

## EXPERIMENTAL DETERMINATION OF FORMING LIMIT DIAGRAM

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### ABSTRACT

*Forming limit diagrams (FLDs) are a convenient and often used tool for the classification of the formability and for the evaluation of the forming process of sheet materials. Forming limits of sheet metal are represented in the forming limit diagram (FLD) occurring by various deformation states. The paper introduces a experiment method for determination of forming limit curve for whole range of the FLD for sheet metal.*

**Key words:** forming limit diagrams (FLD), experiment method

### 1. INTRODUCTION

In the industrial practice it is often important how the forming process is performed. It is necessary to define where the critical areas of necking and fracture are. The forming technology can be analysed before the tool is manufactured what leads to the savings of costs and time. If the forming limit for the particular product is known the process can be optimized. From this point of view the time is saved, the costs are reduced and the quality of products is improved.

The origin of analysis of the forming limits was given in the 1940ies. The first presentation, which includes a diagram similar to the typical FLD, was published by Gossamer in 1946 [1]. The concept of FLDs, as it is known today, was developed by Keeler in 1965 [2]. With the experiments Keeler realised the possibility to show a FLC for sheet metal in a coordinate system of two main strains, but only for the right side of contemporary known FLD ( $\epsilon_2 > 0$ ). This idea was extended by Goodwin [3] at the end of the 60's when the diagram was completed also for the left hand side with deformations of  $\epsilon_2 < 0$ . The term "forming limit" was defined as a critical formability of metallic materials at the crack initiation. In recent 40 years a lot of research work regarding FLDs and their influencing parameters was done. At the beginning of the 1990's the research work was intensified by the start of enhanced practical application of FEA.

The forming limit curve for sheet metal represents a limit up to which the material can be formed before the cracks on the specimen occur. The curve is defined as a correlation between the first

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