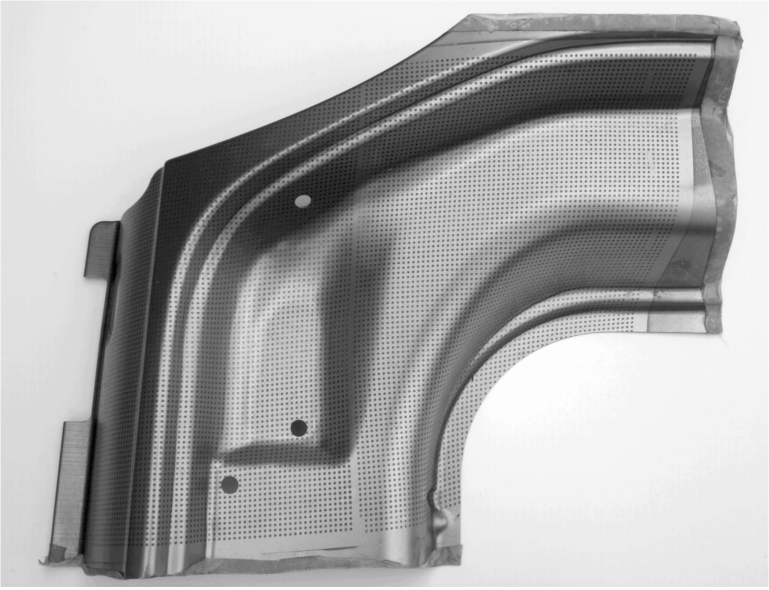
Sheet Metal Forming - 1

Outline

- Introduction
- Key Factors
- Sheet Bending

Introduction

- <u>Sheet metal</u>: metallic sheet typically < 6 mm thick
- Large surface area/volume ratio
- Applications: auto body parts, beverage cans, utensils

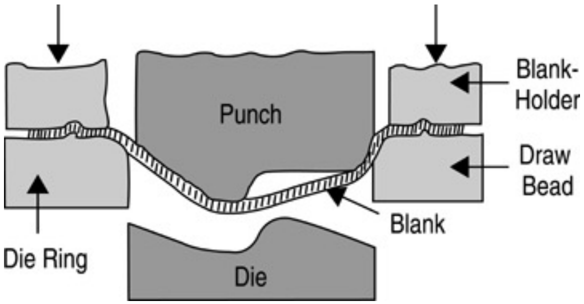


Stamped sheet metal part

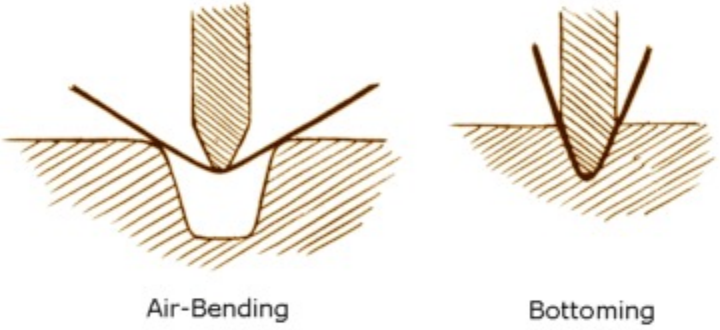
Aluminum can

Introduction

- Sheet forming processes: sheet bending, stamping, deep drawing, shearing, etc.
- Constant volume processes
- Basic deformation modes: bending and stretching



Deep drawing



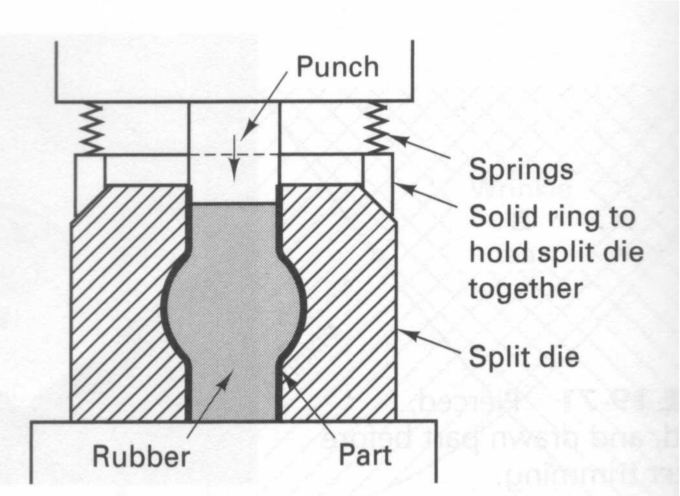
Metal bending machine

Stamping

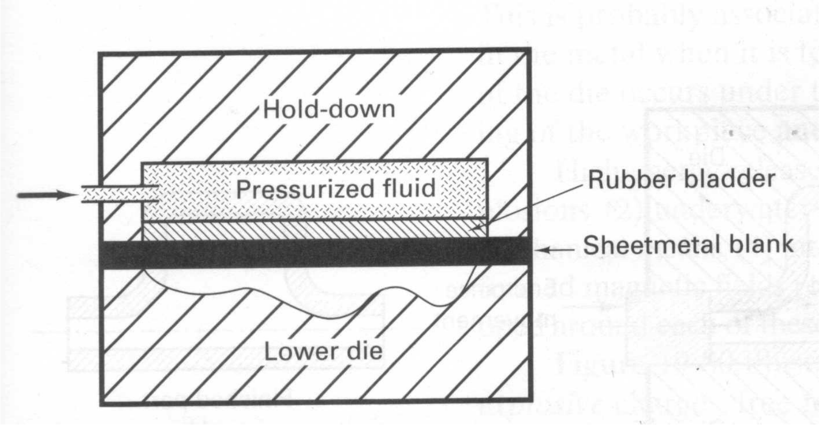
http://video.google.com/videoplay?docid=-6082773547960703710&q=metal+stamping&total=70&start=0&num=10&so=0&type=search&plindex=4

Process Variations

- Forming with flexible (rubber) tooling



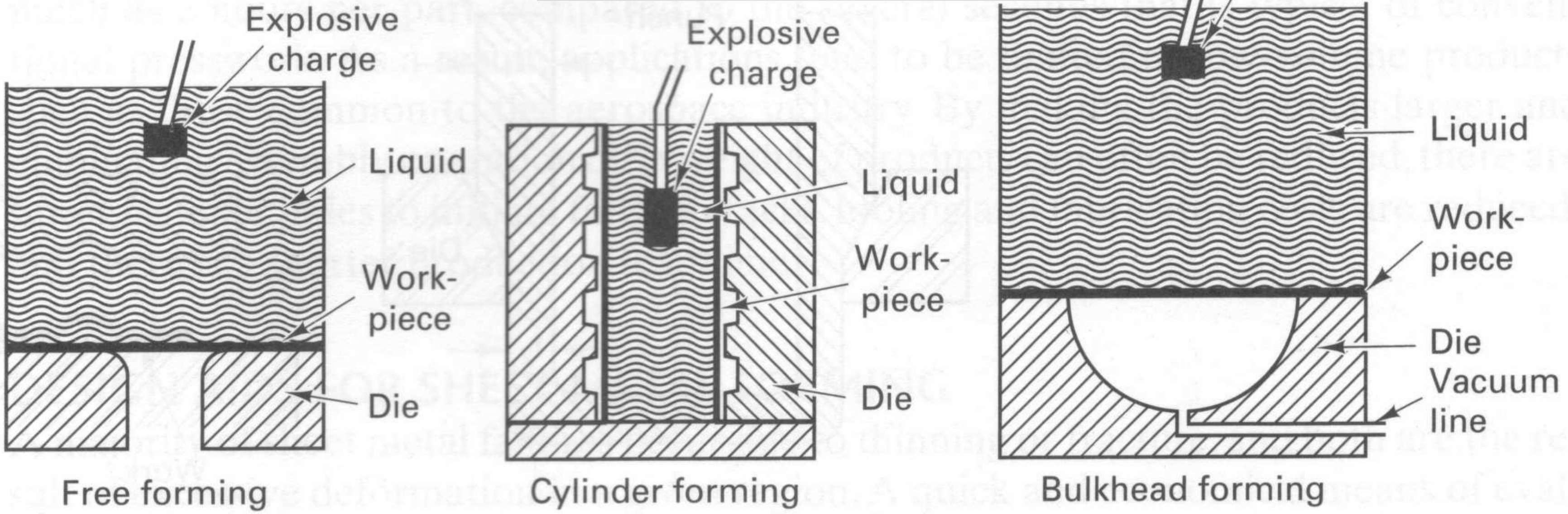
- Hydroforming



Source: DeGarmo, Black, Kohser, 9th Ed., 2003

Process Variations

- Explosive forming



Free forming

Cylinder forming

Bulkhead forming

Source: DeGarmo, Black, Kohser, 9th Ed., 2003

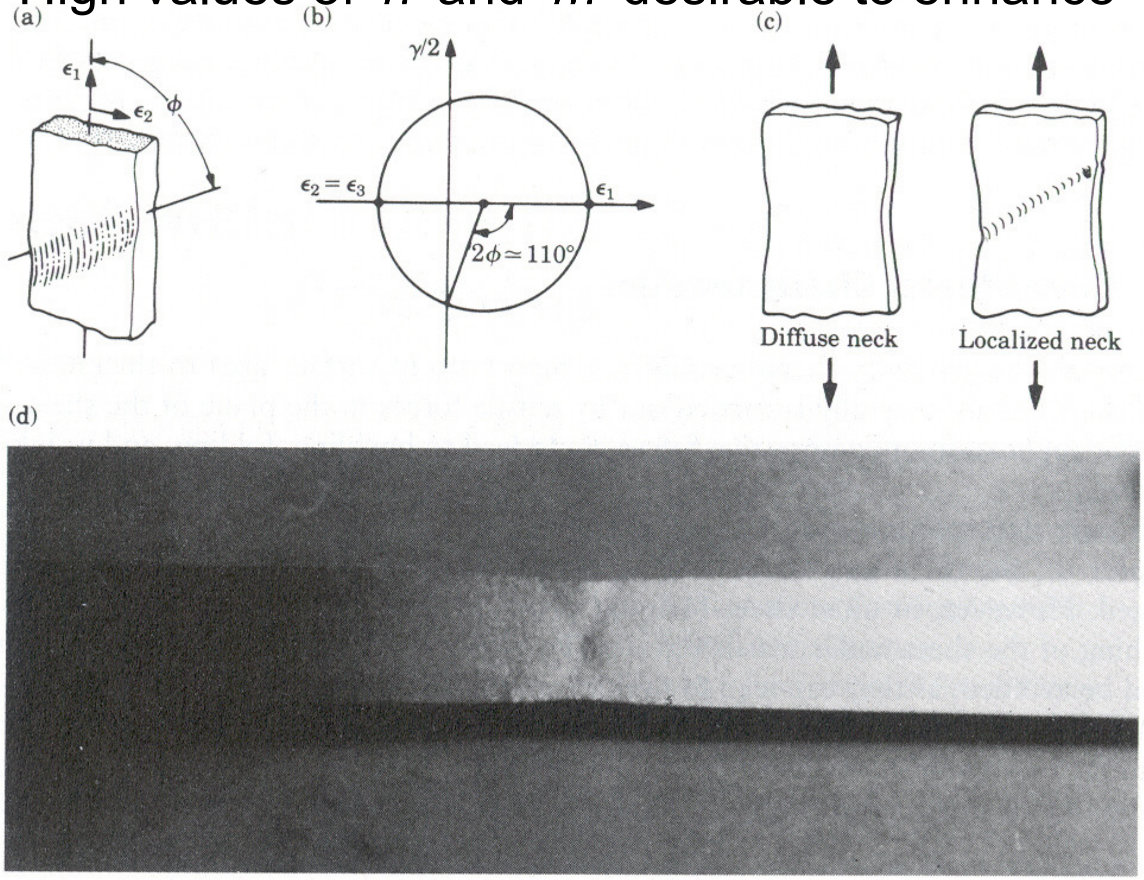
Key Factors

- Elongation: tensile loads in stretching can cause necking → limits uniform elongation. Sheet metal specimens tend to undergo “localized necking”. High values of ‘*n*’ and ‘*m*’ desirable to enhance total elongation.

$$\sigma = K\varepsilon^n$$

$$\sigma = C\dot{\varepsilon}^m$$

$n\uparrow \rightarrow$ uniform elongation$\uparrow$
$m\uparrow \rightarrow$ post-uniform elongation$\uparrow$

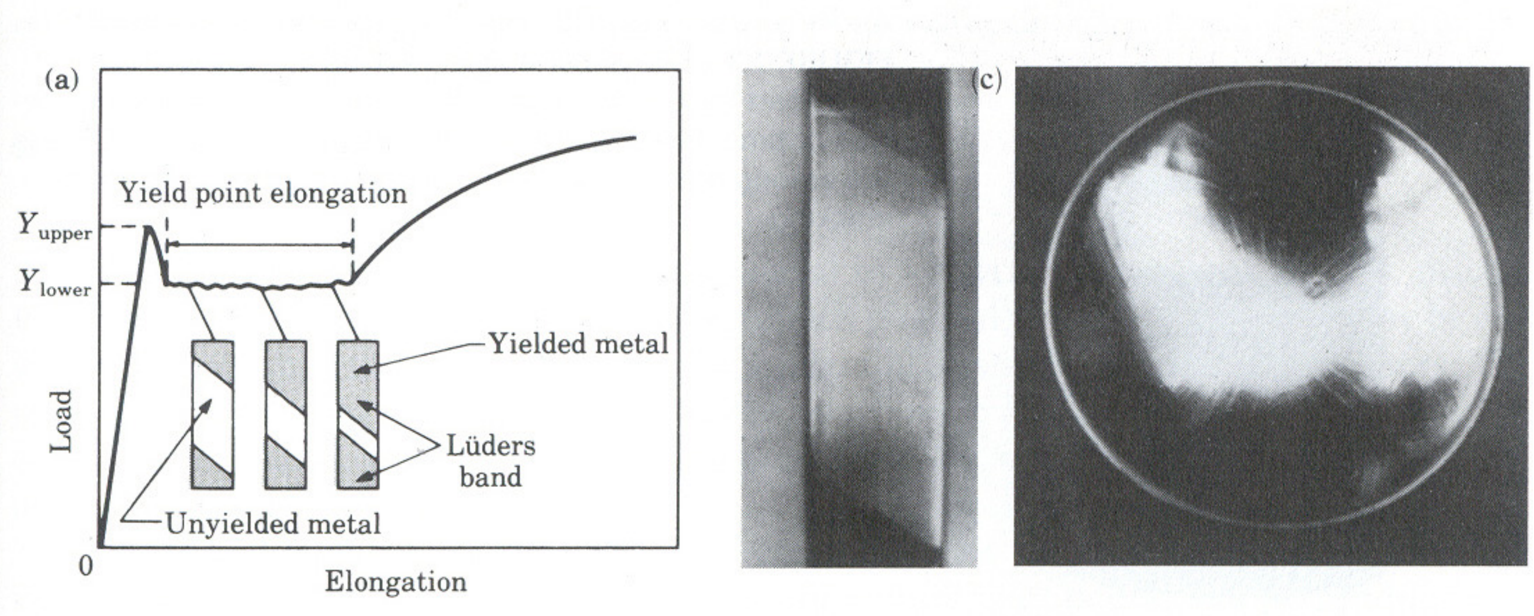


Source: Kalpakjian & Schmidt, 4th Ed., 2003

Key Factors

- Yield-Point Elongation: Yield point elongation is a function of the strain-rate and the grain size; increases as strain-rate↑ and grain size↓

- Characteristic of low carbon steels



Source: Kalpakjian & Schmidt, 4th Ed., 2003

Key Factors

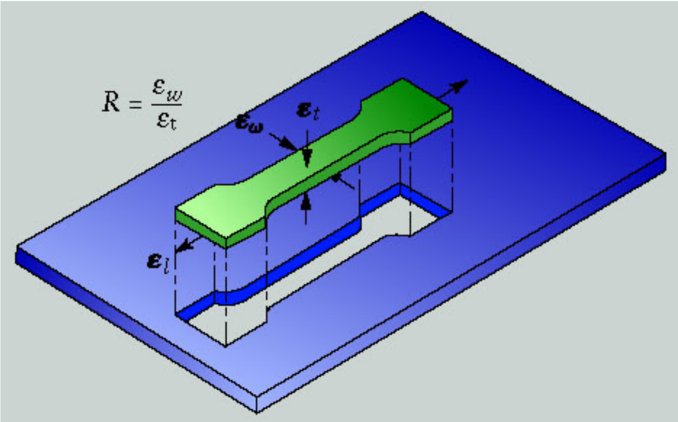
- Anisotropy: directional properties (of rolled sheet)

- Causes
  - crystallographic (from preferred grain orientation)
  - mechanical fibering (impurities, inclusions, etc. aligned in one direction)

- Significance: can lead to defects such as earing, wrinkling, or fracture

- Severity of directionality measured by plastic strain ratio, *R,* or normal anisotropy

$$R = \frac{\text{width strain}}{\text{thickness strain}} = \frac{\varepsilon_w}{\varepsilon_t} = \frac{\ln\left(\frac{w_0}{w_f}\right)}{\ln\left(\frac{t_0}{t_f}\right)} = \frac{\ln\left(\frac{w_0}{w_f}\right)}{\ln\left(\frac{w_f l_f}{w_0 l_0}\right)}$$

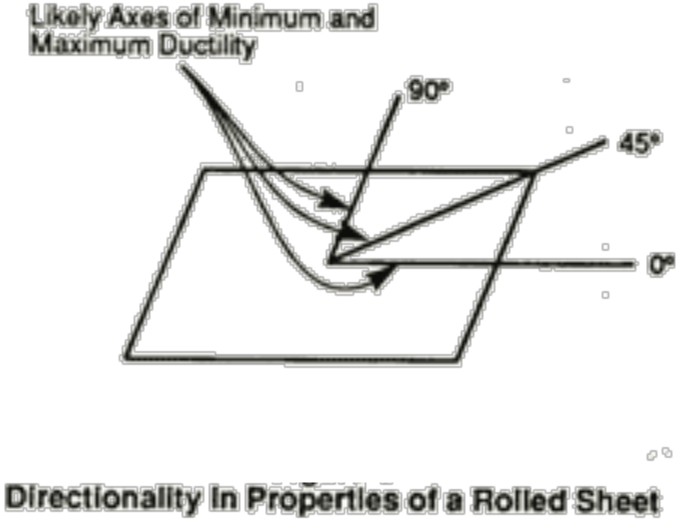


Key Factors

- *R* varies with direction of tensile stress application relative to sheet rolling direction

- Average normal anisotropy, $\overline{R}$

$$\overline{R} = \frac{R_{0^\circ} + 2R_{45^\circ} + R_{90^\circ}}{4}$$



Directionality in Properties of a Rolled Sheet

- Planar anisotropy, ΔR

$$\Delta R = \frac{R_{0^\circ} - 2R_{45^\circ} + R_{90^\circ}}{2}$$

$R_{\theta = 0,\ 45,\ 90}$ are the normal anisotropies in the sheet at the specified angles relative to the rolling direction of sheet

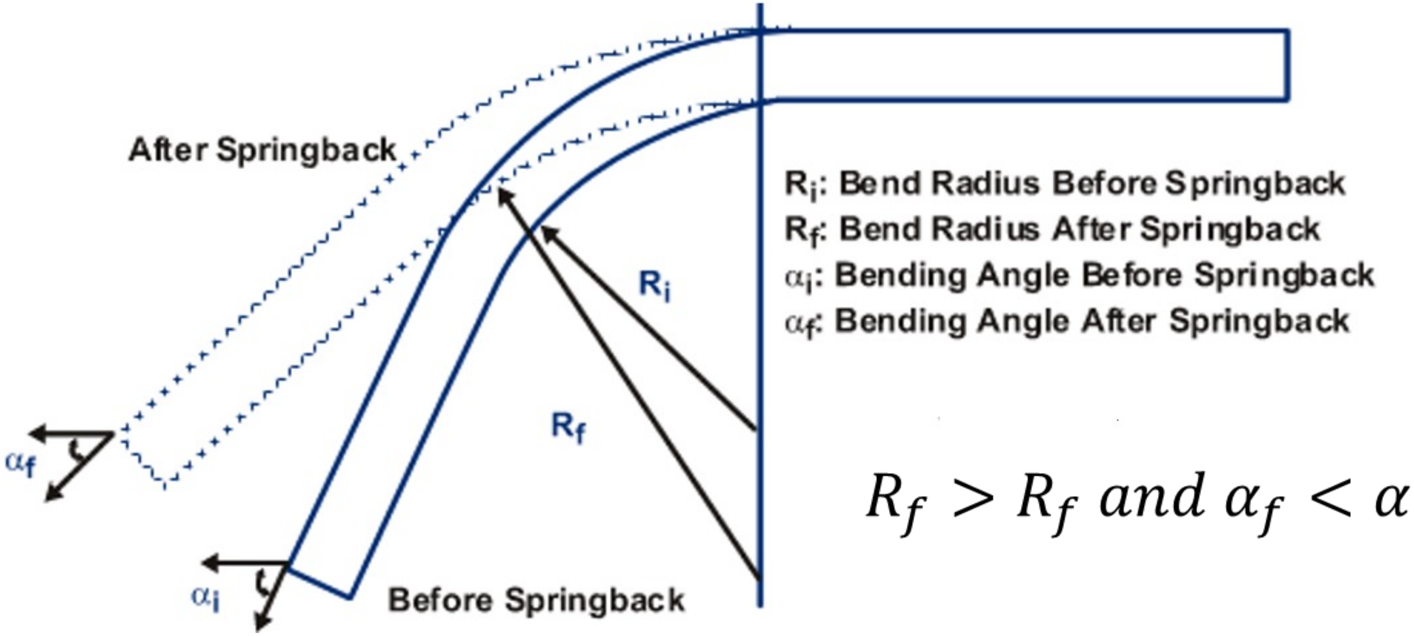
Key Factors

- Grain size: impacts mechanical properties and appearance of surface of sheet
  - Finer grain size → stronger the sheet, smoother surface
- Residual stresses: due to non-uniform deformation
  - Tensile stresses → stress corrosion cracking, part distortion

Source: Kalpakjian & Schmidt, 4th Ed., 2003

Key Factors

- Springback: elastic recovery of sheet; common in bending operations



$$R_f > R_f \; and \; \alpha_f < \alpha_i$$

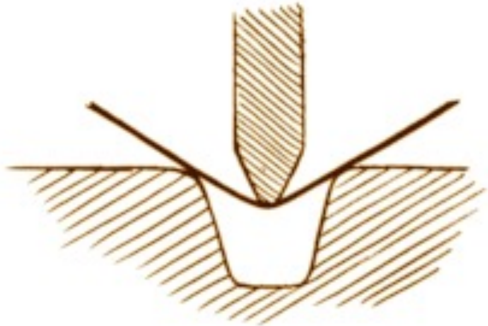
Key Factors

- Wrinkling: due to compressive stresses acting in the plane of the sheet (common in deep drawing)

Source: www2.thefabricator.com

Sheet Metal Bending

- Process used to create parts with bends in them
- Bending also enhances rigidity of part
- Process carried out on a press brake machine

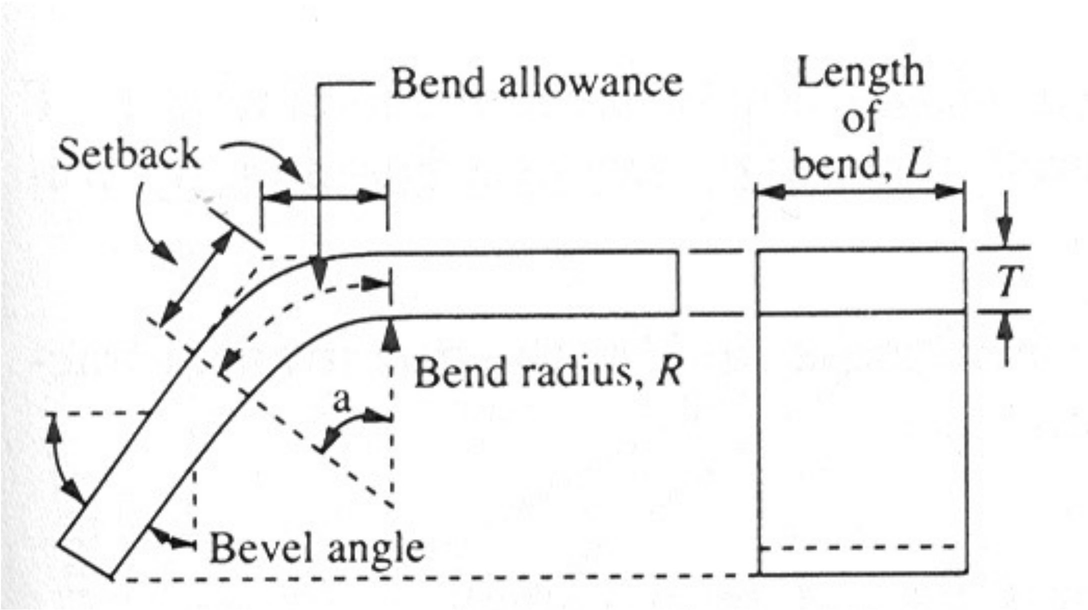


Air-Bending

Bottoming

Metal bending machine

Sheet Metal Bending



Engineering strains (theoretical):

$$e_o = e_i = \frac{1}{\left(2R/T\right)+1}$$

e_i = strain in inner fiber; e_o= strain in outer fiber

$$\therefore \text{ as } \frac{R}{T}\downarrow \quad e_o \uparrow \quad \rightarrow \text{ cracking on outer bend surface}$$

Source: Kalpakjian & Schmidt, 4th Ed., 2003

Sheet Metal Bending

- Minimum bend radius: expressed as an integer (*n*) multiple of the sheet thickness *T* i.e. *nT*
- Determined experimentally
- Theoretically,

$$\text{Min.}\,\frac{R}{T}=\frac{50}{r}-1$$

r = % reduction in area in a tension test

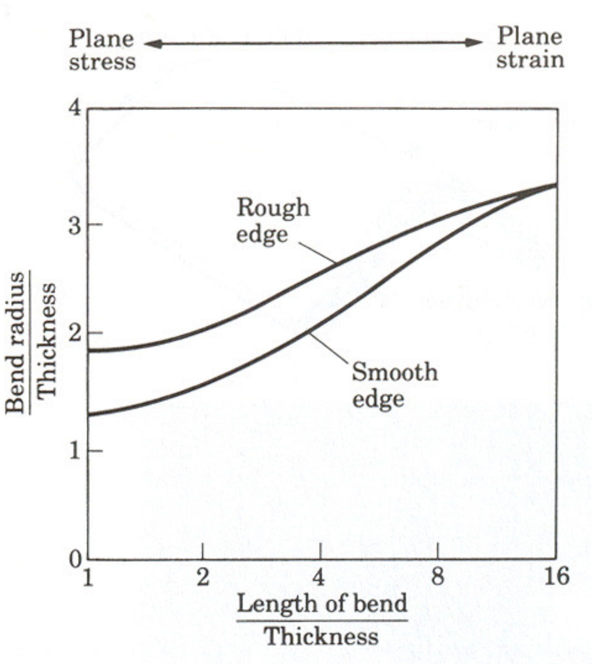
Expression for min. bend radius derived by equating true strain at fracture in tension, ε_f = ε_o, true strain in outer fiber of bent sheet

Note that $$\varepsilon_f=\ln\left(\frac{A_0}{A_f}\right)=\ln\left(\frac{100}{100-r}\right)$$

and $$\varepsilon_0=\ln(1+e_0)=\ln\left(\frac{R+T}{R+0.5T}\right)$$

Factors Affecting Bendability

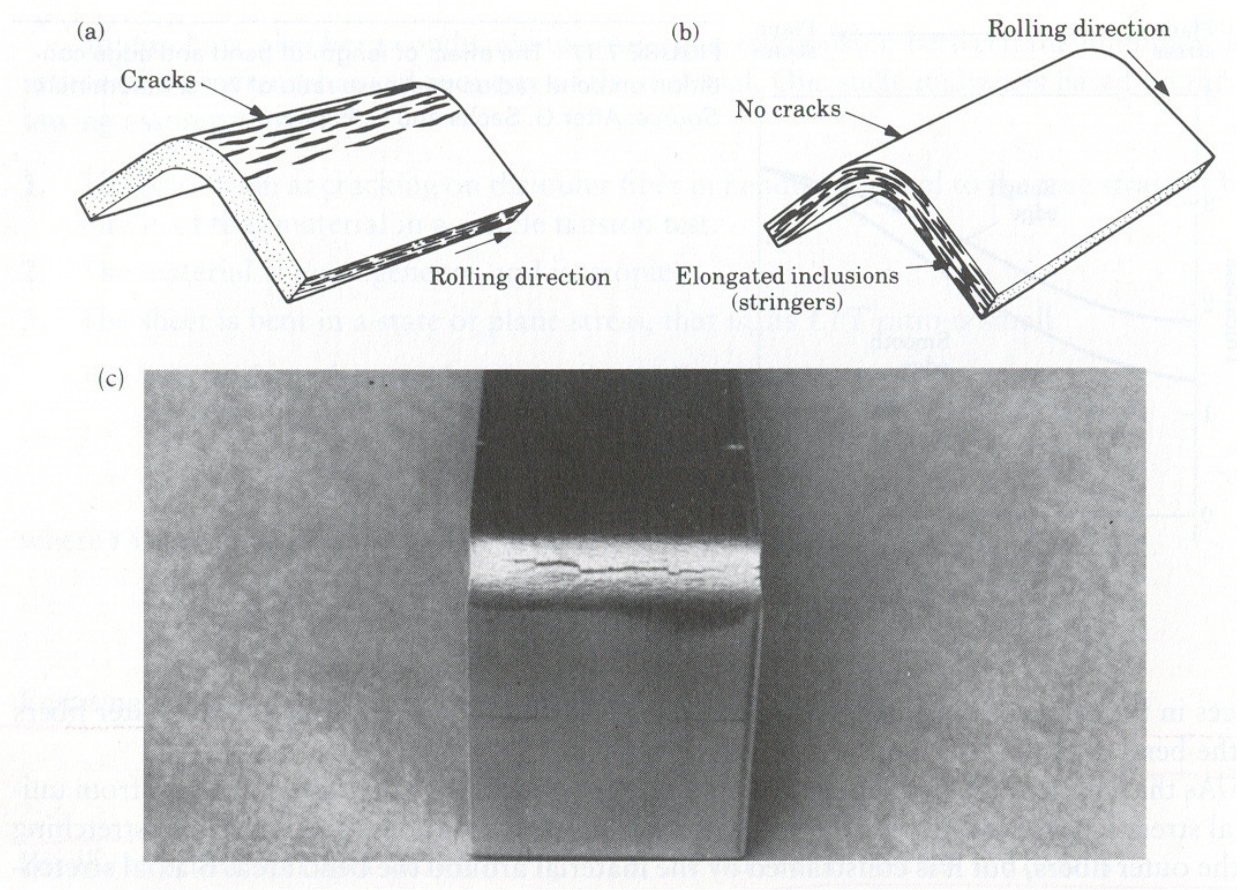
- Bendability can be enhanced by heating, applying compressive stresses in plane of sheet
- As L ↑ → state of strain in outer fiber changes from uniaxial to biaxial → decreases ductility and the Min. R/T ratio ↑



Source: Kalpakjian & Schmidt, 4th Ed., 2003

Factors Affecting Bendability

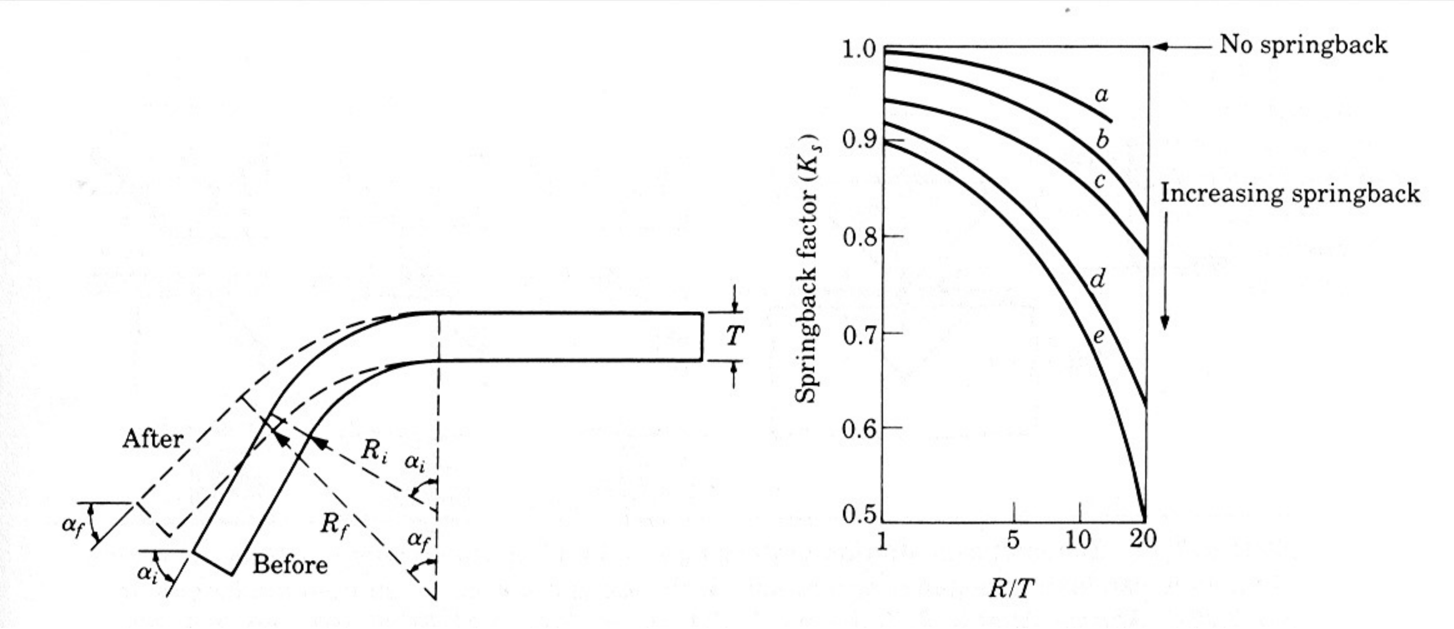
- Direction of Anisotropy



Source: Kalpakjian & Schmidt, 4th Ed., 2003

Factors Affecting Bendability

- Springback: results in larger bend radius and smaller bend angle, α



Springback factor, *K*$_s$

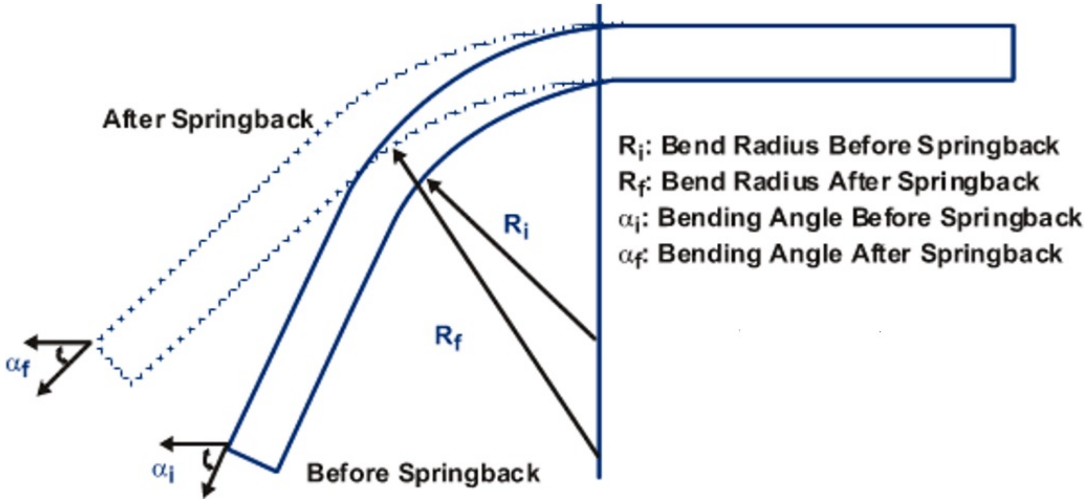
$$K_s = \frac{\alpha_f}{\alpha_i} = \frac{(2R_i/T)+1}{(2R_f/T)+1} \qquad \frac{R_i}{R_f} = 4\left(\frac{R_iY}{ET}\right)^3 - 3\left(\frac{R_iY}{ET}\right)+1$$

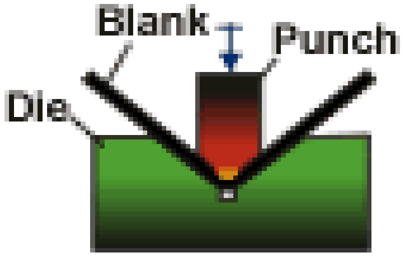
Where *Y* is the yield strength and *E* is the Young’s modulus

Source: Kalpakjian & Schmidt, 4th Ed., 2003

Factors Affecting Bendability

- Springback compensation methods
  - Overbending
  - Heating → lowers yield strength
  - Coining
  - Stretch bending

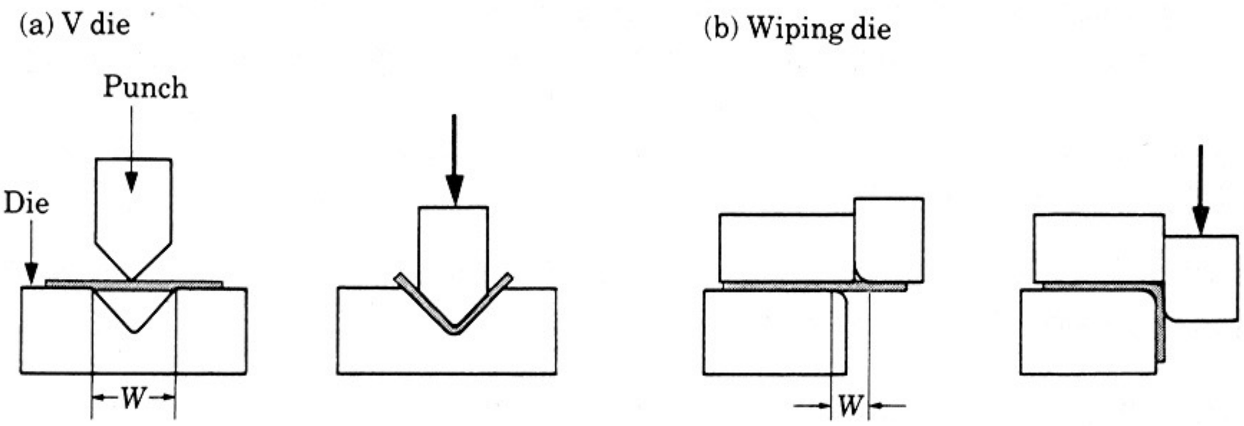




Coining

$$R_f > R_f \text{ and } \alpha_f < \alpha_i$$

Bending Force Calculation



- Max. bending force, $P_{\max}$ (neglecting friction)

$$P_{\max} = \frac{kYLT^2}{W} \approx k\frac{(UTS)LT^2}{W}$$

k =1.2~1.3 for V dies

k = 0.3 for wiping

k = 2.4 for U dies

Source: Kalpakjian & Schmidt, 4th Ed., 2003

Summary

- Sheet metal basics
- Key factors
- Sheet metal bending