

Contents

Preface	V
Terms, symbols and units	1
Part I Metal forming and shearing processes	3
1 Types of production processes	5
2 Terms and parameters of metal forming	7
2.1 Plastic (permanent) deformation	7
2.2 Flow stress	8
2.3 Deformation resistance.....	10
2.4 Deformability	11
2.5 Degree of deformation and principal strain	11
2.6 Strain rate	14
2.7 Exercise.....	14
3 Surface treatment	15
3.1 Cold bulk forming.....	15
3.2 Cold sheet forming.....	16
3.3 Hot forming.....	17
3.4 Exercise.....	17
4 Upset forging	18
4.1 Definition	18
4.2 Application	18
4.3 Starting stock	18
4.4 Permissible deformations	19
4.5 Upsetting force	23
4.6 Upsetting work	23
4.7 Upsetting tooling.....	24
4.8 Achievable precision.....	26
4.9 Defects in upset forging	27
4.10 Example calculations	27
4.11 Exercise.....	32
5 Extrusion	33
5.1 Definition	33
5.2 Application of the process.....	33
5.3 Types of extrusion process.....	34
5.4 Starting stock	35
5.5 Principal strain	35
5.6 Calculation of force and mechanical work.....	36
5.7 Extrusion tooling.....	38
5.8 Reinforcement calculation for single-reinforced dies	39
5.9 Achievable precision	42
5.10 Defects during extrusion	43

5.11	Sequence of operations diagram	43
5.12	Example calculations	44
5.13	Shape classification	49
5.14	Exercise	55
6	Thread and gear rolling	56
6.1	Types of process	56
6.2	Application of the processes	58
6.3	Advantages of thread rolling	59
6.4	Establishing the initial diameter	60
6.5	Rolling speeds with cylindrical dies	61
6.6	Rolling dies	61
6.7	Example	63
6.8	Thread rolling machines	64
6.9	Exercise	68
6.10	Processes and machines for rolling gears	69
7	Cold hubbing	77
7.1	Definition	77
7.2	Application of the process	77
7.3	Permissible deformations	78
7.4	Calculation of force and mechanical work	78
7.5	Materials which can be hubbed	79
7.6	Hubbing speed	80
7.7	Lubrication during hubbing	80
7.8	Characteristics of the workpieces to be hubbed	80
7.9	Hubbing tooling	81
7.10	Advantages of cold hubbing	82
7.11	Defects during cold hubbing	83
7.12	Machines for cold hubbing	83
7.13	Example calculations	84
7.14	Exercise	85
8	Coining (stamping)	86
8.1	Definition	86
8.2	Types and applications of coining processes	86
8.3	Calculation of force and mechanical work	87
8.4	Tooling	88
8.5	Defects during coining	89
8.6	Example	89
8.7	Exercise	90
9	Ironing (wall ironing)	91
9.1	Definition	91
9.2	Application of the process	91
9.3	Starting stock	91
9.4	Principal strain	91
9.5	Calculation of force and mechanical work	93
9.6	Example	93
9.7	Exercise	94

10	Wire drawing	95
10.1	Definition	95
10.2	Application	95
10.3	Starting stock	96
10.4	Principal strain	96
10.5	Permissible deformations	96
10.6	Drawing force	97
10.7	Drawing speeds	97
10.8	Drive power	99
10.9	Drawing tooling	100
10.10	Example	102
10.11	Exercise.....	104
11	Tube drawing	105
11.1	Definition	105
11.2	Tube drawing processes	105
11.3	Principal strain and drawing force	106
11.4	Drawing tooling	107
11.5	Example	108
11.6	Exercise.....	108
12	Extrusion	109
12.1	Definition	109
12.2	Application	109
12.3	Starting stock	110
12.4	The extrusion process	110
12.5	Principal strain	113
12.6	Strain rates during extrusion	113
12.7	Extrusion force	114
12.8	Mechanical work	116
12.9	Tooling	118
12.10	Extrusion presses	120
12.11	Example	121
12.12	Exercise.....	122
13	Impression-die forging (closed-die forging)	123
13.1	Definition	123
13.2	Starting stock	123
13.3	Types and application of the process	124
13.4	Processes in the forging die	126
13.5	Calculation of force and mechanical work	127
13.6	Tooling	132
13.7	Design of impression-die forgings	136
13.8	Achievable precision	137
13.9	Example	137
13.10	Exercise.....	139
14	Deep drawing	141
14.1	Definition	141
14.2	Application of the process	141

14.3	Forming process and stress distribution	142
14.4	Starting stock	143
14.5	Permissible deformation	150
14.6	Deep drawing steps	152
14.7	Calculating the drawing force	154
14.8	Blank holder force	155
14.9	Drawing work	156
14.10	Drawing tooling	158
14.11	Achievable precision	166
14.12	Defects during deep drawing	167
14.13	Example	169
14.14	Hydromechanical deep drawing	172
14.15	Sheet hydroforming	174
14.16	Tube hydroforming	179
14.17	Exercise	184
15	Deep drawing without a blank holder; metal spinning	185
15.1	Deep drawing without a blank holder	185
15.2	Metal spinning	186
15.3	Exercise	192
15.4	Incremental sheet forming	193
16	Bending	194
16.1	Definition	194
16.2	Application of the process	194
16.3	The bending process	194
16.4	Limits of bending deformation	195
16.5	Spring-back	197
16.6	Determining the blank length	198
16.7	Bending force	199
16.8	Bending work	201
16.9	Bending tooling	203
16.10	Bending defects	204
16.11	Example	204
16.12	Bending machines	205
16.13	Exercise	211
17	Embossing	212
17.1	Definition	212
17.2	Application of the process	212
17.3	Calculation of force and mechanical work	213
17.4	Embossing tooling	216
17.5	Embossing defects	217
17.6	Example	217
17.7	Exercise	217
18	Shearing	218
18.1	Definition	218
18.2	Shearing process flow	218
18.3	Types of shearing process	219

18.4	Permissible deformation	220
18.5	Calculation of force and mechanical work	220
18.6	Resultant line of action	222
18.7	Break clearance	225
18.8	Web and rim thickness	227
18.9	Achievable precision	228
18.10	Shearing tooling	229
18.11	Example	238
18.12	Exercise.....	240
19	Fine blanking (precision blanking)	241
19.1	Definition	241
19.2	Fields of application	241
19.3	Shearing process flow	241
19.4	Fine blanking tooling design	242
19.5	Break clearance	242
19.6	Forces during fine blanking	243
19.7	Fine blanking presses	244
19.8	Exercise.....	246
19.9	Laser cutters	247
20	Joining by forming	249
20.1	Clinching	250
20.2	Punch riveting	254
20.3	Self-piercing riveting with semi-tubular rivets	257

Part II Presses

21	Types of press	262
21.1	Presses controlled by work	262
21.2	Presses controlled by the ram path	262
21.3	Presses controlled by force	263
21.4	Exercise.....	263
22	Hammers	264
22.1	Columns and frames	264
22.2	Types of hammer	264
22.3	Constructional design and calculation of impact energy	266
22.4	Fields of application for hammers	273
22.5	Example	274
22.6	Exercise.....	274
23	Screw presses	275
23.1	Forms of structural design	275
23.2	Functions of the individual styles of construction	276
23.3	Calculating the parameters for screw presses	287
23.4	Advantages of screw presses	291
23.5	Typical fields of application of screw presses	291
23.6	Examples	292
23.7	Exercise.....	294

24	Eccentric and crank presses	295
24.1	Types of these presses	295
24.2	Press frame materials	298
24.3	Frame deflection and deflection energy	299
24.4	Eccentric and crank press drives	300
24.5	Calculating the parameters	306
24.6	Example	310
24.7	Application of eccentric and crank presses	312
24.8	Exercise	312
25	Knuckle-joint and toggle presses	313
25.1	Single-point knuckle-joint presses	313
25.2	Toggle presses – modified knuckle-joint presses	314
25.3	Horizontal knuckle-joint and toggle presses	317
25.4	Exercise	317
26	Hydraulic presses	318
26.1	Hydraulic press drives	318
26.2	Example	320
26.3	Advantages of hydraulic presses	321
26.4	Practical application of hydraulic presses	321
26.5	Exercise	324
27	Special-purpose presses	325
27.1	Deep drawing transfer presses	325
27.2	Transfer presses for bulk forming	331
27.3	Automatic punching presses	339
27.4	Exercise	344
28	Workpiece and stock feed systems	345
28.1	Feed devices for piercing or blanking operations	345
28.2	Transport devices in deep drawing transfer presses	346
28.3	Transport devices for transfer presses for bulk forming	347
28.4	Feed devices to supply round blanks	348
28.5	Feed devices to convey single workpieces in steps	348
28.6	Feed devices to supply forging presses	349
28.7	Exercise	349
29	Future developments in metal forming presses and tool changing systems	351
29.1	Flexible manufacturing systems	351
29.2	Automatic tool change systems	362
Part III Tables	367	
Bibliography	401	
Index	403	