

Abstract

The invention relates to a method for warping
5 the machine bed (5) of a punching press, which machine
bed has an aperture (6b) for carrying away punching parts
and rubbish, to compensate at least partially a bending
of the machine bed (5) caused by the punching force dur-
ing the punching operation. Thereby, forces acting trans-
10 verse to the punching direction are introduced into the
machine bed (5) and/or forces acting transverse to the
punching force direction are produced inside the machine
bed (5), by means of which the machine bed (5) warps in
the direction towards the press ram (2) and indeed such
15 that it warps stronger in the area adjacent to the aper-
ture (6b) than in the areas adjacent to its longitudinal
sides.

By the method according to the invention ap-
ertured machine beds (5) of punching presses can, with
20 very little expenses on the equipment side, be spatially
pre-deformed in order to compensate at least partially
bendings caused by punching forces.