

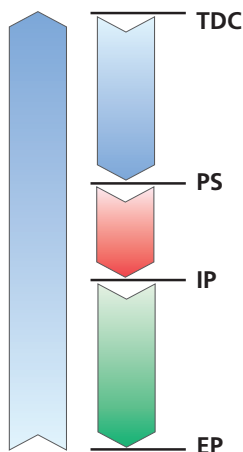
# SCHMIDT® ServoPress

## Operating profiles and applications

SCHMIDT® ServoPresses allow a simple setup of the operating profiles. Different standard operating profiles are provided for a quick set-up. According to experience, these standard operating profiles and the combinations of them cover most applications.

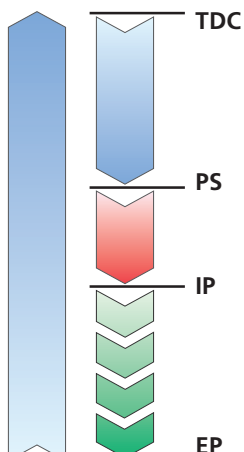
**TDC** = top dead center of the process<sup>1)</sup>  
**PS** = Pressing start, start of the process data recording<sup>1)</sup>  
**PP** = Probing position (depending on the component geometry)  
**IP** = Intermediate position<sup>1)</sup> (is required for monitoring purposes)  
**EP** = End position<sup>1)</sup>  
<sup>1)</sup>adjustable

### Target is "Stroke"



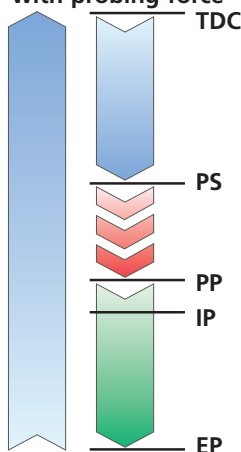
Normal operating profile, is typically combined with bending compensation.

### Target is "Force"



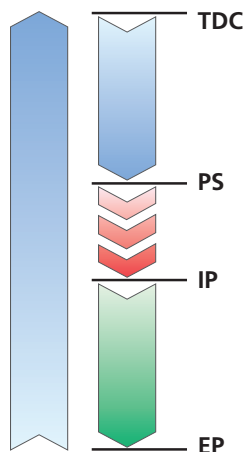
For processes in which the force reached is a measure for the process quality e. g. material compression.

### Target is "delta stroke" with probing force

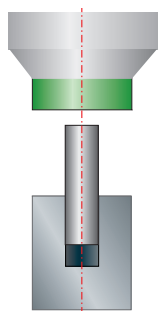


For processes in which component tolerances must be detected. The press detects the surface and presses to a programmed distance from.

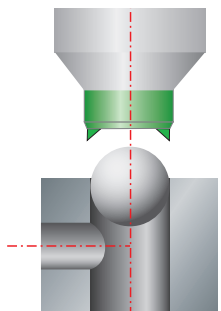
### Target is "Force increase"



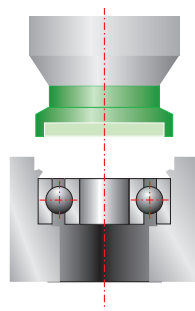
The return stroke is triggered by detecting a customer-defined force slope.



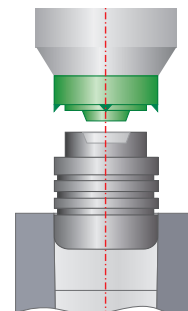
Pressing until reaching a specified position leads to precise results in connection with bending compensation.



Plugging blind bores – a sphere is pressed in and crimped. Force output correlates to material displacement to determine density and retain force independent of stroke.



Pressing to a predetermined force which identifies a target feature with which the final pressing distance is measured and pressed.



Pressing of "Beta" plugs or „König“ expanders. Sealing and retaining function depend on a force increase that is the return stroke criterion for the press.

