

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.

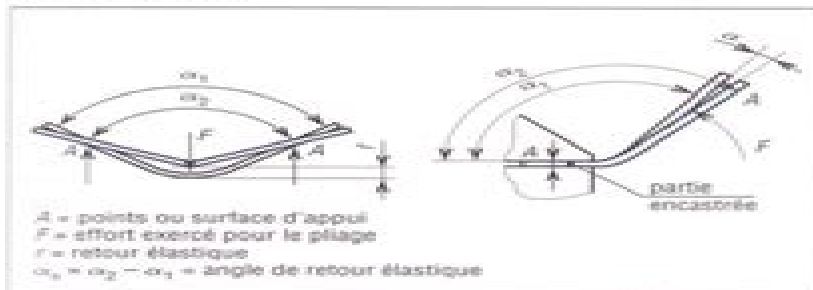


Fig. 1. Exemple de retour élastique de produit plié.

Si le pliage est effectué dans un vê (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 vê augmenté du retour élastique. Si, en fin de pliage à fond de vê 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).

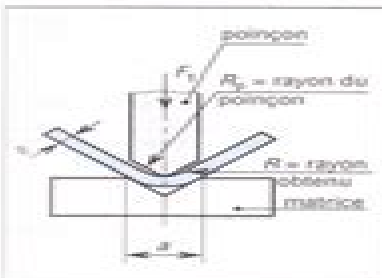


Fig. 2. Pliage en l'air à fond de vê.

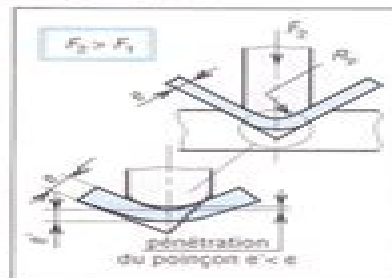


Fig. 3. Pliage (avec frappe).

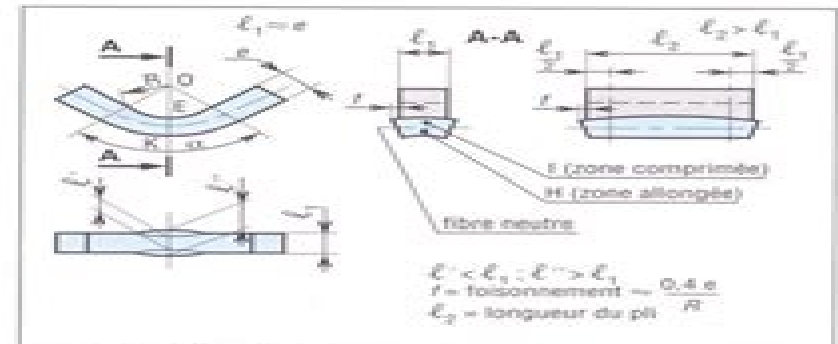


Fig. 4. Résultats obtenus.

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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Table of Contents Precis De Mecanique 3ed

1. Understanding the eBook Precis De Mecanique 3ed
 - The Rise of Digital Reading Precis De Mecanique 3ed
 - Advantages of eBooks Over Traditional Books
2. Identifying Precis De Mecanique 3ed
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Precis De Mecanique 3ed
 - User-Friendly Interface
4. Exploring eBook Recommendations from Precis De Mecanique 3ed
 - Personalized Recommendations

- Precis De Mecanique 3ed User Reviews and Ratings
- Precis De Mecanique 3ed and Bestseller Lists
- 5. Accessing Precis De Mecanique 3ed Free and Paid eBooks
 - Precis De Mecanique 3ed Public Domain eBooks
 - Precis De Mecanique 3ed eBook Subscription Services
 - Precis De Mecanique 3ed Budget-Friendly Options
- 6. Navigating Precis De Mecanique 3ed eBook Formats
 - ePub, PDF, MOBI, and More
 - Precis De Mecanique 3ed Compatibility with Devices
 - Precis De Mecanique 3ed Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Precis De Mecanique 3ed
 - Highlighting and Note-Taking Precis De Mecanique 3ed
 - Interactive Elements Precis De Mecanique 3ed
- 8. Staying Engaged with Precis De Mecanique 3ed
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Precis De Mecanique 3ed
- 9. Balancing eBooks and Physical Books Precis De Mecanique 3ed
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Precis De Mecanique 3ed
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Precis De Mecanique 3ed
 - Setting Reading Goals Precis De Mecanique 3ed
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Precis De Mecanique 3ed
 - Fact-Checking eBook Content of Precis De Mecanique 3ed

- Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
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