

EFFECT OF MATERIAL STRUCTURE MACHINING CHARACTERISTICS OF
HYPEREUTECTIC AL-SI ALLOY

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To My Beloved Mother, Father, Brothers and Sisters

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ABSTRACT

In the present research, experimental results of an investigation of dry turning of hypereutectic aluminium silicon alloy using polycrystalline diamond (PCD) tools are presented. Attention is focused on the effect of workpiece microstructure on the performance of the cutting tools in terms of tool wear, surface roughness and chip formation. The experimental study involves turning operations at three different cutting speeds: 500, 600 and 700 m/min and constant depth of cuts and feed rates. The results obtained showed that PCD tools are important in cutting this hard Al-Si alloy of reduced machinability. The lowest cutting speed provides good machinability and surface finish. The change of workpiece structure was induced by modifying the primary Si phase in Al-Si alloy with strontium (Sr). This attempt found that Sr alone does not lead to a significant reduction in the size of primary Si phase. However, the results indicated that if the structure is modified the tool wear improves compared to the unmodified alloy.

ABSTRAK

Penyelidikan ini membentangkan keputusan hasil ujikaji terhadap pemesinan bahan aloi aluminium silicon hipereutektik tanpa menggunakan bahan penyejuk dengan menggunakan mata alat intan polikristal (PCD). Fokus utama adalah untuk melihat kesan mikrostruktur bendakerja terhadap mata alat dari segi kadar kehausan mata alat, kekasaran permukaan dan pembentukkan tatal. Kajian eksperimen melibatkan proses melarik dengan menggunakan tiga tahap kelajuan pemotongan yang berbeza iaitu 500, 600 dan 700 m/min. Kedalaman pemotongan dan kadar uluran adalah tetap. Hasil kajian menunjukkan bahawa mata alat PCD sangat penting kerana ia dapat memudahkan pemesinan aloi Al-Si yang keras ini. Halaju pemotongan yang paling rendah didapati memberikan kadar pemesinan yang paling baik dan hasil permukaan yang licin. pembahan mikrostruktur bendakerja adalah dihasilkan melalui pengubahsuaian fasa utama Si di dalam aloi Al-Si dengan strontium (Sr). Kajian ini mendapati bahawa Sr sahaja tidak memberi kesan yang nyata dalam pengurangan saiz fasa utama Si. Walau bagaimanapun hasil kajian ini menunjukkan bahawa sekiranya struktur ini diubahsuai, maka kadar kehausan mata alat dapat dikurangkan berbanding dengan aloi yang tidak diubahsuai.

TABLE OF CONTENTS

CHAPTER	TITLE	PAGE
	DECLARATION	ii
	DEDICATION	iii
	ACKNOWLEDGEMENTS	iv
	ABSTRACT	vi
	ABSTRAK	vii
	TABLE OF CONTENTS	viii
	LIST OF TABLES	xii
	LIST OF FIGURES	xiii
	LIST OF APPENDENCES	xvii
1	INTRODUCTION	1
	1.1 Background	1
	1.2 Problem Statement	2
	1.3 Objective of the Project	2
	1.4 Scope of the Project	2
2	LITERATURE REVIEW	4
	2.1 Aluminium and its alloys	4
	2.1.1 Classification of Aluminium Alloys	5
	2.1.1.1 Casting Alloys	5
	2.1.1.2. Wrought Alloys	6
	2.1.2 Applications of Aluminium Alloys	7
	2.1.3 Casting processes	7
	2.2 Al-Si Casting alloys	8

2.2.1	Solidification of Al-Si Alloys	9
2.2.2	Aluminum- silicon – magnesium alloys	10
2.2.3	Hypereutectic Al-Si Alloys	13
2.2.4	Grain Refinement of hypereutectic Al-Si Alloys	14
2.2.5	Modification of Al-Si Alloys	15
2.3	Machining	16
2.3.1	Theory of metal cutting and hard turning	17
2.3.1.1	Hard turning	19
2.3.2	Cutting force	20
2.3.3	Cutting temperature and heat generated	20
2.3.4	Chip Formation	21
2.3.4.1	Chip formation during hard turning	24
2.3.5	Tool life criteria	25
2.3.6	Tool failure modes	25
2.3.6.1	Flank wear	25
2.3.6.2	Crater wear	28
2.3.6.3	Brittle fracture	29
2.3.6.4	Plastic deformation	30
2.3.7	Tool wear mechanism	30
2.3.7.1	Abrasion (abrasive) wear	30
2.3.7.2	Attrition (adhesion) wears	31
2.3.7.3	Diffusion wear	32
2.3.7.4	Oxidation wear	32
2.4	Cutting tools	32
2.4.1	Single point tools	33
2.4.2	Cutting tool material	34
2.4.2.1	High speed steel	34
2.4.2.2	Carbides	34
2.4.2.3	Coated carbides	36
2.4.2.4	Ceramic	36
2.4.2.5	Cubic boron nitride	37

5.2 Recommendations for future work.	74
REFERENCES	75
APPENDIX A	79

LIST OF TABLES

TABLE NO.	TITLE	PAGE
2.1	The general characteristics of aluminium	4
2.2	Cast aluminum alloy groups	6
2.3	Wrought aluminum alloy groups	7
3.1	Chemical compositions of A390	44
3.2	Mechanical Properties of A390	44
4.1.1	Test results for the unmodified alloy for cutting speed of 500 m/min	53
4.1.2	Test results for the unmodified alloy for cutting speed of 600 m/min	54
4.1.3	Test results for the unmodified alloy for cutting speed of 700 m/min	55
4.2.1	Test results for the Sr-modified alloy for cutting speed of 500 m/min	55
4.2.2	Test results for the Sr-modified alloy for cutting speed of 600 m/min	56
4.2.3	Test results for the Sr-modified alloy for cutting speed of 700 m/min	57

LIST OF FIGURES

FIGURE NO.	TITLE	PAGE
2.1	Phase diagram of Al-Si alloy	9
2.2	Types of microstructures that may form during solidification of a casting	10
2.3	Aluminum – silicon phase diagram and microstructures	11
2.4	Cooling curve of a cooled metal and the effect of grain refinement	12
2.5	Orthogonal and oblique cutting, a) orthogonal cutting, b) oblique cutting	16
2.6	Terms used in metal cutting a) Positive rake angle, b) negative rake angle	17
2.7	Merchant force diagram	18
2.8	Turning operation	18
2.9	Force in turning	19
2.10	Heat generation zone	20
2.11	Formation of chip during metal cutting	21
2.12	continuous chip formations during machining	22
2.13	Continuous chips with BUE formation during machining	23
2.14	Discontinuous chip formation	23
2.15	Chip morphology according to hardness and cutting speed	24
2.16	Types of wear observed in cutting tool	25
2.17	Tool life criteria	26
2.18	The effect of cutting speed and the progress of flank wear	27

2.19	Common properties of cutting tool materials	28
2.20	Turning tool geometry showing all angles	33
2.21	Tool designations for single point cutting tool	34
3.1	Summary of the methodology used in the study	40
3.2	Condition of workpiece material	42
3.3	Comparison of the solidification modes in aluminium silicon alloys	44
3.4	Condition of workpiece material (a) as cast, (b) after skinning process	45
3.5	ALPHA 1350S, 2-axis CNC lathe	46
3.6	Tool Maker's Microscope Nikon	46
3.7	Portable Surface Profilometer, Taylor Hobson Surtronic 3+.	47
3.8	Optical Nikon Microscope c/w Image Analyzing Software	47
3.9	Polycrystalline diamond (PCD) tool	48
3.10	Measurements of tool wear in turning according	50
3.11	Metallurgical and specimen preparation equipments, (a) Mounting machine, (b) Polishing machine and (c) Manual sanding machine	52
4.1	Microstructures of a) unmodified and b) Sr-modified AlSi18 alloy (X100)	58
4.2	Wear curves for PCD insert in turning the unmodified alloy versus cutting time at cutting speeds of 500, 600 and 700 m/min	60
4.3	Wear curves for PCD insert in turning Sr-modified alloys versus cutting time at different cutting speeds of 500, 600 and 700 m/min	60
4.4	Image of flank wears of PCD tool when machining unmodified AlSi18 alloy at different cutting speeds: 500, 600, and 700 (m/min).	62
4.5	Image of flank wear of PCD tool when machining Sr-modified AlSi18 alloy at different cutting speeds: 500, 600, 700 (m/min).	63

4.6	Surface roughness obtained when machine unmodified AlSi18 alloy with PCD at different cutting speeds	64
4.7	Surface roughness obtained when machining Sr-modified AlSi18 with PCD at different cutting speeds	65
4.8	Types of chip produced by PCD tool in turning the unmodified AlSi18 alloy at different cutting speeds and cutting time	67
4.9	Types of chip produced by PCD tool in turning Sr-modified AlSi18 alloy at different cutting speeds and cutting time	68
4.10	Image of chip root when cutting unmodified alloy at 500m/min using PCD cutting tool.	69
4.11	Image of chip root when cutting unmodified alloy at 600m/min using PCD cutting tool.	70
4.12	Image of chip root when cutting unmodified alloy at 700m/min using PCD cutting tool.	70
4.13	Image of chip root when cutting Sr-modified alloy at 500m/min using PCD cutting tool.	71
4.14	Image of chip root when cutting Sr-modified alloy at 600m/min using PCD cutting tool.	71
4.15	Image of chip root when cutting Sr-modified alloy at 700m/min using PCD cutting tool.	72
A.1	Type of engine parts was produced by A390 alloy. (Source by SEIL CO. LTD)	79

LIST OF APPENDICES

APPENDIX	TITLE	PAGE
A	application of aluminum silicon alloys	79

CHAPTER 1

INTRODUCTION

1.1 Background

Hypereutectic aluminum–silicon (Al–Si) alloys have been used for many lightweight, high-strength applications. A390 is one of hypereutectic Al–Si alloys, with 18wt% Si, and has been used for internal combustion engine parts, cylinder bodies of compressors and pumps, and brake systems, etc., because of its low thermal expansion coefficient, high hardness, and good wear resistance. In hypereutectic Al–Si alloys, the high silicon content, exceeding the eutectic composition (about 12 wt%), is purposely introduced to enhance the wear resistance at high temperatures, however, the excess silicon, in the form of proeutectic silicon grains (order of 10 μm), is hard, highly abrasive, and significantly impact the machinability.

Tool wear in machining of high-Si aluminum alloys has been characterized as abrasion due to scratching of crushed primary Si particles and adhesion/abrasion induced micro-chipping of the cutting edge due to periodic removals of the built-up workpiece material at the tool surface.

The wear mechanisms of PCD are various in machining different materials. Nowadays, the development of construction industry accelerates the increase of man-made boards. Much attention has been focused on the machining of wood based materials by diamond tools.

1.2 Problem statement

The properties of Al- Si alloy are controlled by the reinforcement and the interface. In particular, many of the considerations arising due to fabrication, processing and considerations performance of Al- Si alloy are related to process that take place in the interfacial region between matrix and reinforcement.

A continuing problem with Al- Si alloy is that they are difficult to machine, tool wear is rapid due to the hardness and abrasive nature of the Si and other reinforcing particles. Polycrystalline diamond (PCD) is an exception, as its hardness is approximately three or four times that of the silicon (Si). This is the reason why PCD is recommended by many researchers, who studied the turning of these materials.

Evaluate the performance of Diamond tool become important depends to application of Al- Si alloy to improve their machinability and to obtain economical tool life in machining Al- Si alloy.

1.3 Objective

The main objective of this thesis is to evaluate the influence of work-piece material structure on machining characteristics of hypereutectic Al-Si cast alloy and to examine the type of chips formed during turning of hypereutectic Al-Si cast alloy.

1.4 Scope of the Project

- a) Work-piece materials preparation
 - Unmodified hypereutectic Al-Si cast alloy.
 - Sr-Modified hypereutectic Al-Si cast alloy
- b) Microstructure Analysis.

- c) Evaluate effect of material structure on machining characteristics during turning using diamond tools.
- d) Performances the tools are evaluated based on wear and tool life criteria.