-hardened tool steel and having a generally rectangular cross section. Punch 10 has a cut-out section 12 with a cutting edge 14 formed at the upper end thereof. Above and below cut-out section 12, on all four sides of the punch, are integral pneumostatic bearing surfaces, only four of which, 16, 18, 20, and 22, are shown. At the top end of punch 10 are a pair of lugs 24 adapted to be operatively coupled to a suitable motion-imparting means such as a pneumatic cylinder.

Turning now to Fig. 2, punch 10 is shown together with a segmented die 26, which comprises three die segments 26a, 26b, and 26c having cutting edges 28a, 28b, and 28c, respectively. The die segments are clustered about a central portion of cut-out section 12 so as to position their cutting edges for proper coaction with cutting edge 14, to effect thereby a desired cutting action upon downward movement of the punch through the die. The generally U-shaped die 26 is segmented as shown so that each leg of the U individually may be machined to the precision required, sharpened, and adjustably set to achieve a "near zero" clearance with the opposing surface of punch 10. The die segments also are made from air-hardened tool

steel.

Fig. 3 shows the punch and die combination of Fig. 2 together with segmented upper and lower pneumostatic bearings 30 and 34. Upper bearing 30 comprises bearing segments 30a, 30b, 30c, and 30d provided with pneumostatic bearing surfaces 32a, 32b, 32c, and 32d respectively. Similarly, lower bearing 34 comprises bearing segments 34a, 34b, 34c, and 34d provided with pneumostatic bearing surfaces 36a, 36b, 36c, and 36d respectively. Both bearings 30 and 34 are positioned so that their bearing surfaces lie in close face-to-face relation to respective ones of the bearing surfaces on punch 10. For example, upper bearing surface 32b lies in close facing relation to punch bearing surface 16, while upper bearing surface 32c lies in such relation to punch surface 18. Similarly, lower bearing surfaces 36b and 36c lie in such relation to punch bearing surfaces 20 and 22 respectively.

Fig. 4 illustrates the combination just described mounted to a stationary, rigid, mounting frame structure 40. In this figure, three of the lower bearing segments are shown extended in a U-shaped manner to provide corresponding integral supports for the die segments. Thus, bearing segment 34a as so extended includes a horizontal leg 38a for supporting die segment 26a. Similarly, bearing segment 34b as extended includes a horizontal leg 38b for supporting die segment 26b, and bearing segment 34c as extended includes a horizontal leg 38c for supporting die segment 26c. Each of the die segments 26a, 26b, and 26c is adjustably mounted on its respective supporting leg by mounting screws 26s in oversized mounting screw holes. The mounting frame structure 40 comprises a tubular steel structure of rectangular cross section including four mutually perpendicular walls 40a, 40b, 40c, and 40d. Upper bearing segment 30d and lower bearing segment 34d are rigidly secured to wall 40d. Similarly, upper bearing segment 30c and extended lower bearing segment 34c are rigidly secured to wall 40c. Upper bearing segment 30c also is secured to the adjacent end of upper bearing segment 30d, and lower bearing segment 34c is secured to the adjacent end of lower bearing segment 34d. Upper bearing segment 30a then is adjustably mounted to the adjacent end of upper bearing segment 30b, which is adjustably mounted to the adjacent end of upper bearing segment 30c. Similarly, lower bearing segment 34a and supporting leg 38a are adjustably mounted to the adjacent ends of lower bearing segment 34b and supporting leg 38b respectively. Fig. 4 shows the foregoing members so mounted upon structure 40 with punch 10 inserted through the openings thus provided by the air bearings and die.

Also depicted in Fig. 4 are upper bearing gas supply ports 30g and lower bearing gas supply ports 34g. Preferably, for convenience, the gas supplied through those ports to their respective bearing surfaces is air. Ports 30g and 34g are schematically shown connected through suitable control means C30 and C34 to a source G of pressurized air. Also schematically shown in this figure is a pneumatic cylinder P, operatively coupled to lugs 24 at the top end of punch 10, for effecting movement of the punch through the die as required for a desired cutting operation.

Fig. 5 is similar to Fig. 4 in that it shows the principal components of the punch and die apparatus just described, but also shows a rectangular work piece K still in its work position after a notch N has been cut in one edge thereof.

Fig. 6 illustrates a set-up bar B that is used in setting up the described apparatus to achieve the required sizing and alignment of its pneumostatic bearings and die. As may be seen from a comparison of Figs. 1 and 6, bar B is similar to punch 10 without cut-out section 12 and lugs 24. Bar B is made slightly wider and thicker than punch 10 in order to achieve the clearances needed between the punch and the bearings and die. In setting up the apparatus, bar B is positioned in the bearing and die openings, and the adjustably mounted bearing and die segments are then set in contact with the opposing surfaces on the bar. The mounting screws for those segments are then tightened, and the bar is removed. In this manner, the bearings and die are precisely aligned with one another, and they are sized to provide the working clearances needed between them and the punch. The punch is then inserted through the bearing and die openings and operatively coupled to the aforementioned pneumatic cylinder P.

Fig. 7 illustrates an alternative embodiment of the present invention. Shown in this figure is a punch 50 which is similar to punch 10 but differs therefrom in that cut-out section 52 of punch 50 is configured to provide a rectangular punch finger 54 having four orthogonal cutting edges 56. Adjustably mounted for alignment with punch finger 54 is a segmented die 58 comprising four die segments 58a, 58b, 58c, and 58d. Those segments have cutting edges 60a, 60b, 60c, and 60d which coast with punch finger cutting edges 56 to cut a rectangular aperture. Punch 50 is provided with pneumostatic bearing surfaces above and below die 58 for cooperation with pneumostatic bearings similar to those described above.

Fig. 8 depicts another embodiment of this invention wherein punch 70 has, within its cut-out section 72, a depending cylindrical punch finger 74 with a circular cutting edge 74e. For convenience, finger 74 may be made removable from the punch.

In this embodiment, the cooperating die 76 is a non-segmented, one-piece die provided with a cylindrical die opening 76o having a circular cutting edge 76e that coacts with punch finger cutting edge 74e to cut a circular aperture. Here too, the punch is constrained and guided by pneumostatic bearings disposed above and below the die.

Fig. 9 illustrates still another embodiment, which is similar to that shown in Fig. 3 but differs therefrom in that die 26' in Fig. 9 is disposed below both pneumostatic bearings 30' and 34'. In this embodiment, punch 80 has its cut-out section 82 and cutting edge 84 located at the bottom end of the punch to cooperate with the die 26' below lower bearing 34'.

Fig. 10 depicts yet another embodiment, which is similar to that shown in Fig. 9 but differs therefrom in that punch 90 in Fig. 10 has, depending from its bottom end, a cylindrical punch finger 92 with a circular cutting edge 92e disposed above a cooperating one-piece die 76' having a cylindrical die opening 76o' and circular cutting edge 76e'. As in the Fig. 8 embodiment, finger 92 may be removable from punch 90 for convenience in sharpening and replacement.

From all of the foregoing, it will be seen that this invention is adaptable for use in various ways to meet a variety of needs in punch and die processes. Such a process as improved by this invention has proven successful in high-volume production applications requiring extremely precise punch constraint and guidance, very little tool wear, and facile set-up and change-over capability.

Claims

1. A high-precision punch and die method comprising the steps of:

(a) providing a rigid mounting frame structure (40);

(b) mounting on said frame structure (40) a pair of pneumostatic bearings (30 and 34) in registered spaced-apart relation to each other, said bearings (30 and 34) each having a plurality of bearing journal segments (30a, b, c, d and 34a, b, c, d) provided with a pneumostatic bearing surface (32a, b, c, d and 36a, b, c, d) and adjustably mountable on said structure (40), said bearing mounting step including adjustably mounting said journal segments (30a, b, c, d and 34a, b, c, d) of both bearings (30 and 34) on said structure (40);

(c) mounting on said frame structure (40) a segmented die (26) in registered spaced-apart relation to said bearings (30 and 34), said die (26) having a plurality of die segments (26a, b, c) provided with a cutting

Also depicted in Fig. 4 are upper bearing gas supply ports 30g and lower bearing gas supply ports 34g. Preferably, for convenience, the gas supplied through those ports to their respective bearing surfaces is air. Ports 30g and 34g are schematically shown connected through suitable control means C30 and C34 to a source G of pressurized air. Also schematically shown in this figure is a pneumatic cylinder P, operatively coupled to lugs 24 at the top end of punch 10, for effecting movement of the punch through the die as required for a desired cutting operation.

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Claims

1. A high-precision punch and die method comprising the steps of:

(a) providing a rigid mounting frame structure (40);

(b) mounting on said frame structure (40) a pair of pneumostatic bearings (30 and 34) in registered spaced-apart relation to each other, said bearings (30 and 34) each having a plurality of bearing journal segments (30a, b, c, d and 34a, b, c, d) provided with a pneumostatic bearing surface (32a, b, c, d and 36a, b, c, d) and adjustably mountable on said structure (40), said bearing mounting step including adjustably mounting said journal segments (30a, b, c, d and 34a, b, c, d) of both bearings (30 and 34) on said structure (40);

(c) mounting on said frame structure (40) a segmented die (26) in registered spaced-apart relation to said bearings (30 and 34), said die (26) having a plurality of die segments (26a, b, c) provided with a cutting



edge (28a, b, c) and adjustably mountable on said structure (40), said die mounting step including adjustably mounting said die segments (26a, b, c) on said structure (40); (d) adjusting said journal segments (30a, b, c, d and 34a, b, c, d) and said die segments (26a, b, c) so as to achieve required sizing and alignment of said bearings (30 and 34) and said die (26);

(e) positioning in said bearings (30 and 34) a punch (10) adapted for guided movement through said bearings (30 and 34) and said die, said punch (10) having integral pneumostatic bearing surfaces (16, 18, 20, 22 et al.) and at least one cutting edge (14), said punch positioning step including positioning said punch (10) between said journal segments (30a, b, c, d and 34a, b, c, d) of each bearing so that said bearing surface (32a, b, c, d and 36a, b, c, d) on each journal segment (30a, b, c, d and 34a, b, c, d) is in close face-to-face relation to an opposing one of said bearing surfaces (16, 18, 20, 22 et al.) on said punch (10), and so that said at least one cutting edge (14) on said punch (10) is disposed in coactable relation to said cutting edge (28a, b, c) on each of said die segments (26a, b, c);

(f) controllably supplying a pressurized gas (G) to said bearing surface (32a, b, c, d and 36a, b, c, d) on each of said journal segments (30a, b, c, d and 34a, b, c, d) to provide required constraint and guidance to said punch (10); and

(g) effecting movement of said punch (10) through said bearings (30 and 34) and said die (26) so as to move said at least one cutting edge (14) on said punch (10) into coacting relation with said cutting edge (28a, b, c) on each of said die segments (26a, b, c).

2. A punch and die method as claimed in Claim 1 wherein said bearing mounting step further includes mounting said bearings (30 and 34) on said structure (40) so that one (30) of said bearings (30 and 34) lies in superposed spaced-apart relation to the other (34) for vertical alignment with said die (26).

3. A punch and die method as claimed in Claim 2 wherein said die mounting step further includes mounting said die (26) on said structure (40) between said bearings (30 and 34), whereby said one bearing (30) lies above and said other (34) lies below said die (26).

4. A punch and die method as claimed in Claim 1 wherein said die mounting step further includes mounting said die (26) on said structure (40) between said bearings (30 and 34), whereby said bearings (30 and 34) are respectively disposed at opposite sides of said die (26).

5. A punch and die method as claimed in Claim 1 wherein said adjusting step includes positioning in said bearings (30 and 34) and said die (26) a mating set-up bar (B) configured and dimensioned to provide said required sizing and alignment when said journal segments (30a, b, c, d and 34a, b, c, d) and said die segments (26a, b, c) are set in contact with said bar (B), said adjusting step further including so setting said segments (30a, b, c, d and 34a, b, c, d and 26a, b, c) and then removing said bar (B).

6. A punch and die method as claimed in Claim 1 wherein said gas (G) is air, said pneumostatic bearings (30 and 34) are air bearings, and said pneumostatic bearing surfaces (32a, b, c, d and 36a, b, c, d) are air bearing surfaces; and wherein said gas supplying step includes controllably supplying pressurized air to said bearing surface (32a, b, c, d and 36a, b, c, d) on each of said journal segments (30a, b, c, d and 34a, b, c, d).

7. A punch and die method as claimed in Claim 1 wherein said movement effecting step includes actuating a pneumatic cylinder (P) operatively coupled to said punch (10).

Patentansprüche

1. Verfahren zum Hochpräzisionsschneiden mit Stempel und Gesenk, dadurch gekennzeichnet, daß

(a) ein starrer Halterungsrahmen (40) vorgesehen ist,

(b) auf dem Halterungsrahmen (40) zwei pneumostatische Lager (30 und 34) im Abstand zueinander ausgerichtet werden und jeweils eine Vielzahl von Lagersegmenten (30a, b, c, d und 34a, b, c, d) umfassen, welche jeweils mit einer pneumostatischen Lagerfläche (32a, b, c, d und 36a, b, c, d) versehen und auf dem Halterungsrahmen (40) verstellbar lagerbar sind, wobei beim Anbringen der Lager die Lagersegmente (30a, b, c, d und 34a, b, c, d) beider pneumostatischen Lager (30 und 34) auf dem Halterungsrahmen (40) verstellbar gelagert werden,



- (c) auf dem Halterungsrahmen (40) ein in Segmente eingeteiltes Gesenk (26) gelagert wird, das im Abstand von den Lagern (30 und 34) mit diesen ausgerichtet wird und eine Vielzahl von Gesenksegmenten (26a, b, c) umfaßt, welche mit einer Schneidekante (28a, b, c) versehen und auf dem Rahmen (40) verstellbar lagerbar sind, wobei beim Anbringen des Gesenks die Gesenksegmente (26a, b, c) auf dem Halterungsrahmen (40) verstellbar gelagert werden,
- (d) die Lagersegmente (30a, b, c, d und 34a, b, c, d) und die Gesenksegmente (26a, b, c) so justiert werden, daß die Lager (30 und 34) und das Gesenk (26) die erforderliche Größe und Ausrichtung haben,
- (e) in den Lagern (30 und 34) ein Stempel (10) positioniert wird, der durch die Lager (30 und 34) und das Gesenk (26) geführt bewegt wird und der einstückig ausgebildete pneumostatische Lagerflächen (16, 18, 20, 22, etc.) sowie mindestens eine Schneidekante (14) umfaßt, wobei beim Positionieren des Stempels (10) dieser zwischen den Lagersegmenten (30a, b, c, d und 34a, b, c, d) eines jeden Lagers so positioniert wird, daß die Lagerfläche (32a, b, c, d und 36a, b, c, d) eines jeden Lagersegments (30a, b, c, d und 34a, b, c, d) einer gegenüberliegenden Lagerfläche (16, 18, 20, 22 etc.) des Stempels (10) unmittelbar zugewandt ist, so daß die mindestens eine Schneidekante (14) des Stempels (10) mit der Schneidekante (28a, b, c) eines jeden Gesenksegments (26a, b, c) zusammenwirken kann,
- (f) der Lagerfläche (32a, b, c, d und 36a, b, c, d) eines jeden Lagersegments (30a, b, c, d und 34a, b, c, d) ein Druckgas (G) kontrolliert zugeführt wird, damit der Stempel (10) die erforderliche Zwangsführung erfährt, und
- (g) der Stempel (10) durch die Lager (30 und 34) und das Gesenk (26) so bewegt wird, daß die mindestens eine Schneidekante (14) des Stempels (10) in Wirkverbindung mit der Schneidekante (28a, b, c) eines jeden Gesenksegments (26a, b, c) gelangt.
2. Verfahren nach Anspruch 1, dadurch gekennzeichnet, daß beim Anbringen der Lager (30 und 34) diese auf dem Halterungsrahmen (40) so gelagert werden, daß eines der Lager (30) im Abstand über dem anderen Lager (34) liegt und so vertikal mit dem Gesenk (26) ausgerichtet wird.
3. Verfahren nach Anspruch 2, dadurch gekennzeichnet, daß beim Anbringen des Gesenks
- (26) dieses auf dem Halterungsrahmen (40) zwischen den Lagern (30 und 34) gelagert wird und das eine Lager (30) über dem Gesenk (26) und das andere Lager (34) unter dem Gesenk (26) liegt.
4. Verfahren nach Anspruch 1, dadurch gekennzeichnet, daß beim Anbringen des Gesenks (26) dieses auf dem Halterungsrahmen (40) zwischen den Lagern (30 und 34) gelagert wird und die Lager (30 und 34) auf jeweils gegenüberliegenden Seiten des Gesenks (26) angeordnet werden.
5. Verfahren nach Anspruch 1, dadurch gekennzeichnet, daß beim Justieren in die Lager (30 und 34) und in das Gesenk (26) eine Paßleiste (B) eingesetzt wird, die so ausgebildet und dimensioniert ist, daß die erforderliche Größe und Ausrichtung gewährleistet sind, wenn die Lagersegmente (30a, b, c, d und 34a, b, c, d) und die Gesenksegmente (26a, b, c) mit der Paßleiste (B) in Berührung gelangen, und daß die Segmente (30a, b, c, d und 34a, b, c, d und 26a, b, c) auf diese Weise eingestellt werden und die Paßleiste (B) dann entfernt wird.
6. Verfahren nach Anspruch 1, dadurch gekennzeichnet, daß es sich bei dem Gas (G) um Luft handelt, daß die pneumostatischen Lager (30 und 34) Luftlager und die pneumostatischen Lagerflächen (32a, b, c, d und 36a, b, c, d) Luftlagerflächen sind und daß bei der Gaszufuhr Druckluft den Lagerflächen (32a, b, c, d und 36a, b, c, d) auf jedem der Lagersegmente (30a, b, c, d und 34a, b, c, d) kontrolliert zugeführt wird.
7. Verfahren nach Anspruch 1, dadurch gekennzeichnet, daß beim Bewegen des Stempels (10) ein mit diesem zusammenwirkender pneumatischer Zylinder (P) betätigt wird.
- Revendications**
1. Procédé de découpage au poinçon et à la matrice de haute précision, comprenant les opérations consistant :
- (a) à prévoir une structure rigide de bâti de montage (40),
- (b) à monter, sur cette structure de bâti (40), deux paliers pneumostatiques (30 et 34) disposés à distance et dans l'alignement l'un de l'autre, ces paliers (30 et 34) comportant chacun plusieurs segments d'appui de palier (30a, b, c, d et 34a, b, c, d) qui présentent une surface de palier



pneumostatique (32a, b, c, d et 36a, b, c, d) et sont agencés de façon à pouvoir être montés d'une manière ajustable sur la structure (40), cette opération de montage de paliers comprenant un montage desdits segments d'appui (30a, b, c, d et 34a, b, c, d) des deux paliers (30 et 34) d'une manière ajustable sur la structure (40).

(c) à monter, sur la structure de bâti (40), une matrice en segments (26) espacée vis-à-vis des paliers (30 et 34) et dans l'alignement de ces derniers, cette matrice (26) comportant plusieurs segments de matrice (26a, b, c) qui présentent un bord de coupe (28a, b, c) et sont agencés de façon à pouvoir être montés d'une manière ajustable sur la structure (40), l'opération de montage de matrice comportant un montage des segments de matrice (26a, b, c) d'une manière ajustable sur la structure (40),

(d) à ajuster les segments d'appui (30a, b, c, d et 34a, b, c, d) et les segments de matrice (26a, b, c) de façon à obtenir le dimensionnement et l'alignement voulus des paliers (30 et 34) et de la matrice (26),

(e) à positionner, dans les paliers (30 et 34), un poinçon (10) agencé de façon à pouvoir être déplacé d'une manière guidée dans les paliers (30 et 34) et la matrice, ce poinçon (10) comportant des surfaces de palier pneumostatique (16, 18, 20, 22 et autres) réalisées d'une seule pièce et au moins un bord de coupe (14), l'opération de positionnement du poinçon comprenant un positionnement du poinçon (10) entre les segments d'appui (30a, b, c, d et 34a, b, c, d) de chaque palier, de façon telle que la surface de palier (32a, b, c, d et 36a, b, c, d) de chaque segment d'appui (30a, b, c, d et 34a, b, c, d) soit située suivant une disposition face à face rapprochée vis-à-vis de l'une, située en regard, des surfaces de palier (16, 18, 20, 22 et autres) du poinçon (10) et d'une façon telle qu'au moins un bord de coupe (14) du poinçon (10) soit situé suivant une disposition, permettant une coopération, vis-à-vis du bord de coupe (28a, b, c) de chacun des segments de matrice (26a, b, c),

(f) à envoyer, d'une manière réglable, un gaz comprimé (G) à la surface de palier (32a, b, c, d et 36a, b, c, d) de chacun des segments d'appui (30a, b, c, d et 34a, b, c, d) de façon à fournir au poinçon (10) une retenue et un guidage voulus et

(g) à exécuter un déplacement du poinçon (10) dans les paliers (30 et 34) et la matrice (26) de façon à déplacer le ou les bords de

coupe (14) du poinçon (10) suivant une disposition de coopération avec le bord de coupe (28a, b, c) de chacun des segments de matrice (26a, b, c).

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2. Procédé de découpage au poinçon et à la matrice suivant la revendication 1, selon lequel l'opération de montage de palier comprend en outre un montage des paliers (30 et 34) sur la structure (40) de façon telle qu'un premier (30) des paliers (30 et 34) soit situé suivant une disposition relative espacée et superposée vis-à-vis de l'autre palier (34) en vue d'un alignement vertical avec la matrice (26).

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3. Procédé de découpage au poinçon et à la matrice suivant la revendication 2, selon lequel l'opération de montage de matrice comprend en outre un montage de la matrice (26) sur la structure (40) entre les paliers (30 et 34), de sorte que le premier palier (30) est situé au-dessus de la matrice (26) et l'autre palier (34) au-dessous de cette dernière.

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4. Procédé de découpage au poinçon et à la matrice suivant la revendication 1, selon lequel l'opération de montage de matrice comprend en outre un montage de la matrice (26) sur la structure (40) entre les paliers (30 et 34), de sorte que les paliers (30 et 34) sont disposés respectivement de part et d'autre de la matrice (26).

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5. Procédé de découpage au poinçon et à la matrice suivant la revendication 1, selon lequel l'opération d'ajustement comprend un positionnement, dans les paliers (30 et 34) et la matrice (26), d'un barreau de mise au point d'adaptation (B) conformé et dimensionné de façon à fournir le dimensionnement et l'alignement voulus lorsque les segments d'appui (30a, b, c, d et 34a, b, c, d) et les segments de matrice (26a, b, c) sont placés au contact du barreau (B), l'opération d'ajustement comprenant en outre un tel placement des segments (30a, b, c, d et 34a, b, c, d et 26a, b, c), puis un retrait du barreau (B).

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6. Procédé de découpage au poinçon et à la matrice suivant la revendication 1, selon lequel le gaz (G) est de l'air, les paliers pneumostatiques (30 et 34) sont des paliers pneumatiques et les surfaces de palier pneumostatique (32a, b, c, d et 36a, b, c, d) sont des surfaces de palier pneumatique et selon lequel l'opération d'envoi de gaz comprend un envoi, d'une manière réglable, d'air comprimé à la surface de palier (32a, b, c, d et 36a, b, c, d) de chacun

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des segments d'appui (30a, b, c, d et 34a, b, c, d).

7. Procédé de découpage au poinçon et à la matrice suivant la revendication 1, selon lequel l'opération d'exécution de déplacement comprend un actionnement d'un vérin pneumatique (P) accouplé fonctionnellement au poinçon (10).

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