

# Mercedes

## C Class C230

# WORKSHOP MANUAL



# 2008-2009

Mercedes C Class C230 Workshop Service Repair  
Manual

Repair - Service - Wiring Diagrams - Workshop Manual

# 7 Mercedes C230 Repair Manual

**Louis-Philippe Edmonston**



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web in this method you have to use some numerical calculation formulas to derive your flat pattern layout markings of required fabrication shapes or sheet metal shapes you have to use different formulas for different shapes and you can calculate in very simple ways

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web how does sheet metal fabrication work there are several different ways to shape sheet metal but they all boil down to two broad categories sheet metal can either be cut or formed as there are many different ways of cutting and forming sheet metal many specific tooling types are needed which can drive up costs

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web the following sections show the methods used to calculate flat patterns for brake bent or die formed sheet metal parts the later sections describe the geometry and instructions for laying out sheet metal developments and transitions also included are calculations for punching requirements of sheet metal parts and tooling requirements for

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web ketiv technologies ketiv ava introduction 1 1 bend parameters used in this document the following parameters and terms are used throughout this document figure 1 basic

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web die engineering layouts and formulas a reference book illustrating and describing the key designs of punches and dies based on precept and formulas sheet metal layout simplified

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web higher volumes pressing sheet metal is often more cost efficient due to the speed and ability to automate the majority of the process the definitions of bending and pressing can be seen in chapter 3 2 the method of pressing sheet metal also enables more complex geometries and thus makes it possible to eliminate welding of the components

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web sheetmetal layout formulas to calculate the cut sizes locations of bend lines and interior features demonstrated through the fabrication of marine components typical to steel and aluminum pleasure craft fabrication of metallic pressure vessels

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web form height to thickness ratio to determine the minimum form height for sheet metal use the following formula  $d \geq 2.5t$  r see below the height can be less but it required secondary operations and is far more costly 5

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web jan 26 2022 if the shop is using a v die to make the flange there is a minimum and maximum length that any flange can be in general the flange needs to be at least 3 though we suggest 4 times longer than the thickness of the material for sheet metal that s 0 120 thick that means a minimum flange length of 0 480 long

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web nov 9 2012 more than one sheet metal bending formula press brake technicians can use various formulas to calculate bend functions for instance in this article we have used the following for outside setback  $ossb = \frac{t}{\sin(\frac{\alpha}{2})}$  tangent degree of bend angle 2 material thickness inside radius