

1. PLIAGE

1.1 Principe

Sous l'action d'une force appliquée sur un flan (ou sur une ébauche) reposant sur deux ou plusieurs appuis (fig. 1) ou encastré à une extrémité (fig. 2), le produit est fléchi. Lorsque l'effort cesse, si le fléchissement a été suffisant, le flan ne reprend pas sa forme initiale, mais une forme intermédiaire qui est d'autant plus éloignée de celle obtenue par le fléchissement maximum que l'élasticité du métal est grande. Ce retour élastique, couramment appelé « ressaut », est constaté dans les opérations montrées par les figures 1 et 2.

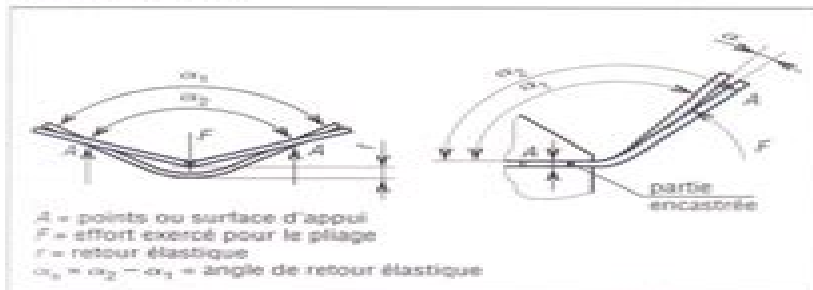


Fig. 1. Exemple de retour élastique de produit plié.

Si le pliage est effectué dans un vè (fig. 2) suivant la position du poinçon en fin de course, différents angles intermédiaires peuvent être obtenus avec le même outillage, l'angle terminal étant celui du vè augmenté du retour élastique. Si, en fin de pliage à fond de vè le poinçon continue sa course, il provoque une forgeage local par un léger encastrement de son extrémité dans l'épaisseur (fig. 3). Le métal, déplacé équilibre, par déformation plastique, les contraintes des zones comprimées avec celles qui sont tendues (fig. 4), le retour élastique est quasiment supprimé. C'est l'opération de pliage avec frappe (fig. 3).

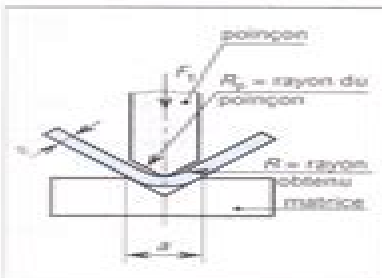


Fig. 2. Pliage en l'air à fond de vè.

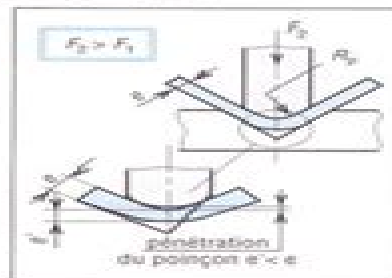


Fig. 3. Pliage (avec frappe).

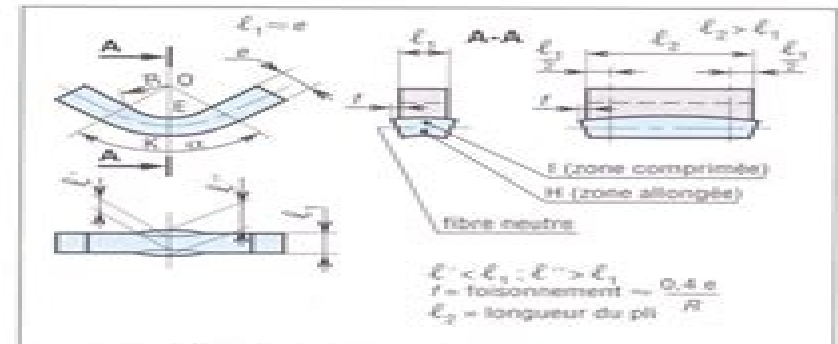


Fig. 4. Résultats obtenus.

1.2 Analyse de la déformation

Sous l'action du poinçon, le métal compris dans la section I est soumis aux forces de compression et de traction pour H, leur intensité s'annule sur la fibre neutre et leur valeur maximum est atteinte en E et K. Le maintien de l'équilibre des sections (l'une qui augmente, l'autre qui diminue) provoque un déplacement de la fibre neutre vers le rayon intérieur.

— Approximativement, la fibre neutre est située à :

- $e/2$ si $R/e \geq 3$;
- $2e/5$ si $R/e = 2$;
- $e/3$ si $R/e = 1$.

À partir de cette remarque et toujours avec approximation, il est possible de définir :

- l'allongement supporté par les fibres les plus tendues ;
- le développement du flan théorique.

1.2.1 Allongement de la fibre extérieure.

Il est défini par la relation.

$$A \% = \frac{(R + e) \alpha - (R + e/2) \alpha}{(R + e/2) \alpha} \times 100 \quad \text{si } R \geq 3e$$

Exemple : A % = 14 % acceptable pour un acier doux mais insuffisant pour un acier dur.

Nota : l'influence de la relation entre R et e oblige, pour éviter les criques sur métaux fragiles (fig. 6), à plier dans le sens perpendiculaire au sens de laminage, ou à établir un compromis (fig. 6) (voir également tableau du tome 1 pour les rayons recommandés suivant les métaux).

1.2.2 Développement du flan (fig. 5)

Si R₁ et R₂ sont les rayons de la fibre neutre

$$L_1 = l_1 + \frac{2 \pi R_1 \alpha_1}{360} + l_2 + \frac{2 \pi R_2 \alpha_2}{360} + l_3 \quad (\alpha \text{ en degrés})$$

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