



UNIVERSITI TEKNIKAL MALAYSIA MELAKA

**STUDY ON THE EFFECT OF EDM DIE SINKING
PARAMETERS ON THE SURFACE FINISH OF MILD STEEL**

This report submitted in accordance with requirement of the Universiti Teknikal
Malaysia Melaka (UTeM) for the Bachelor of Manufacturing Engineering
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by

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APPROVAL

This report is submitted to the Faculty of Engineering Technology of UTeM as a partial fulfillment of the requirements for the degree of Bachelor of Engineering Technology Manufacturing (Process and Technology) with (Hons.). The member of the supervisory is as follow:

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Mohd Razali bin Md Yunos

ABSTRACT

Die sinking electrical discharge machining EDM is one of the earliest non-traditional machining processes and has a capability in producing high precision parts. An inappropriate EDM die sinking machining parameter will affects the quality of the surface roughness parts because the spark gap between work piece and electrode are lower. Therefore, this research was conducted to investigate the effect of EDM die sinking machining parameters on surface roughness of mild steel material. The spark gap and peak current were manipulated to find the best combination of EDM machining parameters. The machine surfaced will analysed using surface roughness test and the image of textured are captured by using microscope. At the end of this experiment, it is shown that spark gap and peak current have the maximum influence on surface roughness. When the spark gap was increased, the value of surface roughness decreased which give finer surface structure, and when peak current increase, the value of surface roughness, will be higher and produce the rough surface finish.

ABSTRAK

Electik nyahcas mesin EDM adalah salah satu proses pemesinan moden yang paling awal dan mempunyai keupayaan untuk menghasilkan bahagian dengan ketepatan yang tinggi. Ketidaksesuaian parameter yang digunakan daripada proses EDM akan memberi kesan kepada kualiti bahagian-bahagian kekasaran permukaan kerana sela bunga api di antara bahan kerja dan elektrod adalah lebih rendah. Oleh itu, kajian ini dijalankan untuk mengkaji kesan daripada proses EDM parameter kepada kekasaran permukaan keluli lembut untuk kemasukan sela bunga api. Arus puncak dan jarak percikan akan dikaji untuk mencari kombinasi terbaik parameter pemesinan EDM. Permukaan yang telah dimesin oleh EDM akan dianalisis dengan menggunakan ujian kekasaran permukaan dan imej bertekstur direkod dengan menggunakan mikroskop. Di akhir eksperimen ini, kajian menunjukkan bahawa arus puncak dan jarak percikan memberi impak yang besar pada permukaan keluli. Apabila jarak percikan meningkat, permukaan keluli menjadi semakin licin dan apabila arus puncak meningkat, permukaan keluli menjadi semakin kasar.

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TABLE OF CONTENT

DECLARATION.....	iii
APPROVAL.....	iv
ABSTRACT.....	v
ABSTRAK.....	vi
DEDICATION.....	vii
ACKNOWLEDGEMENT.....	viii
LIST OF CONTENTS.....	ix
LIST OF FIGURE.....	xiv
LIST OF TABLE.....	xvii
LIST OF SYMBOL AND ABBREVIATIONS.....	xviii
CHAPTER 1	
1.1 Introduction.....	1
1.2 Current Situation.....	2
1.3 Problem Statement.....	2
1.4 Project Objective.....	3
1.5 Project Scope.....	4
CHAPTER 2	
2.1 Introduction.....	5
2.2 History of EDM Machine.....	8
2.3 Electrical Discharge Machining EDM.....	8

2.4	EDM Machining Process.....	9
2.4.1	Wire Cut.....	11
2.4.2	Small Hole Drilling.....	12
2.4.3	Die Sinking.....	14
2.5	EDM Machine Capabilities.....	15
2.6	EDM Machine Limitation.....	16
2.7	EDM Machine Advantages and Disadvantages.....	16
2.7.1	Advantages of EDM Machine.....	17
2.7.2	Disadvantages of EDM Machine.....	18
2.8	Electrode.....	19
2.8.1	Type of Electrode.....	20
2.8.2	Brass Electrode.....	21
2.8.3	Tungsten Electrode.....	22
2.8.4	Copper Electrode.....	23
2.8.5	Graphite Electrode.....	24
2.9	Dielectric Fluid.....	26
2.10	EDM Parameters.....	29
2.10.1	Peak Current.....	32
2.10.2	Spark Gap.....	32
2.11	EDM Die Sinking Machine.....	33
2.11.1	Machine Specification (mm).....	34
2.11.2	Machine Overview / Features.....	35
2.11.3	Machine Floor Plan / Layout.....	36

2.12	Surface Integrity.....	37
2.13	Material (Mild Steel).....	39
2.13.1	Chemical Composition.....	39
2.13.2	Mechanical Properties.....	40
2.13.3	Advantages of Mild Steel.....	41
2.13.4	Disadvantages of Mild Steel.....	41
2.14	Mean and Standard Deviation.....	42
2.14.1	Mean.....	42
2.14.2	Standard Deviation.....	42
2.14.3	Minitab.....	43
2.14.4	Microsoft Excel.....	44
2.14.5	SPSS (Statistical Package for Social Science).....	45
2.15	Milling Machine.....	46
2.15.1	Type of Milling Machine.....	47
2.16	Surface Roughness Measuring Tester (MITUTOYO SJ-410).....	48
2.17	Inverted Research Microscope (ZEISS, Axio vert.AI).....	49
2.17.1	Advantages of Axio vert.AI Microscope.....	50

CHAPTER 3

3.1	Introduction.....	51
3.2	Process Flow.....	52
3.3	Title Selection.....	54
3.4	Literature Review.....	54
3.5	Design of Experiment.....	55

3.6	Experimental Setup.....	57
3.6.1	Tool Preparation.....	57
3.6.2	Specimen Preparation	59
3.7	Machining Process.....	60
3.7.1	Machining Illustration.....	61
3.7.2	Machining Step Operation.....	61
3.8	Surface Roughness Test.....	63
3.8.1	Surface Test Step.....	63
3.9	Surface Integrity Test.....	65
3.10	Mean and Standard Deviation Analysis.....	67
3.11	Expected Result.....	68
 CHAPTER 4		
4.1	Experimental Result.....	69
4.2	Analysis of Experiment.....	73
4.2.1	Effect of spark gap (SG) on surface roughness (Ra).....	73
4.2.2	Effect of peak current (IP) on surface roughness (Ra).....	75
4.3	Surface Microstructure.....	77
4.3.1	Effect of spark gap (SG) on surface structure.....	77
4.3.2	Effect of peak current (IP) on surface structure.....	79
4.4	Discussion.....	81
 CHAPTER 5		
5.1	Conclusion.....	83
5.2	Recommendation.....	85

REFERENCES	87
APPENDIX A	89
APPENDIX B	92
APPENDIX C	94
APPENDIX D	96

LIST OF FIGURE

Figure 1.1:	Schematic of EDM die sinking process.....	3
Figure 2.1:	Mild steel.....	7
Figure 2.2:	Phase of electrical discharge in EDM.....	10
Figure 2.3:	Mechanism of wire cut.....	12
Figure 2.4:	Mechanism of small hole drilling.....	13
Figure 2.5:	Mechanism of die sinking.....	14
Figure 2.6:	Electrode end wear.....	19
Figure 2.7:	Electrode melting points.....	20
Figure 2.8:	Brass electrode.....	22
Figure 2.9:	Tungsten electrode.....	23
Figure 2.10:	Copper electrode.....	24
Figure 2.11:	Graphite electrode.....	26
Figure 2.12:	Dielectric fluid.....	28
Figure 2.13:	Spark gap area.....	33
Figure 2.14:	EA12D die sinking machine.....	33
Figure 2.15:	EDM die sinking machine layout.....	36
Figure 2.16:	Pillar crystal formed during solidification.....	38
Figure 2.17:	Mild steel.....	41
Figure 2.18:	Layout of Minitab software.....	44

Figure 2.19:	Layout of Excel software.....	45
Figure 2.20:	Layout of SPSS.....	46
Figure 2.21:	Milling machine.....	48
Figure 2.22:	Roughness tester Mitutoyo SJ-410.....	49
Figure 2.23:	Inverted microscope.....	50
Figure 3.1:	Flow chart for PSM 1.....	52
Figure 3.2:	Flow chart for PSM 2.....	53
Figure 3.3:	Size of the electrode (tool).....	58
Figure 3.4:	Dimension of work piece.....	59
Figure 3.5:	Actual part of work piece.....	59
Figure 3.6:	Milling machine.....	60
Figure 3.7:	CAD drawing for work piece and tool for machining.....	61
Figure 3.8:	Surface roughness testing.....	64
Figure 3.9:	Surface roughness data.....	65
Figure 3.10:	Surface integrity testing.....	66
Figure 4.1:	Relationship of surface roughness and spark gap.....	73
Figure 4.2:	Effects of surface roughness on spark gap.....	74
Figure 4.3:	Dr. Navdeep's spark gap value range compare to this experiment...75	
Figure 4.4:	Relationship of surface roughness and peak current.....	76
Figure 4.5:	Effects of surface roughness on peak current.....	77
Figure 4.6:	Surface structure 20x magnification (spark gap, SG= 1 mm).....	78
Figure 4.7:	Surface structure 20x magnification (spark gap, SG= 15 mm).....	78
Figure 4.8:	Surface structure 20x magnification (Peak current, IP= 2.1 A).....	79

Figure 4.9: Surface structure 20x magnification (Peak current, $I_P = 3.5 \text{ A}$).....80

LIST OF TABLE

Table 2.1:	EDM machine specification.....	34
Table 2.2:	Chemical composition in mild steel.....	39
Table 2.3:	Mechanical properties for mild steel.....	40
Table 3.1:	Machine parameters for first set specimen.....	55
Table 3.2:	Machine parameters for second set specimen.....	56
Table 3.3:	Constant parameters for each specimen.....	57
Table 3.4:	Properties of copper electrode.....	58
Table 3.5:	Elemental compositions for mild steel.....	60
Table 3.6:	MITUTOYO SJ-410 parameter.....	64
Table 4.1:	Result of experiment for spark gap variable (surface roughness).....	70
Table 4.2:	Result of experiment for peak current variable (surface roughness).....	72
Table 4.3:	Mean data for surface roughness on spark gap effect.....	73
Table 4.4:	Mean data for surface roughness on peak current effect.....	75

CHAPTER 1

INTRODUCTION

1.1 Introduction

In order to make the reader understand, there must be an introduction for every kind of report. An introduction also must be written in the excellent way so that the reader will be excited to read more about the report even though they just read the introduction part. In this part, there just a basic information about the project such as problem statement, objective of the project, current situation and project scope. All of this information is written in a summary way, that's because the further information will be written in literature review.

Literature review is one of the scope studies. It works as guide to run this analysis. It will give part in order to get the information about electrical discharge machine (EDM) and will give idea to operate the test. From the early stage of the project, various literature studies have been done and the uses of research journals, books, printed or online conference article were the main source in the project guides. History of the EDM will be story little bit in this section. Literature review section work as reference, to give information and guide base on journal and other source in the media.

For methodology part, it will present the information about process flow of the project. It is the combination of the PSM 1 and PSM 2 process flow. In this chapter, there will be the design of experiment (DOE) for this project, experiment set up, tool preparation, specimen preparation, machining set up, testing the specimen after machining and data analysis using selected method and software. Methodology

session is a part that will make the reader understand the step that been take in order to complete this project.

1.2 Current Situation

EDM die sinking is being use in worldwide now a day. All of the machine has their own parameter that been set by their users. There a place that want to produce a rough surface finish, and another place want to produce a smooth surface finish. The parameter is use depend on the purpose of work. Sometime there a place that misused the parameter, so that it will not get the 100% requirement product. So that why this study is all about, to study the best parameter to be use in order to get the optimum surface finish.

1.3 Problem Statement

The limitations of EDM die sinking is due to the slow rate of material removal. This is because of the gap between electrodes that strike to towards the work piece at one time. Besides that, EDM die sinking involves high power consumption in its process. The process may require high energy power to run each process. In addition, the process of EDM die sinking is affected by the work piece layer. Surface defects are important in term of quality and accuracy of tolerance. The EDM parameter play a vital role in deciding machining characteristics like surface integrity, energy consumption and efficiency of EDM process especially on mild steel material.

Figure 1.1 shows the schematic of EDM die sinking process between electrode and work piece. Two metal parts will be submerged in an insulating liquid that are connected to a source of current and it is switched on and off automatically depending on the parameters set on the controller. When the current is switched on, an electric tension is created between the two metal parts. If the two parts are brought together to within a fraction of an inch, the electrical tension is discharged and a spark jumps across. Where it strikes, the metal is heated up so much that it melts. Innumerable such sparks spray, one after the other (never simultaneously) and

gradually shape the desired form in the piece of metal, according to the shape of the electrode. Several hundred thousand sparks must fly per second before erosion takes place.

In the case of EDM die sinking, the required shape is formed negatively in the metal with a three-dimensional electrode. By superimposed movements in the main axes x, y, c, z, the most varied shapes, indentations and cavities are created, such as cannot in part be achieved by any other machining system.

A value of surface roughness may be specified so that expensive finishing processes are eliminated, thereby reducing costs, or alternatively to improve the mechanical properties of a component. Repeating strike of electrode onto the work piece will give some damaged at material structured inside of work piece.

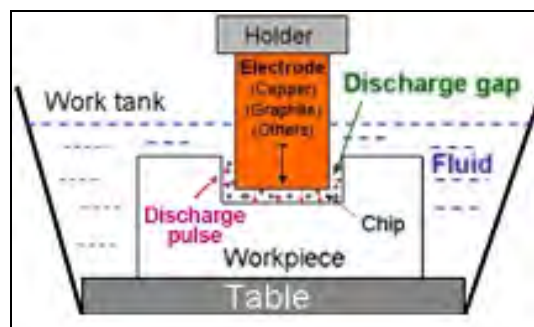


Figure 1.1 Schematic of EDM die sinking process

Source: www.sodick.co.in

1.4 Project Objectives

This project is come out with 4 objectives requirement:

- a) To design an appropriate experiment on the mild steel EDM die sinking process.
- b) To identify the parameters in EDM die sinking machining.
- c) To investigate the effects of EDM die sinking parameters on surface finish and microstructure.

- d) To suggest the optimum parameters of EDM die sinking in order to get a required or specified surface finish.

1.5 Project Scope

Scopes for this project is based on objectives that have stated and there are the several scopes that will be carrying out:

- a) Focusing on getting the best EDM machining parameters to get the good surface finish of the mild steel.
- b) Surface finish of mild steel will be studied using Inverted Research microscope.
- c) Material used in this experiment as work piece is mild steel.
- d) Material used in this experiment as tool electrode is copper.
- e) Machine model is EA12DM.

CHAPTER 2

LITERATURE REVIEW

2.1 Introduction

The electrical discharge machining EDM is one of the major manufacturing processes widely applied in die and mould making industry to generate deep and three-dimensional complex cavities in many different classes of materials under roughing and finishing operations. EDM is the thermal erosion process in which metal is removed by a series of repeated electrical discharges between a cutting tool acting as an electrode and a conductive work piece, in the presence of a dielectric fluid.

The advantages of EDM include machining of machining part that has complex shape. Complex shapes that would otherwise be difficult to produce with conventional cutting tools. Parts with complex, precise and irregular shapes for forging, press tools, extrusion dies, difficult internal shapes for aerospace and medical applications can be made by EDM process. EDM process find application in various fields such as the automotive, medical, aerospace, electrical and electronic industries.

Besides that, extremely hard material does not have to very close tolerances. This is including stainless steel, copper, graphite, and exotic metals that would cause difficulties during conventional machining. Materials of any hardness can be cut as long as the material can conduct electricity (H. Ramasawmy, 2004). The tool does not contact the work piece directly so even delicate materials can be machined using EDM.

The EDM process can be used in two different ways, the first way is a reshaped or formed electrode (tool), usually made from graphite or copper, is shaped to the form of the cavity it is to reproduce. The formed electrode is fed vertically down and the reverse shape of the electrode is eroded (burned) into the solid work piece. During the EDM process the work piece and the electrode are submerged in the dielectric oil, which is an electrical insulator that helps to control the arc discharge. The dielectric oil, that provides a means of flushing, is pumped through the arc gap. This removes suspended particles of work piece material and electrode from the work cavity.

The second way is a continuous-travelling vertical-wire electrode, the diameter of a small needle or less, is controlled by the computer to follow a programmed path to erode or cut a narrow slot through the work piece to produce the required shape. The wire-cut EDM is a discharge machine that uses computer numerical control (CNC) movement to produce the desired contour or shape. It does not require a special shaped electrode, instead it uses a continuous-traveling vertical wire under tension as the electrode. The electrode in wire-cut EDM is about as thick as a small diameter needle whose path is controlled by the machine computer to produce the shape required.

Very small work pieces where conventional cutting tools may damage the part from excess cutting tool pressure. EDM is often used to create prototypes for the aerospace industry. It is also used for creating dies for badges and jewellery. There is no direct contact between tool and work piece. Due of this, the surface of material will not have any adverse effects. Therefore delicate sections and weak materials can be machined without any distortion. In addition, a good surface finish can be obtained where at the end of process no burrs are left in machined surface.

Very fine holes can be easily drilled. EDM can be very useful for small hole drilling, often used in electronics. An interesting application is for removing tools such as drill bits which have broken off inside a work piece. Small hole EDM drilling, also known as fast hole EDM drilling, hole popper, and start hole EDM drilling. Now, small hole EDM machining is used for production work and the drilling speed have been achieved up. Holes can be drilled in any electrical conductive material, whether hard or soft, including carbide.

Discharge occurs when there are voltage gap between the electrode and work piece. Heat from the discharge vaporizes minute particles of work piece material, which are then washed from the gap by the continuously flushing dielectric fluid. The intensity of the electric field in the volume between the electrodes becomes greater than the strength of the dielectric when the distance between the two electrodes is reduced which breaks, allowing current to flow between the two electrodes.

The experiment will be conducted on a material called mild steel. Mild steel are used widely in mould manufacturing because of its properties of good corrosion resistance, excellent polish ability, good wear resistance, good machinability and good stability in hardening. Mild steel is recommended for all types of moulding tools and its special properties make it particularly suitable for moulds. Figure 2.1 shows the example shape of mild steel material used in this project.



Figure 2.1 Mild steel

Source: Steel Ltd catalogue