

## Table of Contents

### 1. Special Issue Plenary Keynotes

D.Y. Yang

Innovation and Creativity in Metal Forming

N. Bay

Trends and Visions in Metal Forming Tribology

J.M. Allwood

Steel and Aluminium in a Low Carbon Future

E. Oñate

Advances on Finite Element Methods and Particle-based Methods for Metal Forming Processes

M. Ernst

Servo Forming is more than a Trend

W.Z. Misiolek

Modelling of Microstructure Response to Deformation Parameters in Selected Metal Forming Processes

M. Hoshino

New Extrusion of Variable Cross Section Shape and Curved Frame

### 2. Bulk Metal Forming

T. Sato, H. Utsunomiya, T. Sakai

Effects of Sudden Friction Change on Rolling Characteristics

K. Hara, H. Utsunomiya, T. Sakai, S. Yanagi

Influence of Oxide Scale on Hot Rolling Characteristics of Steel Sheet

M. Graf, R. Kawalla

Deformation Behaviour and Mechanical Properties of Oxide Scales during Hot Metal Forming Processes

T. Iwamoto, H. Tanaka, K. Yanagi

An Experimental Study on Diamond Burnishing Tool Wear and Its Lifetime Estimation

C. Hubert, L. Dubar, M. Dubar, A. Dubois

Strategy of Simulation of the Edge-trimming/Cold Rolling Sequence: Numerical Study of Edge Cracking

M. Daamen, T. Förster, G. Hirt

Experimental and Numerical Investigation of Double Roller Casting of Strip with Profiled Cross Section

H.B. Xie, Z.Y. Jiang, W.Y.D. Yuen

Analysis of Edge Crack Initiation during Cold Rolling of Thin Strip

M. Kihara, K. Ohara, J. Yanagimoto

Simulation for Microstructural Evolution and Deformation Resistance of Nb Microalloyed Steels during Hot Rolling

- S. Abdelkhalek, H. Zahrouni, P. Montmitonnet, N. Legrand, M. Potier-Ferry  
Latent and Manifested Flatness Predictions in Thin Strip Cold Rolling: Comparison of Coupled and non-Coupled FEM Approaches
- D. Dávalos Julca, T. Förster, B. Wietbrock, G. Hirt  
Lightweight Design by Flexible Rolling and Strip Profile Rolling
- M. Asadi, N. Schlosser, H. Palkowski  
Use of Bake Hardening Effect after Local Strengthening in Dual Phase Steel
- R. Neugebauer, A. Sterzing, R. Zachäus, M. Bergmann  
Property Distribution in Aluminium Material Processed by Gradation Rolling
- A. Kainz, M. Widder, E. Parteder, G. Hein, K. Schörkhuber, K. Zeman  
An Enhanced Iterative Algorithm for the Contact Between Elastic Roll Stack and Elasto-Viscoplastic Strip and Plate in Hot Rolling
- K. Agarwal, Y. Zhu, R. Shivpuri  
Robust Design of No-Twist-Mill Parameters for Reduced Geometric Variation in the Hot Rolling of Steel Rods and Coils
- R. Krux, M. Zemko  
FEM-modelling of Barrel-type Cross-roll Piercing and Analysis of the Induced Rotational Motion of the Plug Bar
- K. Kawai, N. Maeda, T. Yamauchi, Y. Morita, H. Koyama  
Rotary Forming of Annular Grooves onto a Circular Tube
- P. Mangin, L. Langlois, R. Bigot  
Role of Surface Texture on Workpiece Angular Deformation in Cross Wedge Rolling
- E. Pashinska, V. Varyukhin, A. Zavdoveev, V. Stolyarov  
Effect of Rolling With Shear Technology on Structure, Properties and Plasticity of Low-carbon steel
- M.A. Carruth, J.M. Allwood  
The Forming of Variable Cross-section I-Beams by Hot Rolling
- R. Zhou, J. Cao, C. Xu, K. Ehmann  
An Investigation on Multi-pass Deformation-based Surface Texturing
- Y. Takashima, E. Takenouchi  
Deformation and Rolling Force in Universal Rolling of Narrow Flange Width H-beam
- R. Kebriaei, J. Frischkorn, S. Reese  
Influence of Geometric Parameters on Residual Porosity in Process-integrated Powder Coating by Radial Axial Rolling of Rings
- L.G. Guo, H. Yang  
A Process Planning Method and Process Stability Analysis in Cold Ring Rolling
- X.K. Wang, L. Hua, C.D. Zhu

Study on the Process Control for a New Type of Vertical Hot Ring Rolling Mill

C. Simsir, I. Eisbrecher, M. Hunkel, T. Lübben, F. Hoffmann

The Prediction of the Distortion of Blank-Hardened Gear Blanks by Considering the Effect of Prior Manufacturing Operations

R. Rentsch, E. Brinksmeier

Experimental and Numerical Analysis of the Distortion of Forged Gear Wheel Blanks

X.Z. Han, W.C. Xu, D.B. Shan

Investigation on isothermal forging process and microstructure evolution of Mg-10Gd-2Y-0.5Zn-0.3Zr alloy

Y.S. Na, W.D. Yoo, J.H. Lee

Process Design for Hot Free Forging of Duplex Stainless Steels by Applying Dynamic Materials Model

A. Stephen, F. Vollertsen

Influence of the Rod Diameter on the Upset Ratio in Laser-based Free Form Heading

R. Morimoto, Y. Kume, M. Kobashi, N. Kanetake

Solid-Phase Recycling of 7000 Series Al Alloy by Compressive Torsion Processing

S. Kajikawa, T. Iizuka, K. Yamaishi, N. Hatanaka, N. Takakura, K. Kanayama

Small Container Fabrication Using Closed Die Wood Forging

K. Asai, K. Kitamura, M. Terano

Evaluation of Anti-Galling Property of Surface-Hardening Tools for Hot Aluminium Forging Using Tapered-Plug Penetration Test

E. Ceron, N. Bay, M. Arentoft, P.T. Tang

Testing a New Microporous Lubricant Carrier for Cold Forging

Y. Sagisaka, I. Ishibashi, T. Nakamura, E. Sasaoka, K. Hayakawa

Evaluation of Environmentally Friendly Lubricant for Aluminium Alloy Cold Forging

J.H. Park, B.Y. Yoo, Y.H. Kim, X. Ma

Stress Analysis of Ultrasonic-Assisted Upsetting based on Two Dynamic Friction Models

T. Okajima, S. Oe, H. Yoshida, S. Isogawa, T. Kimura, T. Ishikawa

Proposal of Punch Wear Prediction Model for Warm Backward Extrusion

Y. Murata, T. Takahashi

Measurement of Die Deformation in Backward Extrusion Process for Various Tool Dimensions

A. Sivaraman, U. Chakkingal

Workability of an Aluminium Alloy Processed by Equal Channel Angular Pressing

L. Donati, N. Ben Khalifa, L. Tomesani, A.E. Tekkaya

Die coatings influence evaluation and friction model selection in aluminium extrusion by means of visioelasticity technique

A. Jäger, N. Ben Khalifa, V. Psyk, A.E. Tekkaya

## Thermo-mechanical Processing of Aluminum Profiles Subsequent to Hot Extrusion

S. Gall, S. Müller, W. Reimers

Extrusion of Magnesium Sheets with Increased Width

T. Shirakawa, M. Asakawa, S. Shirasaki, Y. Ohno

Effect of Deformation Heat Generated During Cold Drawing on Drawn Bar Diameter by Numerical FEM Analysis

K. Yoshida, T. Yamashita, A. Tanaka

Prevention of Wire Breaks in Gold Fine Wire Drawing and Improvement in Wire Straightening

T. Furushima, T. Ikeda, Y. Noda, K. Manabe

Deformation and Heat Transfer Analysis of Dieless Drawing Process for Metal Tube

U. Weidig, N. Barbakadze, S. Wagner, K. Steinhoff

Thermo-mechanical Microforming of Wire by Dieless Drawing Process

S.K. Hwang, Y.G. Jin, H.M. Baek, D.K. Kim, I.H. Son, Y.T. Im

A Continuous Hybrid Process for Manufacturing High-strength Low Carbon Steel

K. Nishimura, M. Asakawa, B. Li

Roller Leveler Straightening and Additional Twisting for Coiled Wire

### 3. Sheet Metal Forming

J.C. Park, D.Y. Seong, D.Y. Yang, M.H. Cha

Development of an Innovative Bending Process Employing Synchronous Incremental Heating and Incremental Forming

M. Thome, J. Vochsen

High-Speed Calculation Tool for Design of the JCO Pipe Forming Process

M. Baumgart, A. Steinböck, A. Kugi, B. Douanne, G. Raffin-Peyloz, L. Irastorza, T. Kiefer

Modeling and Active Compensation of the Compliance of a Hot Leveler

L. Steinwender, A. Kainz, K. Krimpelstätter, K. Zeman

Numerical Simulation of Tension Losses and Reaction Forces in Tension Levellers

N. Noma, T. Kuwabara

Effect of Analysis Conditions on the Accuracy of Springback Simulation in Draw-bending of High Strength Steel Sheet and Experimental Validation

B. Engel, S. Kersten

Analytical Models to Improve the Three-Roll-Pushbending Process of Tube-Profiles

S.J. Yuan, C. Han, Y. Wang, S. Yang

Shear Hydro-bending of Light Alloy Tubes

R. Boman, J.-P. Ponthot

Continuous Metal Forming Process Simulation using the Arbitrary Lagrangian Eulerian Formulation

D.S. Shim, D.Y. Yang, D.J. Lee, M.S. Han, M.S. Ko

Investigation into the Process Design for the Manufacture of Doubly Curved Plates in the Incremental Roll Forming Process and its Experimental Verification

T. Ohashi, H-J. Lian, S. Saito, A. Namisashi, T. Sato, J. Lin

Reduction of Machine Difference of Jolt in Stamping with a Multi-Point Die Support System

B.-A. Behrens, I. El-Galy, T. Huinink, C. Buse

Online Monitoring of Deep Drawing Process by Application of Acoustic Emission

N. Hagino, J. Endou, S. Katoh

Visualization of Contact Condition between Workpiece and Die During Stamping

B. Bassa, F. Sabourin, M. Brunet

A New Shell and Solid-shell Formulation Using Complete 3D Constitutive Laws

Y. Harada, T. Tsuda, I. Fukuda

Forming of Pure Titanium Sheets by Multi-stage Deep Drawing Process

D.C. Ahn, Y.J. Chung

An Analytical Approach for Designing Multi-Stage Cylindrical Cup Deep Drawing

D.H. Kim, M.B. Moon, Y.J. Kim, Y.G. Kim, K.S. Kim

Lightweight Car Body Manufactured through Hotstamping and Tailor Welding of Blanks

H.S. Choi, W.S. Lim, P.K. Seo, C.G. Kang, B.M. Kim

Local Softening Method for Reducing Trimming Load and Improving Tool Wear Resistance in Cutting of a Hot Stamped Component

B. Masek, H. Jirkova, L. Kucerova, D. Aisman, I. Eliasova, M. Zemko

Innovative Concepts for Hot Stamping Process

R. Neugebauer, A. Göschel, A. Rautenstrauch, E. Meza-García

Influence of the Steel Alloy Composition on Phase Transitions and its Applicability to Hot Forming Process

O. Sokolova, A. Carradó, H. Palkowski

Adhesion and Formability of Thin Steel/Polymer/Steel Hybrid Sandwich Composites

W. Homberg, J. Dau, U. Damerow

Combined Forming of Steel Blanks with Local CFRP Reinforcement

M. Heyde, K. Roll

Building Lightweight Cars by Using Steels with Graded Properties

S. Rösel, M. Merklein

Enhancing Forming Limits by Using a Magnetorheological Fluid as Active Fluid Medium for Hydroforming

M. Schenk, J.M. Allwood, S.D. Guest

Cold Gas-Pressure Folding of Miura-ori Sheets

A.W. Behrens, J. Ellert

Form-Field-Structure-Pressing Process (FSP) A Method to increase static and dynamic Stability of thin Sheet-Metal-Structures

X.S. Wang, Z.L. Hu, L.J. Xie, S.J. Yuan

Double-sided High Pressure Hydroforming of Thin-walled Aluminum Alloy Tube

T. Maeno, K. Mori, C. Unou

Influence of Initial Wall Thickness of Tube on Formability in Hot Gas Bulging of Aluminium Alloy Tube Using Pressure of Sealed Air and Resistance Heating

C. Yang, G. Ngaile

Preform Design for Tube Hydroforming Based on Wrinkle Formation

C. Taplick, W. Schmitt, F. Rullmann, C. Ludwig, P. Groche

High Strength Hydroformed Steel Profiles with Free Flanges

Z.B. He, L. Li, X.B. Fan, Y.L. Lin, S.J. Yuan

Reduction of the Friction in Guiding Zone during Tube Hydroforming

A. Fiorentino, R. Marzi, E. Ceretti, C. Giardini

Friction Coefficient Estimation in THF by Means of Numerical Inverse Method

S. Tanaka, K. Hayakawa, T. Nakamura

Incremental Sheet Forming with Direction Control of Path Planes

H. Vanhove, J. Gu, H. Sol, J.R. Duflou

Process Window Extension for Incremental Forming through Optimal Work Plane Rotation

W.C. Emmens, A.H. van den Boogaard

Formability in Incremental Sheet Forming and Cyclic Stretch-Bending

B. Taleb Araghi, M. Bambach, G. Hirt, J. Zettler

Investigations into the Process Mechanics of the Hybrid Process Combination of Stretch Forming and Incremental Sheet Forming

O. Anghinelli, G. Ambrogio, R. Di Lorenzo, G. Ingarao

Environmental Costs of Single Point Incremental Forming

G. Ingarao, F. Gagliardi, O. Anghinelli, R. Di Lorenzo

A Sensitivity Analysis on Environmental Sustainability in Sheet Metal Forming

M. Otsu, T. Ichikawa, M. Matsuda, K. Takashima

Improvement of Formability of Magnesium Alloy Sheets by Friction Stir Incremental Forming

O. Music, J.M. Allwood

Tool-path Design for Metal Spinning

W. Homberg, D. Hornjak

Friction-Spinning of Tubular Components – Basic Research on Parameter Influence and Process Design

S. Maki, T. Hattori, E. Nakanishi

Punching Test of High Strength Steel Sheet in Rapid Cooling Stage Following Austenitizing by Rapid Resistance Heating

K. Hirota, H. Cho

Accuracy of Micro Piercing Process Using Press Indenting and Chemical Etching

M. Hirsch, R. Golle, H. Hoffmann

Tool-Endurance of High-Speed Stamping Tools with Plates of Magnesium and Carbon Fibre Laminate

Y. Fukuzawa, S. Nagasawa, T. Satho, S. Suzuki, H. Sakayori

Analysis of Rotary Cutting Mechanism of Aluminium Sheet

M. Deng, Y.G. Zhang, L. Lv, Y.Q. Wu

Research on Fine-blanking Forming on the Low Plasticity and Large Thickness Parts

M. Zimmermann, F. Klocke, F. Schongen, B. Feldhaus

Fine Blanking of Helical Gears – Finite Element Simulations and First Experimental Results

Y. Yoshida, N. Yukawa, T. Ishikawa

Notched Plate Tensile Test Using Image Analysis and Its Application for Deformation

S. Kajino, T. Tanaka, M. Asakawa

Reduction of Shear Droop by Torsion with Static Shear Load of Bars and Wire

J. Kobayashi, P.V. Duc, K. Sugimoto

Stretch-flangeability of 1.5GPa Grade TRIP-aided Martensitic Cold Rolled Sheet Steels

K. Mori, Y. Abe, Y. Ikeda

Improvement of Formability for Expansion of Punched Hole of Ultra-High Strength Steel Sheets by Smoothing of Sheared Edge

S.C. Heo, Y.H. Seo, T.W. Ku, W.J. Song, J. Kim, B.S. Kang

Derivation of Initial Blank Shape for Thick Plate Forming Process and Its Application to Flexible Forming

A. Papaioanu, M. Liewald

Influence of Pre-stretching on Dent Resistance of Stretch Formed Parts

T. Oya, C. Jeong, J. Yanagimoto, T. Koseki

Effect of the Ductility Enhancement on the Forming Limit of the Multilayer Metallic Sheet

H. Kim, M. Kimchi, N. Kardes, T. Altan

Effects of Variable Elastic Modulus on Springback Predictions in Stamping Advanced High-Strength Steels (AHSS)

#### 4. Joining

R. Matsumoto, T. Chida, H. Utsunomiya

Improvement of Bonding Strength of Bar and Plate in Indentation Plastic Joining with Bar Oscillation

Using Servo Press

Y. Kasuga, T. Kmai, K. Yoshida, S. Kawamori, T. Okai

Joining of a Shaft with a Disk by Shape Memory Polymer or Alloy Taking Easy Disassembly into Consideration

C. Nielsen, P. Martins, W. Zhang, N. Bay

Mechanical Contact Experiments and Simulations

T. Iizuka, S. Kajikawa, N. Hatanaka, N. Takakura

Fundamental Formability of SPC/A1100 Hybrid Sheet Welded by Butt Laser Welding

T. Pasang, J.C. Sabol, W.Z. Misiolek, R.M. Mitchell, A.B. Short, G. Littlefair, A.J. Thome

Metallurgical Characterization of Deformed Electron Beam Welded Dissimilar Titanium Alloys

T. Okabe, M. Aratani, Y. Yokoyama, S. Toyoda, H. Kimura, M. Egi, A. Kawanishi

Finite Element Analysis of the Electric Resistance Welding Phenomenon

Y. Abe, K. Taromaru, T. Kato, K. Mori

Improvement of Joinability in Mechanical Clinching of Sheets Using Step Punch

U. Beyer, B. Awiszus

Using Flat-Clinching to Obtain Plastic-Metal Compounds

M. Lou, Y.B. Li, Z.Q. Lin, G.L. Chen

Effects of Direct Current on Formability of Self-Piercing Riveted Joints of Dissimilar Sheet Metals

## 5. Material Characterization and Modelling

E.S. Perdahcıoglu, H.J.M. Geijselaers

Prediction of the mechanical behaviour of TRIP steel

B. Zillmann, M. Härtel, T. Halle, T. Lampke, M.F.-X. Wagner

Flow Behavior of Automotive Aluminum Sheets During In-Plane Uniaxial and Biaxial Compression Loading

Q. Yin, A. Brosius, A.E. Tekkaya

Modified Plane Torsion Tests for Sheet Metal Characterization

M. Merklein, M. Biasutti

Forward and Reverse Simple Shear Test Experiments for Material Modeling in Forming Simulations

J. Liu, J. Li, C. Wang, L. Ruan, Z. Cui

Flow Characteristics and Intrinsic Workability of Magnesium Alloy AZ61

E. Coruk, C. Karadogan

Flow Curve Evaluation by Optic Strain Measurements and Force Balance at the Most Critical Section in the Neck Region of a Tensile Specimen

Z. Keran, M. Math, P. Piljek

Modified Hydraulic Bulging for Determination of Flow Stress Curve



E. Billur, Y. Demiralp, A.R. Groseclose, B. Wadman, T. Altan  
Factors Affecting the Accuracy of Flow Stress Determined by the Bulge Test

J. Gerlach, T. Beier, H. Grass, I. Heinle, L. Kessler, A. Lipp  
Identification And Validation Of Yield Locus Parameters With Respect To Industrial Forming Simulation Needs

H. Aretz, S. Keller  
On the Non-Balanced Biaxial Stress State in Bulge-Testing

L. Paraianu, S. Comsa, I. Bichis, D. Banabic  
Influence of the Mechanical Parameters on the Forming Limit Curve

M. Terano, K. Kitamura  
Determination of Planar Anisotropy on Radius-plane for Small Tube by Small-Cube Compression Test

R. Kuziak, M. Pietrzyk  
Physical and Numerical Simulation of the Manufacturing Chain for the DP Steel Strips

R. Mahnken, A. Schneidt  
Material Modelling of Austenite to Bainite Transformation

G.C. Gu, E. Becker, L. Langlois, R. Pesci, R. Bigot  
Microstructure Evolution and Material Flow of Steel in Semi-solid Forming Process

F. Chen, Z.S. Cui, J. Liu, L.Q. Ruan  
Mesoscale Simulation of the Microstructural Evolution for Low Pressure Rotor Steel during Multi-stage Hot Forging Processes

M. Soltanpour, J. Yanagimoto  
A New Approach to Evaluate Static Recrystallization Kinetics

R.B. Song, Q.F. Dai, X.X. Guan, Z.F. Guo  
Effect of Martensite Volume Fraction on Tensile Properties of DP1000 Cold Rolled Dual Phase Steel

N. Yukawa, T. Ishikawa, T. Matsuo, Y. Nozaki  
Development of Virtual Laboratory System for Prediction of Microstructure and Mechanical Properties in Hot Forging of Vanadium Microalloyed Steel

M. Baiker, D. Helm  
Crystal Plasticity Assisted Calibration of Finite Plasticity Model And the Application to Sheet Metal Forming

K. van Putten, F. Roters, G. Hirt  
Investigation of the Plane Strain Compression of an Oligocrystalline Specimen

Y. Chung, M-G. Lee, F. Barlat, D.C. Ahn  
Experimental and Numerical Investigation of Surface Roughness in Ferritic Stainless Steel

H.W. Li, H. Yang  
A Computational Efficient and Stable Model of Rate Dependent Crystal Plasticity

T. Uemori, S. Sumikawa, S. Tamura, H. Hamasaki, T. Naka, R. Hino, F. Yoshida  
Constitutive Equations of Bauschinger Effect under Stress Path Changes

H. Vegter, P. van Liempt  
Modelling of Workhardening of Multiphase Steels

H. Kano, J. Hiramoto, T. Inazumi, T. Uemori, F. Yoshida  
Influence of Yield Functions on Parameters of the Yoshida-Uemori Model

T. Clausmeyer, S. Bargmann, G. Gershteyn, M. Schaper, B. Svendsen  
Finite-element Simulation of the Evolution of Plastic Anisotropy

A. Van Bael, J. Gawad, P. Eyckens, G. Samaey, D. Roose, P. Van Houtte  
Modelling Texture Anisotropy and its Evolution in Sheet Forming Processes

Y. Peng, S. Huang, D. Li  
Modelling Flow Stress and Texture Evolution in AZ31 Alloy during Uniaxial Compression at Elevated Temperature

L. Madej, K. Perzynski, W. Wajda, H. Paul, P. Cybułka, L. Rauch  
Numerical Analysis of the Texture Evolution on the Basis of the CPFEM and Digital Material Representation

F. Abu-Farha, L. Hector, Jr., M. Nazzal  
Pneumatic Stretching Test for Evaluating the Formability of AA5083 at QPF Conditions

Y. Kiliçlar, M. Engelhardt, H. von Senden genannt Haverkamp, M. Schwarze, I. Vladimirov, D. Bormann, S. Reese, Fr.-W. Bach  
Combined Quasi-Static-Dynamic Forming Processes – Material Modelling, Experimental Validation and Finite Element Technology

W.J. Song, Y.S. Byun, S.C. Heo, S.W. Kim, Y.S. Lee, T.W. Ku, B.S. Kang, J. Kim  
Prediction and Confirmation of Analytical Forming Limit Curves of Magnesium Alloy Sheet based on Flow Stress Modelling and Experiments Considering Temperature and Strain Rate Effects

M. Malekipour Gharbi, C. Labergère, H. Badreddine, C. Soyarslan, A. Weinrich, M. Hermes, S. Chatti, H. Sulaiman, K. Saanouni, A.E. Tekkaya  
Advanced Experimental-Numerical Investigations of Cold Bending of High Strength Steels

I.N. Vladimirov, M.P. Pietryga, S. Reese  
Prediction of Forming Limit Diagrams at Fracture by an Anisotropic Finite Plasticity Model with Ductile Damage

C. Hubert, L. Dubar, M. Dubar, A. Dubois, F. Lauro, D. Morin  
A Non-associative Flow Rate Formulation for Lemaitre's Damage Model

J. Chottin, E. Hug, M. Rachik  
Damage Accumulation in DP1000 Steel Sheets Submitted to Various Stress States

J. Lian, N. Vajragupta, S. Münstermann, W. Bleck  
On Application of a Damage Plasticity Model to Sheet Metal Forming of DP Steel

H. Kim, W. Mohr, P. Zelenak, M. Schimming, M. Kimchi  
Predictions of Hole-Edge Failure for TRIP 780 Structural Component During a Static Bend Test

K. Komori  
Improved Void Model for Simulating Inner Fracture Defects in Drawing

A. Ghiotti, S. Bruschi, P.F. Bariani  
Damage Modelling in Cold Forging Process Chains

D. Vilotic, S. Alexandrov, M. Plancak, D. Movrin, A. Ivanišević, M. Vilotic  
Material Formability at Upsetting by V-Shape Dies

A. Timmer, F. Klocke, V. Bäcker, M. Zimmermann, B. Feldhaus  
Holistic Crack Prediction in Cold Forging Processes Through a Temporal and Phenomenological  
Distinguishing Crack Criterion

6.