

Method for implementing a comprehensive cutting and sorting process to produce standard-sized blanks from grade-specified rolled steel consists of the following: in the first stage of the cutting operation, a “partially open” shear-off cutting scheme is employed, in which the rotation of the rolled stock in the stationary clamping blade is restricted, while the mobility of the section of the rolled stock being cut is unrestricted. The energy of elastic deformation of the press frame and drive, which is released at the moment of blank separation, is used to perform an additional second stage of the forming process—plastic deformation of the blank in a single press stroke.