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OVERCUT ON CHEMISTRY MACHINING OF BRASS, CHROME STEEL, AND ATOMIC NUMBER 13 MISTREATMENT BRASS ELECTRODES

Mr. Wasim Khan

NIMS University, Jaipur

1. INTRODUCTION

ELECTROCHEMICAL machining is developed to beat the difficulties in machining of materials, like too arduous, too delicate or too advanced. it's supported Associate in Nursing anodal dissolution throughout electrolysis [1]. It depends on the work of Michael Faraday UN agency has found if 2 metal electrodes area unit submerged in Associate in Nursing solution and connected to a DC supply, metal particles area unit depleted from the anode so plated on the cathode. If the solution flows at sufficient rate, it'll stop the metal particles from deposition on the cathode and flushes them removed from the machining space. The metal removal is finished by electrolytic action. the form of the work is especially determined by the form of the tool and by the tool movement towards the work. The metal removal rate depends on the applied current density and therefore the gap dimension. many observations relevant to electronic warfare are often delineated as follows [2].

ECM ordinarily produces Associate in Nursing overcut. In hole drilling, for instance, high current densities occur within the space between the forefront of the drilling conductor and therefore the work because the conductor moves to the present direction. On the opposite hand, there's no conductor movement to the aspect gap, therefore lower current densities occur during this space. If binary compound is employed because the solution, the overcut within the aspect gap is far bigger as a result of its current potency remains high for a large vary of current densities [2].

2.RESEARCH

Methodology A.Electrodes and workpieces work materials area unit one millimeter thickness of brass, chrome steel, and atomic number 13 whereas the tool conductor is a pair of mmdiameter of brass rod, as shown in Fig. 1.
B.Operating conditions A setting of parameters utilized in the experiment is shown in Table I. It shows that the potential unitage is unbroken constant at fifteen volt throughout the experiment whereas this varies PRN. a number of the settings follow a reference [3].

C.Experimental Procedures The machining is finished by applying voltage between the tool conductor and therefore the work. The solution flows in machining space at a flow of six m/s. The machining is started by setting the gap dimension of zero.5 millimeter between the conductor and therefore the work. Machining lasts for four minutes so the conductor moves zero.89 millimeter toward the work for thirty second. After that, the machining continues for one additional minute. the full machining time is five.5 minute for every material. As presently because the machining has completed, the applied voltage is then transitioned and therefore the brass conductor is backward from the machining space.
D. electronic warfare Machine A custom engineered electronic warfare machine is employed throughout the experiment as shown in Fig. 2. The machine is truly a hybrid diesinking ECM-EDM machine. it's three axes that may be controlled separately through a pc or a PLC. The electronic warfare has its own solution current system and machining space, separated from the EDM.

3. RESULTS AND ANALYSIS

All materials area unit machined at identical condition and therefore the results area unit shown in Table II. A comparison between the materials in a very graphical kind is shown in Fig. 3.

As shown in Table II, the best average overcut has been found in brass with one.62 mm, followed by atomic number 13 with zero.33 mm, so very cheap average of overcut is in chrome steel with zero.30 mm. These results of experiment showed that the 2 of 3 materials, atomic number 13 and chrome steel, have similarities in average of overcut as clearly shown in Fig. 3. Meanwhile, brass material has vital distinction with average of overcut up to five times more than those 2 materials. The holes created when machining on brass, chrome steel, and atomic number 13 area unit shown in Fig. 4. it's clear that among these 3 materials, solely brass that has not created a hole through the fabric. The brass would like longer to form a hole as a result of its average overcut is far larger than the chrome steel and atomic number 13. It desires around eleven minutes to provide a hole through one millimeter thickness of brass.

The angle of overcut for every material is shown in Fig. 5. Assumed linear line, the brass has the most important angle among the ascertained materials, followed by the chrome steel and atomic number 13. A correlation analysis has been conducted to understand the connection between the typical overcut and therefore the average angle of overcut, as shown in Table III. With a constant of correlation r = zero.998, the typical overcut contains a sturdy correlation with the typical angle of overcut in a very positive means. The larger the overcut created throughout machining, the larger the angle of overcut created.

A further experiment has been done by dynamical the diameter of the tool. With six mm-diameter of brass tool conductor, Associate in Nursing atomic number 13 has been electrochemically machined mistreatment the setting as shown in Table IV. this varied between one.25 – 2.78 A, that more than this needed once machining mistreatment a pair of millimeter conductor. this can be as a result of the expanse of the conductor on a six millimeter conductor is larger than its surface on a a pair of millimeter conductor. it's obvious that the larger the diameter, the upper current is needed throughout machining. Meanwhile, this drawn throughout machining of chrome steel is one.11 – 2.84 A.

The average of holes diameter created is seven.72 mm, therefore the average overcut is zero.86 mm. Then, if the overcut is compared with the diameter of conductor, it's regarding fourteen.36%. This result doesn't have a way distinction from the proportion on experiment mistreatment a pair of millimeter conductor that is sixteen.50% as shown in Table VI. However, for the chrome steel, the proportion of overcut to the diameter of conductor has considerably totally different if mistreatment a pair of and six millimeter conductor diameter.

The angle of overcut is shown on Fig. 7 and 8. From Fig. seven (stainless steel), 43° angle on the left is created mistreatment a pair of millimeter conductor whereas 46° angle on the proper is created mistreatment six millimeter conductor. Meanwhile, from Fig. eight (aluminium), 42° angle on the left is created mistreatment a pair of millimeter conductor whereas 43° angle on the proper is created mistreatment six millimeter conductor.

4. CONCLUSIONS

Overcut on chemistry machining has been ascertained. the kind of machined material has impact to the overcut. On average, brass turn out Associate in Nursing overcut of one.62 millimeter with angle of 61o , whereas chrome steel produce less overcut i.e. 0.30 millimeter with angle of overcut 43o and therefore the atomic number 13 with zero.33 millimeter overcut and 42o of overcut angle. The electronic warfare has been done mistreatment a pair of millimeter of brass conductor and one millimeter thickness of work material. mistreatment six millimeter of brass conductor, the overcut of chrome steel is zero.40 millimeter with angle of overcut 46o whereas on atomic number 13 the overcut is zero.86 millimeter with 43o of overcut angle. there's a powerful positive relationship between the overcut and therefore the angle of overcut amongst these 3 materials ascertained, i.e. r = 0.998.

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