



## METHODS FOR IMPROVING MACHINING ACCURACY IN THE MANUFACTURING OF ROTATIONAL PARTS ON RDB MACHINES

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### ABSTRACT

*The manufacturing industry increasingly demands higher precision in rotational component production, particularly for critical applications in aerospace, automotive, and precision engineering. This comprehensive review examines multiple strategies for enhancing machining accuracy in Rotary Draw Bending (RDB) processes, focusing on both conventional and advanced approaches. Through systematic analysis of recent research and technological developments, we identify and evaluate several effective methods: implementing localized thermal fields to control material behavior and reduce springback, applying push assistant loading (PAL) conditions to manage material flow and minimize defects, developing accurate mathematical models for process optimization, utilizing data-driven machine learning approaches for predictive accuracy, and optimizing tooling systems and parameters. The findings demonstrate that a combined approach integrating thermal, mechanical, and data-driven strategies can significantly improve dimensional accuracy, reduce springback, and minimize defects such as wrinkling and cross-sectional deformation in RDB processes. This research provides valuable insights for manufacturers seeking to enhance precision in rotational part production while maintaining efficiency and cost-effectiveness in industrial applications.*

### Introduction

Rotary Draw Bending (RDB) has emerged as one of the most **versatile and precise** methods for manufacturing bent tubular components and rotational parts across various industries. The process's ability to produce **complex geometries** with high dimensional accuracy makes it particularly valuable for aerospace, automotive, and HVAC applications where precision is paramount. In RDB processes, the workpiece undergoes **complex deformation** through a system of constrained dies—typically including a

bend die, clamp die, pressure die, and mandrel—which work in concert to form the material around a specific radius. This **multi-die constraint system** enables production of precise thin-walled bent components with high bending limits, including small bending radii that would be challenging with alternative methods like roll bending, compression bending, or stretch bending.

Despite its capabilities, maintaining high **machining accuracy** in RDB processes presents significant challenges that have attracted substantial research attention. The **inherent complexity** of the deformation mechanics leads to several persistent issues including springback (the elastic recovery of the material after deformation), wall thinning, cross-sectional distortion, and wrinkling at the intrados (inner radius) of the bend. These defects become increasingly pronounced when manufacturing components with smaller bending radii ( $R_d/D < 2.0$ ), which are increasingly required in modern applications due to space constraints in assembly. The **dimensional inaccuracies** resulting from these phenomena not only affect the structural integrity of the components but also lead to assembly issues and performance degradation in final products.

The **traditional approaches** to addressing these accuracy challenges have primarily relied on trial-and-error methods and experience-based parameter selection, which are increasingly inadequate for modern manufacturing requirements. These methods are **time-consuming, cost-intensive**, and often fail to achieve optimal results consistently. More recently, **sophisticated simulation techniques** using Finite Element Analysis (FEA) have been employed to predict deformation behaviors and optimize process parameters. However, these simulations often exhibit deviations between calculated and actual component geometries due to unmodeled physical phenomena, parameter fluctuations, and transient effects within the forming system.

This comprehensive review aims to address these challenges by systematically analyzing **recent advancements** and **innovative methodologies** for improving machining accuracy in RDB processes. Specifically, we examine the effects of **localized thermal fields, push assistant loading conditions, advanced modeling techniques**, and **data-driven machine learning approaches** on the dimensional accuracy of rotational parts manufactured through RDB. By synthesizing findings from recent research and identifying knowledge gaps, this work provides both researchers and practitioners with a consolidated reference for advancing precision in RDB processes and establishes directions for future investigation in this critical area of manufacturing technology.

### Literature Review

The pursuit of improved accuracy in Rotary Draw Bending processes has generated substantial research interest, with studies exploring various aspects of the process mechanics, material behavior, and technological innovations. A comprehensive analysis of the literature reveals several **key areas** of focus and development in understanding and enhancing RDB precision.

### Fundamental Deformation Mechanics in RDB

The foundation of accuracy improvement in RDB begins with understanding the **basic deformation mechanics** governing the process. During RDB, the tube undergoes complex, multi-axial stress states that result in non-uniform deformation across the cross-section. Li et al. (2010) provided a comprehensive analysis of these deformation behaviors, highlighting how

thin-walled tubes (with diameter-to-wall-thickness ratios  $D/t > 20$ ) are particularly susceptible to defects when subjected to RDB with small bending radii. Their work demonstrated that the **strain distribution** across the tube wall thickness is inherently uneven, with tensile stresses dominating at the extrados (outer radius) and compressive stresses at the intrados (inner radius). This fundamental stress imbalance creates the conditions for the most common accuracy challenges in RDB: wall thinning at the extrados, thickening at the intrados, and the potential for wrinkling due to compressive instability.

A critical concept in understanding and controlling these deformation behaviors is the **Neutral Layer (NL)** position—the theoretical plane within the material that experiences neither tension nor compression during bending. Traditional bending theory often assumes the NL coincides with the geometric centerline, but in practice, it shifts toward the inner radius due to the complex stress states in RDB. This **NL shift phenomenon** has been identified as a crucial factor affecting final part accuracy, as it directly influences material flow, thickness distribution, and residual stress patterns. Research has shown that controlling this shift through various means represents a significant opportunity for accuracy improvement.

#### **Thermal Assistance Strategies**

The application of thermal fields to enhance RDB accuracy represents a **growing research area** with promising results. Early investigations into temperature-assisted bending were limited, but recent studies have demonstrated the significant potential of thermal strategies. Research on **localized thermal fields** has shown that selectively heating specific regions of the tube cross-section can fundamentally alter material behavior and deformation patterns.

The underlying principle of these thermal approaches involves **exploiting the temperature dependence** of material properties, particularly flow stress and ductility. By creating controlled temperature gradients across the tube section, researchers have successfully manipulated the NL position and reduced springback. The application of **uniform thermal fields** across the entire cross-section has been shown to reduce forming forces and improve material formability, but can lead to excessive wall thinning at the extrados. Conversely, **localized heating** strategies that target specific regions (particularly the compression zone) have demonstrated the ability to balance material flow more effectively, simultaneously reducing springback while controlling wall thickness variations.

#### **Modeling and Simulation Approaches**

The development of **accurate predictive models** has been a persistent theme in RDB research, with early approaches focusing on analytical solutions and increasingly moving toward computational methods. Initial modeling attempts employed **simplified assumptions** of material behavior (e.g., perfect plasticity) and geometry, which limited their accuracy in practical applications. Later developments incorporated more **sophisticated material models** that accounted for strain hardening, anisotropy, and other complex material behaviors.

Finite Element Analysis has emerged as the **dominant modeling approach** for RDB processes, with continuous improvements in element formulations, contact algorithms, and material models enhancing prediction accuracy. Bardelcik and Worswick (2005) conducted comparative studies on element formulation effects, finding that both shell and solid elements could predict overall strain and thickness results effectively, though with different trends in

each model. However, despite these advances, significant challenges remain in **completely capturing** all relevant physical phenomena in simulations, particularly regarding transient effects, complex friction conditions, and material property variations.

#### **Data-Driven and Machine Learning Approaches**

The emergence of **data-driven methodologies** represents the most recent evolution in RDB accuracy improvement research. While traditional simulation-based approaches continue to dominate, there is growing recognition of the limitations of purely physics-based models. The **TubeBEND dataset**, introduced recently, provides a comprehensive collection of real-world RDB process data, marking a significant step toward enabling machine learning applications in this field.

Early applications of machine learning in RDB have focused on **predicting key quality metrics** such as springback and cross-sectional deformation based on process parameters. These approaches have demonstrated promising results, with some studies reporting **superior performance** compared to traditional simulations in terms of both accuracy and computational efficiency. However, the literature also indicates that the effectiveness of these data-driven models is heavily dependent on the availability and quality of real-world data that captures the full range of process variations and physical phenomena not fully replicated in deterministic simulations.

#### **Identified Research Gaps**

Despite the substantial progress documented in the literature, several **significant research gaps** remain. There is limited comprehensive research on the **combined application** of multiple accuracy enhancement strategies (e.g., thermal assistance with push assistant loading and data-driven optimization). Additionally, most studies focus on specific aspects of accuracy (e.g., springback or wall thinning) without providing **integrated solutions** that address multiple accuracy challenges simultaneously. The transition from simulation-based predictions to real-world applications also represents a significant challenge, with a need for more research validating proposed methods in industrial settings. Finally, there is a notable scarcity of studies addressing the **economic implications** of different accuracy improvement strategies, making it difficult for manufacturers to make informed decisions about technology adoption.

#### **Methods**

This section comprehensively examines the **diverse methodologies** employed for enhancing machining accuracy in RDB processes. Our systematic approach categorizes these methods into distinct but complementary strategies, each targeting specific aspects of the accuracy challenge through different mechanisms and implementations.

#### **Thermal Field Application**

The controlled application of thermal fields during RDB represents a **sophisticated approach** to accuracy improvement that leverages the temperature-dependent behavior of materials. Implementation strategies vary based on the specific heating method and temperature distribution pattern:

- **Uniform Cross-Sectional Heating:** This approach involves elevating the temperature of the entire tube cross-section to a consistent level before and during bending. Implementation typically utilizes **induction heating systems** that can rapidly bring the material to target temperatures ranging from 200°C to 800°C, depending on the material properties and forming

requirements . The primary mechanism of accuracy improvement lies in the **reduction of flow stress** and increased material ductility at elevated temperatures, which lowers forming forces and reduces springback by decreasing the elastic component of deformation.

- **Localized Thermal Fields:** More advanced implementations apply **differential heating** across the tube cross-section, creating controlled temperature gradients that strategically alter material behavior. Research has demonstrated that selectively heating the compression zone (intrados) to temperatures 100-300°C higher than the tension zone (extrados) can significantly reduce wrinkling tendencies while maintaining control over wall thinning . This approach works by **balancing the flow stresses** between regions under tension and compression, effectively shifting the Neutral Layer position to optimize material flow.

- **Experimental Implementation:** In practice, thermal field application requires **specialized equipment** including induction coils with precise positioning systems, temperature monitoring with infrared sensors or thermocouples, and integration with the RDB machine control system. The experimental setup described in the literature typically places the heating system immediately preceding the deformation zone, allowing the preheated material to enter the bending process under controlled thermal conditions .

#### **Push Assistant Loading (PAL) Conditions**

Push Assistant Loading encompasses a set of techniques that apply **additional axial forces** during the bending process to control material flow and stress distribution. The PAL approach includes two primary implementation strategies:

- **Pressure Die Assistance:** This method utilizes the pressure die to apply an **axial compressive force** to the tube outside the bending zone. The mechanical implementation involves modifying the pressure die mechanism to incorporate **programmable servo-control** that can precisely regulate the applied force throughout the bending process . The effectiveness of this approach is quantified through the push assistant level ( $f_p$ ), a dimensionless parameter representing the ratio of axial compressive stress to material flow stress, typically maintained in the range of 0.1-0.3 for optimal results .

- **Booster System Implementation:** For more advanced control, **dedicated booster systems** apply axial forces directly to the tube end through separate servo-mechanisms. These systems offer **independent control** of both force magnitude and timing, enabling more precise manipulation of material flow into the deformation zone . The key parameters include booster force ( $F_b$ ), application timing relative to the bending cycle, and the force profile throughout the process.

The **fundamental mechanism** through which PAL improves accuracy involves altering the stress state in the deformation zone to encourage more favorable material flow. By applying axial compression, PAL techniques counteract the tensile stresses that normally predominate in conventional RDB, reducing the net tension at the extrados and consequently minimizing wall thinning. Simultaneously, these methods facilitate the movement of material from the straight section into the bend area, helping to maintain cross-sectional geometry and reduce distortion .

*Table 1: PAL Parameters and Their Effects on Accuracy*

Parameter	Typical Range	Primary Effect	Optimal Value Considerations
Push Assistant Level ( $f_p$ )	0.1-0.3	Reduces wall thinning by 15-25%	Higher values risk wrinkling; material-dependent
Booster Force ( $F_b$ )	10-30% of material yield force	Controls material feed into bend zone	Must be synchronized with bending speed
Application Timing	Varies with bend angle	Affects deformation distribution	Early application benefits springback reduction
Force Profile	Constant vs. Variable	Influences thickness distribution	Variable profiles better for complex geometries

**Mathematical Modeling and Process Optimization**

The development of **accurate mathematical models** provides the foundation for systematic improvement of RDB accuracy without exclusive reliance on empirical methods. Contemporary modeling approaches include:

- **Analytical Formulations:** Advanced analytical models have been developed to predict stress distribution, NL shift, and springback based on **fundamental principles** of mechanics and material behavior. These models incorporate the **temperature-dependent properties** when thermal assistance is employed, enabling prediction of thermal effects on accuracy metrics. The primary advantage of analytical approaches lies in their computational efficiency and physical transparency, though they typically incorporate simplifying assumptions that limit their accuracy for complex cases.

- **Finite Element Analysis:** Comprehensive 3D FE models represent the **most detailed approach** to RDB process simulation. Modern implementations employ **sophisticated material models** that account for elastic-plastic behavior, anisotropy, and temperature dependence. The development of these models requires careful attention to **contact definitions** between the tube and various dies, friction conditions, and element formulation selection. Validation studies have demonstrated that properly calibrated FE models can predict springback with errors below 0.5° for a 90° bend and thickness distribution with errors below 9.3%.

- **Process Optimization Frameworks:** Based on these models, **systematic optimization methodologies** enable identification of optimal process parameters for accuracy enhancement. These frameworks typically employ **response surface methodology** or **evolutionary algorithms** to navigate the multi-dimensional parameter space, balancing competing objectives such as springback reduction, wall thinning minimization, and distortion control.

- **Data-Driven Machine Learning Approaches**

The emergence of **comprehensive datasets** and advanced machine learning algorithms has enabled a new paradigm for accuracy improvement in RDB processes:

- **Real-World Data Collection:** The foundation of these approaches is the acquisition of **high-quality process data** from actual bending operations. The TubeBEND dataset exemplifies this trend, comprising 318 rotary tube bending processes with detailed recordings of process parameters (tool movements, forces, torques) and resulting geometry metrics (springback, cross-sectional deformation). This data infrastructure enables the development of **predictive models** that capture relationships not fully represented in theoretical simulations.

- **Machine Learning Implementation:** Various ML algorithms have been applied to RDB accuracy prediction, including **Random Forest models** for springback prediction, **Support Vector Machines** for wrinkle detection, and **Multi-Task Learning approaches** for simultaneous prediction of multiple accuracy metrics. These models typically use process parameters (bend radius, bend angle, material properties, PAL settings) as inputs and generate predictions for key accuracy indicators.

- **Integration with Traditional Methods:** The most effective implementations combine **data-driven insights** with physics-based understanding, creating hybrid approaches that leverage the strengths of both methodologies. For example, ML predictions can guide initial parameter selection, which is then refined through limited physical trials or targeted simulations.

#### **Tooling System and Parameter Optimization**

Beyond the advanced strategies discussed above, **fundamental improvements** in conventional RDB elements remain essential for accuracy enhancement:

- **Tooling Design Optimization:** The geometry and configuration of bending dies significantly influence accuracy outcomes. Research has demonstrated that **precision-machined dies** with optimized groove geometries can reduce cross-sectional distortion by 20-30% compared to standard designs. Particular attention should be paid to the **mandrel design**, including ball number, placement, and interface conditions, as these factors directly affect internal support during bending.

- **Process Parameter Selection:** Systematic optimization of **conventional parameters** including bending speed, lubrication conditions, and interferences between tooling elements represents a foundational approach to accuracy improvement. Experimental studies have identified that **parameter interactions** often produce non-intuitive effects, necessitating structured experimentation approaches such as Taguchi methods or factorial designs.

- **Advanced Material Characterization:** Comprehensive accuracy improvement requires **detailed understanding** of material behavior under the specific conditions encountered in RDB. This includes characterization of **anisotropic properties, hardening behavior**, and **elastic modulus evolution** with plastic deformation, all of which significantly influence accuracy outcomes.

#### **Results and Discussion**

The implementation of various accuracy enhancement strategies in RDB processes has yielded **significant improvements** across multiple dimensions of machining precision. This

section presents and analyzes the outcomes of these approaches, examining their effectiveness, limitations, and practical implications for manufacturing applications.

**Impact of Thermal Field Application on Accuracy Metrics**

The controlled application of thermal fields during RDB has demonstrated **substantial benefits** for machining accuracy, though with important considerations regarding implementation specifics. Research findings reveal several key outcomes:

- **Springback Reduction:** Uniform heating approaches have shown springback reduction of 25-35% for stainless steel tubes when heated to temperatures of 300-500°C. More sophisticated localized heating strategies, which create temperature differences of 150-250°C between intrados and extrados, have achieved even greater improvements, reducing springback by up to 45% compared to room temperature bending. The mechanism behind this enhancement involves the **reduction of flow stress** at elevated temperatures, which decreases the elastic component of deformation and consequently reduces the elastic energy available for springback.

- **Wall Thickness Control:** The effect of thermal fields on wall thickness distribution presents a more complex picture. While uniform heating tends to exacerbate wall thinning at the extrados due to reduced material strength, targeted heating of the compression zone has demonstrated the ability to **improve thickness uniformity** by balancing material flow between tension and compression regions. Specifically, implementations with temperature gradients of 200°C (higher at intrados) have reduced maximum wall thinning from approximately 25% to 15% while simultaneously decreasing thickening at the intrados from 30% to 20% compared to conventional RDB.

- **Wrinkle Suppression:** Localized heating of the compression zone has proven particularly effective for **wrinkle prevention**, especially when bending thin-walled tubes with small radii. The mechanism involves the **selective reduction** of compressive flow stress at the intrados, which alleviates the instability that leads to wrinkling. Experimental results indicate that appropriate thermal strategies can increase the wrinkling limit by 15-20%, enabling the production of tighter bends without defect formation.

*Table 2: Comparison of Thermal Assistance Strategies for RDB Accuracy Improvement*

Strategy	Springback Reduction	Wall Thinning Control	Wrinkle Suppression	Implementation Complexity
Uniform Heating	25-35%	Limited benefit	Moderate improvement	Low to moderate
Localized Heating (Intrados focus)	35-45%	Significant improvement (10-15% reduction)	High improvement	High
Sequential Heating	30-40%	Moderate improvement	High improvement	Moderate

Strategy	Springback Reduction	Wall Thinning Control	Wrinkle Suppression	Implementation Complexity
Gradient Control	40-50%	Significant improvement (15-20% reduction)	Highest improvement	Highest

**Effectiveness of Push Assistant Loading Strategies**

The implementation of PAL conditions has emerged as a **highly effective approach** for accuracy enhancement, with demonstrated benefits across multiple defect types:

- **Wall Thinning Mitigation:** Research has consistently shown that appropriate PAL application reduces wall thinning at the extrados by 15-25% across various materials and bending geometries. The mechanism involves the introduction of **axial compressive stresses** that counteract the tensile stresses responsible for thinning. This effect follows a diminishing returns pattern, with initial force application producing significant benefits that gradually plateau at higher force levels, eventually leading to wrinkling if excessive forces are applied.

- **Cross-Sectional Deformation Control:** PAL strategies have demonstrated particular effectiveness in controlling cross-sectional distortion (ovaling), with reductions of 20-30% reported in experimental studies. This improvement stems from the more favorable stress state created by PAL, which reduces the net tension that would otherwise promote collapse of the cross-section. The relationship between PAL parameters and distortion control is complex, with optimal results requiring careful balancing of multiple factors including force magnitude, application timing, and coordination with other process parameters.

- **Interaction Effects:** A crucial finding from recent research is the **significant interaction** between PAL parameters and other process conditions. For example, the effectiveness of specific PAL strategies varies substantially with material properties, bending radius, and wall factor (D/t ratio). These interactions highlight the importance of **system-level optimization** rather than isolated parameter adjustment, as the optimal PAL configuration depends on the complete set of process conditions.

**Performance of Modeling and Machine Learning Approaches**

The development and implementation of advanced modeling techniques have yielded **substantial improvements** in prediction accuracy and process optimization:

- **Prediction Accuracy:** Modern analytical models have demonstrated the capability to predict springback angle with errors below 0.5° for a 90° bend and thickness distribution with errors below 9.3%. These performance metrics represent significant advances over earlier modeling approaches, enabled by more sophisticated representations of material behavior and boundary conditions. However, it is important to note that these error levels apply within validated parameter ranges and may increase when extrapolating beyond the calibration domain.

- **Machine Learning Performance:** Data-driven approaches have shown particularly promising results for springback prediction, with some implementations achieving prediction errors below  $0.3^\circ$  for aluminum alloy tubes. The performance of these models is heavily dependent on the **quality and breadth** of training data, with comprehensive datasets like TubeBEND enabling more robust and generalizable predictions. Comparative studies have indicated that ML approaches can match or exceed the accuracy of FE simulations for specific prediction tasks while requiring substantially less computational time.

- **Industrial Implementation Challenges:** Despite their impressive technical performance, advanced modeling and ML approaches face significant **practical barriers** to widespread industrial adoption. These include the requirement for specialized expertise, data acquisition infrastructure, and computational resources. Additionally, the **limited transparency** of some complex models creates resistance among practitioners who require understandable rationale for parameter decisions.

### Synthesis and Comparative Analysis

The comprehensive analysis of accuracy improvement methods reveals several **overarching insights** with important implications for practice and future research:

- **Complementary Nature of Strategies:** The most significant accuracy improvements are achieved through **combined approaches** that leverage multiple strategies simultaneously. For example, the integration of thermal assistance with optimized PAL conditions has demonstrated synergistic effects, producing better results than either approach implemented independently. This complementarity stems from the different but interconnected mechanisms through which these strategies operate—thermal methods primarily affect material behavior, while PAL approaches manipulate stress states, together addressing the accuracy challenge from multiple angles.

- **Context-Dependent Effectiveness:** The performance of any specific accuracy enhancement method is highly dependent on the **application context**, including material properties, geometric constraints, and production requirements. For instance, thermal strategies show particular promise for high-strength materials with limited formability at room temperature, while PAL approaches offer greater benefits for thin-walled components prone to cross-sectional distortion. This context dependence underscores the importance of **systematic selection methodologies** that match improvement strategies to specific application characteristics.

- **Economic Considerations:** While technical performance is crucial, the **economic viability** of accuracy enhancement methods ultimately determines their practical adoption. Currently, methods like mathematical modeling and parameter optimization offer favorable cost-benefit profiles, as they primarily require intellectual rather than capital investment. In contrast, approaches involving significant equipment modifications (e.g., thermal assistance systems) or extensive data infrastructure (e.g., comprehensive ML implementations) present higher barriers to implementation that must be justified by sufficient quality improvements or cost savings in downstream operations.

### Conclusion and Future Work

#### Conclusion

This comprehensive review has systematically examined and analyzed **multiple strategies** for enhancing machining accuracy in the manufacturing of rotational parts using

Rotary Draw Bending machines. Through detailed evaluation of recent research and technological developments, several key conclusions can be drawn:

First, the implementation of **localized thermal fields** represents a highly promising approach for accuracy improvement, particularly for challenging materials and bending geometries. By creating controlled temperature gradients across the tube cross-section, this method effectively manipulates material flow stress and Neutral Layer position, resulting in significant reductions in springback (35-45%) and improved wall thickness distribution. The strategic application of heat to specific regions enables manufacturers to balance the competing deformation mechanisms at the intrados and extrados, addressing multiple accuracy challenges simultaneously.

Second, **Push Assistant Loading conditions** offer a powerful mechanical approach to accuracy enhancement through strategic manipulation of stress states. The application of controlled axial forces during bending enables more favorable material flow, reducing wall thinning by 15-25% and cross-sectional distortion by 20-30%. The effectiveness of PAL strategies depends critically on proper parameter selection, including force magnitude, application timing, and coordination with other process variables, highlighting the importance of systematic optimization approaches.

Third, **advanced modeling techniques** and emerging **data-driven methodologies** are fundamentally transforming the approach to accuracy improvement in RDB processes. Modern analytical models can predict springback with errors below  $0.5^\circ$ , while machine learning approaches trained on comprehensive real-world datasets are increasingly matching or exceeding the performance of traditional simulations with substantially reduced computational requirements. These methodologies enable more targeted and efficient process development, reducing reliance on costly trial-and-error approaches.

Ultimately, the most significant accuracy improvements are achieved through **integrated approaches** that combine multiple complementary strategies. The synergistic application of thermal, mechanical, and data-driven methods addresses the complex challenges of RDB accuracy from multiple directions, enabling manufacturers to meet increasingly stringent precision requirements while maintaining production efficiency and economic viability.

#### Future Work

Based on the current state of research and identified gaps, several promising directions for future investigation emerge:

- **Hybrid Modeling Approaches:** There is a significant opportunity to develop **integrated modeling frameworks** that combine physics-based simulations with data-driven machine learning techniques. Such hybrid approaches could leverage the strengths of both methodologies—the generalizability of physics-based models and the adaptive accuracy of data-driven approaches—to create more robust and accurate prediction tools for RDB accuracy optimization.

- **Real-Time Control Systems:** Future research should explore the development of **closed-loop control systems** that continuously adjust process parameters based on in-process monitoring of accuracy metrics. These systems could utilize real-time sensor data (forces, temperatures, dimensional measurements) to make dynamic adjustments, potentially compensating for material variability and other unpredictable factors that challenge conventional open-loop approaches.

• **Multi-Stage Bending Applications:** Most current research focuses on single-bend geometries, but industrial applications often require **complex multi-bent components**. Future work should investigate accuracy enhancement strategies in multi-stage bending processes, where error accumulation and interaction effects between successive bends present additional challenges that are not fully addressed by current methods.

• **Economic Analysis Frameworks:** To facilitate industrial adoption, researchers should develop **comprehensive economic models** that quantify the cost-benefit relationships of different accuracy enhancement strategies. These frameworks would help manufacturers make informed decisions about technology investments based on both technical performance and economic considerations, addressing a critical gap in the current literature.

• **Advanced Material Applications:** As new materials continue to emerge in industrial applications, there is a continuing need to adapt and optimize accuracy enhancement strategies for these materials. Particular attention should be given to **composite structures, additively manufactured components, and high-strength alloys** that present unique challenges and opportunities for RDB processes.

In conclusion, while significant advances have been made in improving machining accuracy for rotational parts manufactured through RDB processes, considerable opportunities remain for further enhancement through integrated approaches, advanced technologies, and expanded application domains. The continuing evolution of these methodologies promises to further enhance the precision, efficiency, and applicability of RDB in meeting the demanding requirements of modern manufacturing.

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