
**Metallic materials — Tube —
Flanging test**

Matériaux métalliques — Tubes — Essai de rabattement de collerette



Reference number
ISO 8494:2013(E)



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Contents

	Page
Foreword	iv
1 Scope	1
2 Symbols, designations and units	1
3 Principle	2
4 Testing equipment	2
5 Test piece	2
6 Procedure	2
7 Test report	3

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Foreword

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The committee responsible for this document is ISO/TC 164, *Mechanical testing of metals*, Subcommittee SC 2, *Ductility testing*.

This third edition cancels and replaces the second edition (ISO 8494:1998), of which it constitutes a minor revision.

Metallic materials — Tube — Flanging test

1 Scope

This International Standard specifies a method for determining the ability of metallic tubes of circular cross-section to undergo plastic deformation during flange formation.

This International Standard is intended for tubes having an outside diameter no greater than 150 mm and a wall thickness no greater than 10 mm, although the range of diameters or wall thickness for which this International Standard is applicable may be more exactly specified in the relevant product standard.

2 Symbols, designations and units

Symbols, designations and units for the flanging test of tubes are given in [Table 1](#) and are shown in [Figure 1](#).

Table 1

Symbol	Designation	Unit
a^a	Wall thickness of the tube	mm
D	Original outside diameter of the tube	mm
D_u	Maximum outside diameter of the flange	mm
L	Length of the test piece before the test	mm
R	Corner radius of the flanging tool	mm
b	Angle of the conical mandrel	degree

^a The symbol T is also used in steel tube standards..

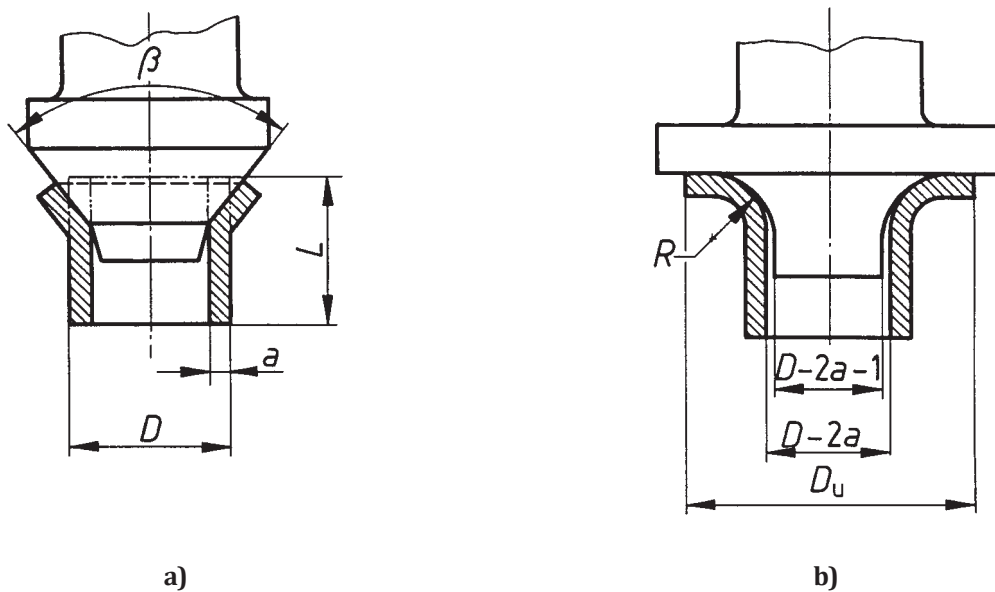


Figure 1

3 Principle

Forming of a flange on the end of a test piece cut from the tube, in a plane perpendicular to the axis of the tube, until the external diameter of the flange reaches the value specified in the relevant product standard.

4 Testing equipment

4.1 Variable-speed press or universal testing machine.

4.2 Forming equipment, made of polished material of sufficient hardness, consisting of

- a) a conical mandrel having a suitable angle (generally 90°);
- b) a flanging tool having
 - a cylindrical end of a diameter 1 mm less than the inside diameter of the tube,
 - a flat concentric portion, perpendicular to the axis of the flanging tool, and having a diameter no less than the required diameter of the flange;
- c) a supporting die, which may be used to support the tube during the formation of the flange.

5 Test piece

5.1 The length of the test piece shall be approximately $1,5D$. The test piece may be shorter provided that the remaining cylindrical part of the test piece after flanging is at least $0,5D$.

5.2 Both ends of the test piece shall be in the plane perpendicular to the axis of the tube. The edges of the end to be tested may be rounded by filing or chamfered by other methods.

NOTE Non-rounded or non-chamfered edges are permissible if the test result meets the test requirements.

5.3 When welded tubes are subjected to the test, the internal welded flash may be removed.

6 Procedure

6.1 In general, the test shall be carried out at ambient temperature within the limits of 10 °C to 35 °C. The test carried out under controlled conditions shall be made at a temperature of $23\text{ °C} \pm 5\text{ °C}$.

6.2 Preform the test piece by forcing the conical mandrel into one end of the test piece until the diameter of the drifted test piece is such that a flange having the specified diameter (D_{fl}) can be formed [see [Figure 1 a](#)].

6.3 Remove the conical mandrel and, if the piece is not already cracked, replace it with the flanging tool [see [Figure 1 b](#)].

6.4 Form the flange by applying axial force to the test piece until the drifted portion has formed a flange of the required diameter perpendicular to the axis of the test piece.

6.5 The conical mandrel may be lubricated. The conical mandrel shall not rotate relative to the test piece during the test.

6.6 In case of dispute, the rate of movement of the forming tools shall not exceed 50 mm/min.

6.7 The diameter of the flange (D_u) and the radius R shall be as specified in the relevant product standard.

6.8 Interpretation of the flanging test shall be carried out in accordance with the requirements of the relevant product standard. When these requirements are not specified, the test piece shall be considered to have passed the test if no cracks are visible without the use of magnifying aids. Slight cracking at the edges shall not be considered a cause for rejection.

7 Test report

A test report shall be provided when so specified in the relevant product standard. In this case, the test report shall include at least the following information:

- a) a reference to this International Standard, i.e. ISO 8494;
- b) identification of the test piece;
- c) dimensions of the test piece;
- d) maximum outside diameter of the expanded part of the test piece, D_u , or relative expansion as a percentage of the original diameter, D ;
- e) corner radius R of the flanging tool, when relevant;
- f) result of the test.

