

# Sheet Metal Fabrication

The complete design guide

## Press brake forming

Press brake forming is the process where metal is bent or folded when a die and a punch are used to bend the sheet of metal.

This is most often used to form parts from ferrous alloy steel great for both prototyping and production runs.

The maximum sheet thickness is usually less than 8 times the



### Bending



Bending is a good method which gives desired shape for the design require.

Bending is performed available in 2 forms.



Parting the bend radius.

## Forming near holes

When a bend is made too close to a hole the hole may become deformed. To save the cost of punching or drilling in a secondary operation, the following formulae can be used to calculate the minimum distance required.

As a rule of thumb, the distance from the outside of the material to the bottom of the cutout should be equal to the minimum flange length as prescribed by the air bend force chart.

For a hole  $\leq 1"$  diameter the minimum distance  $(D) = 2T + R$

For a slot or hole  $> 1"$  diameter the minimum distance  $(D) = 2.5T + R$

When using a punch press, or laser cutting, holes should never be less than that of the material thickness.



The minimum distance to adjacent features for bend radius

Feature Type	Minimum distance guideline
Minimum hole and slot	≥ 2 times the material thickness + bend radius
Minimum slot and hole	≥ 2 times the material thickness + bend radius
Minimum hole to slot and edge	≥ 2 times the material thickness
Minimum adjacent cutout hole	≥ 2 times the material thickness
Minimum to adjacent hole and an edge	≥ 2 times the material thickness
Minimum to adjacent hole and hole	≥ 2 times the material thickness + bend radius
Minimum corner adjacent hole and corner	≥ 2 times the material thickness + bend radius
Minimum corner adjacent hole	≥ 2 times the material thickness

# Sheet Metal Design Handbook Quality Tool

**McMaster-Carr Supply Company**



## **Sheet Metal Design Handbook Quality Tool:**

*Tool and Manufacturing Engineers Handbook: Design for Manufacturability* Thomas J. Drozda, Charles Wick, Philip Mitchell, Ramon Bakerjian, John T. Benedict, Raymond F. Veilleux, 1983 Addresses important topics of DFM including how it relates to concurrent engineering management issues getting started in DFM how to justify using DFM applying quality tools and how DFM is affecting computer technology and vice versa Covers topics starting with the creative thinking process to combining DFM with geometric dimensioning and tolerancing Also includes product design information that designers should know when committing pen to paper or mouse to mat

**Tool and Manufacturing Engineers Handbook: Quality Control and Assembly** Thomas J. Drozda, Charles Wick, Raymond F. Veilleux, 1983 Quality Control and Assembly helps you meet today's competitive pressures for measuring quality making continuous quality improvements streamlining assembly and making the transition to automated assembly systems and applications

**Tool and Manufacturing Engineers Handbook Desk Edition** W. H. Clobberly, Ramon Bakerjian, 1989 The TMEH Desk Edition presents a unique collection of manufacturing information in one convenient source Contains selected information from TMEH Volumes 1-5 over 1,200 pages of manufacturing information A total of 50 chapters cover topics such as machining forming materials finishing coating quality control assembly and management Intended for daily use by engineers managers consultants and technicians novice engineers or students

Sheet Metal Forming Processes and Die Design Vukota Boljanovic, 2004 This book is a complete modern guide to sheet metal forming processes and die design still the most commonly used methodology for the mass production manufacture of aircraft automobiles and complex high precision parts It illustrates several different approaches to this intricate field by taking the reader through the hows and whys of product analysis as well as the techniques for blanking punching bending deep drawing stretching material economy strip design movement of metal during stamping and tooling

*Sheet Metal Handbook* Ron Fournier, 1989-05-11 Imagine transforming a flat sheet of aluminum alloy into an attractive hood scoop Or designing and making your own aluminum wheel tubs floorpan and dashboard for your street machine How about learning to design and build your own body panels manifolds brackets and fuel tanks These are just a few of the many tips and techniques shared by master metal craftsman Ron Fournier Author of HP's award winning Metal Fabricator's Handbook Fournier packs decades of experience designing and shaping sheet metal components for Indy cars drag race cars road racers street rods and street machines into 144 pages You'll find tips on Setting up your own shop Selecting and using basic hand tools Proper use of English wheels bead rollers brakes and power hammers Pattern design and proper sheet metal selection Basic metal shaping techniques The art of hammer forming Proper riveting techniques And finally tips on restoring original sheet metal Whether you're restoring a '32 Ford constructing a race car building a show winning street rod or street machine or perhaps developing your skills for work in the metal industry you'll find the information in this book invaluable and a perfect addition to any home automotive library

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Company,1996    **Work** ,1895    *Heating & Air Conditioning Contractor* ,1929    **American Machinist & Automated Manufacturing** ,1924    **Manual Training Magazine** Charles Alpheus Bennett,William Thomas Bawden,1923  
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**E M F Electrical Year Book** ,1923    **The American Artisan** ,1919    MacRae's Blue Book ,1989    **MacRae's Blue Book and Hendricks' Commercial Register** ,1927    **Deburring and Edge Finishing Handbook** LaRoux K. Gillespie,1999  
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