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h2>there has been a revival of interest in the use of lap joints in the manufacturing of aluminium-based components. the lap joints for this application are either of the flat-lap type or the lap-weld type, both of which require the combination of an al-cu phase diagram and corresponding methods of joining [2]. the lap joints can be manufactured by hammering, which is a batch process, or clinching, which is a continuous process. in continuous clinching, aluminium is introduced into a clinching tool, which then holds the joint together. the clinching process is considered to be one of the most demanding applications of die-casting aluminium alloys. the first main problem in the clinching process is to heat the material such that the yield point is reduced as much as possible, thereby increasing the ductility of the material. the second main problem is to reduce the brittleness of the die casting alloys without compromising the functionality. the third main problem is to achieve a sufficient interlock between the two components to be joined. in both types of lap joints, the clinching process of aluminium die casting is usually performed by using an induction heating technique, which is then followed by a subsequent heat treatment. in general, the initial heating step is performed for 10-20 min, followed by an interlock anneal for 20-30 min and a final anneal

for 10-20 min. in the case of flat-lap joints, the heating and annealing time is typically performed one after the other, which leads to a large amount of free time between the two heating processes, resulting in a high probability of the casting being damaged. in order to address this problem, the authors of [1] use a series of thermal cycles to anneal the hot lap, reduce the brittleness, prevent collapse and/or joint segregation. however, this heating cycle is not able to reduce the brittleness of the die casting alloy. consequently, the authors conclude that the use of a single, short heating cycle or a multi-step heating strategy is necessary in order to achieve the expected lifetime of the lap joints. in the present study, a new heating method is described which can be integrated into the clinching process to reduce the brittleness of the aluminium alloys. this reduces the risk of the aluminium casting becoming damaged, even if there is no free time between the heating and annealing processes. the aim of the present study was to develop a technology to allow using a shorter and more efficient heating cycle in the clinching process, therefore offering a benefit to the clinching process. the two main aims of this study were to determine the effect of the heating time on the material properties and to develop a new induction heating process, which is able to reduce the brittleness of

the die casting alloy.

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*** If you like this article, please help us by signing up for our FREE newsletter. We have over 10,000 subscribers! If every person that signed up read ONE e-mail per week we would reach our goals in a year. However, if every person read 10 e-mails per week we would reach our goals in a month! This will help us to reach our next goals. Once the heating time has been found, the influence of the die body surface area can be examined. For this purpose, clinch points with larger surface areas were designed. Furthermore, the difference in length of the die-side surfaces of the clinch points is examined. It was found that the heating time is strongly dependent on the geometry of the clinch point. The optimal heating time for producing crack-free clinch points is achieved for a die-side surface area between 25cm² and 30cm². After the optimization of the heating time has been successfully accomplished, the influence of the surface area can be examined. Here, the surface area of the die-side surface of the clinch point must be increased by dividing the surface into several sections. The optimization of the heating time was performed several times for different surface areas.

The results showed that it is possible to achieve crack-free clinch joints without a significant increase in the heating time. The optimized heating time was between 3 and 4s. This is between 50% and 100% faster than the heating time needed for a surface area of about 28cm². The aim of the investigations described in this article is to improve the clinching of aluminum die casting. The focus is on clinching an aluminum die casting alloy by local heat treatment and hence to join them in a process-safe manner. For this purpose, a heating strategy is used to warm up the die casting alloys to reduce temporarily and reversibly the elongation and the yield strength in the material. In preliminary investigations, three different heating strategies (heating plate, resistance heating and inductive heating) have been investigated. Induction heating has been selected as the most suitable method due to the short heating time and the production of crack-free clinch points.

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