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Evolutionary Optimization Of Sheet Metal Forming

By Ganesh Kakandikar

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Drawing/Forming/Stamping is a compression-tension forming process, which are widely used sheet metal working processes in the industries, to produce cup shaped components at a very high rate. In this process the blank is generally constrained over the draw punch into the die to give required shape of cavity. In drawing the sheet material is subject to a large plastic deformation combined with a complex flow of material. When a metal sheet is deep drawn, the development of wrinkling and a decrease in the limit drawing ratio should be simultaneously suppressed. Blank holder is applied to prevent the wrinkling in the flange & cup wall. Wrinkling is basically initiated by localized buckling due to compressive stresses in circumferential direction. Tensile stress in radial direction causes tearing. Friction coefficient is usually used as a main indicator of friction, which is dependent on material, contact surface and lubricant. Appropriate Punch nose radius & Die profile radius should be selected. The success of process depends upon various parameters and their interactions. It important to understand the influence of all...



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