Development of Empirical Model for Tube Hydroforming Process using RSM

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Abstract
Tube hydroforming Process (THP) is a new forming technology to produce complex tubular components in minimum number of phases. In this process the pressurized fluid and axial feed by axial plungers is used to produce the required geometry. The components which are developed by the tube hydroforming technique are structurally superior and stiff.

The present study is to establish an empirical model for tube hydroforming process using simulation and experimental results. And also investigated and analyzed the effect of the various input parameters on the output responses. Annealed Inconel600 tubes with the diameter of 57.15mm and thickness 1.45mm are deformed to investigate the control variable. Tubes are simulated using DEFORM -3D FEM tool.

Many number of control variable are involved in tube hydroforming process. From the previous research study and pilot experiments, it has been noticed that the internal pressure (IP), axial feed (AF) & Tube Length (TL) has predominant effect on the process. Hence, IP, AF & TL are considered as input and influencing parameters. After various pilot experiments on annealed Inconel 600 tubes, the ranges and level of each process parameter are noted.

To minimize the expenditure on process, material and to minimize the time, FEM tool DEFORM -3D is used to analyze the effect of various parameters on tube hydroforming. Taguchi L27 orthogonal array is selected to minimize the number of simulation to analyze the process variables with same accuracy.

After successful simulation runs, the RSM (Response Surface Methodology) is applied to develop a numerical model to the responses. Further, the developed mathematical models are further for further to optimization the THP.

Keywords: Tube Hydro forming process, FEM simulation, annealed Inconel 600, Response surface methodology.

INTRODUCTION
Global wise Tube hydroforming process is becoming more popular forming technique due to its capabilities to form various tubular components with high strength. Now a days, all manufacturing industries are showing attention on THP as the process having ability to manufacture the difficult tubular products in single phase with better mechanical and structural properties.

THP is an advanced forming process, in this process, deforms different hollow tubular cross-sections to a predefined shape of section of using hydraulic pressure and axial force. Stepped hollow shafts, metallic bellows, automobile chassis components and radiator supports are some of the application of the tube hydroforming.

[1] Many advantages find in THP than routine manufacturing process like welding, machining, and stamping process such as: (i) Weight reduction, (ii) Controlled wall thinning, (iii) Low tool cost, (iv) Better structural strength and stiffness, (v) minimizing secondary phase operations, (vi) better dimensional accuracy, and (viii) low wastage.

Figure 1. illustrates the working principle of THP. Annealed Inconel 600 tubes are inserted in between the two half of free bulge test die and the two ends of the tube are sealed by two axial plungers moving along the tube axis. Initial axial load applied on the ends of the tube for sealing of the tube as applied high pressure liquid is supplied inside the tube. The internal pressure is applied inside the tube to deform the tube. This hydraulic pressure is applied uniformly throughout internal side of the tube. The axial forces increase further to achieve better thickness control.

University Grant Commission (UGC-India) for provided financial support through minor research project grant (Proposal No. 6099/15).
Internal pressure is increased in THP until the tube expands to required shape or wall meets the inner surface of the die cavity. The process steps in THP are illustrated in the figure no 1. In this, the tube is placed between the die. By controlling the input factors, it is possible to produce quality products by the THP by avoiding various failures such as buckling, wrinkling, or bursting.

To minimize the difficulties during the tube hydroforming process, it requires the analysis of various process parameters and their effect on the output response of tube hydroforming to judge the quality of the process. Due to this reason, selected this process for further investigation.

The quality of components which are produced by THP depends on the selection of loading path i.e. combination of internal pressure and axial movement. The present research includes that the exploration of the effect of input parameters on the formability.

Free bulge test THP is conducted using FEM tool DEFORM 3D, different simulation runs were conducted to study and analyze the effect of input process parameters on the output responses.

![Figure 1: Tube Hydroforming Process (THP)](image)

The main aim of the free bulge hydroforming is to test the hydro-formability of the tubular material. For this investigation, maximum bulge ratio without any failure is taken as one of the output response. Along with the above objective, another objective has considered as minimum thinning ratio.

The proposed methodology for the current investigation is to develop a numerical relation using FEM simulation using DEFORM 3D and Design Expert 10. This empirical model can be used further for development of objective functions.

![Figure 2: Free Bulge Tube Hydroforming process.](image)
used for modeling of the tube hydroforming process. Using RSM (Response Surface Methodology), the THP was modeled. The adequacy of the obtained model was tested using Analysis of variance (ANOVA). Regression Coefficient (R2) is used to the adequacy of the predicted model. After confirm the adequacy of the model, these models will be used for further optimization of the THP. The effect of internal pressure, tube length and axial feed on the output responses such as bulge ratio and thinning ratio are analyzed and plotted using Design Expert 10 software. In the present investigation die, axial plungers and tube are modeled using AutoCAD 16 and exported to DEFORM 3D and tube material is selected as Inconel 600 and properties of the material is given as annealed INCONEL600. The dimensions of the die, axial plunger and tube are match with the dimension of the experimental setup at the IIT Mumbai, India.

The novelty in this research is that only a very few researchers worked on the super alloys hydroforming applications and comparisons has made between simulation and experimentation.

**SIMULATION PROCESS**

FEM simulation of tube hydroforming process using DEFORM 3D includes various steps. First step, solid modeling of various components such as upper and lower die, axial plungers and the tubular blank. The geometry of the all components are matched with geometry of experimental setup which is located at Indian Institute Technology, Bombay, India to verify the experimental and simulation results. In the present investigation all solid models and the tooling assembly structure are created using AutoCad 2016. All of solid models are then converted in to the suitable formats such that the simulation solver should understand [1]. CAE engineers need to create the simulation-related models for the given deformation system like physical model, mathematical model and numerical model. The boundary and initial conditions, geometry constraints have to be predefined. The type of elements, mesh density and solution parameters are describes by numerical model.

Computer aided engineering (FEM based) simulation process includes four steps

(a) Preprocessing: create or import the geometry, definition of material, meshing, finalizing the boundary conditions, declaration of the number of steps, stopping criteria, providing input parameters et..

(b) Simulation process: The solver runs the simulation to execute the FEA.

(c) Post processing: After completion of simulation is display in the post processor.

(d) Results analysis and evaluation: All the results received from the post processor, are analyzed and evaluated.

The simulation results received from the DEFORM 3D are compared with the experimental data. The results which are received from the simulation are not acceptable, then appropriate modifications have to be made in terms of part design and modeling, tool geometry and design, process conditions, material and its properties, and re-simulate the process are agreed with experimental results.

**Solid Modelling:**

Various parts such as upper and lower die, two axial plungers and tubular blanks with three different lengths are modelled with dimensions same as the experimental setup using AutoCAD 16 and are shown in below figures 3-6. Geometrical details of the die and tube are given in table 1.
All dimensions of the die and axial plungers are same as the experimental die setup shown in figure 7. The simulations for the free bulge test of a straight tube is performed using DEFORM 3D and the simulation runs has conducted at various conditions as per the Taguchi’s L27 orthogonal array on the INCONEL 600 tube.

Presently, INCONEL 600 is considered as the tube material. This material having superior properties like resistant to corrosion, heat and oxidation since it is a nickel based super alloy. This material exhibits high tensile strength and good creep properties.

![Figure 7. Experimental die setup](image)

Detail of the chemical composition of the stated material are noted in table 2. Table 3 illustrated the mechanical properties of the tubular material.

**Table 2. Chemical Composition of Annealed INCONEL 600**

<table>
<thead>
<tr>
<th>Element</th>
<th>Ni</th>
<th>Cr</th>
<th>Fe</th>
<th>Mn</th>
<th>Cu</th>
<th>Si</th>
<th>S</th>
<th>C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Percentage</td>
<td>72.31</td>
<td>16.54</td>
<td>9.90</td>
<td>0.14</td>
<td>0.017</td>
<td>0.4</td>
<td>0.001</td>
<td>0.012</td>
</tr>
</tbody>
</table>

**Table 3. Tensile Properties of the Tube Material**

<table>
<thead>
<tr>
<th>0.2% proof load(KN)</th>
<th>Ultimate load(KN)</th>
<th>0.2% proof stress (MPa)</th>
<th>U.T.S (MPa)</th>
<th>Modulus (MPa)</th>
<th>% of elongation</th>
</tr>
</thead>
<tbody>
<tr>
<td>3.02</td>
<td>9.55</td>
<td>174</td>
<td>549</td>
<td>153084</td>
<td>41.64</td>
</tr>
</tbody>
</table>
The aim of free bulging THP is to test the hydro-formability in terms the maximum possible bulge without any defects. To study the bulge, bulge ratio denoted by \( \frac{d_f}{d_i} \) is taken as output responses. To investigate the variation in the thickness during the bulge, another output response selected is the thinning ratio. The thinning and the bulge ratio are two output responses considered. The thinning ratio is defined by

\[
\text{Thinning ratio} = \frac{t_o - t_f}{t_o}
\]

\[
\text{Bulge ratio} = \frac{d_f}{d_i}
\]

Where \( t_o \) and \( t_f \) are the original and final thicknesses before and after the THP, \( d_i \) and \( d_f \) are the initial and final diameters of the before and after bulge tube hydroforming as shown in Fig. 2.

From literature study, internal pressure, axial movement and tube length are most effecting input parameters on the bulge and thinning ratio. Due to this reason, the above parameters are taken as the decision variables and trial experiments were conducted to find the working range of input parameters. Two levels such as maximum and minimum levels are coded with +1 and -1. The middle level of each factor is coded with ‘0’ and calculated using following expression (1).

\[
X_i = \frac{2[2X - (X_U + X_L)]}{(X_U - X_L)}
\]

Here, \( X_L \) and \( X_U \) represents the minimum level and \( X_U \) represents the maximum level. \( X_i \) denotes is intermediate level coded value of each parameter \( X \). \( X \) is a value between \( X_L \) to \( X_U \) of each process parameter. For the current investigation all process parameter, its ranges and units are shown in the table 4.

**TABLE 4. RANGES AND LEVELS PROCESS PARAMETERS OF TUBE HYDROFORMING**

<table>
<thead>
<tr>
<th>Process parameters</th>
<th>Units</th>
<th>Notation</th>
<th>Low level (-1)</th>
<th>Centre level (0)</th>
<th>High level (+1)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Internal Pressure (P)</td>
<td>Bar</td>
<td>( x_1 )</td>
<td>230</td>
<td>250</td>
<td>270</td>
</tr>
<tr>
<td>Axial Movement (AM)</td>
<td>mm/sec</td>
<td>( x_2 )</td>
<td>0.2</td>
<td>0.35</td>
<td>0.5</td>
</tr>
<tr>
<td>Length of the Tube (L)</td>
<td>mm</td>
<td>( x_3 )</td>
<td>195</td>
<td>210</td>
<td>225</td>
</tr>
</tbody>
</table>

FEM simulation has done at 27 different process conditions as per Taguchi L27 orthogonal array. The 27 different process conditions are showing in table 5.

**TABLE 5. L27 ORTHOGONAL ARRAY FOR SIMULATION TUBE HYDROFORMING**

<table>
<thead>
<tr>
<th>Run</th>
<th>( X_1: \text{Internal pressure} )</th>
<th>( X_2: \text{Axial force} )</th>
<th>( X_3: \text{Length} )</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>230</td>
<td>0.2</td>
<td>195</td>
</tr>
<tr>
<td>2</td>
<td>230</td>
<td>0.2</td>
<td>210</td>
</tr>
<tr>
<td>3</td>
<td>230</td>
<td>0.2</td>
<td>225</td>
</tr>
<tr>
<td>4</td>
<td>230</td>
<td>0.35</td>
<td>195</td>
</tr>
<tr>
<td>5</td>
<td>230</td>
<td>0.35</td>
<td>210</td>
</tr>
<tr>
<td>6</td>
<td>230</td>
<td>0.35</td>
<td>225</td>
</tr>
<tr>
<td>7</td>
<td>230</td>
<td>0.5</td>
<td>195</td>
</tr>
<tr>
<td>8</td>
<td>230</td>
<td>0.5</td>
<td>210</td>
</tr>
<tr>
<td>9</td>
<td>230</td>
<td>0.5</td>
<td>225</td>
</tr>
<tr>
<td>10</td>
<td>250</td>
<td>0.2</td>
<td>195</td>
</tr>
<tr>
<td>11</td>
<td>250</td>
<td>0.2</td>
<td>210</td>
</tr>
<tr>
<td>12</td>
<td>250</td>
<td>0.2</td>
<td>225</td>
</tr>
<tr>
<td>13</td>
<td>250</td>
<td>0.35</td>
<td>195</td>
</tr>
<tr>
<td>14</td>
<td>250</td>
<td>0.35</td>
<td>210</td>
</tr>
<tr>
<td>15</td>
<td>250</td>
<td>0.35</td>
<td>225</td>
</tr>
<tr>
<td>16</td>
<td>250</td>
<td>0.5</td>
<td>195</td>
</tr>
<tr>
<td>17</td>
<td>250</td>
<td>0.5</td>
<td>210</td>
</tr>
<tr>
<td>18</td>
<td>250</td>
<td>0.5</td>
<td>225</td>
</tr>
<tr>
<td>19</td>
<td>270</td>
<td>0.2</td>
<td>195</td>
</tr>
<tr>
<td>20</td>
<td>270</td>
<td>0.2</td>
<td>210</td>
</tr>
<tr>
<td>21</td>
<td>270</td>
<td>0.2</td>
<td>225</td>
</tr>
<tr>
<td>22</td>
<td>270</td>
<td>0.35</td>
<td>195</td>
</tr>
<tr>
<td>23</td>
<td>270</td>
<td>0.35</td>
<td>210</td>
</tr>
<tr>
<td>24</td>
<td>270</td>
<td>0.35</td>
<td>225</td>
</tr>
<tr>
<td>25</td>
<td>270</td>
<td>0.5</td>
<td>195</td>
</tr>
<tr>
<td>26</td>
<td>270</td>
<td>0.5</td>
<td>210</td>
</tr>
<tr>
<td>27</td>
<td>270</td>
<td>0.5</td>
<td>225</td>
</tr>
</tbody>
</table>

**METHODOLOGY**

Figure. 8 explains that the current methodology and discussed about various steps of the proposed methodology in further sections. Many number of variables are effects the hydroforming process. Among these variables, the significant variables are determined by the literature and from the trail experiments. To minimize the computational difficulty, only significant process parameters are considered for the analysis.
17]. DOE is used to minimize the time, material and cost for the process. Using DOE, Taguchi L27 simulation runs are selected to analyze the process without effecting accuracy

Figure 8. The flow chart of the proposed methodology.

Response Surface Methodology (RSM):

The RSM is a mathematical tool to investigate the relationships between input factor of the tube hydroforming process to process responses. By applying the regression analysis on the experimental results, it produces a model of output responses to some individual factors.

All the independent input parameters of the process are denoted in quantitative form as shown in the following equation

\[ Y = f(X_1, X_2, X_3, \ldots, X_n) \pm \epsilon \]  
\[ (2) \]

Here \( X_1, X_2, X_3, \ldots, X_n \) are the independent input parameters, \( Y \) is the output response and \( f \) is its function. The main aim of RSM is to approximating the function \( f \) using appropriate lower order polynomial in some region of the independent input parameters. If the outcome is well defined by a linear model of the input parameters, the expression (2) can be rewrite as the linear model (2):

\[ Y = C_0 + C_1X_1 + C_2X_2 + \ldots + C_nX_n \pm \epsilon \]  
\[ (3) \]

However, if a curvature appears in the system, then a higher order polynomial such as the quadratic model may be used and expressed as follows (4)

\[ Y = C_0 + \sum_{i=1}^n C_iX_i + \sum_{i=1}^n d_iX_i^2 \pm \epsilon \]  
\[ (4) \]

The goal of the RSM is to explore the responses within the limits of process parameters and also to find the province of interest where the out responses reaches its optimum or near optimal value [1].

Response Surface methodology Procedural steps:

Various sequential steps of RSM are described below [18-22]:

1. The initial step involved in RSM is establishment of design of experiments to conduct appropriate experiments or simulations to found reliable responses.

2. Development of a numerical model of the second order response surface with the best fittings.

3. Locating the optimal set of experimental or simulation tube hydroforming process parameters that provides the high or low value of output response.

4. Represent the influence of the input factor on the response both directly and the interactively using 2 dimensional and 3 dimensional graphs.

Design of Experiments (DOE):

The initial and important step in RSM is DOE after finalizing the problem statement. As per the previous research, number of experimental designs are existed such are Full Factorial Designs, Fractional Factorial Designs, Latin-square Designs, Box-Behnken Designs, Central Composite Designs (CCD), V-Optimal Designs, A-Optimal Designs, G-Optimal Designs, D-Optimal Designs.

From the above experimental designs, one among them has to be selected based on the requirements and constraints. For the present research work, Central Composite Designs (CCD) is chosen to finish the experiments and simulation runs.

Central Composite Design (CCD)

One of the popular experimental design for response surface methodology is central composite design.

The CCD has 3 sets of design points and are listed below

- Factorial points,
- Star or axial points,
- Center points.

All points in CCD are defined in terms of coded values like -1, 0, 1 are shown in the figure 9. CCD are intended to approximate the coefficients of a quadratic model.

Figure 9. Illustration of Points in central composite design
Factorial Points:
In 3 level and 3 factor experimental design, all levels of the factors are code with -1, 0, and 1. Here ‘-1’ represent the low level of the factor and ‘+1’ represent the high level of the factor and ‘0’ the intermediate value. All possible combinations of the levels (coded values -1, 0 and 1) of each factors are included in three level factorial design. All corners of the cube in the figure represent factorial points. There are eight factorial design points possible for a 3-factor case in central composite design as shown in figure 9. Following are the eight combinations of this design.

(1, 1, -1) (1, -1, -1) (-1, -1, -1) (-1, 1, -1) (1, 1, 1) (1, -1, 1) (-1, -1, 1) (-1, 1, 1)

Star or Axial Points:
Star points or axial points are found at center of each face of the cube and are showing in figure 9. The other name for this design is face centered CCD. Following are the 6 possible combinations of this design.

(0, 1, 0) (0, 0, -1) (1, 0, 0) (-1, 0, 0) (0, 0, 1) (0, -1, 0)

Center Points:
Center points represent the points when all level of each factors are set to 0 that is intermediate point of each factor. This is represented as (0, 0, 0) shown in figure 9.

RESULTS & DISCUSSION
Bulge and thickness are measured and calculated bulge and thinning ratios from the bulge and thinning ratio expressions after successful simulation runs at different conditions and are noted in table 6.

### TABLE 6. TUBE HYDROFORMING RESPONSES AT DIFFERENT CONDITIONS.

<table>
<thead>
<tr>
<th>Run</th>
<th>Internal Pressure</th>
<th>Axial Force</th>
<th>C:Length</th>
<th>D/Di</th>
<th>(T_f-T_i)/T_i</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>230</td>
<td>0.2</td>
<td>195</td>
<td>1.125</td>
<td>0.2335</td>
</tr>
<tr>
<td>2</td>
<td>230</td>
<td>0.2</td>
<td>210</td>
<td>1.1556</td>
<td>0.2361</td>
</tr>
<tr>
<td>3</td>
<td>230</td>
<td>0.2</td>
<td>225</td>
<td>1.1054</td>
<td>0.2343</td>
</tr>
<tr>
<td>4</td>
<td>230</td>
<td>0.35</td>
<td>195</td>
<td>1.2416</td>
<td>0.21874</td>
</tr>
<tr>
<td>5</td>
<td>230</td>
<td>0.35</td>
<td>210</td>
<td>1.2182</td>
<td>0.2242</td>
</tr>
<tr>
<td>6</td>
<td>230</td>
<td>0.35</td>
<td>225</td>
<td>1.2216</td>
<td>0.2305</td>
</tr>
<tr>
<td>7</td>
<td>230</td>
<td>0.5</td>
<td>195</td>
<td>1.2904</td>
<td>0.2172</td>
</tr>
<tr>
<td>8</td>
<td>230</td>
<td>0.5</td>
<td>210</td>
<td>1.2871</td>
<td>0.2325</td>
</tr>
<tr>
<td>9</td>
<td>230</td>
<td>0.5</td>
<td>225</td>
<td>1.2225</td>
<td>0.23071</td>
</tr>
</tbody>
</table>

Development of Empirical models:
After successful completion of simulation runs for tube hydroforming at 27 different conditions, the output responses such as bulge and thinning ratio are collected and used to employed the proposed methodology. The aim the present methodology is to finding the mathematical relationship between out puts to the process parameters is to optimize tube hydroforming.

Design Expert10 V is a statistical analysis tool [15]. Using Design Expert, regression coefficients of the proposed modes are computed.

Analysis of variance (ANOVA):
Using quadratic model, analysis of variance is carried out. The statistical data of analysis of variance for the bulge ratio is noted in table 7 and for thinning ratio is noted in table 8. From previous study, it is noted that the value of “prob. > F” is less than 0.05 then the model which is proposed is treated as significant. From the 7 and 8, it is observed that the values of “prob. > F” are lesser than 0.05 in all instance for the proposed model and this indicate that the proposed models [16] are significant. The obtained equation for the above models are represent in the equation 4 and 5.
\[
\frac{d_f}{d_i} = +1.32 + 0.11x_1 - 0.061x_2 - 0.16x_3 + 0.047x_1x_2 \\
+ 0.26x_1x_3 - 0.066x_2x_3 - 0.046x_1^2 \\
+ 0.066x_2^2 - 0.16x_3^2 
\]  
\( (5) \)

\[
\frac{t_o - t_f}{t_o} = +0.20 - 0.020x_1 + 0.0848x_2 + 0.010x_3 \\
- 0.013x_1x_2 + 0.038x_1x_3 + 0.0954x_2x_3 \\
- 0.013x_1^2 + 0.13x_2^2 - 0.037x_3^2 
\]  
\( (6) \)

**TABLE 7. ANALYSIS OF VARIANCE [PARTIAL SUM OF SQUARES] FOR ΔF/ΔI**

<table>
<thead>
<tr>
<th>Source</th>
<th>Sum of Squares</th>
<th>df</th>
<th>Mean Square</th>
<th>F Value</th>
<th>p-value Prob &gt; F</th>
</tr>
</thead>
<tbody>
<tr>
<td>Model</td>
<td>1.80</td>
<td>9</td>
<td>0.20</td>
<td>45.30</td>
<td>&lt; 0.0001*</td>
</tr>
<tr>
<td>A-Internal pressure</td>
<td>0.20</td>
<td>1</td>
<td>0.20</td>
<td>45.32</td>
<td>&lt; 0.0001</td>
</tr>
<tr>
<td>B-Axial force</td>
<td>0.068</td>
<td>1</td>
<td>0.068</td>
<td>15.33</td>
<td>0.0011</td>
</tr>
<tr>
<td>C-Length</td>
<td>0.47</td>
<td>1</td>
<td>0.47</td>
<td>106.61</td>
<td>&lt; 0.0001</td>
</tr>
<tr>
<td>AB</td>
<td>0.026</td>
<td>1</td>
<td>0.026</td>
<td>5.99</td>
<td>0.0256</td>
</tr>
<tr>
<td>AC</td>
<td>0.80</td>
<td>1</td>
<td>0.80</td>
<td>180.41</td>
<td>&lt; 0.0001</td>
</tr>
<tr>
<td>BC</td>
<td>0.052</td>
<td>1</td>
<td>0.052</td>
<td>11.71</td>
<td>0.0033</td>
</tr>
<tr>
<td>A2</td>
<td>0.013</td>
<td>1</td>
<td>0.013</td>
<td>2.91</td>
<td>0.1065</td>
</tr>
<tr>
<td>B2</td>
<td>0.026</td>
<td>1</td>
<td>0.026</td>
<td>5.95</td>
<td>0.0260</td>
</tr>
<tr>
<td>C2</td>
<td>0.15</td>
<td>1</td>
<td>0.15</td>
<td>33.51</td>
<td>&lt; 0.0001</td>
</tr>
<tr>
<td>Residual</td>
<td>0.075</td>
<td>17</td>
<td>4.419E-003</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Cor Total</td>
<td>1.88</td>
<td>26</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Std. Dev.</td>
<td>0.066</td>
<td></td>
<td>R-Squared</td>
<td>0.9229</td>
<td></td>
</tr>
<tr>
<td>Mean</td>
<td>1.14</td>
<td></td>
<td>Adj R-</td>
<td>0.8821</td>
<td></td>
</tr>
</tbody>
</table>

* - Refers to Significant terms

**Acceptability or adequacy test:**

The obtained empirical models from the ANOVA are tested for their acceptability

**Multiple regression coefficients (R^2):**

The acceptability or adequacy test using regression coefficient is one the popular method. R^2 is calculated to authenticate that whether the fitted models actually describe the experimental or simulation data. The quality of the fit for the obtained model is generally expresses in terms of R^2[16].The multiple regression coefficient R^2 is defined as the ratio of variability given by the model and total variability in the experimental or simulation data. From the literature, if regression coefficient value i.e. R^2 value is nearer to 1, then the obtained model is fits for the experimental or simulation data.

The regression coefficient R^2 in the table 7 for the bulge ratio is obtained 0.9229 which is closer to 1(unity) and which is noticed that the 2nd-order model can illuminate the variation in bulge ratio up to the extent of 92.29%.

From Table 8, it is noticed that regression coefficient R^2 is 0.8821 for the thinning ratio. This shows, the 2nd-order model can illuminate the variation in thinning ratio up to the extent of 88.21%.

The adjusted R^2 is used to provide opportunity to estimate a further appropriate estimation of R^2 value. Using expression 7, the adjusted R^2 value is to be computed.

\[
Adjusted R^2 = 1 - \frac{[(1-R^2)(N-1)]}{N-K-1} 
\]  
\( (7) \)

Here, N stands for number of observations and K stands for total number of predictors. R^2 is depends on N and K. If value N is smaller and K is larger, then the variation between R^2 and adjusted R^2 is larger (since(N-1) / (N-K-1) << 1). In other hand, if value N is very large and K is small, then the variation between the R^2 and adjusted R^2 is very minimum, that means the value of R^2 is much closer to adjusted R^2 value (since(N-1) / (N-K-1) is closer to 1).

It is noticed that form the table 7 for the bulge ratio the R^2 and adjusted R^2 values are 0.9929 and 0.8821 which are closer to each other.

Whereas for the thinning ratio from the table 8

It is observed that the R^2 and adjusted R^2 values are 0.9611 and 0.9405. the variation between R^2 and adjusted R^2 is very minimum.

From the ANOVA statistics of the bulge ratio and thinning ratio, it is observed that the values of R^2 and adjusted R^2 are closer to each other and the variation is minimum. This means that the model which is developed can represent the process adequately.

**TABLE 8. ANALYSIS OF VARIANCE [PARTIAL SUM OF SQUARES] FOR (ΔF/ΔI)**

<table>
<thead>
<tr>
<th>Source</th>
<th>Sum of Squares</th>
<th>df</th>
<th>Mean Square</th>
<th>F Value</th>
<th>p-value Prob &gt; F</th>
</tr>
</thead>
<tbody>
<tr>
<td>Model</td>
<td>0.15</td>
<td>9</td>
<td>0.016</td>
<td>49.38</td>
<td>&lt; 0.0001*</td>
</tr>
<tr>
<td>A-Internal pressure</td>
<td>7.438E-003</td>
<td>1</td>
<td>7.438E-003</td>
<td>22.66</td>
<td>0.0002</td>
</tr>
<tr>
<td>B-Axial force</td>
<td>1.297E-003</td>
<td>1</td>
<td>1.297E-003</td>
<td>3.95</td>
<td>0.0632</td>
</tr>
</tbody>
</table>
Further, the adequacy of the developed model is validated using normal probability plot of residuals. The normal probability plots are plotted to validate where the data is normally distributed and for any assumption is violated. If all the data points are distributed closer to the line in normal probability plot, then it is considered that the normality of the developed model is feasible. If the data points are spattered away from the line, then normality of the developed model is treated as not feasible.

The normal probability plots of the residuals for bulge ratio and thinning ratio are shown in figure 10 and figure 11 respectively. These plots are used to assess the model adequacy.

**CONCLUSIONS**

Tube hydroforming is one of the advanced forming technique to form difficult tubular components in a single phase. Even many number advantages like structural properties, minimum number of secondary operation etc. with tube hydroforming, but industries still facing the problems to use hydroforming technique like selection of optimum process parameters. In present research bulge ratio and thinning ratio are taken as the quality characteristics to verify the quality of TFP. At initial stage of tube hydroforming, one of the crucial stage is the selection of input factors since these are show a major role to achieve better bulge ratio and thinning ratio.

Therefore, it requires the development of a methodology to find the optimum process parameter. In present investigation internal pressure, axial feed and length of the tube are taken as process parameters to achieve desired product quality as these are more significant. In this research mainly focused on development of empirical models for the input process parameters by using simulation data.

Equation 4 and 5 are the two numerical model which are developed in this investigation. From the table 7 and 8, it observed that the $R^2$ values for bulge ratio and thinning ratio are found to be 0.9929 and 0.9611 which are very close to 1. That designates that the developed models can be used for further optimization of the hydroforming process parameters.
analysis and optimization. The normal probability plots are also plotted between the process parameters and the output responses. Hence, this methodology for tube hydroforming can be used to automate the process.

ACKNOWLEDGMENT

The authors are thankful to the MITS, Madanapalle, AP, India for supporting cooperation for successful completion this research and also thankful to University Grant Commission (UGC) for providing financial support through minor research project grant (Proposal No. 6099/15).

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