



Sheet Metal Deep Drawing and Cupping Tester - QualiCDTT™ 60



STANDARDS

EN 1669

ISO 11531

ISO 1520

ISO 20482

APPLICATIONS

Sheet Metal Deep Drawing Tester and Cupping Testing Machine QualiCTDD™ 60

This advanced **Computer-Controlled Deep Drawing and Cupping Testing Machine** is a precision instrument for testing the process performance of metal sheets and strips. The Erichsen cupping test is conducted according to standards ISO 20482 and ISO 1520. The deep drawing or earing test device complies with EN1669 and ISO 11531 standards. The hole expansion test device adheres to ISO 16630 standards.

This machine conforms "Metal Material Sheet and Thin Belt Erichsen Cupping Test" for evaluating the plastic deformation performance of metal sheets and strips. It can also be used for "Metal Material Ear Test Method" and "Non-Ferrous Metal Cup Test Method" to test the anisotropy of non-ferrous metal plates. With the relevant mold, it can also conduct tests according to national standards "Color Paint and Varnish Cup Process Test" and "Metal Sheet Forming Performance and Test Method."



The cupping test involves using a specified steel ball or ball punch to apply pressure to the sample with a 10kN clamping force until the sample develops a penetration crack. The depth of the punch penetration (in mm) represents the cupping test value of the plate, which is used to determine the material's plastic deformation performance.

The cup punching test involves pressing a wafer ($\phi 55$, $\phi 100$) between the pressure rim and the die. Under the punch's impulse, the sample undergoes radial extension and bending plastic deformation, forming a cylindrical cup. This test determines the anisotropy indicated by the ear production rate. The sample is a disc, and the tensile ratio of the disc to the punch diameter is 1.8.

FEATURES

Sheet Metal Deep Drawing Tester and Cupping Testing Machine QualiCTDD™ 60 Characteristics of the Machine:

- The cupping testing machine features a new structural principle that achieves constant speed control.
- The new cupping testing machine uses a permanent servo motor for constant speed loading. The hydraulic sensor has been replaced with a new sensor, significantly improving the accuracy and precision of cupping values.
- The cupping test value measurement instrument is a grating measurement (displacement sensor) with a reading resolution of 0.001mm, enhancing machine controllability.
- Both hardware configuration and force transmission principles have been significantly improved compared to the original machine. The computer control configuration achieves machine perfection, allowing for report generation, storage, batch processing, curve drawing, and more.
- The machine features an automatic stop function for plate cracks and is equipped with a camera to accurately determine the crack cup process value.
- Integrated control offers high integration, strong control functions, high data processing ability, and high reliability.
- The computer controls the test process, enabling the dynamic display of clamping force load value, puncturing load value, cupping process value, test speed, and test curve.

- The test system includes data processing and graph processing capabilities, allowing for complete test report and test curve printing.
- The clamping load pressure can be conveniently adjusted for different materials.
- Different test fixtures can be easily replaced according to various test methods.
- The machine features a compact structure, making it simple and easy to operate.

TECHNICAL SPECIFICATIONS

Sheet Metal Deep Drawing Tester and Cupping Testing Machine QualiCTDD™ 60 Technical Specifications

Maximum test force	60 kN
Range of test force	0.2 kN □ 60 kN
Test accuracy	±1 □
Speed of test	2 □ 100mm/min (under control of arbitrary rate and constant speed)
Thickness of gripping specimen	0.05 □ 2mm (high-precision sensor can accommodate ultra-thin sheet metal tests)
Journey of cramping piston	40mm

Resolution of cupping value	0.01mm
Standard Configuration	
<ol style="list-style-type: none">1. Main Machine2. Computer3. One mold for standard cupping testing<ul style="list-style-type: none">○ One punch (Ø20mm)○ One cushion type die (Ø33mm)○ One pressing die (Ø27mm)4. Circuit control amplifier, configured with a high-precision photoelectric encoder.5. Clamping hydraulic control system.	
Optional Items	
<ol style="list-style-type: none">1. Deep drawing cupping punching mold2. Non-standard cupping mold3. Hole expansion test mold and cone cupping test mold	



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Toll-Free: 1.877.884.TEST (8378) | Fax: 954.697.8211
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Address: 8201 Peters Rd., #1000,
Plantation, FL 33324, USA.

Qualitest Canada & International

Tel: +1.905.944.9825 | Fax: +1.905.944.0304
E-mail: sales@qualitest-inc.com
Address: 70 East Beaver Creek Rd., #9, Richmond Hill,
Ontario L4B 3B2, Canada.

Qualitest Latin America (Mexico and LATAM Region)

E-mail: ventas@qualitest-inc.com

Qualitest KSA (Regional Office)

Tel: +966 11 500 6659
Address: Level 7, 3.09, District 3, King Abdullah
Financial District, Riyadh, Saudi Arabia

Qualitest Singapore (ASIA PACIFIC Regional Office)

Tel: +65 6393 5480 | E-mail: singapore@qualitest-inc.com
Address: 50 Raffles Place, Singapore Land Tower,
Level 46, Singapore, 048623.

Qualitest Indonesia (Representative Office)

Tel: +62 21 2985 9522 | Fax: +62 21 2985 9889
E-mail: indonesia@qualitest-inc.com
Address: One Pacific Place Level 11, Jl. Jend. Sudirman,
Kav. 52-53, SCBD Area, Jakarta 12190, Indonesia.

Qualitest FZE (Regional GCC/ME Office)

Tel: +971 4 8819252 | Fax: +971 4 8819262
Email: gcc@qualitest-inc.com
Address: Jafza One, BB 1610, Jebel Ali Free Zone,
PO Box 261440, Dubai, UAE.

Qualitest India

E-mail: india@qualitest-inc.com
Address: 15th Floor, Dev Corpora, Pokhran Road No.1,
Eastern Express Highway, Thane, Maharashtra,
Mumbai, 400601, India

