

# THE VARIABLE CONTACT PRESSURE INFLUENCE ON THE TENSILE FORCE IN THE PROCESS OF STRIP SLIDING IN THE FLAT DIE IN IRONING

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## Resume

Possibilities to influence the deep drawing process during its duration are limited and generally consist of influences at the flange of the thin sheet, mainly by the contact pressure (the blank holding force). The common characteristics of previous investigations were setting of the fixed values of the blank holding force or the holder's pressure within the ironing tool. The objective of this investigation was the continuous setting of the variable pressure during the sliding process, via the preset functions, in order to analyze the variable pressure influence on the ironing process.

This is why an experimental computerized device was designed and constructed for analyzing the influence of the variable contact pressure on the sliding process of the model strip during the flat-die test. The multi-parameter experiment was conducted; various materials of the tested pieces were applied (primarily thin sheet made of Al alloys and low-carbon steels sheet, with and without coating); different versions of the tool's contact elements were used, with various friction regimes and influential parameters (variable contact pressure during the sliding process, etc.). This experimental device practically represents a simulator for realization and studying of the physical model of an important segment of the ironing process in the completely realistic conditions (materials, tools, etc.).

The aim was to find the optimal combination of the variable contact pressure and the tribological parameters, so that the punch force, as one of the process output parameters, would have the minimal value, as well as to avoid the undesired effects during the forming (difficult sliding of the flange, appearance of thin sheet's wrinkling, structural destruction, etc.).

Understanding the mutual dependence of the holder's variable pressure and other influences should enable improvement of the ironing process control and should contribute to better understanding of the phenomena occurring at the thin sheet's flange.

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## 1. Introduction

Possibilities to influence the deep drawing process during its time of conducting are limited. They are reduced to influence on the thin sheet flange, mainly through the contact pressure (the blank holding force) and by action of the draw beads on the holder. The characteristics common to all the previous investigations in this field were setting of the fixed values of the blank holding force

or the holder's pressure within the ironing tool.

The objective of this investigation was continuous setting of the variable pressure during the sliding process, via the preset functions, in order to analyze the variable pressure influence on the ironing process, as well as other influences (die, contact conditions, material, etc.).

Influence of the variable contact pressure in the ironing process represents a very



















