Abstract

A method of gripping a substantially planar workpiece while providing compensation for variations in thickness is described. During the process, the workpiece is overdriven into a clamping member before clamping force is applied, and the positions of the clamping member before and after application of the clamping force are measured. These measurements are then used to control a compensating movement of the tooling table and optionally a final lift of the conveyance rails.

FIG. 5