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Combined Hardening Behavior for Sheet Metal and its Application

Nguyen Duc Toan



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*Combined Hardening Behavior for Sheet Metal
and its Application*

by

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About this Monograph

This book proposed modification hardening model to account for the expansion (isotropic) and translation (kinematic) of the yield loci in terms of the hardening model. The capability of the model is demonstrated by showing two characteristic effects of tension-compression and compression curves: crossing and Bauschinger effects.

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Table of Contents

Table of Contents	i
List of Figures.....	iii
List of Tables	v
Preface	vii
Chapter 1: Introduction	1
1.1 Motivation.....	1
1.2 Literature review	2
1.3 Goals of this book.....	4
Chapter 2: Continuum Mechanics Models and Development of VUMAT.....	5
2.1 Introduction.....	5
2.2 Constitutive Models	5
2.2.1 Basic Definitions and Assumptions	6
2.2.2 Isotropic Hardening	8
2.2.3 Kinematic Hardening	9
2.2.4 Combined Isotropic and Kinematic Hardening	11
2.3 Implementation of Combined Hardening Law and Development of VUMAT	12
2.3.1 Derivation of the Constitutive Equations Elasticity	13
2.3.2 Integration procedure.....	14
2.3.3 Verification of VUMAT subroutine	16
2.3.4 A Modification of Combined Non-linear Hardening	18
Chapter 3: Application of Proposed Hardening Model to Predict Fracture and Improve Press Formability of Door Hinge	21
3.1 Introduction.....	21
3.2 Finite element procedures	23
3.2.1 Materials.....	23
3.2.2 Ductile fracture criterion.....	23
3.2.3 Combination of finite element simulation and criteria for ductile fracture.....	24
3.3 Taguchi's Orthogonal Array	26

3.4	Results and Discussion	27
3.5	Conclusion.....	33
Chapter 4: Study of Incremental Sheet Forming for Complex Shape and its Improvement.		34
4.1	Introduction.....	34
4.2	Finite Element Simulation.....	38
4.2.1	Geometry and FE models	38
4.2.2	Materials.....	39
4.2.3	Boundary conditions, loading, and interactions.....	39
4.2.4	Ductile fracture criterion.....	39
4.3	Obtained CAE input file procedures	39
4.3.1	Tool path generation	39
4.3.2	CAE input file modifications	42
4.4	Taguchi's Orthogonal Array	43
4.5	Estimation of FLC in incremental SHEET forming.....	45
4.6	Results and Discussion	47
4.7	Conclusion.....	53
Chapter 5: Case Study for Magnesium Alloy Sheets to Predict Ductile Fracture of Rotational Incremental Forming.....		54
5.1	Introduction.....	54
5.2	Finite element procedures.....	55
5.2.1	Johnson–Cook model at elevated temperatures	57
5.2.2	Problem description, geometry and FE models for rotational incremental forming of magnesium alloy sheet.....	59
5.2.3	Ductile fracture criterion.....	61
5.3	Results and discussion	61
5.3.1	Effect of tool down-step	65
5.3.2	Effect of tool radius.....	66
5.4	Conclusion.....	67
Bibliography.....		68

List of Figures

Figure 2.1: Yield surface in deviatoric stress space.	6
Figure 2.2: Conversion of data from a uniaxial tension test to equivalent plastic strain versus von Mises stress.	8
Figure 2.3: Geometric interpretation of the consistency condition for kinematic hardening.	10
Figure 2.4: Effect of the hardening parameter β on uni-axial response.	11
Figure 2.5: ABAQUS and VUMAT subroutine.	13
Figure 2.6: Geometric interpretation of the incremental form of the consistency Condition for combined hardening.	15
Figure 2.7: Geometric interpretation of the radial returned correction.	16
Figure 2.8: Schematic of the novel tension/compression test [9]	17
Figure 2.9: The comparisons between the experiment result and FE simulation results of combined kinematic/isotropic hardening.	18
Figure 2.10: Uni-axial tension-compression (T-C) and compression-tension (C-T) simulation results of proposed model comparing with experiment data (a) and with various of pre-strain (b)	19
Figure 2.11: FE simulation results for three-point bending-unbending process.	20
Figure 3.1: Typical failure of a door hinge in critical area.	21
Figure 3.2: Deformed shape in finite element simulation, where maximum of integral value I was 1.343 in concerned area.	22
Figure 3.3: Finite element model for test simulation.	24
Figure 3.4: The general updating flow-chart of subroutine.	25
Figure 3.5: Definition of factors in concerned area.	26
Figure 3.6: Deformed shapes of product failure in finite element simulation based on (a) isotropic hardening, (b) kinematic hardening, and (c) combined isotropic/kinematic hardening law.	28
Figure 3.7: Evolutional stress state in concerned area.	28
Figure 3.8: Estimation of scalar parameter (β).	29
Figure 3.9: Deformed shape in finite element simulation of optimum case, where integral value I was 0.725 in concerned area.	32
Figure 3.10: Case No. 8: $R=20\text{mm}$, $a=20^\circ$, $b=90^\circ$, $r=5\text{mm}$, $I=0.748$. No crack occurred in concerned area.	32
Figure 4.1: Deformed shapes in experiment of failure test sample.	36
Figure 4.2: The FE simulations for a failure test sample.	37
Figure 4.3: Finite element model for simulation.	38
Figure 4.4: The method to obtain CL data and simulation process.	40
Figure 4.5: Verification of the intersection points.	40
Figure 4.6: Calculation of cutter location (CL) points.	41
Figure 4.7: Tool path strategy.	42
Figure 4.8: Definition of the difference of major strain ($\Delta\varepsilon$).	43
Figure 4.9: Definition of considering parameters.	44
Figure 4.10: Obtainment of FLC in incremental forming.	46
Figure 4.11: Estimation of scalar parameter (β).	47
Figure 4.12: The evolution of deformed shape in FEM for optimum case of $A_3B_3C_3$ (i) and simulation result of I value (ii).	50
Figure 4.13: Experimental result for optimum case of $A_3B_3C_3D_1$ ($R=4\text{mm}$, $H=0.7\text{mm}$, and $\mu=\mu_1=\mu_2=0.1$).	51
Figure 4.14: Comparisons between section view of evolutional stages of FEM simulation and design section at tool stroke of $h = 8.5\text{mm}$, $h = 17\text{mm}$, and $h = 22\text{mm}$	52
Figure 4.15: Comparison of shape distribution between FE simulation and experiment results.	52
Figure 5.1: Stress-strain curves obtained from in-plane uniaxial compression tests at room temperature (Ref. [97]).	56

Figure 5.2: Yield loci obtained from biaxial tensile tests and in-plane uniaxial compression tests (Ref. [97])	56
Figure 5.3: The stress-strain curves with measured values [97]	58
Figure 5.4: The stress-strain curves calculated using FE simulation and compared with the measured values	58
Figure 5.5: The square cups formed by rotational incremental sheet forming of (a) 45° wall angle, (b) 60° wall angle, and (c) 70° wall angle at which the crack was occurred (Ref. [19])	59
Figure 5.6: Forming limit for rotational incremental forming	60
Figure 5.7: Finite element model for incremental forming simulation	60
Figure 5.8: Heat generation in the contact areas between the specimen and the tool	61
Figure 5.9: Evolution of equivalent stress-strain curve in incremental forming in case of (a) without considering Johnson-Cook model and (b) considering Johnson-Cook model	62
Figure 5.10: Deformed shape in finite element simulation in case of (a) 45° wall angle, (b) 60° wall angle, and (c) 70° wall angle	63
Figure 5.11: FLCF obtainment from FE simulation at the corner and wall area for the case of 70° wall angle.	64
Figure 5.12: Deformed shape in FE simulation in case of 70° wall angle, tool radius of 6 mm, and (a) tool down-step of 0.8 mm; (b) tool down-step of 1.2 mm	65
Figure 5.13: FLCF with different tool down-step and 6 mm tool radius	65
Figure 5.14: Deformed shape in FE simulation in case of 70° wall angle, tool down-step of 0.8 mm, and (a) tool radius of 4 mm; (b) tool radius of 8 mm	66
Figure 5.15: FLCF with different tool radius and 0.4 mm tool down-step	66

List of Tables

Table 2.1: <i>Mechanical properties of tested material (Magnesium alloy sheet)</i>	17
Table 3.1: <i>Mechanical properties of tested material (SAPH-440)</i>	23
Table 3.2: <i>Factors and their levels in FEM simulation</i>	26
Table 3.3: <i>Taguchi's L₉ orthogonal array for simulations</i>	27
Table 3.4: <i>L₉ orthogonal array and calculated observed values</i>	30
Table 3.5: <i>ANOM and ANOVA Table of effect on ductile fracture value (I)</i>	31
Table 4.1: <i>Mechanical properties of tested material (Cold Rolled Steel)</i>	39
Table 4.2: <i>Factors and their levels in FEM simulation</i>	45
Table 4.3: <i>Taguchi's L₉ orthogonal array for simulations</i>	45
Table 4.4: <i>L₉ orthogonal array and calculated observed values</i>	48
Table 4.5: <i>ANOM and ANOVA Table for effect of difference in major strain($\Delta\varepsilon$)</i>	48
Table 4.6: <i>ANOM and ANOVA Table of effect on ductile fracture value (I)</i>	49
Table 5.1: <i>Maximum temperature of the tool and specimen for each square cup (Ref. [97])</i>	55
Table 5.2: <i>Thermo-physical properties of magnesium alloy AZ31 as function of temperature T (in °C) (Ref. [99])</i>	59

Preface

Modeling the material behavior accurately in tension-compression and compression-tension load is essential to sheet metal forming simulation, failure and springback prediction, especially when the material points experience cyclic loadings. The combined linear hardening model proposed previously is modified to model the transient behavior more realistically by describing the scalar parameter β as a function of equivalent strain when compressive and reversed stress occurred.

This book proposed modification hardening model to account for the expansion (isotropic) and translation (kinematic) of the yield loci in terms of the hardening model. The capability of the model is demonstrated by showing two characteristic effects of tension-compression and compression curves: crossing and Bauschinger effects. Only modification of the scalar parameter β is added to describe the evolution of cyclic curves, which can be identified from tensile-compression tests and curve fittings. The proposed model is applied to sheet metal forming, fracture and springback predictions at room and elevated temperature. Tension-compression tests are firstly simulated and compared with available experimental data in order to fit and make the functions of scalar parameter β . The corrected data are then applied for complicated forming process e. g. predict the fracture and improve the press formability of door hinge, the incremental sheet metal forming for complicate shape, and rotational incremental sheet forming for magnesium alloy sheets.

In order to predict the ductile fracture, a modification of combined kinematic and isotropic hardening law is implemented and evaluated from the histories of ductile fracture value (I) by means of finite element analysis. Here, the criterion for a ductile fracture, as developed by OYANE, (*Journal of Mechanical Work. Technology*, 4 (1980), pp. 65–81), is carried out via a user material, using finite element code. To improve press formability and secure a safe product without any failure, the finite element method (FEM) simulations are coupled with Taguchi's orthogonal array experiment.

To improve press formability of a door hinge, three design variables – the die corner radius, declination of the bead punch, and peak angle of the bead punch – are selected to be improved. The numeric simulations reveal that the die corner radius is the most important variable, and its modification is most effective in improving the press formability for a door hinge. The simulation results are confirmed with experimental ones.

To simulate incremental sheet forming process for the product of complex shape (e.g. human face), a combination of both computer-aided manufacturing (CAM) and finite-element modelling (FEM) simulation, is utilized. Here, the results, using ABAQUS/Explicit finite-

element code, are compared with forming limit curve at fracture in order to predict and improve the forming conditions by changing process variables of tool radius, tool down-step, and friction coefficient. First, the CAM simulation is used to create cutter location data. This data are then calculated, modified, and exported to the input file format required by ABAQUS through using MATLAB programming. The FEM results are implemented for negative incremental sheet forming and then investigated by experiment

To simulate the effect of the large amount of heat generation at elements in the contact area due to friction energy of the rotational tool-specimen interface on equivalent stress-strain evolution in incremental forming, Johnson-Cook model was applied and also compared with equivalent stress-strain curves obtained by tensile test at elevated temperatures. The (FE) simulation results of ductile fracture was then compared with the experimental results of 80 mm × 80 mm × 25 mm square shape with 45 °, 60 °, and 80 mm × 80 mm × 20 mm square shape with 70 ° wall angles. The trend of (FE) simulation results were quite good agreement with experiment results. Finally, the effect of process parameters e. g tool down-step and tool radius on the ductile fracture value and forming limit curve at fracture (FLCF) were investigated using (FE) simulation results.

Dr. Nguyen Duc Toan