

Abstract

5 The invention relates a method for warping
the machine bed (5) and/or the press ram (2) of a punch-
ing press to compensate at least partially a bending
caused by the punching force of the machine bed (5) or
the press ram (2) during punching operation, respec-
tively. For this a temperature gradient is generated se-
10 lectively within the machine bed (5) and/or within the
press ram (2) according to the invention, with the effect
of making the machine bed (5) warping in the direction
towards the press ram (2) and/or the press ram (2) warp-
ing in the direction towards the press bed (5).

15 In this way, machine beds (5) and press rams
(2) of punching presses can be pre-deformed for the com-
pensation of bendings caused by the punching force with a
very small expenses on the equipment side, without having
to deviate from existing and proven structure concepts.
20 Additionally the method according to the invention can be
applied to existing presses.