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Standard Test Method for Plastic Strain Ratio r for Sheet Metal¹

This standard is issued under the fixed designation E517; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reappraisal. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reappraisal.

1. Scope

1.1 This test method covers special tension testing for the measurement of the plastic strain ratio, r , of sheet metal intended for deep-drawing applications.

1.2 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.3 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.4 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 *ASTM Standards:*²

E6 Terminology Relating to Methods of Mechanical Testing

E8/E8M Test Methods for Tension Testing of Metallic Materials

E83 Practice for Verification and Classification of Extensometer Systems

E92 Test Methods for Vickers Hardness and Knoop Hardness of Metallic Materials

E177 Practice for Use of the Terms Precision and Bias in ASTM Test Methods

E691 Practice for Conducting an Interlaboratory Study to Determine the Precision of a Test Method

3. Terminology

3.1 *Definitions of Terms Specific to This Standard:*

3.1.1 *delta r (Δr)*—measure of the tendency of sheet to draw in nonuniformly and to form ears in the flange of deep-drawn cylindrical parts in the directions of higher r value (see 10.4).

3.1.1.1 *Discussion*—In cold-reduced and annealed low-carbon steel sheet, r_0 and r_{90} are usually greater than r_{45} , while in hot-rolled steels r_{45} may be greater. Other earing tendencies occur; thus, for some materials the earing tendency may be better represented by $r_{\max} - r_{\min}$.

3.1.2 *plastic-strain ratio r* (in sheet metal that has been strained by uniaxial tension sufficiently to induce plastic flow) is the ratio of the true strain that has occurred in a width direction w perpendicular to the direction of applied stress and in the plane of the sheet, to the concomitant true strain in the thickness direction t . Thus, r is numerically equal to

$$r = \epsilon_w / \epsilon_t \quad (1)$$

where:

ϵ_w = width strain, and

ϵ_t = thickness strain.

¹ This test method is under the jurisdiction of ASTM Committee E28 on Mechanical Testing and is the direct responsibility of Subcommittee E28.02 on Ductility and Formability.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

3.1.2.1 *Discussion*—Due to difficulty in measuring thickness changes with sufficient precision, in practice an equivalent relationship is commonly used, based on length and width strain measurements (see 9.1.2):

3.1.3 r_m —weighted average of r values obtained in three directions: 0° (parallel), 45° (diagonal), and 90° (transverse) to the rolling direction (see 10.3):

3.1.3.1 *Discussion*—Some materials may show significantly different values of r for other test directions, in which case an average value may include these when special note is made and another subscript is used to avoid confusion with r_m as defined in 3.1.3. Symbols which are often used interchangeably with r_m are r^- and r -Bar:

3.1.4 *yield point elongation* (for a material that has a yield point) is the total strain associated with discontinuous yielding.

3.1 The definitions relating to tension testing appearing in Terminology E6 shall apply to this test method. *Definitions of Terms Common to Mechanical Testing:*

3.1.1 The definitions relating to tension testing appearing in Terminology E6 shall apply to this test method. Some of those important terms include discontinuous yielding, yield-point elongation, and upper yield strength.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *earing tendency delta, r or Δr , n* —measure of the tendency of sheet to draw in nonuniformly and to form ears in the flange of deep-drawn cylindrical parts in the directions of higher values of r (see 10.4).

3.2.1.1 *Discussion*—

In cold-reduced and annealed low-carbon steel sheet, r_0 and r_{90} are usually greater than r_{45} , while in hot-rolled steels r_{45} can be greater. Other earing tendencies occur; thus, for some materials the earing tendency can be better represented by $r_{\max} - r_{\min}$:

3.2.2 *plastic strain ratio, r , n* —in sheet metal that has been strained by uniaxial tension sufficiently to induce plastic flow, the ratio of the true strain that has occurred in a width direction w perpendicular to the direction of applied stress and in the plane of the sheet, to the concomitant true strain in the thickness direction t .

3.2.2.1 *Discussion*—

The plastic strain ratio, r , is numerically equal to

$$r = \epsilon_w / \epsilon_t \quad (1)$$

where:

ϵ_w = width strain, and
 ϵ_t = thickness strain.

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3.2.2.2 *Discussion*—

Due to difficulty in measuring thickness changes with sufficient precision, in practice an equivalent relationship is commonly used, based on length and width strain measurements (see 9.1.2).

3.2.3 r_m —weighted average of values of r obtained in three directions: 0° (parallel), 45° (diagonal), and 90° (transverse) to the rolling direction (see 10.3).

3.2.3.1 *Discussion*—

Some materials may show significantly different values of plastic strain ratio, r , for other test directions, in which case an average value may include these when special note is made and another subscript is used to avoid confusion with r_m as defined in 3.2.3. Symbols that are often used interchangeably with r_m are r^- and r -Bar.

4. Significance and Use

4.1 The plastic strain ratio r is a parameter that indicates the ability of a sheet metal to resist thinning or thickening when subjected to either tensile or compressive forces in the plane of the sheet. It is a measure of plastic anisotropy and is related to the preferred crystallographic orientations within a polycrystalline metal. This resistance to thinning or thickening contributes to the forming of shapes, such as cylindrical flat-bottom cups, by the deep-drawing process. The value of r , therefore, is considered a measure of sheet-metal drawability. It is particularly useful for evaluating materials intended for parts where a substantial portion of the blank must be drawn from beneath the blank holder into the die opening.

4.2 For many materials ~~this the~~ plastic strain ratio remains essentially constant over a range of plastic strains up to maximum applied force in a tension test. For materials that give different values of r values at various strain levels, a superscript is used to designate the percent strain at which the value of r value was measured. For example, if a 20 % elongation is used, the report would show r^{20} .

4.3 Materials usually have different values of r values when tested in different orientations relative to the rolling direction. The angle of sampling of the individual test ~~coupons~~ specimen is noted by a subscript. Thus, for a test specimen whose length is aligned parallel to the rolling direction, ~~the plastic strain ratio, r , value would be~~ reported as r_0 . If, in addition, the measurement was made at 20 % elongation and it was deemed necessary to note the percent strain at which the value was measured, the value would be reported as r_0^{20} .

4.4 A material that has ~~a yield an~~ upper yield strength (yield point) point followed by discontinuous yielding stretches unevenly while this yielding is taking place. In steels, this is associated with the propagation of Lüders' bands on the surface. The accuracy and reproducibility of the determination of plastic strain ratio, r , will be reduced unless the test is continued beyond this yield-point elongation. Similarly, the discontinuous yielding associated with large grain size in a material decreases the accuracy and reproducibility of determinations of plastic strain ratio, r , made at low strains.

5. Interferences

5.1 Many factors ~~may~~ affect the measurements taken for determining ~~the value of r value~~. In particular, errors in the measurement of the change in width can cause the reported ~~the value of r value~~ to be invalid. The following phenomena are known to cause severe errors in the measurement of the change in width ~~thus affecting the and affect the value of r value~~ reported.

5.1.1 ~~Canoeing—Canoeing—~~Canoeing is a phenomenon ~~which that~~ occurs in some materials when they are stretched. In these materials, the test specimen bows about its longitudinal axis ~~taking and takes~~ on a shape resembling the bottom of a canoe. In this case, unless the measurements of the change in width are compensated for, there will be significant errors in the ~~calculated~~ value of r .

5.1.2 ~~Sharp Knife Edges—Sharp—~~Knife Edges—Knife edges, used to measure the change in width automatically, while the specimen is stretched, ~~may can~~ cause localized deformation of the specimen under the knife edges. This problem is intensified ~~by if~~ the knife edges ~~being are~~ sharp and attached to the specimen with high forces. This combination produces a compressive stress 90° to the tensile stress ~~being~~ applied to stretch the specimen, which causes localized deformation. As a result, excessively high values of r values ~~may be~~ are calculated.

6. Apparatus

6.1 Measuring Devices:

6.1.1 Instruments for measuring length and width shall be checked for accuracy and be graduated to permit measurements to be made to ± 0.001 in. (± 0.02 mm) or better.

6.1.2 If the longitudinal strain or the transverse strain, or both, are to be obtained using an extensometer, the extensometer system shall conform to Practice E83 as Class C or better. The ~~extensometers—extensometer~~ system shall be verified over a range appropriate for the strains used to determine the plastic strain ratio, r value.

6.2 ~~Testing Machine—~~The testing machine used to strain the specimen shall be capable of uniaxially straining the specimen in accordance with the requirements in 9.2.5 or 9.3.4.

7. Test Specimen

7.1 ~~Size—~~The length and width of the specimen are not critical, provided care is used to stretch the gauge section in a uniform manner, avoiding grip effects and anomalous changes along the gauge lengths.

7.1.1 The specimen shall include the full sheet thickness unless otherwise specified.

7.1.2 The thickness of the gauge section of the specimen shall be uniform within 0.0005 in. (0.013 mm) in the gauge section. If the as-received surface is nonuniform, the surface shall be prepared by machining or by grinding to this tolerance.

7.1.3 The distance between a gauge mark and a grip shall be at least twice the width of the reduced section (or gauge width for parallel strips) of the specimen.

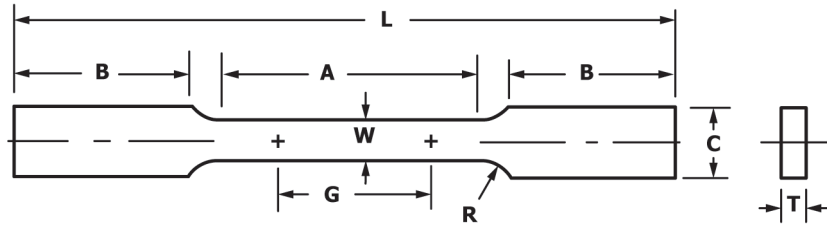
7.1.4 Duplicate specimens should be tested and the average value of r value of these reported for each test direction. If necessary, a third determination may be made, rejecting the extreme.

7.2 ~~Type—~~Any of three types of specimen may be used. Other types including subsize specimens ~~are acceptable—~~may be used provided they give comparable values of equivalent accuracy.

7.2.1 *Specimen A, with reduced section, as shown in Fig. 1*—While this is similar to Fig. 6 of Test Methods E8E8/E8M, the reduced section shall be parallel-sided rather than tapered.

7.2.2 *Specimen B, with a uniform width of 0.75 in. (20 mm), machined edges, and no reduced section, as shown in Fig. 2.*

7.2.3 *Specimen C, precision-sheared a uniform width of 1.125 in. (28.58 mm), or with machined edges and no reduced section, as shown in Fig. 3.*



Dimensions

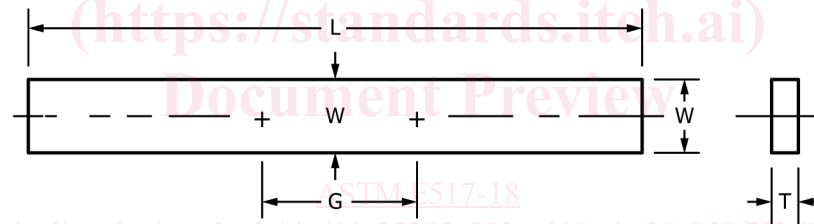
		Specimen A			
		Standard		Alternative	
		in.	mm	in.	mm
G	Gage length	2.00 ± 0.01	50 ± 0.25	1.00 ± 0.005	25 ± 0.13
G	Gauge length	2.00 ± 0.01	50 ± 0.25	1.00 ± 0.005	25 ± 0.13
W	Width (Note 2 and Note 3)	0.500 ± 0.01	12.5 ± 0.25	0.500 ± 0.01	$12.5 \pm 0.25^{\dagger}$
W	Width (Note 1 and Note 2)	0.500 ± 0.01	12.5 ± 0.25	0.500 ± 0.01	12.5 ± 0.25
T	Thickness	thickness of material		thickness of material	
R	Radius of fillet, min	$\frac{1}{2}$	13	$\frac{1}{2}$	13
L	Overall length, min	8	200	$7\frac{1}{4}$	180
A	Length of reduced section, min	3	75	$2\frac{1}{4}$	60
B	Length of grip section, min	2	50	2	50
C	Width of grip section, approximate	$\frac{3}{4}$	20	$\frac{3}{4}$	20

NOTE 1—The edges of the reduced section shall be machined parallel over the gauge length within a tolerance of 0.0005 in. (0.012 mm).

NOTE 2—The ends of the reduced section shall not differ in width by more than 0.005 in. or 0.013 mm. However, the width within the gauge length must conform to 8.3.

[†]Editorially corrected in June 2007.

FIG. 1 Rectangular Tension Test Specimens with Reduced Parallel Section, for Section Determination



Dimensions

		Specimen B			
		Standard		Alternative	
		in.	mm	in.	mm
G	gauge length	2.00 ± 0.01	50 ± 0.25	1.00 ± 0.005	25 ± 0.13
W	gauge width	0.75 ± 0.005	20 ± 0.13	0.75 ± 0.005	20 ± 0.13
G	gauge length	2.00 ± 0.01	50 ± 0.25	1.00 ± 0.005	25 ± 0.13
W	gauge width	0.75 ± 0.005	20 ± 0.13	0.75 ± 0.005	20 ± 0.13
T	Thickness	thickness of material		thickness of material	
L	Overall length, min	8	200	7	175
G	Width of specimen (Note)	0.75 ± 0.005	20 ± 0.13	0.75 ± 0.005	20 ± 0.13
C	Width of specimen (Note)	0.75 ± 0.005	20 ± 0.13	0.75 ± 0.005	20 ± 0.13

NOTE 1—Edges of Specimen B shall be machined parallel over the full length within a tolerance of 0.0008 in. (0.020 mm).

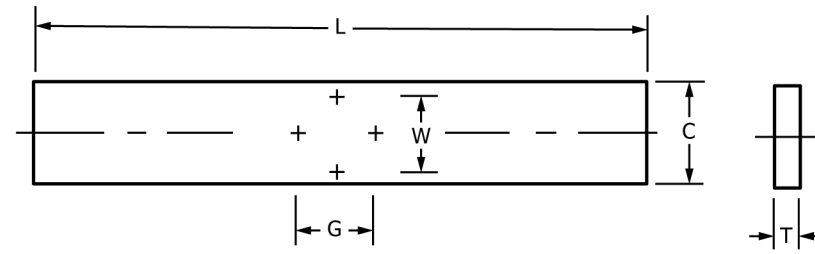
FIG. 2 Machined Rectangular Tension Test Specimens, Parallel Strip, for Strip Determination

7.2.3.1 Gauge lengths for Specimen C shall be marked on the sheet surface perpendicular to and parallel to the specimen edges. The gauge marks shall be made with Vickers diamond indenters described in Test Method E92, or similar precise marks.

8. Specimen Preparation

8.1 Specimen blanks shall be sheared or sawed individually and with the exception of Specimen C, which may be used as sheared, shall be machined individually or in packs to remove cold-worked edges.

8.2 The dimensions of each specimen shall be measured for uniformity of thickness and width in the gauge section to meet the requirements of 7.1.2 and 8.3.



		Specimen C	
		in.	mm
G	Gage Length	0.75 ± 0.005	20 ± 0.13
W	Gage Width	0.75 ± 0.005	20 ± 0.13
T	Thickness	thickness of material	
L	Overall Length, min	7	175
C	Width of specimen	1.125 ± 0.125	28.58 ± 3.17

FIG. 3 Sheared Rectangular Tension Test Specimen, Parallel Strip, for Strip Determination

8.3 Within the gauge length, parallelism of the edges shall be maintained so that no two width measurements differ by more than 0.1 % of the measured width (Specimens A and B only).

8.4 Reasonable care shall be taken to position the gauge marks symmetrically to the midpoint and centerline of the specimen or reduced section.

8.4.1 Gauge marks shall be lightly scribed or punched in the surface of the specimen or made with a Vickers diamond indenter.

8.4.2 The gauge lengths shall be in compliance with 7.1.3.

8.4.3 For Specimen A, the gauge length shall be centered in the reduced section.

8.4.4 For Specimen C, a double set of gauge marks shall be used in compliance with 7.2.3.1.

9. Procedure

9.1 If the tensile properties of the material are unknown, either establish strain limits for determining the plastic strain ratio. Either make an autographic force/extension record or run a separate tension test to determine the yielding characteristics and the elongation in accordance with Test Methods E8E8/E8M, using the specimen shown in Fig. 6 of Test Methods E8E8/E8M. This will establish strain limits within which the r determination may be made.

9.1.1 The plastic strain ratio, r , may be determined from width and thickness changes resulting from plastic deformation provided these changes can be measured with sufficient accuracy in a tension test.

9.1.2 For most thin sheet metals, however, it is preferable to measure the length and width changes should be measured and, assuming constant volume, calculate the value of r calculated by one of the following procedures: the Manual or Automatic Procedure:

9.2 Manual Procedure:

9.2.1 Determine the original width of the specimen, w_0 , within ± 0.0005 in. (± 0.013 mm). If a gauge length of 0.75 in. (20 mm) is used, as for Specimen C, one width measurement is sufficient. If a gauge length of 1.00 in. or (25 mm) or longer is used, make width measurements at a minimum of three evenly spaced places within the gauge length and use the average.

9.2.2 Measure the original gauge length, l_0 , within ± 0.001 in. (± 0.025 mm) in a 1.00-in. (25-mm), or a 0.75-in. (20-mm) gauge section, and within ± 0.002 in. (± 0.05 mm) in a 2.00-in. (50-mm) gauge section.

9.2.3 When gauge marks are made with two indenters mounted a known distance apart in a fixture, only final the original gauge length and width measurements are needed; measurements may be omitted.

9.2.4 Pull the specimen axially until it is stretched beyond any yield-point elongation but not exceeding the strain at maximum applied force. Measurement accuracy is improved as the strain is increased within the above limits, as explained in X3.3.1.

NOTE 1—Measurement accuracy is improved as the strain is increased within the above limits, as explained in X1.3.3.1. Strains of 15–20% are commonly utilized used for determining the r-value-plastic strain ratio of formable low carbon steel products.

9.2.5 The rate of straining shall be ≥ 0.5 in./in./min (0.5 mm/mm/min) or less, unless otherwise specified.

9.2.6 Measure the final width, w_f , and gauge length, l_f , in the same manner and tolerance as the initial values. Make these measurements with no tensile force applied to the specimen.

9.3 Automatic Procedure:

9.3.1 Attach extensometers conforming to that comply with 6.1.2 to the specimen to measure the longitudinal and transverse strain. Transverse extensometers must shall not cause and must shall not measure additional transverse deformation due to the knife edges deforming the specimen during the test.

9.3.2 Record the gauge length of the extensometers. In the case of the extensometer measuring transverse strain, the gauge length may be the width of the specimen.

9.3.3 Pull the specimen axially.

9.3.4 The rate of straining shall be $0.5/\text{min}$ – 0.5 in./in./min. (0.5 mm/mm/min) or less, unless otherwise specified.

9.3.5 Determine the change in width corresponding to a change in length from the data created by the extensometers, when the specimen is stretched beyond any yield-point elongation, but has not exceeded the strain at maximum applied force. Measurement accuracy is improved as the strain is increased within the above limits, as explained in X1.3.3.1.

NOTE 2—For complete compatibility with the manual method, only the plastic component of the strain values measured should be used in the determination of the Measurement accuracy r value by the automatic method, unless it can be shown that the elastic component of the total strain is negligible. (The error in calculated r value decreases with increasing strain, higher modulus, lower strength, and at lower r values.) Plastic strains can be determined by reducing the tensile force on the specimen to zero with the extensometers in place, or they can be calculated by subtracting the elastic strains from the total strains indicated by the extensometers. The longitudinal elastic strain at any point may be calculated by dividing the true stress at that point by the nominal value of the modulus of elasticity. The transverse elastic strain may be calculated by multiplying the longitudinal elastic strain by the nominal value of Poisson’s ratio. Examples: If an r value of 2.0 at 15 % strain is determined for steel using longitudinal and transverse strain measurements measured at a true stress of 50 000 psi (345 MPa), subtracting the elastic strain component from these is increased within the above limits, as explained in X1.3.3.1 measurements would increase the r value calculated from 2.0 to approximately 2.03. If an r value of 1.0 at 10 % strain is determined for aluminum using longitudinal and transverse strain measurements measured at a true stress of 50 000 psi (345 MPa), subtracting the elastic strain component from these measurements would increase the r value calculated from 1.0 to approximately 1.03.

9.3.5.1 For complete compatibility with the manual method, only the plastic component of the strain values measured should be used in the determination of the value of r by the automatic method, unless it can be shown that the elastic component of the total strain is negligible.

NOTE 3—The uncertainty in the calculated value of r decreases with increasing strain, higher modulus, lower strength, and at lower values of r . One method to determine plastic strain is to reduce the tensile force on the specimen to zero with the extensometers in place. Another method is to calculate the plastic strain by subtracting the elastic strains from the total strains indicated by the extensometers. The longitudinal elastic strain at any point is the true stress at that point divided by the nominal value of the modulus of elasticity. The transverse elastic strain can be calculated by multiplying the longitudinal elastic strain by the nominal value of Poisson’s ratio. Examples: If the plastic strain ratio at 15 % strain determined for steel using longitudinal and transverse strain measurements and measured at a true stress of 50 000 psi (345 MPa) is $r = 2.0$, subtracting the elastic strain component from these measurements would increase the calculated value of r from 2.0 to approximately 2.03. If the plastic strain ratio at 10 % strain determined for aluminum using longitudinal and transverse strain measurements measured at a true stress of 50 000 psi (345 MPa) is $r = 1.0$, subtracting the elastic strain component from these measurements would increase the calculated value of r from 1.0 to approximately 1.03.

9.3.6 l_o = the gauge length of the longitudinal extensometer.

9.3.7 w_o = the gauge length of the transverse extensometer.

9.3.8 l_f = l_o + the change in length determined in 9.3.5.

9.3.9 w_f = w_o + the change in width determined in 9.3.5.

NOTE 3—The manual procedure shall be used as a referee. [ASTM E517-18](#)

9.3.10 The manual procedure shall be used as a referee. [35283-593c-408e-ba38-959f53b481bc/astm-e517-18](#)

10. Calculation

10.1 Calculate the plastic strain ratio, r , as follows:

$$r = \epsilon_w / \epsilon_t \tag{2}$$

$$r = \frac{\epsilon_w}{\epsilon_t} \tag{2}$$

where:

$$\epsilon_w = \ln(w_f / w_o) \text{ and}$$

$$\epsilon_t = \ln(l_f / l_o)$$

Assuming the volume remains constant:

$$\epsilon_t = \ln(l_o w_o / l_f w_f) \tag{3}$$

$$\epsilon_t = \ln\left(\frac{l_o w_o}{l_f w_f}\right) \tag{3}$$

10.1.1 Invert as follows to eliminate negative values:

$$r = \frac{\ln(w_o / w_f)}{\ln(l_f w_f / l_o w_o)} \tag{4}$$

$$r = \frac{\ln\left(\frac{w_o}{w_f}\right)}{\ln\left(\frac{l_f w_f}{l_o w_o}\right)} \tag{4}$$