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Citation for published version (APA):

Boers, S. H. A., Schreurs, P. J. G., & Geers, M. G. D. (2005). *Optimum path and discrete 3D forming*. Poster session presented at Mate Poster Award 2005 : 10th Annual Poster Contest.

Document status and date:

Published: 01/01/2005

Document Version:

Publisher's PDF, also known as Version of Record (includes final page, issue and volume numbers)

Please check the document version of this publication:

- A submitted manuscript is the version of the article upon submission and before peer-review. There can be important differences between the submitted version and the official published version of record. People interested in the research are advised to contact the author for the final version of the publication, or visit the DOI to the publisher's website.
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- The final published version features the final layout of the paper including the volume, issue and page numbers.

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Optimum path and discrete 3D forming

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Introduction

A discrete die enables a variable strain path during forming; products with an optimized internal strain distribution can be produced, e.g. the lifetime of parts carrying cyclic (thermal) loading can be enhanced considerably. From an industrial perspective, discrete die forming is a useful concept in a small-lot production environment because different products can be made with the same reconfigurable die and many resources are saved.

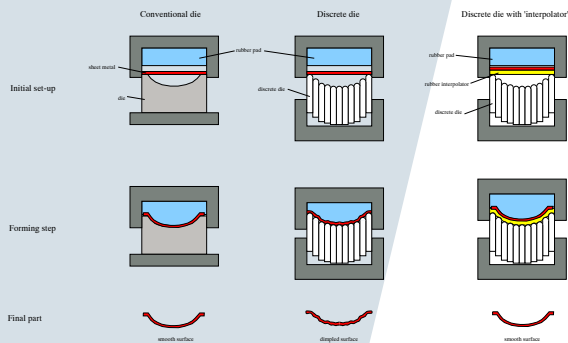


Figure 1 The concept of discrete die forming uses reconfigurable pins in combination with a rubber interpolator to prevent the dimpling of the product.

Objective

A numerical tool to calculate, using the deformation path dependent Teodosiu model, time-varying die shapes, yielding different internal strain distributions for geometrically identical products. Validation will be done by using the prototype of the discrete die.



Figure 2 Prototype of high resolution discrete die with a working volume of 10x20x30 mm that consists of more than 500 discrete elements.

Methods

- Deformation path dependent forming experiments with the prototype for validating the numerical material model.
- Determination of strain distribution and product geometry with photogrammetry technique.
- Numerical algorithm, providing the intermediate die shapes for an optimally formed workpiece.

Results

Geometrically equal products have been fabricated with three different loading paths of which one is proportional and two are non-proportional. Different results are obtained for the two non-proportional loading paths. In a two-step forming experiment, a sample without defects is produced whereas the one-step formed sample has fractured at the center.

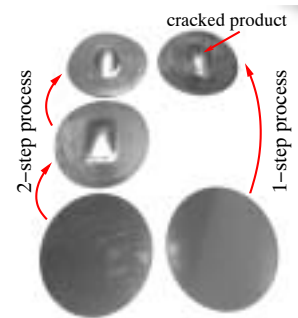


Figure 3 Multi-step forming experiment with discrete die.

The proportional loading path results in a sample with minimal thickness reduction at the center compared to the two non-proportional loading experiments.

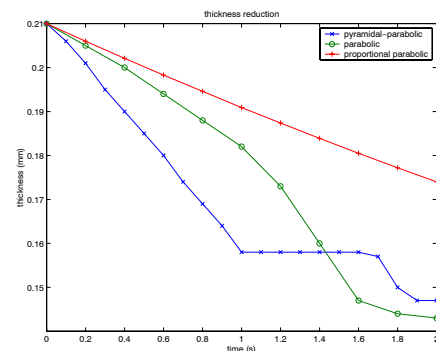


Figure 4 Thickness reduction of the center for the proportional, one-step and two-step forming experiment.

Discussion

- The Teodosiu model and material parameters must be validated by doing non-proportional loading tests with the prototype.
- A criterion must be formulated to define an 'optimally formed' workpiece.
- A numerical tool must be implemented within FEM framework to determine intermediate die shapes.

References

- S. Li, E. Hoferlin, A. v. Bael, P. v. Houtte and C. Teodosiu (2001), Finite element modeling of plastic anisotropy induced by texture and strain-path change, International Journal of Plasticity 19 (2003), 647-674