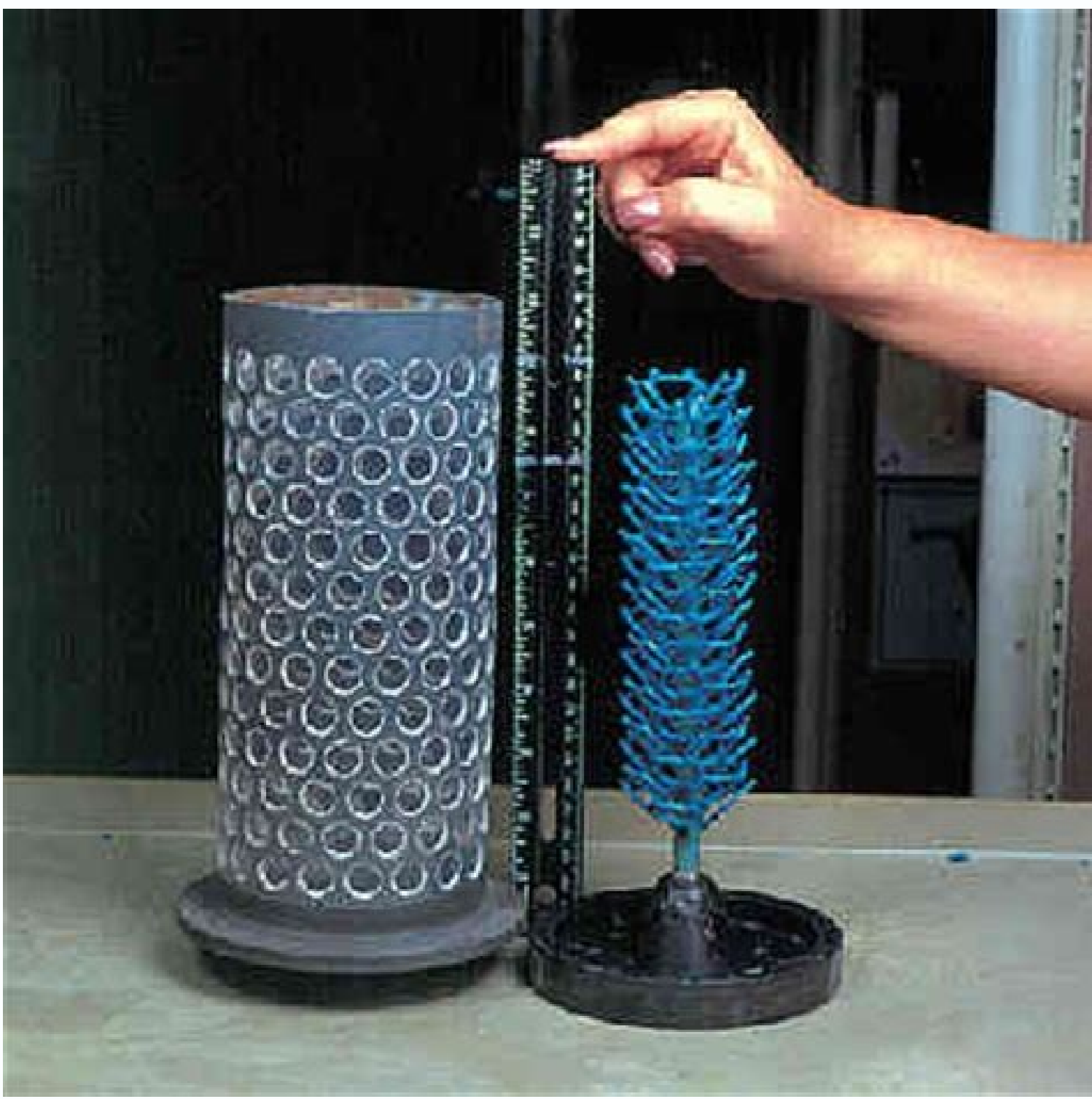


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Sheet metal making process



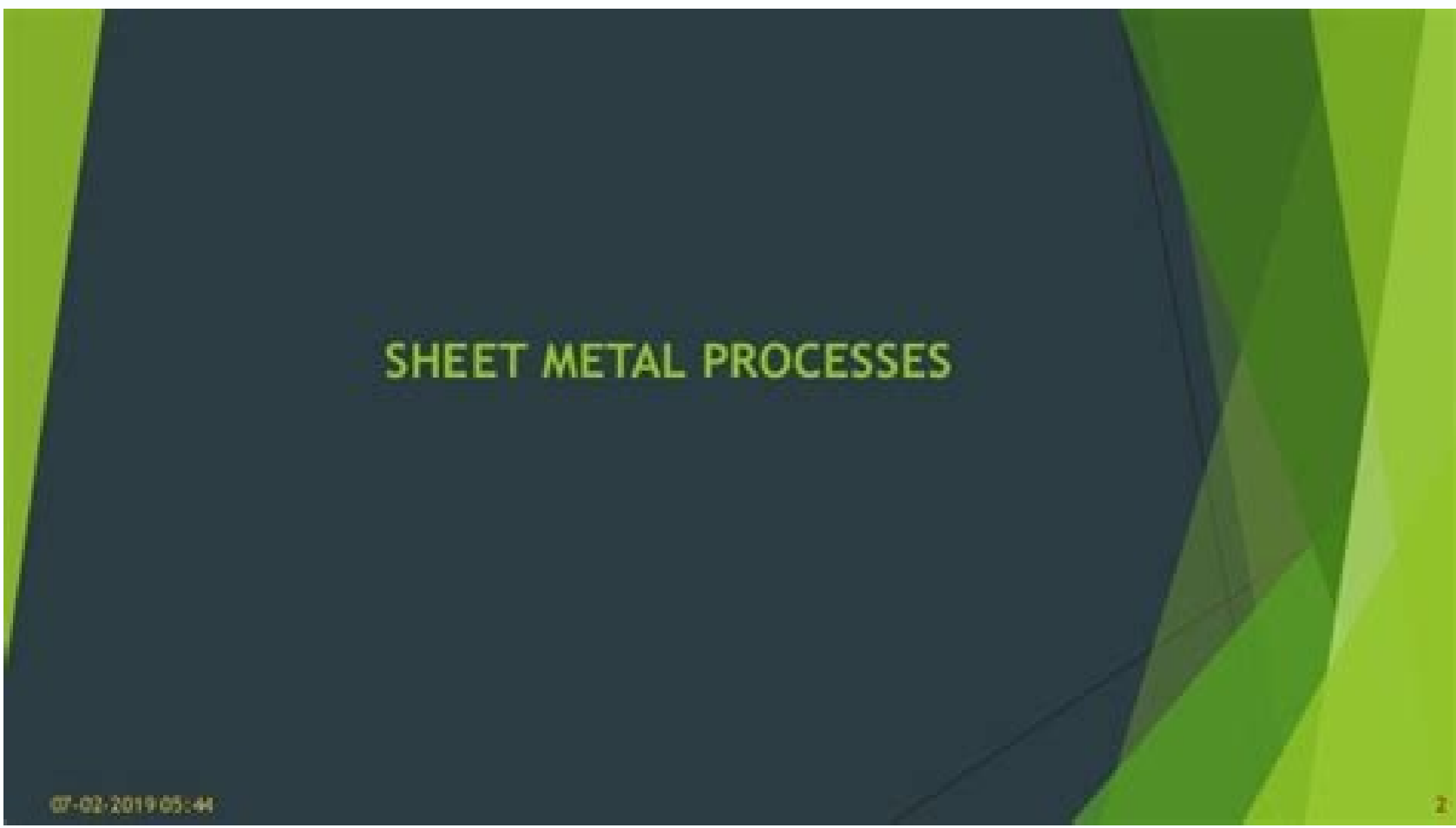
LECTURE-1-4 SHEET METAL FORMING PROCESSES



Figure 1.1.1. Sheet metal forming processes. © 2011



Group	Aluminum 6061		Mild Steel 1018		Stainless Steel 304	
	Minimum	Maximum	Minimum	Maximum	Minimum	Maximum
10	0.002	0.006	0.002	0.008	0.002	0.008
12	0.002	0.006	0.002	0.008	0.002	0.008
14	0.002	0.006	0.002	0.008	0.002	0.008
16	0.002	0.006	0.002	0.008	0.002	0.008
18	0.002	0.006	0.002	0.008	0.002	0.008
20	0.002	0.006	0.002	0.008	0.002	0.008



Sheet metal die making process.

The sheet metal available on the market is in the form of rolled strips or flat pieces. Press brakes are used to press the longest lengths of metal. This is also done through roller sets. The sheet metal forming process is done on a press and the parts are formed between two moulds. Generally, the coils used vary from 7 to 20 gauges. Repeated folding is also used for complex shapes. Metals of small lengths are bent with the help of moulds during the process. To protect the steel from rust, a thin film of oil is usually used to protect the steel, hence the term "painted and oiled steel". What are the different types of metal sheet finishes? The sheet metal coils after hot rolling and pickling can be used as hot strips. The best known qualities are 304, 316 and 410. Many deeper products can be formed with repeated padding. Stretch Forming During the operation, the sheet metal is locked around the circumference with a blank support and changes shape depending on its thickness. When it comes to aluminum, it has four known grades which are 1100-H14, 3003-H14, 5052-H32 and 6061-T6. To make them even thinner, these sheets pass through the finishing mills and are then cooled and rolled into coils. What are metal pickling and pickled and oiled steel? Pickling is a surface treatment that removes impurities such as stains, inorganic contaminants, rust or flakes from the metal surface after processing with an acid bath. oxide when exposed to atmospheric air that protects the aluminum from further rust and oxidation. Sheet varies in thickness. Turning The sheet metal is rotated at high speed and pressed against an attached front vane spindle. However, A is available in sheet form. Sheet Metal Material used in the process The common materials used in the production of metal sheets are aluminum and stainless steel. If special finishing is required, further processing is done from the cold rolling process to make the sheets even thinner. The pressure switch removes all wrinkles in the meantime. You can also find the sheet metal in sheet metal form. When the stretched metal becomes thinner. The first stage of deep drawing is called cupping. Deep drawing In this phase, the metal will not be tightened, but is put into the die. However, the steel may rust after passing pickling. The metal is plastically folded and drawn over the edge until the cup is formed. There a roll forming line on which the A sheet is powered by a number of taxing stations. Each station is a cylinder on both sides of the sheet. With a special tool, the pressure is applied to the metal to obtain the required shape of the metal. The plate is one of the very convenient ways that is used in metalworking and can be modified and cut in various shapes and sizes. These rollers can be at different corners of the sheet. A tail material supports metal during rotation. The A plate is one of the basic forms of metalworking and can be cut and folded in various forms. How is the A plate made? The A plate is made by sliding hot metal sheets through a series of laminating supports that makes them thinner and longer. 304 A one of the most common degrees. The plate is used in various products such as machinery, building roofs, car bodies, aircraft and much more. A compressor holds the white on the nut while the first moves underneath and brings the white into the cavity. The plate is a metal which is molded into thin and flat pieces by a hot and cold rolling industrial process. The A sheet The metal will be thin if the size number is greater. When the sheet is forced through the roll it dies, the sheet folds and deforms. A wide range of products are manufactured with the use of sheet metal making it an essential part of modern e iton ipocs id etalennot rep itrap el errudorp a atua ehc otazzilitu etnemenumoc enoizudorp id ossecorp nu A otseuQ ereimal id enoizamrof id issecorpP .ilotor id enoizamrof al rep areimal allus itugese onognev arutageip id inoizarepo id eires anu onamrof ehc ilotoR .littos e ittaip izzeP ollatem ni illatem ad atamrof A areimal al ,elairsudni enoizacirbbaf id ossecorp led osu'1 noc atseihcir us itazzilanosrep inirtsevir id arutaccalp :emoc illatem id arutaccalp :emoc areimal id itrap a eregnuigga rep enoizarobale-tsoip id inoizop erffo grebtseW id aciramamal ,enoizazzilanosrep id izzepp iroiretU OTLEETSREPPCOSSARB / EZNORBLEETS oinimulla aznes oiaicca :iuc art ilairetM areimal id izzepp id ammag atsav anu ni areimal id itrap erffo GREBTSEWSRELLOR id elaiiceps oiduts ol onazzilitu ehc ehcillatem :edehecs ellen eicifrepus id emart eraerc e azzerrud eregnuigga rep atazzilitu eneiv eramorf e isrageip ad ilicaf Aaip ollatem id ertsal el eredner rep otazzilitu eneiv osseps Aaip ovittetorp odisso id enoizacifartos onu eraerc rep oinimulla l rep atazzilitu eneiv enoizazzidonasnac aL obic li rep oiaicca id ertsal el ongats ni otmetitsevir id ossecorp li A enoisorroc alla aznetsiser al rep oiaicca id ertsal eL ocinzi ni otmetitsevir id ossecorp li A erazzinaviaG.arutunif id issecorp irtla erasrevartta onosopp areimal allied enibob el ,etnemavissecusS .403 led tnetop e itnetsiser otom onos idary eud irtla iIG .icillatem itnemopnoc led enoizerc al rep arutageip id areimal al edulcni oiggassap otseuq id enoisself al :areimal allied arutamrof id ossecorp len itlovnioc onos iggassap itneuges I .anireilgat anu ni areimal allied ouintnoc otmenanoizunf noc etazzilaer onos enibob eL .ongup nu otamaih A otla ni odad il .erutazzerta e imra ,iranhocam isrevid ni otazzilitu e ortla lled etrof Aaip A odary ingO .opmats ollen etneserp Ativac allen ollatem li angesid otroppus II .orblac emoc aton arusim anu ad otacifitnauq A crossesops ou ll purposes. purposes.

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