

## PRINCIPLES OF METAL WORKING PROCESSES

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### INTRODUCTION

Forging, dates back to ancient times, was associated with the village blacksmith. Virtually all-ductile metals may be forged by first preheating the work piece to a forging temperature. The work piece can be a billet, a wrought bar, a cast or sintered ingot etc. The forging process can then be completed, by hammering the work piece to the desired shape. The design and control of metal working processes depend on the characteristic of the material, conditions of metal and tools interface, operating deformation mechanism and equipment used for working. 'Damascene technique' meant the forge welding of steel and iron or two types of steel. 'Damascus sword' was prepared by this technique. Forging has a marked beneficial effect on the metals being shaped. Their toughness and strength are improved because the process results in a beneficial orientation of the metal grain structure. The repeated hot working causes the metal to become more dense and the grain flow lines to follow the contour of the final component. The as cast structure is detrimental to the mechanical properties and therefore, it requires modification to improve the mechanical properties by refinement of microstructure and homogenous distribution of phases. The generic bulk forming processes are forging, rolling, extrusion and drawing. All these processes give a very high plastic deformation to the materials as the strain rate involved in these processes are considerable high. Forging is a high strain rate process where material is shaped under the effect of impact load or pressure.

The rolling is a process where slab or stock is dragged through the gap between two rolls rotating in opposite direction. Rolling is the most important metal working process and can be performed on either hot or cold metal. The work is subjected to high compressive stresses from the squeezing action of the rolls and to surface shear stresses as a result of the friction between the rolls and the metal. The frictional force is the responsible for drawing the metal into the rolls. Cold rolling of metal has reached to a position of major importance in industries. Sheets, foils, strips with good surface finish are produced by cold rolling.

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