

FUNDAMENTALS OF METAL FORMING

Metal Forming

- Large group of manufacturing processes in which plastic deformation is used to change the shape of metal workpieces
- The tool, usually called a **die**, applies stresses that exceed yield strength of metal
- The metal takes a shape determined by the geometry of the die

Stresses in Metal Forming

- Stresses to plastically deform the metal are usually **compressive**
Examples: forging, rolling, extrusion
- However, some forming processes:
 Stretch the metal (**tensile** stresses)
 Others bend the metal (tensile and compressive)
 Still others apply **shear** stresses

*Tensile - capable of being stretched or extended; ductile.
*Shear stress - exists when two parts of a material tend to slide across each other in any typical plane of shear upon application of force parallel to that plane.

Material Properties in Metal Forming

Desirable material properties:

- **Low yield strength and high ductility**

*Yield strength refers to an indication of maximum stress that can be developed in a material without causing plastic deformation.

These properties are affected by temperature:

Ductility increases and yield strength decreases when work temperature is raised

Other factors:

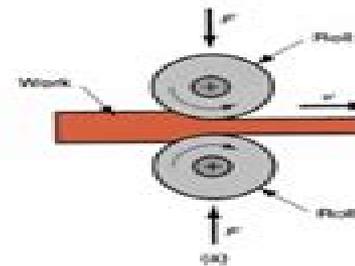
Strain rate and friction

Bulk Deformation Processes

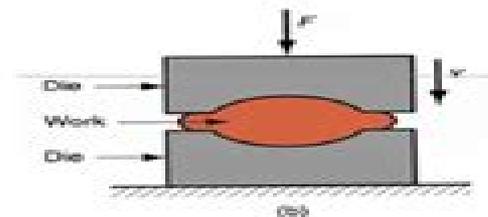
- Characterized by significant deformations and massive shape changes
- "Bulk" refers to workparts with relatively low surface area-to-volume ratios
- Starting work shapes include cylindrical billets and rectangular bars

BASIC PROCESSES BULK DEFORMATION

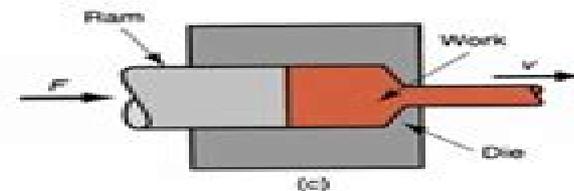
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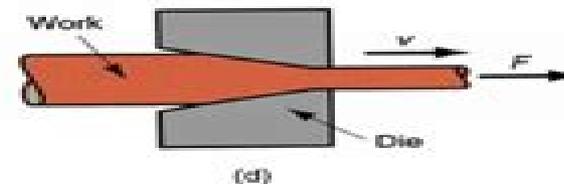
B. Forging



C. Extrusion



D. Drawing



Handbook Of Metal Forming Processes

DP Hallahan



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Table of Contents Handbook Of Metal Forming Processes

1. Understanding the eBook Handbook Of Metal Forming Processes
 - The Rise of Digital Reading Handbook Of Metal Forming Processes
 - Advantages of eBooks Over Traditional Books
2. Identifying Handbook Of Metal Forming Processes
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Handbook Of Metal Forming Processes
 - User-Friendly Interface
4. Exploring eBook Recommendations from Handbook Of Metal Forming Processes
 - Personalized Recommendations
 - Handbook Of Metal Forming Processes User Reviews and Ratings
 - Handbook Of Metal Forming Processes and Bestseller Lists
5. Accessing Handbook Of Metal Forming Processes Free and Paid eBooks
 - Handbook Of Metal Forming Processes Public Domain eBooks
 - Handbook Of Metal Forming Processes eBook Subscription Services
 - Handbook Of Metal Forming Processes Budget-Friendly Options
6. Navigating Handbook Of Metal Forming Processes eBook Formats

- ePub, PDF, MOBI, and More
 - Handbook Of Metal Forming Processes Compatibility with Devices
 - Handbook Of Metal Forming Processes Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Handbook Of Metal Forming Processes
 - Highlighting and Note-Taking Handbook Of Metal Forming Processes
 - Interactive Elements Handbook Of Metal Forming Processes
 8. Staying Engaged with Handbook Of Metal Forming Processes
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Handbook Of Metal Forming Processes
 9. Balancing eBooks and Physical Books Handbook Of Metal Forming Processes
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Handbook Of Metal Forming Processes
 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
 11. Cultivating a Reading Routine Handbook Of Metal Forming Processes
 - Setting Reading Goals Handbook Of Metal Forming Processes
 - Carving Out Dedicated Reading Time
 12. Sourcing Reliable Information of Handbook Of Metal Forming Processes
 - Fact-Checking eBook Content of Handbook Of Metal Forming Processes
 - Distinguishing Credible Sources
 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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