

# قالب های برش گام به گام طراحی و ساخت

فصل سوم: نوار تغذیه

ویرایش اول

زمستان ۹۳

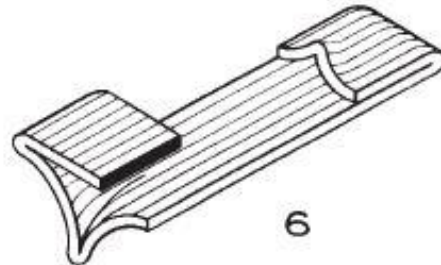
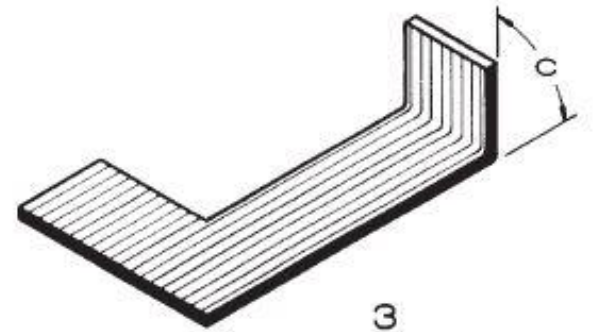
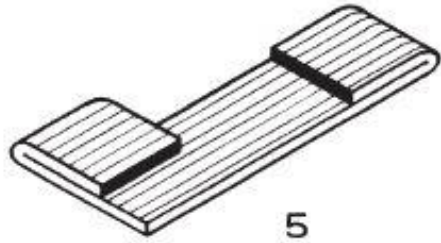
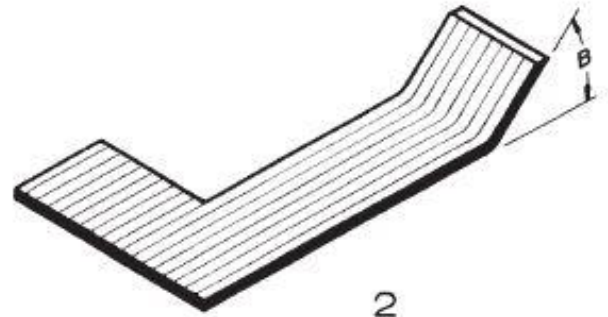
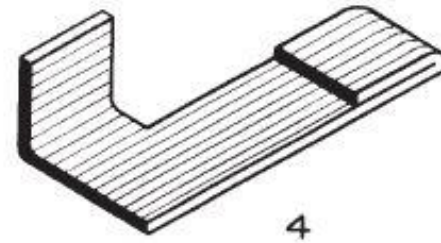


Figure 3.1 Various tempers of cold-rolled steel from hard (1) to dead soft (6) and kinds of deformation possible with each.

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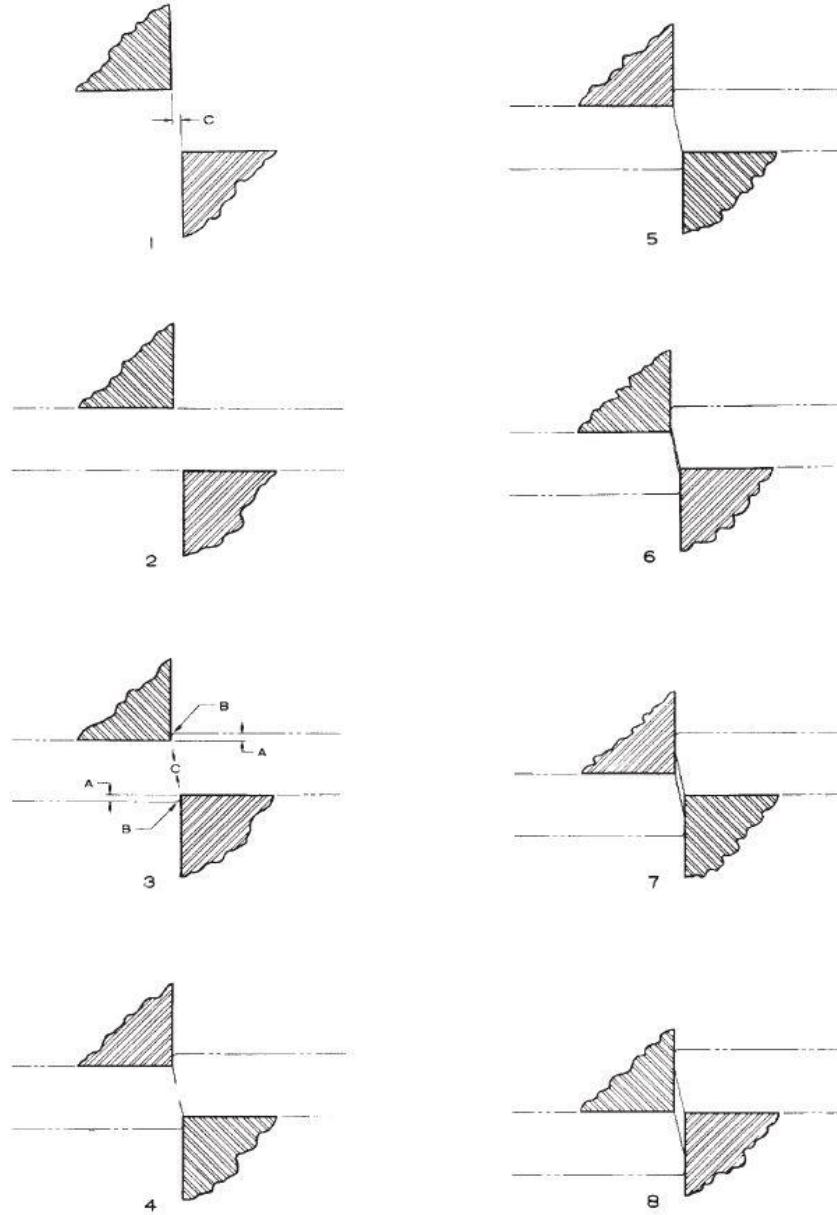


Figure 3.2 Mechanics of shear-enlarged views of clearance between cutting edges of a shearing die (step 1) and material undergoing shear (steps 2 to 8).

one (1 part) die enlarged a of edges cutting new clearance views enlarged to right & left (8 of 2 parts) material undergoing shear (steps 2 to 8)

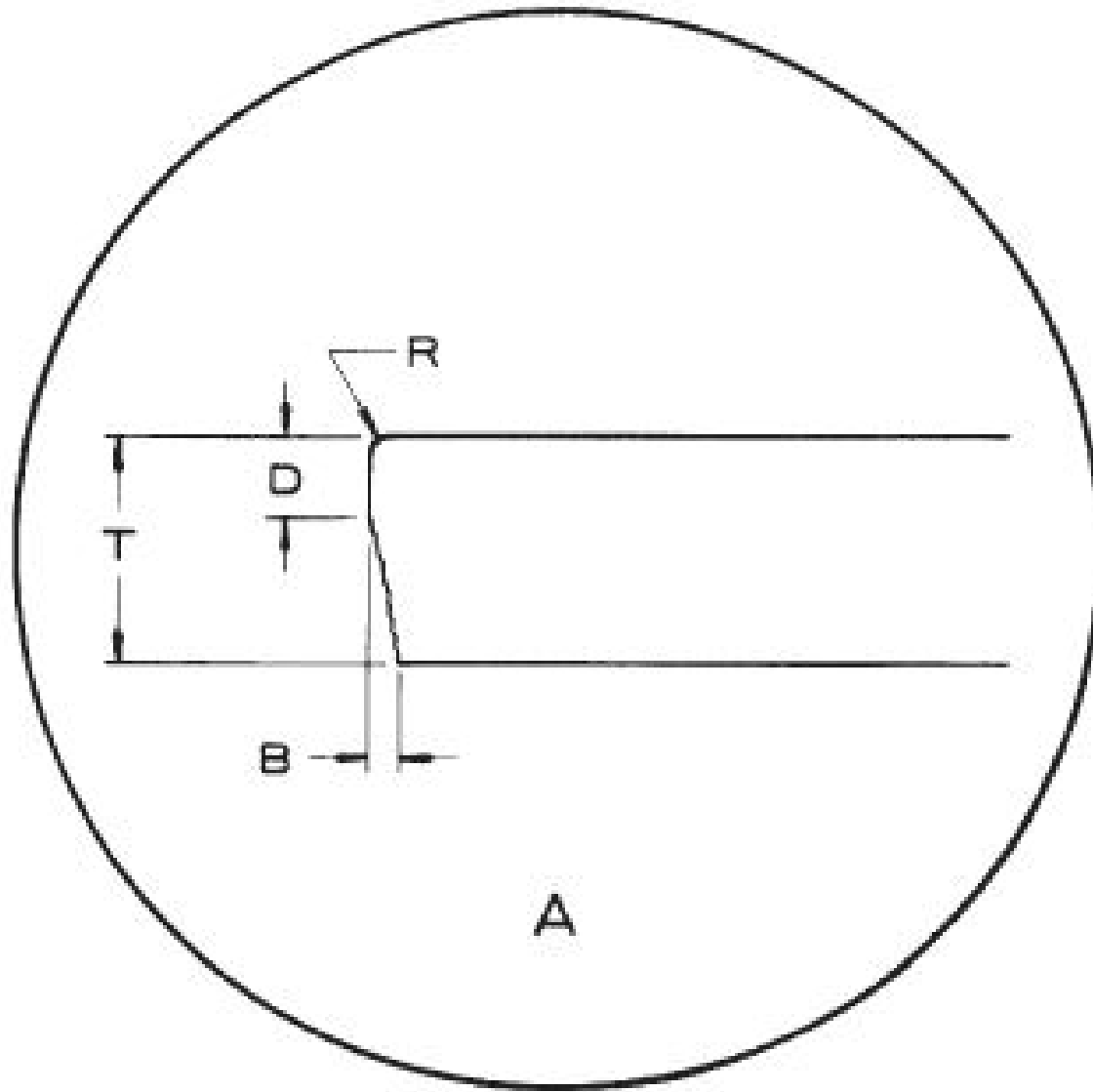


Figure 3.3 Enlarged view of sheared blank edge.

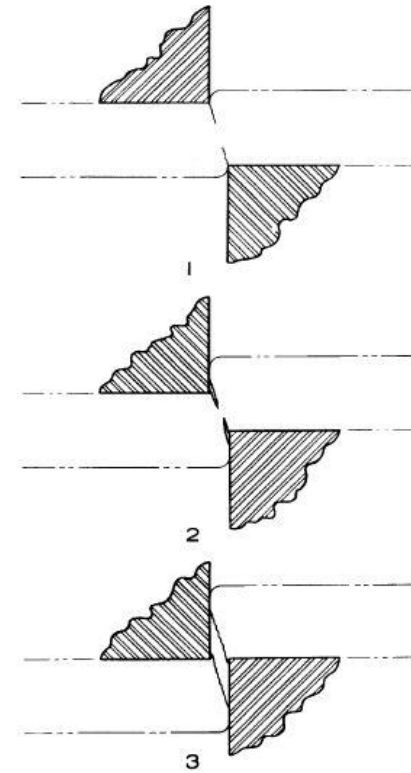
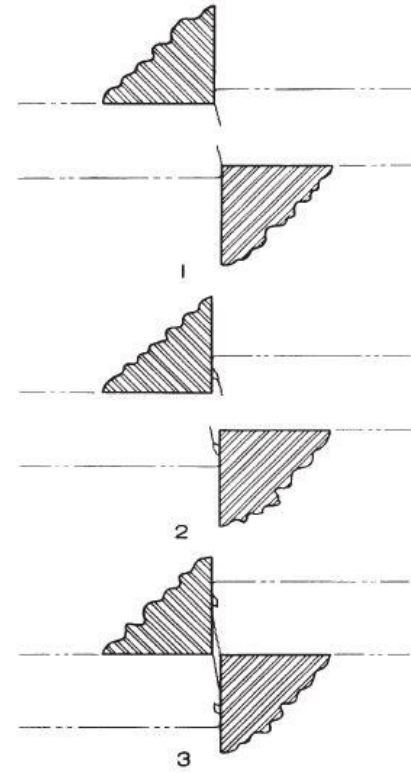
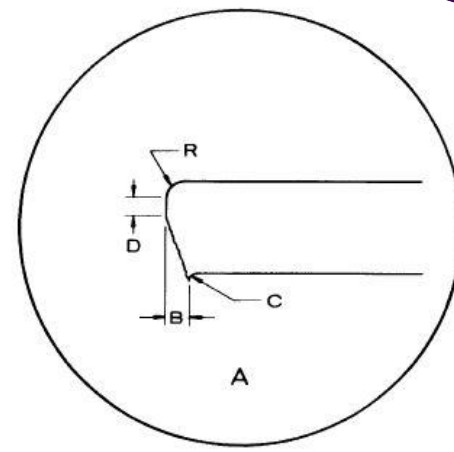
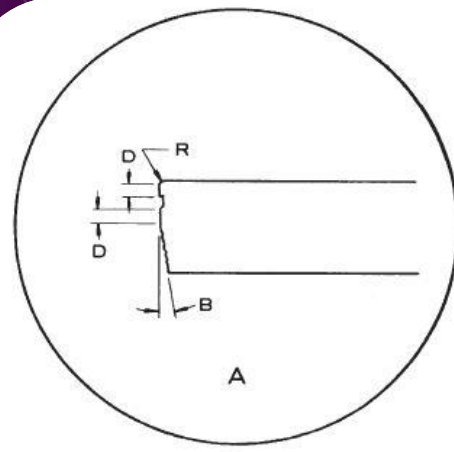


Figure 3.4 Enlarged views of blank edge sheared: a) with insufficient clearance A and material undergoing shear with insufficient clearance (1 to 3); and b) with excessive clearance A and material undergoing shear with excessive clearance (1 to 3).

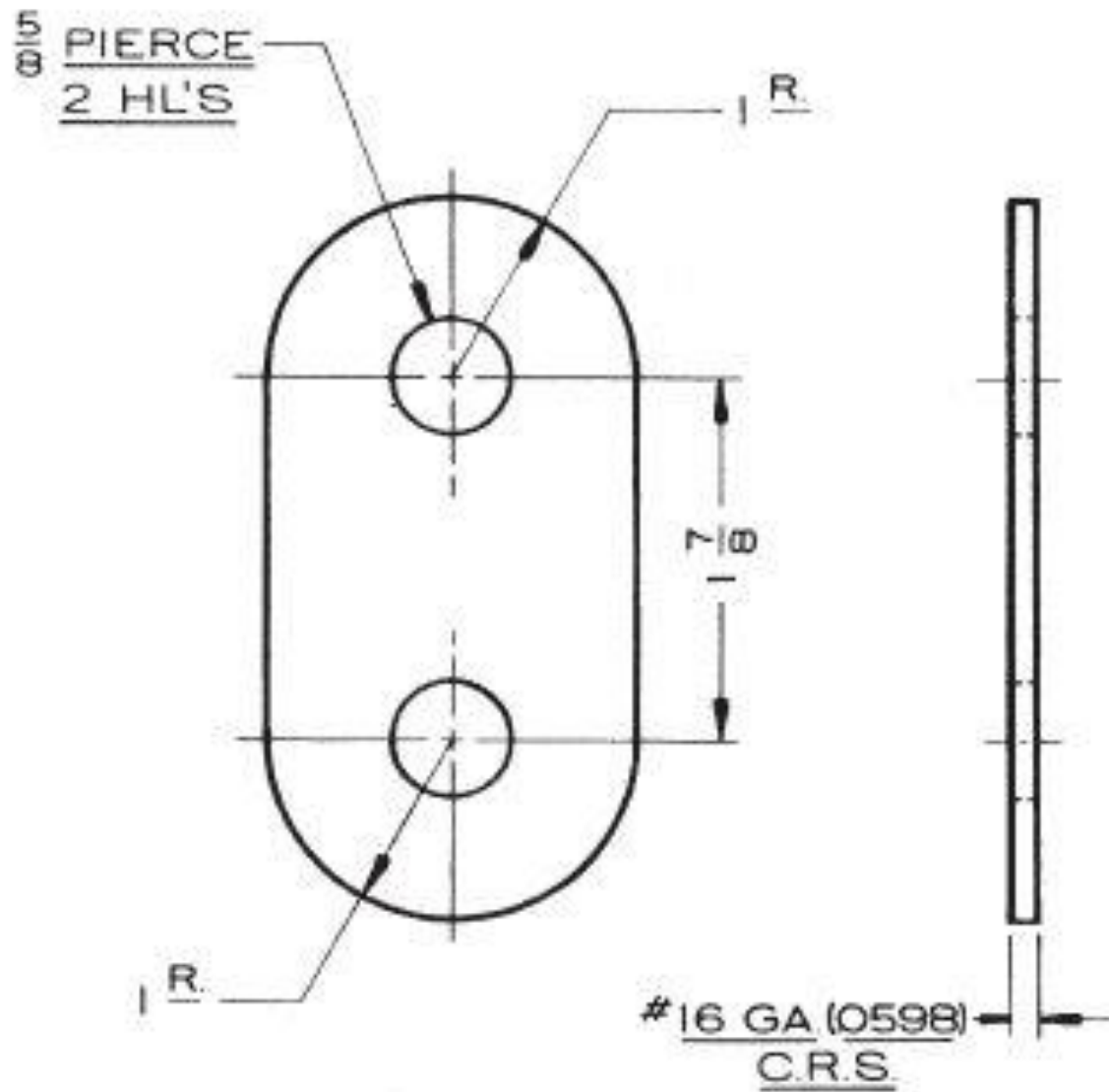


Figure 3.5 Typical part drawing.

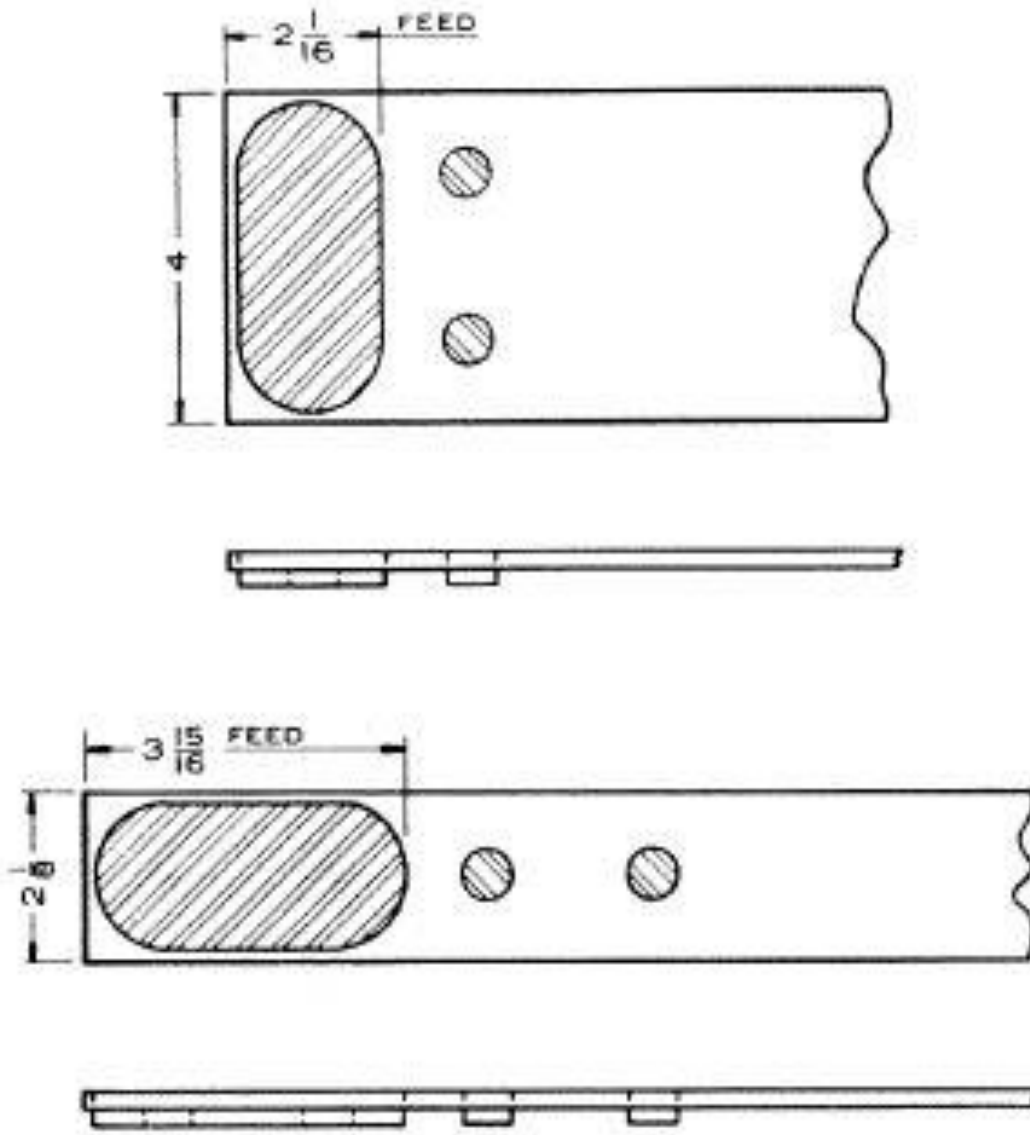


Figure 3.6 Blank layouts necessitating either wide or narrow strips.

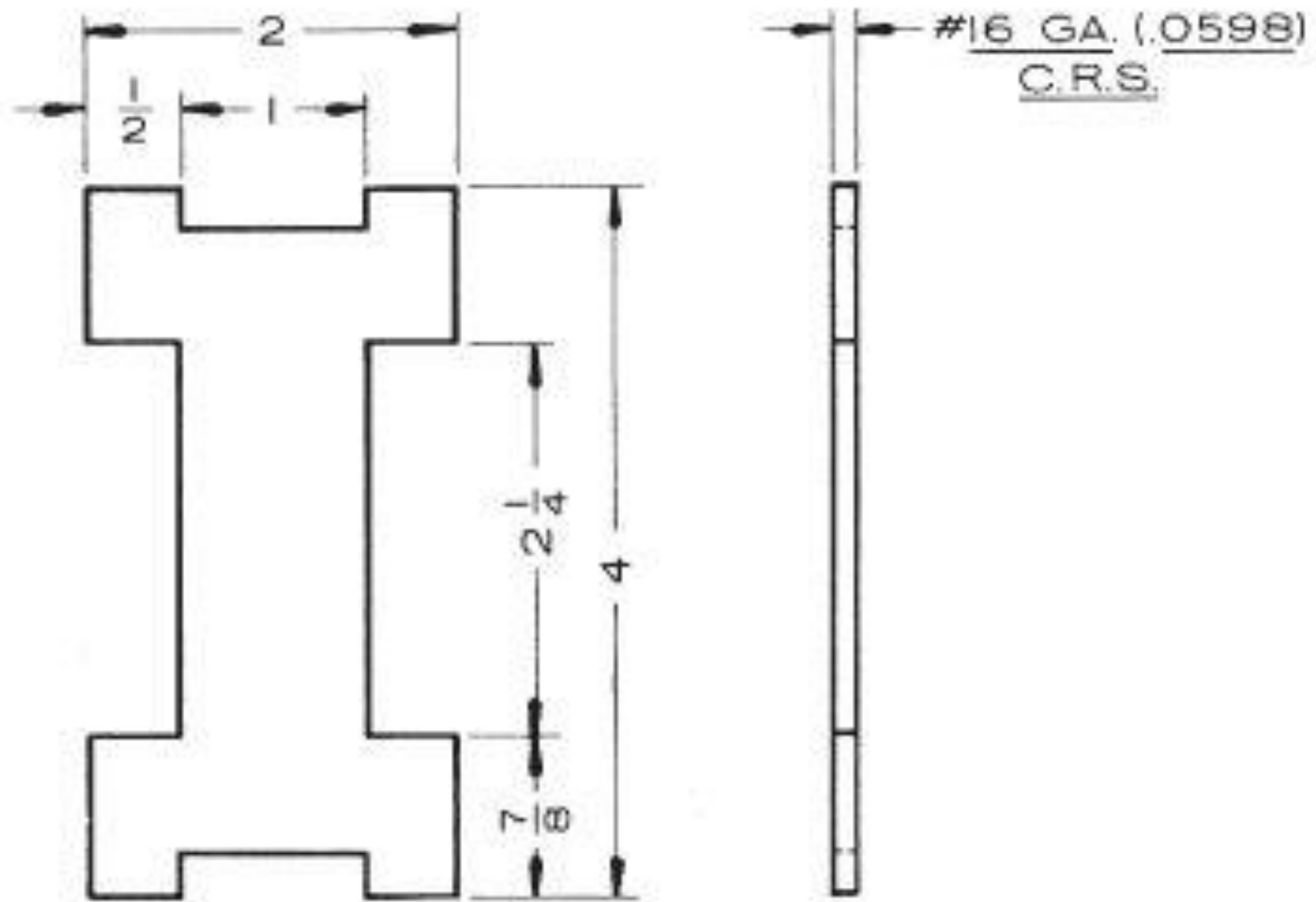


Figure 3.7 Typical part for production in cut-off die.



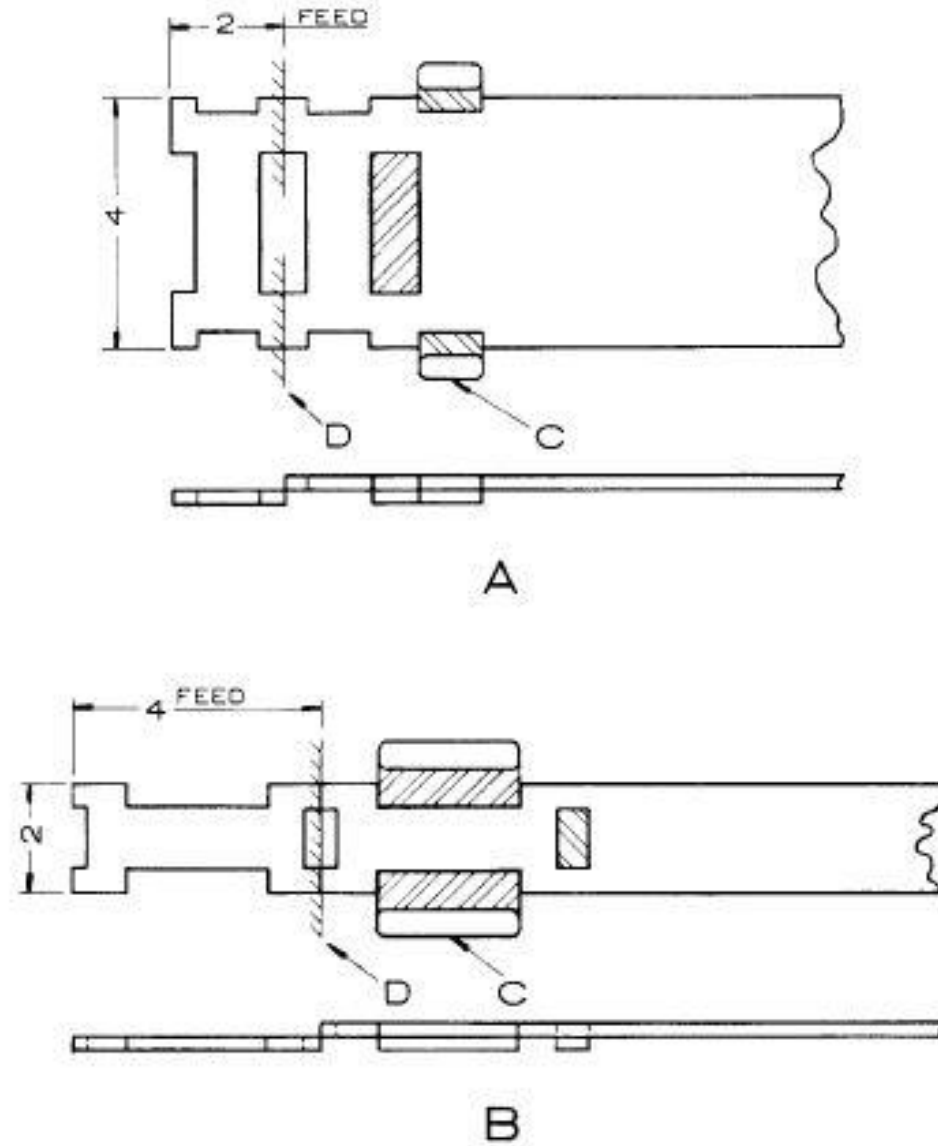


Figure 3.8 Blank layout for part shown in Figure 3.7 run, either the wide (A) or narrow (B) way.

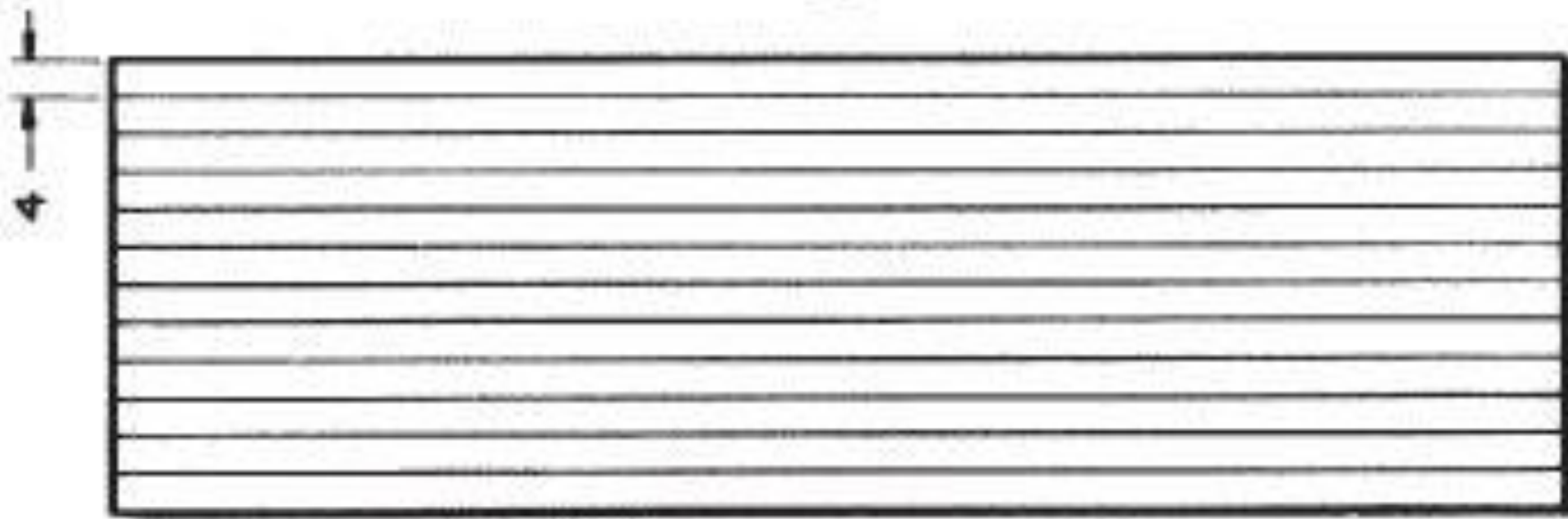
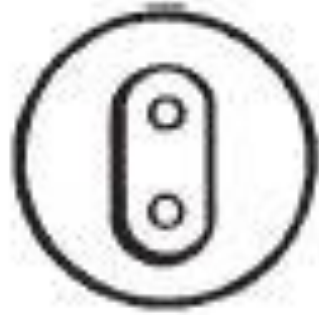


Figure 3.9 Number of strips obtainable with wide strip blank layout.

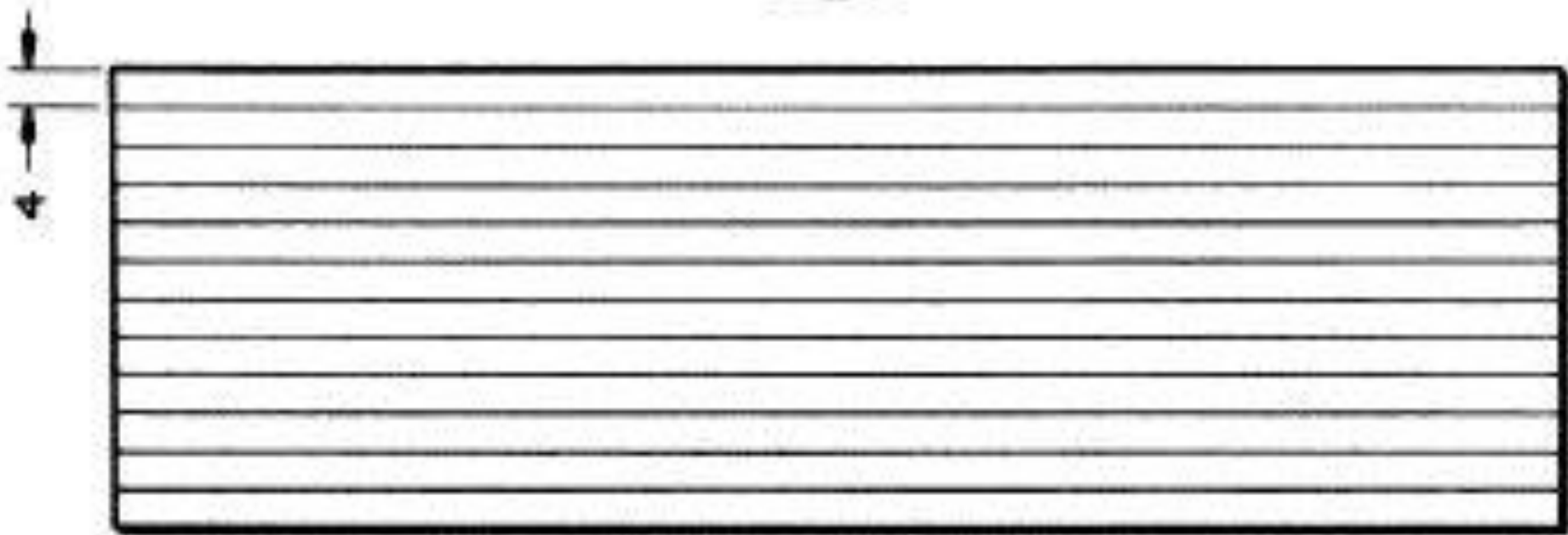


Figure 3.10 Strips per sheet with wide strip blank layout for production in a cut-off die.

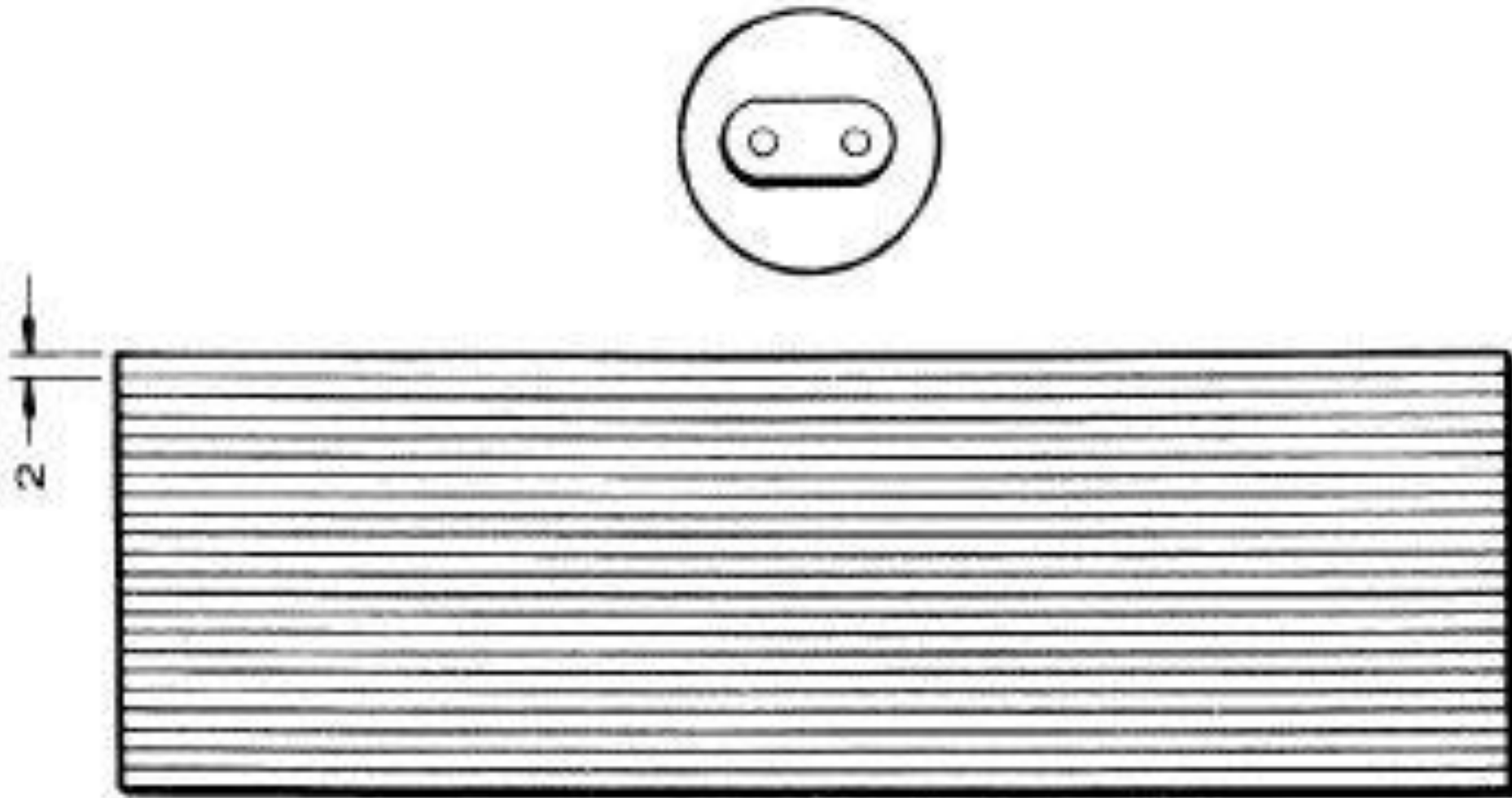


Figure 3.11 Number of strips obtainable with narrow strip blank layout.

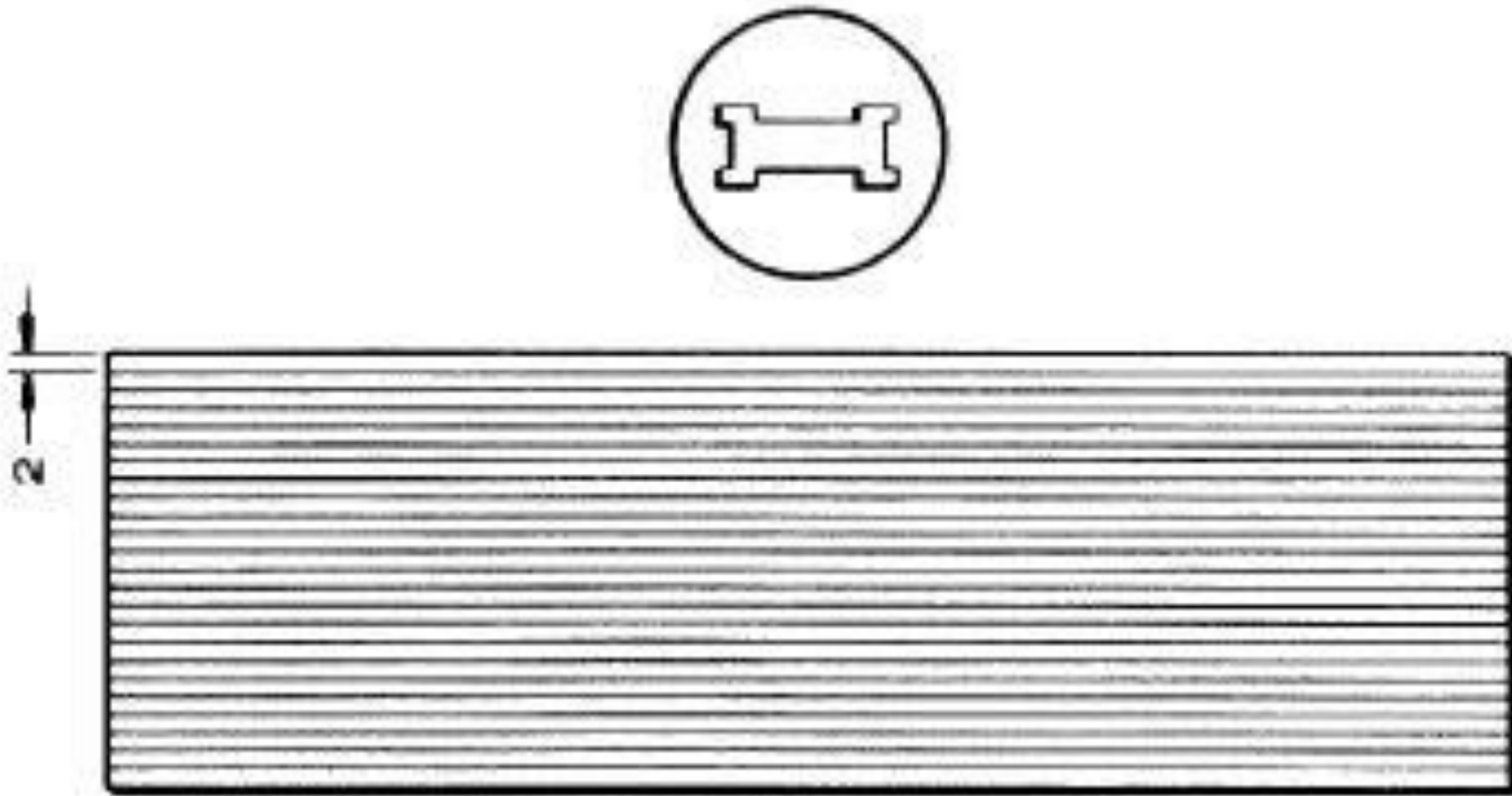


Figure 3.12 Strips per sheet with narrow strip blank layout for production in a cut-off die.

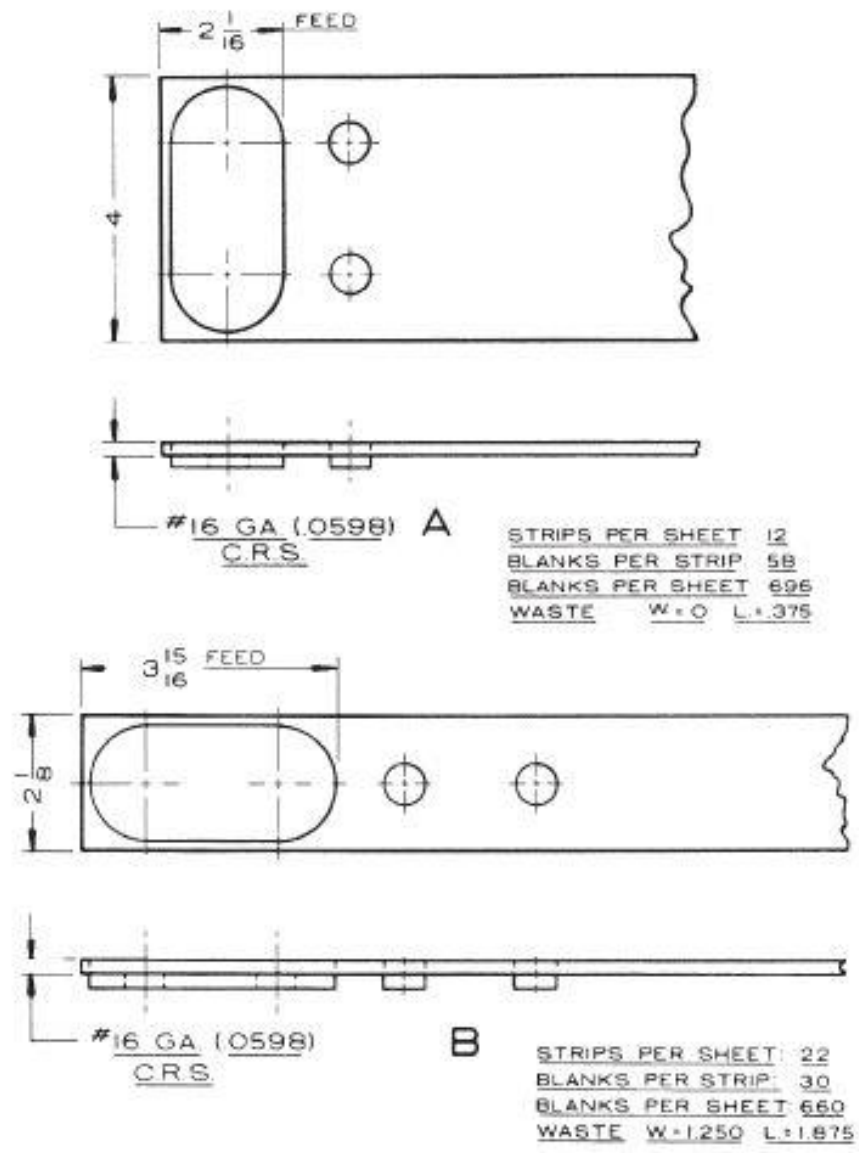


Figure 3.13 Complete strip layouts for blanks run either the wide (A) or narrow (B) way.

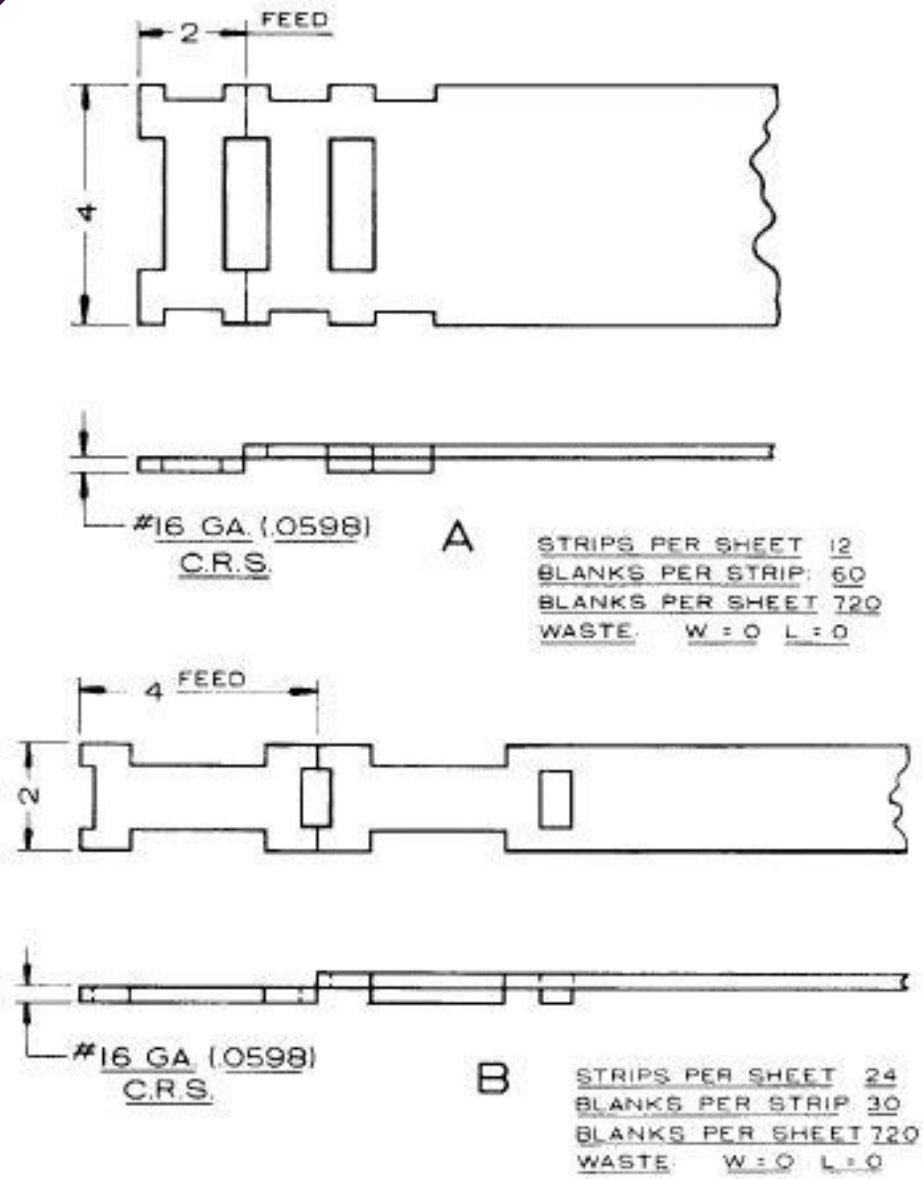


Figure 3.14 Strip layouts for blanks run either the wide (A) or narrow (B) way.

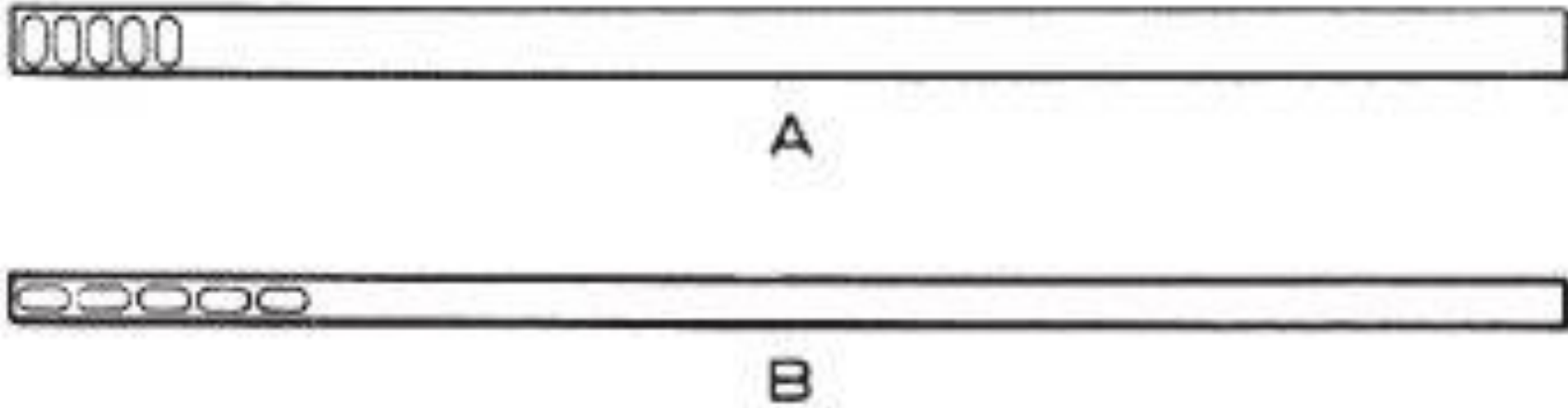


Figure 3.15 Strips ready for feeding either the wide (A) or narrow (B) way.

(A) or narrow (B) way.

Figure 3.15 Strips ready for feeding either the wide





A

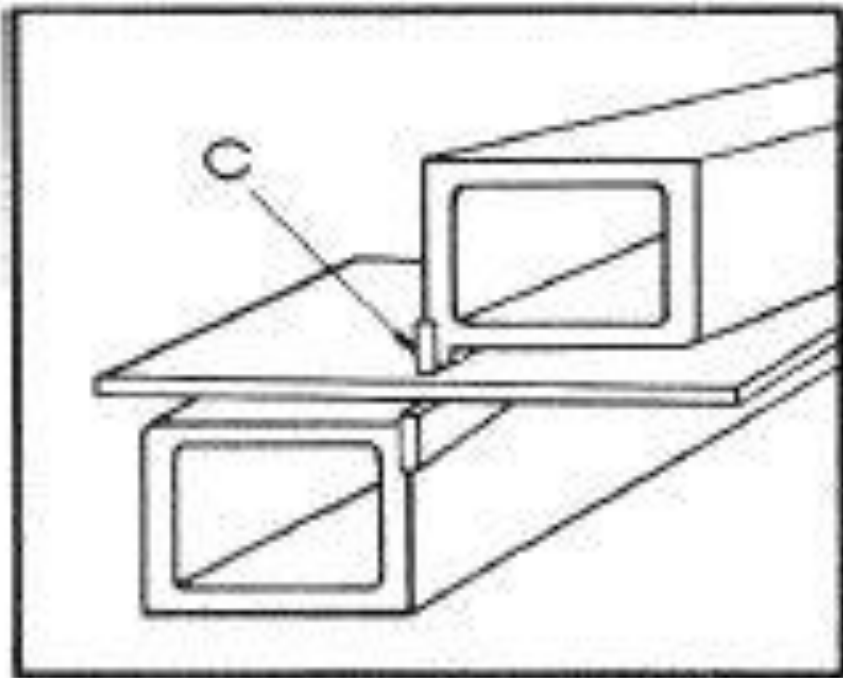


B

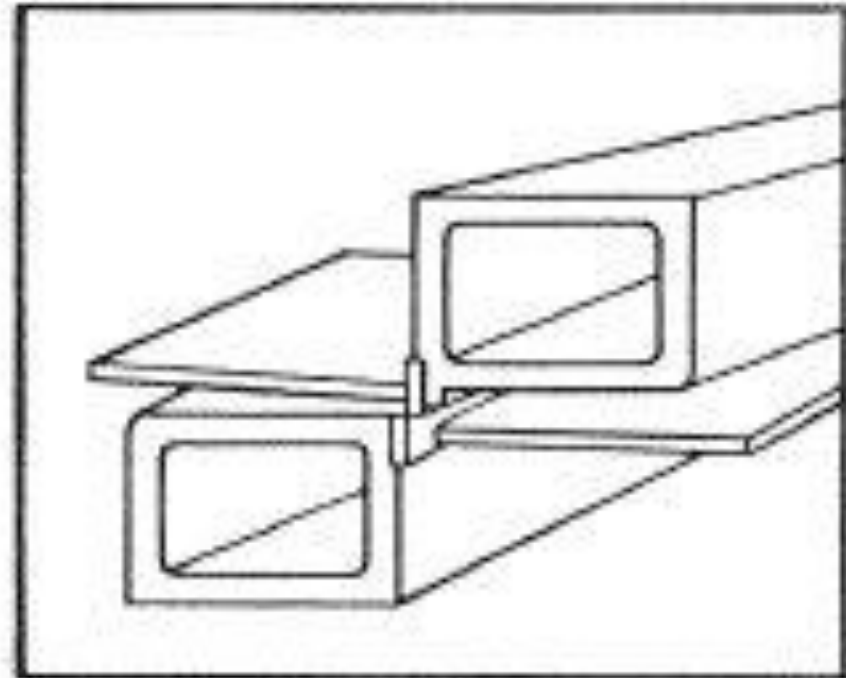
Figure 3.16 Strips ready for feeding either the wide (A) or narrow (B) way in a cut-off die.

(A) or narrow (B) way in a cut-off die.

Figure 3.16 Strips ready for feeding either the wide



A



B

Figure 3.17 Producing metal strips from sheet by shearing.

shearing.

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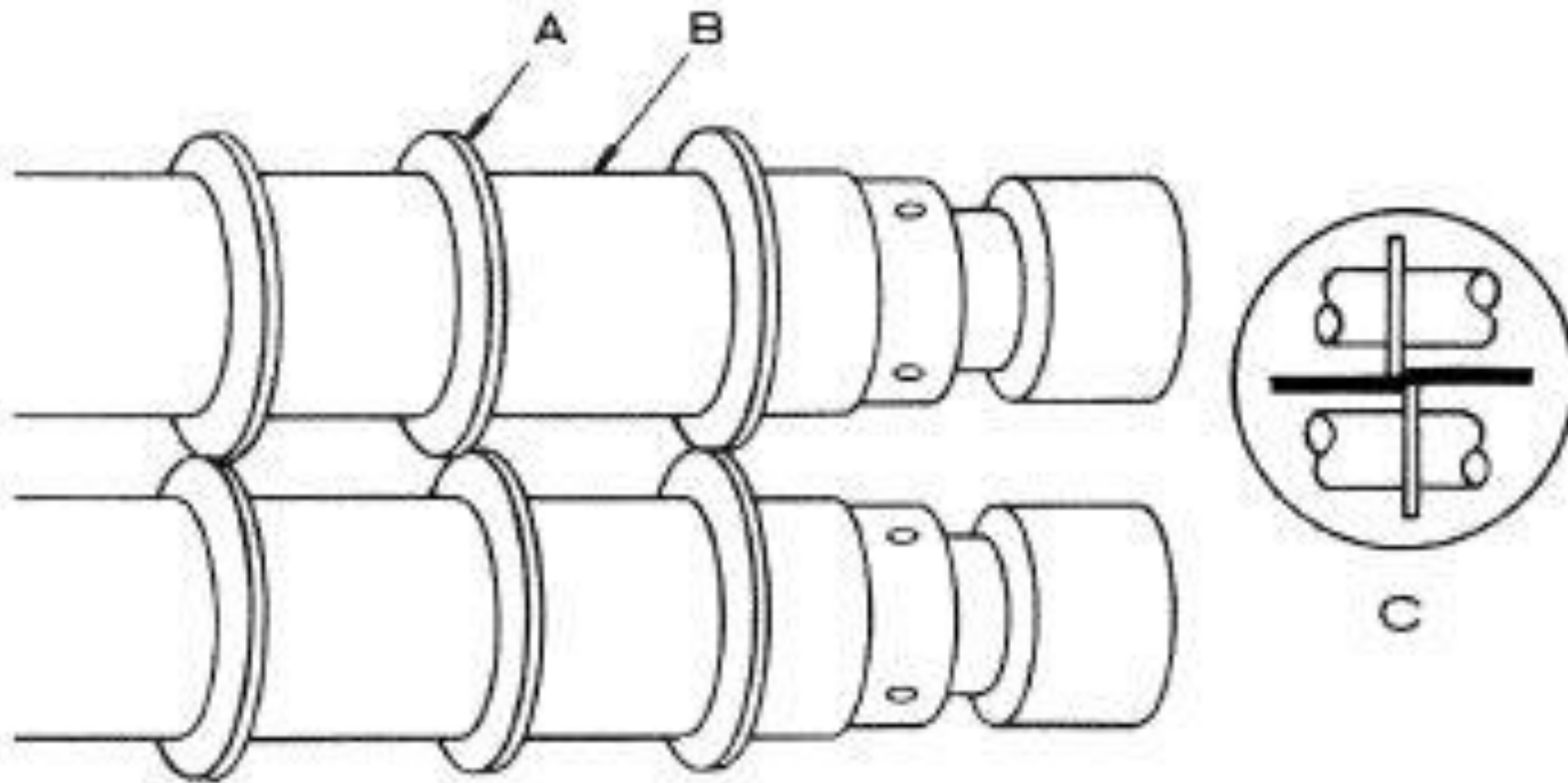
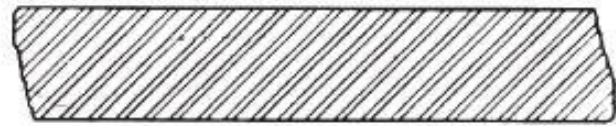


Figure 3.18 Cutting rolls for slitting strips from sheet.

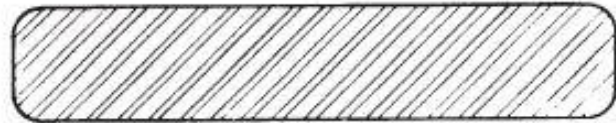
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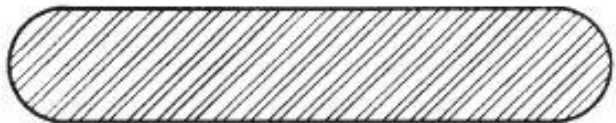
1



2



3



4



5

Figure 3.19 The various edge contours shown are the result of different production processes.

پایان فصل سوم

با سپاس از توجه شما...