New Developments in **Sheet Metal Forming**

Edited by Mathias Liewald



INSTITUTE FOR METAL FORMING TECHNOLOGY OF THE UNIVERSITY OF STUTTGART



DEUTSCHE GESELLSCHAFT FÜR MATERIALKUNDE E.V.

INVENTUM

Digital download of conference proceedings:



ISBN 978-3-88355-411-2

Papers of the

Internatioal Conferences on "New Developments in Sheet Metal Forming" and "New Developments in Hydroforming"

in Fellbach (near Stuttgart) – Germany, held on May 10th and 11th, 2016. Conference chairman: Univ. Prof. Dr.-Ing. Dr. h. c. Mathias Liewald MBA Director of the Institute for Metal Forming Technology (IFU) of the University of Stuttgart, in cooperation with:

"Forschungsgesellschaft Umformtechnik mbH" (FGU, Stuttgart / Germany), "Deutsche Gesellschaft für Materialkunde e.V." (DGM, Frankfurt / Germany)

All contributions to these conference proceedings were published as submitted by the authors, who are fully responsible for the contents and the orthography of their papers.

© 2016 INVENTUM GmbH Postfach 20 07 14, 53137 Bonn, Deutschland All rights reserved

Printed in Germany





Preface - NEBU

The International Conference "New Developments in Sheet Metal Forming" held in Stuttgart / Germany is organised every second year alternatingly with the International Conference "New Developments in Forging Technology". The main goal of both conferences is to gather

engineers and experts from the industry as well as scientists from universities to discuss the current state of the art, and future tendencies and targets in research and development of new sheet metal and/or bulk metal forming technologies.

Annually, the Institute for Metal Forming Technology (IFU / Stuttgart / Germany) organises this event in collaboration with the Forschungsgesellschaft Umformtechnik mbH (FGU / Stuttgart / Germany). For many years, the concept of the conference was to focus on effectively transferring scientific results into value added chains of companies operating in the field of sheet metal forming and other market segments. Therefore, the topics of the papers selected to be presented at the conference should have a reference to current research activities in sheet metal forming, hot forming, and tool design in Europe, the United States, and Asia. Through the conference and its contributions it is intended to present strategic issues of rather general topics in the field of producing sheet metal components to external specialists and determine the recent state of the art on an international level.

During this two-day conference, experts from both universities and industrial companies will present their papers and discuss their newly achieved results with experts from all over the world. Conference topics include investigations performed at several European metal forming institutes, at companies from the industry, and at the Institute for Metal Forming Technology (IFU) of University of Stuttgart. Thus, a balanced mix of practical and theoretical contributions will be presented. In 2016, special attention was paid to present and publish modern practical solutions in hot and cold forming of sheet metal materials, modern concepts of material compositions, as well as heat treatment and new approaches in order to integrate modern sensors into the tool structure to control process development during serial production. Another priority of the conference was to identify potentials of lightweight materials, which are applied in engineering, transporting and mobile systems. Therefore, the opening presentations in particular pay attention to recent questions in metal forming technologies and near future manufacturing strategies! Furthermore, the technological potential of new material developments / alloys will be disclosed to make attendees able to respond easily to occurring questions when running their day to day business in the sheet metal forming industry, or when visiting companies of today's system suppliers.

Company visits offered on Monday, May 9th, 2016 and contributions from numerous international acting market players and different technological research institutions in Germany are objecting present and deep insight into current developments and research work in the field of sheet metal manufacturing. During the conference, the visitors and speakers are given the opportunity of contributing professionally, analysing and observing trends, exchanging ideas, and cultivating personal networks. Therefore, the conference programme includes visits to industrial companies and a welcoming evening at IFU on the day before conference, the gala dinner on the 1st conference day, and exhibitions throughout the entire conference.

I would like to thank all of the authors for contributing and inspiring this conference! I also am grateful for the support of Deutsche Gesellschaft für Materialkunde e.V. (DGM), Frankfurt / Main, Germany, who will attach these proceedings to its publishing programme. This collection of papers presented on May 10th and 11th, 2016 in Fellbach / Stuttgart in Germany will be distributed widely and will be available to all international experts involved.

Yours sincerely

M. hiwald

Univ.-Prof. Dr.-Ing. Dr. h. c. Mathias Liewald MBA

Table of Contents

Preface M. Liewald	V
Current Research Work in the Field of Sheet Metal Forming at the Institute of Metal Forming Technology (IFU) <i>M. Liewald et al.</i>	1
NEBU	
International Conference New Developments in Sheet Metal Forming May 10 th – 11 th , 2016	
Strategic Opening Lectures	
Transformation to a New Era – Roadmap for Suppliers <i>B. Gottschalk</i>	25
Efficient. Networked. Innovative J. Früh, O. Beisel, R. Stauder	41
New Developments in Servo Press Technology K. Aida, K. Rothenhagen, A. Papaioanu	51
Future Component Requirements and Product Analyses	
Multi-Material Lightweight Design for Electronic Vehicles – Challenges in Produ G. Deinzer, F. Diebold, M. Kothmann	ection 57
Forming of Composite Materials for Technical Application <i>P. Middendorf, P. Böhler, J. Fial, M. Engelfried</i>	73
Forming of AMAG 7xxx Series Aluminium Sheet Alloys <i>T. Grohmann</i>	85
Process Simulation in Sheet Metal Forming	
Current Trends in Die Engineering and Construction towards an Industrialized Production of Sheet Metal Forming Dies <i>A. Emrich</i>	103
Automatic Die Face Engineering Using "Die-Starter" R. Narainen, H. Porzner, V. Chaillou	115

Permanent Deformations of AA6016 Sheet Metal Parts after Paint Drying Processes in Car Manufacturing J. Regensburger, C. Albiez, P. Ackert, JP. Nicolai, WG. Drossel	127
Systematic Process Improvement of Stamping Processes B. Carleer, M. Stippak, I. Burchitz	143
Modern Lightweight Materials and Material Modelling	
Large Sclae Manufacturing of Composite Parts in Compression Molding F. Henning, B. Thoma, B. Hangs, C. Keckl	153
Lode Angle and Strain Rate Dependent Ductile Fracture in Advanced High Strength Steel C. Roth, B. Erice, D. Mohr	169
AHSS Development and Application Technologies for POSCO's Solutions towards Automotive Industry <i>K. Chung, Y. Kang</i>	171
Hot Stamping Process of Aluminium 7xxx Sheets, Simulative Investigation A. Kraly, D. Vipavc, F. Grabner, N. Ross, M. Kumar	177
Tools and Process Technology	
The Latest BRUDERER Machine and Strip Feed Solutions for Stamping and Metal Forming <i>G. Ebneter, A. Kuhli</i>	189
New Methods for Sheet Metal Forming with Bihler Servo Technology C. Schäfer	205
Simulation along the Process Chain in Sheet Metal Forming	
Feasibility-Simulation and Systematic Process Improvement of Hot Forming Parts as well as Mapping of Results to Vehicle Simulation <i>M. Stillger, T. Brenne</i>	213
Current Challenges in Forming and Joining Simulation A. Werber, K. Wiegand	231
Optical 3D Metrology in Sheet Metal Development and Production H. Friebe, M. Klein, A. Grube	243
Strength Simulation during Desinging Phase of Critical Areas of Forming Dies R. Pfitzenmaier, M. Sowada	257

Hot Forming of Sheet Metal
Development of Zink Coated Parts for Hotstamping I. M. Gonzales, O. Straube
Press Hardening of Galvanized Steel Components for BIW Applications

265

Modern Tool Steels – A Prerequisite for Successful Hot Stamping of Steel Sheets R. Rahn, I. Schruff

289

277

Material Characterisation

R. Kelsch

Α	dvance	d N	Aaterial	C	haract	erisati	on	of TWI	P S	Steels
<i>E</i> .	Billur,	В.	Çetin, l	R.	Onur	Uğuz,	<i>K</i> .	Davut,	Е.	Arslar

303

319

HFQ ® – Making a Step Change in the Use of High Strength Aluminium Sheet G. J. S. Adam, D. Foster, J. Sellors

Future Potentials of Process Technology when Forming Stainless Steels *P. Schmid, M. Liewald*

325

Formability of Annealed AZ61 Magnesium Alloy at Elevated Temperatures *M. Ramezani, T. Neitzert*

337



International Conference New Developments in Hydroforming May 10th, 2016

IHP-Forming Solutions for Large-Scale Production

Hydroform Intensive Body Structure (HIBS II) with Advanced
and Ultra High Strength Steels
D. Gogwicko

353

D. Gearicke

Hydroforming in High-Volume Production *P. Freytag, J. Neubert, S. Kluge*

365

Hydroforming, Advanced High Strength Steel, Springback, Reduced Weight, Series Production

373

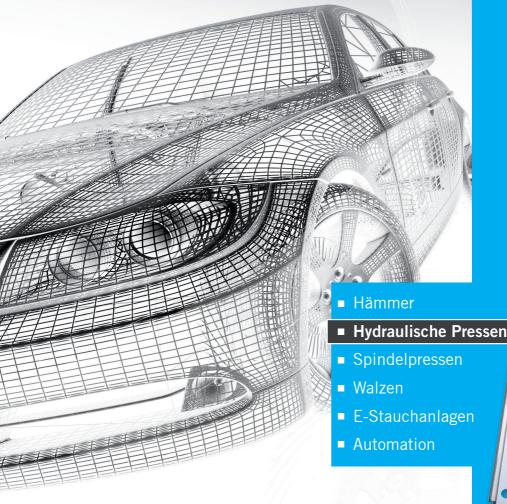
H. Hänelt, H. Freydank

Material Specific Solutions for IHP-Forming

Case Study: Springback Prediction and Reality in Hydroforming K. Hertell, G. Monclesi, W. Teufel	379
High-Pressure Sheet Metal Forming of Various Complex Components in a Single Process Cycle R. Wesselmann, A. Lückmann	397
20 Years of Hydroforming Experience at the Fraunhofer IWM – Innovative Process Variants D. Landgrebe, A. Albert, A. Paul, B. Domes, M. Pröhl	403
Hydroforming Hybrid – Affordable Hybrid Light Weight Design R. Ruez, S. Knoll	425
Machines and Semi-Finished Products	
Predictive Maintenance and Process Quality Assurance in Hydroforming – How Intelligent Algortihms can be of Help H. Valpertz, A. Hoffmann	435
Recent Hydroform and Flexform Development S. Olsson	445
Steel Tailored Tubes – Key Aspects on the Feasibility of Multistep Manufacturing Processes A. Arroyo, I. Eguia, A. Ziggiotti, J. Klarner, D. Massagé, A. Björkblad, J. Contreras	459
Wrinkle Control in Hydroforming Process of Curved Surface Shell of Aluminum Alloy Sheet W. Liu, Y. Chen, Y. Yu, S. Yuan	473

Sitzschienen geformt auf hydraulischen Tiefziehpressen





Hydraulische Tiefziehpressen eignen sich insbesondere für tiefe Teile, schwierige Formen und besondere Werkstoffe.

Mit der Baureihe TZP sowie zahlreichen Optionen und Automatisierungslösungen bietet LASCO maßgeschneiderte Pressen und Anlagen für die Blechumformung.



