

JIS

JAPANESE INDUSTRIAL STANDARD

**Symbols of Forming Ratio
for Steel Forging**

JIS G 0701 – 1957

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by

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**In the event of any doubt arising,
the original Standard in Japanese is to be final authority.**

JAPANESE INDUSTRIAL STANDARD

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Symbols of Forming Ratio
for Steel ForgingG 0701-1957
(Reaffirmed: 1988)1. Scope

This standard specifies symbols of forming ratio for hot forged steel.

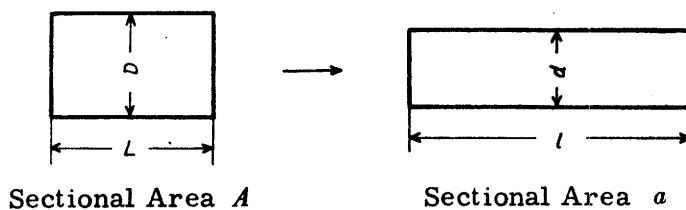
2. Forming Ratio

2.1 The forming ratio for steel forgings manufactured by various hot forging operations shall be denoted by the deformation ratio in the direction of the largest of three principal plastic strains.

2.2 The symbols of the forming ratio shall be, as a rule, suffixed with the designated notation corresponding to the forging operation and shall be clearly denoted in the order of working.

3. Designations and Symbols of Forming Ratio

3.1 Solid Forging The forging operation by which a solid reduces its sectional area and increases its length shall be designated as solid forging, of which the forming ratio shall be expressed as follows:



Forming Ratio

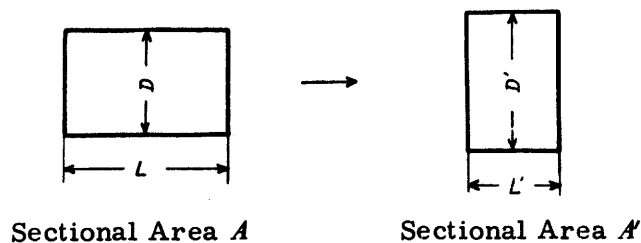
$$\frac{A}{a} \text{ or } \frac{l}{L}$$

Notation for the
Operation

S

Example: 2S

3.2 Upsetting Forging The forging operation by which a solid increases its sectional area and reduces its length shall be designated as upsetting forging, of which the forming ratio shall be expressed as follows:



Forming Ratio

$$\frac{1}{\frac{L}{L'}}$$

Notation for the
Operation

U

Example: 1/2 U

When an upsetting operation is followed by a solid forging, the over-all forming ratio shall be expressed as follows: