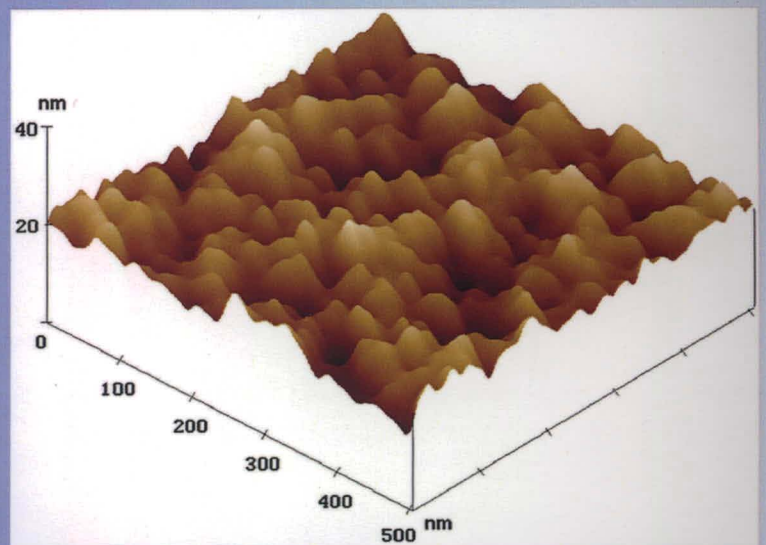
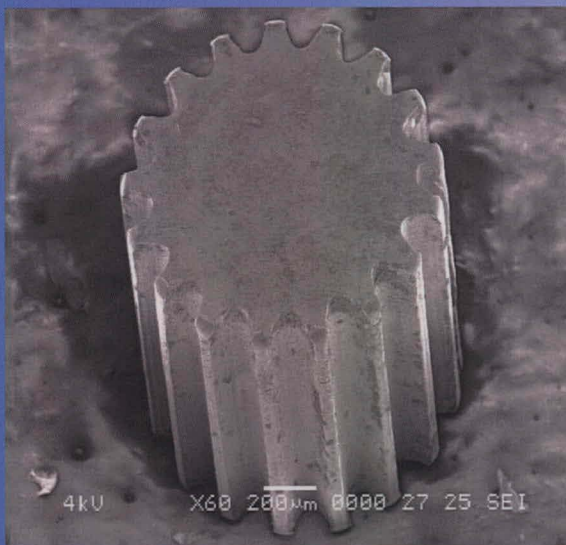
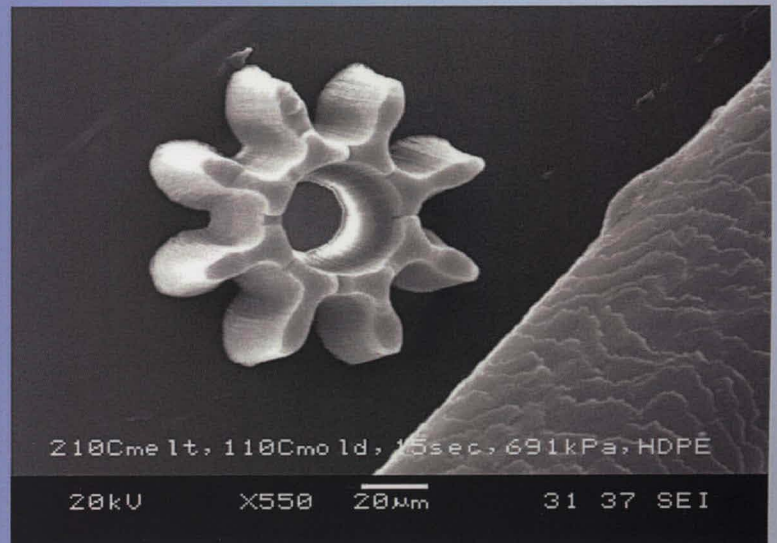
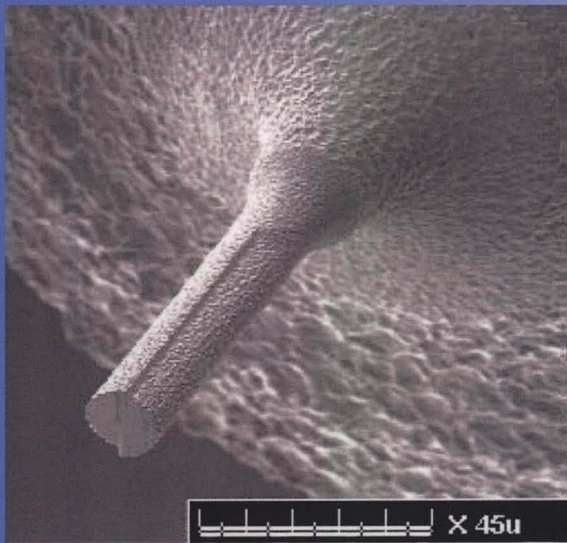


Advanced Machining Process



Editors

Mohammad Yeakub Ali

AKM Nurul Amin

Erry Yulian Triblas Adesta

IIUM PRESS

INTERNATIONAL ISLAMIC UNIVERSITY MALAYSIA



Advanced Machining Process

Editors

**Mohammad Yeakub Ali
AKM Nurul Amin
Erry Yulian Triblas Adesta**



IIUM Press

Published by:
IIUM Press
International Islamic University Malaysia

First Edition, 2011
©IIUM Press, IIUM

All rights reserved. No part of this publication may be reproduced, stored in a retrieval system, or transmitted, in any form or by any means, electronic, mechanical, photocopying, recording, or otherwise, without any prior written permission of the publisher.

Perpustakaan Negara Malaysia

Cataloguing-in-Publication Data

Mohammad Yeakub Ali, AKM Nurul Amin & Erry Yulian Triblas Adesta: Advanced Machining Process

ISBN: 978-967-418-162-8

Member of Majlis Penerbitan Ilmiah Malaysia – MAPIM
(Malaysian Scholarly Publishing Council)

Printed By:
IIUM PRINTING SDN.BHD.
No. 1, Jalan Industri Batu Caves 1/3
Taman Perindustrian Batu Caves
Batu Caves Centre Point
68100 Batu Caves
Selangor Darul Ehsan
Tel: +603-6188 1542 / 44 / 45 Fax: +603-6188 1543
EMAIL: iiumprinting@yahoo.com

Advanced Machining Process

Table of Contents

<i>Preface</i>	<i>ii</i>
<i>Acknowledgement</i>	<i>iii</i>
<i>Copyright</i>	<i>iv</i>
<i>PART 1: ELECTRO DISCHARGE MACHINING</i>	<i>1</i>
Chapter 1	2
Tool Wear rate during Electrical Discharge Machining (EDM) with Eccentric Electrode <i>Ahsan Ali Khan, Affendi Bin Saad and Mohd Zulfadli Isma Bin Mohd Isa</i>	
Chapter 2	7
Wear Ratio and Work Surface Finish during Electrical Discharge Machining (EDM) with Eccentric Electrode <i>Ahsan Ali Khan, Affendi Bin Saad and Mohd Zulfadli Isma Bin Mohd Isa</i>	
Chapter 3	12
Role of Current, Voltage and Spark on-time on Electrode Material Migration during EDM <i>Ahsan Ali Khan, Nurul Shima Mohd Noh</i>	
Chapter 4	18
A Study on Material Removal Rate during EDM with Tantalum Carbide-Copper Compacted Electrode <i>Ahsan Ali Khan, Mohammad Azhadi Bin Mohammad Hambiyah and Mohd Faiz Bin Nazi Nadin</i>	
Chapter 5	23
Features of EDM of Mild Steel with Ta-Cu Powder Compacted Electrodes <i>Ahsan Ali Khan, Mohammad Azhadi Bin Mohammad Hambiyah and Mohd Faiz Bin Nazi Nadin</i>	
Chapter 6	28
Relationship between Machining Variables and Process Characteristics during Wire EDM <i>Ahsan Ali Khan, M. B. M. Ali and N. B. M. Shaffiar</i>	

Chapter 7		33
	Influence of Machining Parameters on Surface Roughness during EDM of Mild Steel	
	<i>Ahsan Ali Khan, Erry Y.T. Adesta and Mohammad Yeakub Ali</i>	
Chapter 8		38
	Machining of Ceramic Materials: A Review	
	<i>Abdus Sabur, Md. Abdul Maleque and Mohammad Yeakub Ali</i>	
Chapter 9		44
	Formation of Micro-cracks and Recast Layer during EDM of Mild Steel using Copper Electrodes	
	<i>Ahsan Ali Khan, Erry Y.T. Adesta and Mohammad Yeakub Ali</i>	
Chapter 10		49
	Features of Electrode Wear during EDM of Mild Steel with TaC-Cu Powder Compacted Electrodes	
	<i>Ahsan Ali Khan, Mohd Faiz Bin Nazi Nadin and Mohammad Azhadi Bin Mohammad Hambiyah</i>	
Chapter 11		54
	Influence of Current, Spark On-time and Off-time on Electrode Wear during EDM of Mild Steel	
	<i>Ahsan Ali Khan, Mohd Faiz Bin Nazi Nadin and Mohammad Azhadi Bin Mohammad Hambiyah</i>	
Chapter 12		59
	A Comparative study on Work Surface Hardness EDMed by Ta-C Powder Compacted and Copper Electrodes	
	<i>Ahsan Ali Khan, Mohd Faiz Bin Nazi Nadin and Mohammad Azhadi Bin Mohammad Hambiyah</i>	
Chapter 13		65
	An Introduction to Electrical Discharge Machining	
	<i>Ahsan Ali Khan and Mohammed Baba Ndaliman</i>	
Chapter 14		70
	Developments in EDM Process Variables	
	<i>Ahsan Ali Khan, Mohammed Baba Ndaliman and Mohammad Yeakub Ali</i>	

PART 2: MICROMACHINING	76
Chapter 15	77
Focused Ion Beam Micromachining: Technology and Application <i>Israd Hakim Jaafar, Nur Atiqah, Asfana Banu, Mohammad Yeakub Ali</i>	
Chapter 16	83
Finish Cut of Titanium Alloy using Micro Electro Discharge Milling for Nano Surface Finish <i>Mohammad Yeakub Ali, Muhamad Faizal, Asfana Banu, and Nur Atiqah</i>	
Chapter 17	89
Investigation of MRR for Finish Cut of Titanium Alloy using Micro Electro Discharge Milling <i>Mohammad Yeakub Ali, Mohd Saifuddin, Nur Atiqah, and Asfana Banu</i>	
Chapter 18	95
Investigation of TWR for Finish Cut of Titanium Alloy using Micro Electro Discharge Milling <i>Mohammad Yeakub Ali, Mohd Saifuddin, Nur Atiqah, and Asfana Banu</i>	
Chapter 19	101
Investigation of Chip Formation and Minimum Chip Thickness in Micro/Meso Milling: Methodology and Design of Experiment <i>Mohammad Yeakub Ali, Noor Adila Mansor and Siti Hamizah Mass Duki</i>	
Chapter 20	107
Micro/Meso Milling of Aluminium Alloy 1100: Analysis and Modelling of Minimum Chip Thickness <i>Mohammad Yeakub Ali, Noor Adila Mansor and Siti Hamizah Mass Duki</i>	
Chapter 21	113
Effect of Micro End Milling Tool Diameter on Minimum Chip Thickness <i>Mohammad Yeakub Ali, Noor Adila Mansor and Siti Hamizah Mass Duki</i>	
Chapter 22	119
Micro Wire Electrical Discharge Machining of Tungsten Carbide: Methodology and Procedure <i>Mohammad Yeakub Ali, Ahmad Chaaban Elabtah and Musab Jamal Alrefaie</i>	
Chapter 23	124
Micro Wire Electrical Discharge Machining of Tungsten Carbide: Analysis of Surface Roughness <i>Mohammad Yeakub Ali, Ahmad Chaaban Elabtah and Musab Jamal Alrefaie</i>	
Chapter 24	130
Micro Wire Electrical Discharge Machining of Tungsten Carbide: Analysis of Material Removal Rate <i>Mohammad Yeakub Ali, Musab Jamal Alrefaie and Ahmad Chaaban Elabtah</i>	
Chapter 25	136
Micro Electro Discharge Machining of Micro Pillar Array: Process	

Chapter 25		136
	Micro Electro Discharge Machining of Micro Pillar Array: Process Development	
	<i>Mohammad Yeakub Ali, Wan Emira Azaty and Nor Suriza</i>	
Chapter 26		142
	Micro Electro Discharge Machining of Micro Pillar Array: Analysis of Surface Finish	
	<i>Mohammad Yeakub Ali, Wan Emira Azaty and Nor Suriza</i>	
Chapter 27		148
	Micro Electro Discharge Machining of Micropillar Array: Analysis of Material Removal Rate	
	<i>Mohammad Yeakub Ali, Nor Suriza and Wan Emira Azaty</i>	
Chapter 28		154
	Vibration Issue in Micro End Milling	
	<i>Mohammad Yeakub Ali, Muhamad Lutfi and Mohamad Ismail Fahmi</i>	
Chapter 29		159
	Fabrication of Micro Filter by Electro Discharge Machining	
	<i>Abdus Sabur and Mohammad Yeakub Ali</i>	

PART 3: PRECISION MACHINING	165
Chapter 30	166
High Speed Milling of Mould Steel using 1.5mm-diameter End-mills <i>Mohamed Konneh, Khairunnisa Ahmad and Rose Fazleen</i>	
Chapter 31	172
Precision Grinding of Silicon Carbide using 46 μm Grain Diamond Cup Wheel <i>Mohamed Konneh and Ahmad Fauzan</i>	
Chapter 32	178
Precision Grinding of Silicon Carbide using 76 μm Grain Diamond Cup Wheel <i>Mohamed Konneh and Mohd Shukur Zawawi</i>	
Chapter 33	184
Precision Grinding of Silicon Carbide using 107 μm Grain Diamond Cup Wheel <i>Mohamed Konneh and Mohd Fadzil</i>	
Chapter 34	190
Investigation of Surface Integrity during Precision Grinding of Silicon Carbide using Diamond Grinding Pins <i>Mohamed Konneh, Mohamad Lutfi and Mohamad Shahrilnizam</i>	
Chapter 35	196
A Comparative Study on Flank Wear and Work Surface Finish during High Speed Milling of Cast Iron with Different Carbide Tools <i>Ahsan Ali Khan, Zuraida Aman Nor Rasid and Izausmawati Yusof</i>	

Features of EDM of Mild Steel with Ta-Cu Powder Compacted Electrodes

Ahsan Ali Khan[✉], Mohammad Azhadi Bin Mohd Hambiyah and Mohd Faiz Bin Nazi Nadin
Faculty of Engineering – International Islamic University Malaysia

✉ : aakhan@iium.edu.my

Keywords: Electro discharge machining, Surface roughness; electrodes, Tantalum carbide; Copper

Abstract. During EDM work surface roughness can be influenced by using powder compacted electrodes. The present study shows that surface roughness of workpiece is higher when using TaC/Cu green compacted electrode compared to that produced by pure copper electrode. When using TaC/Cu green compacted electrode, more material is deposited on the workpiece surface and a thick layer is formed on the surface. In addition, the particles from the electrode are randomly deposited on the workpiece surface. On the contrary, there will be only a very thin layer of material from electrode will be deposited on the workpiece surface when using pure copper electrode. A thick deposited layer with randomly deposited particles will create rougher surface rather than a thin layer. That is why surface roughness is high when using TaC/Cu green compacted electrode.

Introduction

In normal EDM process by using conventional electrode like copper and brass, the surface quality especially corrosion resistance of work material does not improve. It needs further processing to enhance the corrosion resistance and this will increase the machining cost. Powder metallurgy (PM) compacted electrode is the best method to overcome this problem because during machining operation, the material from the compacted electrode will be deposited on top surface of work material. Hence, it will increase the corrosion resistance of work material while machining cost is reduced. It is also reported by some investigators that work surface roughness can also be improved using PM compacted electrodes.

The level of workpiece modification or workpiece alloying in EDM can be greatly improved with the usage of PM compacted electrode. The speed to develop layer formation on the workpiece surface also can be increased. The thickness of recast layer also is increased by applying PM compacted electrode. Harder layers on the workpiece surface can be beneficial in providing increased abrasion and corrosion resistance to the workpiece [1, 2].

Green PM compacted electrode is the electrode made by mixing two or more metal powder and pressing it by the compression machine without going through the sintering process. Compacting pressure during in the fabrication of green PM compacted electrode give major effect to the electrical, thermal and mechanical properties of the electrode. When the compacting pressure is high, the electrical, thermal and mechanical properties will show significant improvements [3].