

. Unfolding the flanges

The next stage in the draw die development is to unfold or 'lay-out' the flanges around the outside of the panel. This is achieved by cutting 2-D sections across the panel. (This is similar to the multi-section approach.)

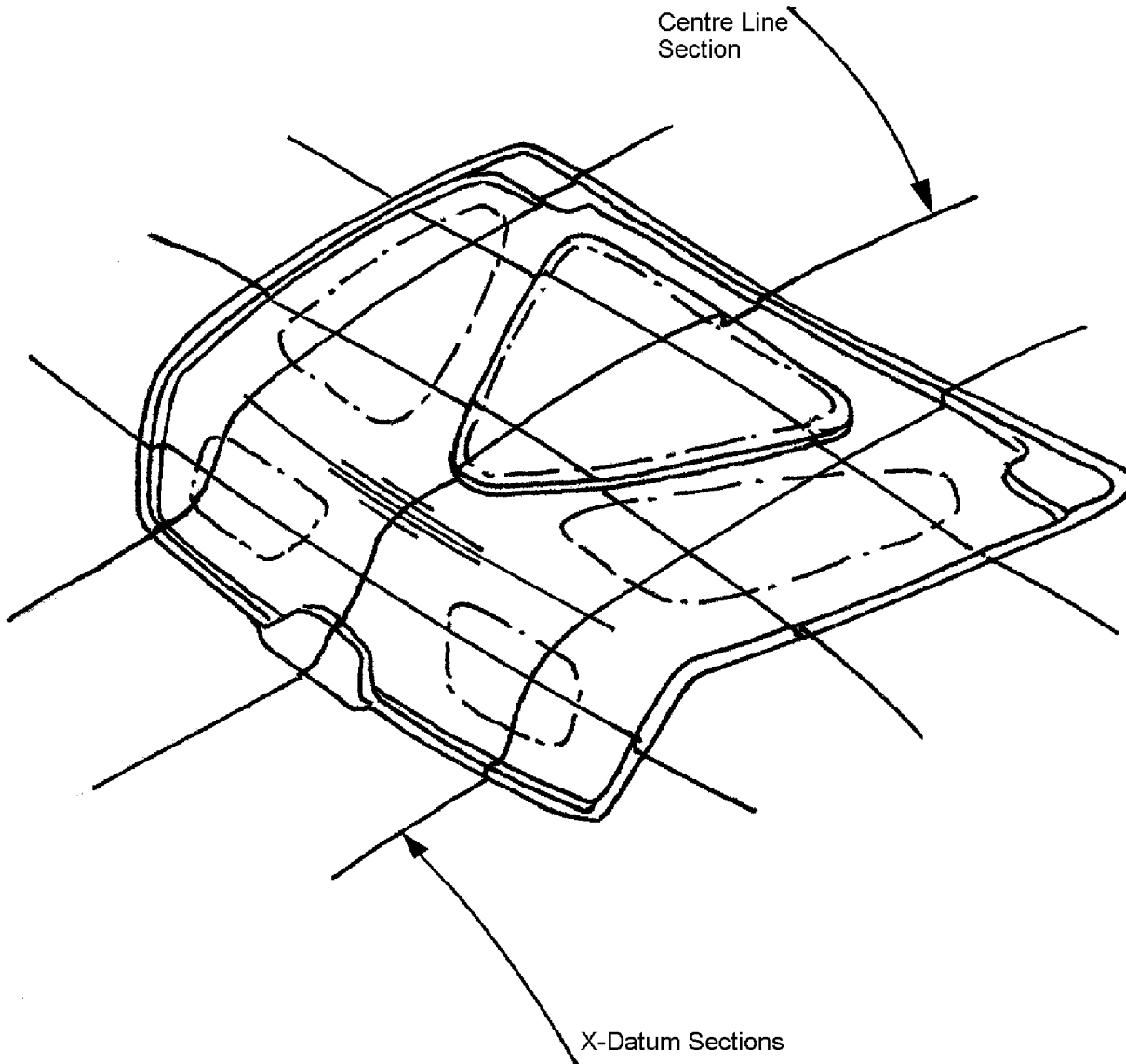


Figure 5-24. Isometric View of the Trunk Lid Inner Showing Section Lines

Taking each section in turn, the flanges are laid out to suit the trimming operation. Direct trimming is preferred, but there may be requirements to leave the flange at an angle. The maximum recommended angles for direct trimming are 20 degrees 'up', and 30 degrees 'down'. A typical section, with a flange laid out for trimming is shown here.

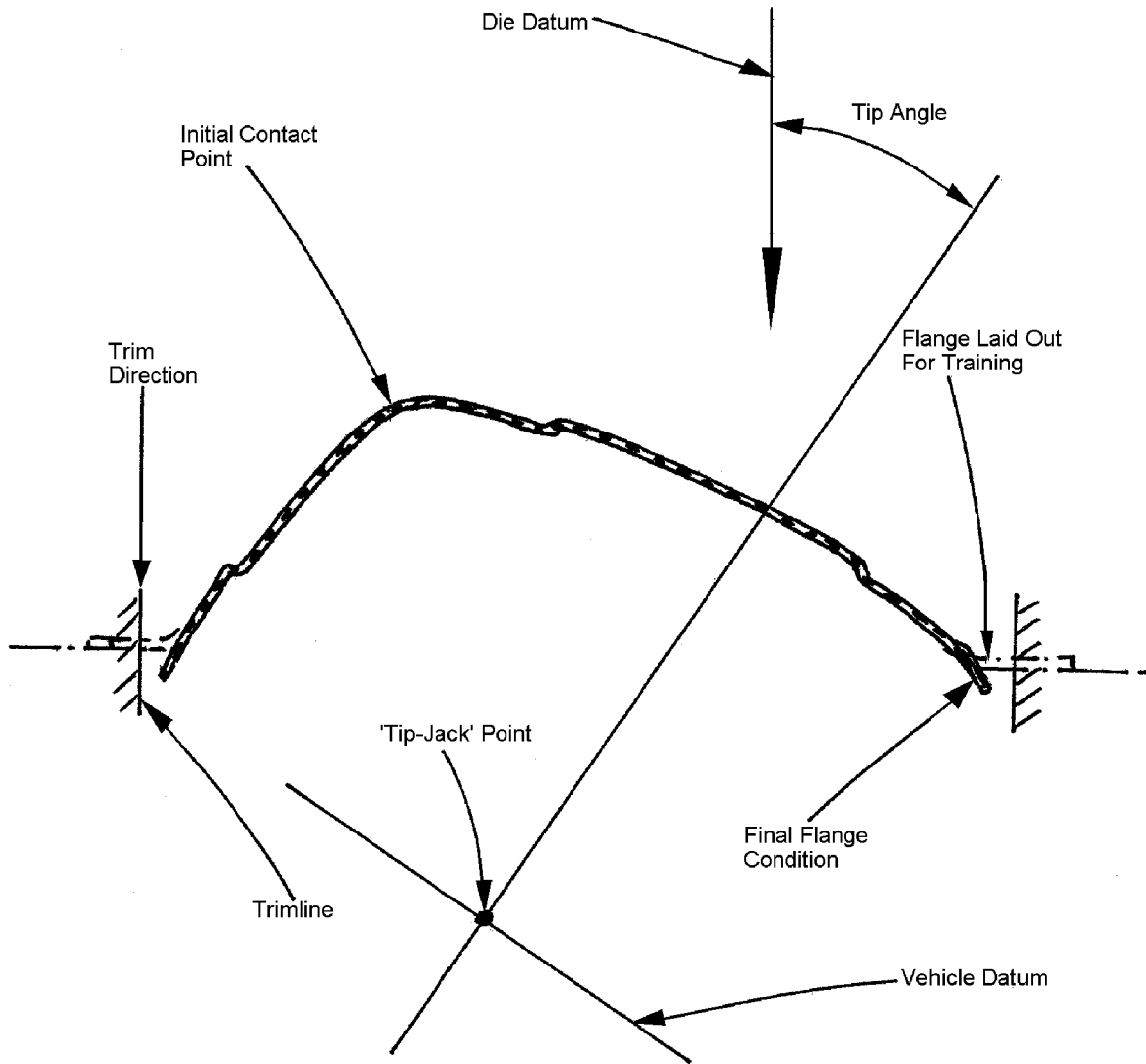


Figure 5-25. Centre-line Sectional View Through the Trunk Lid Inner