

EXPERIMENTAL INVESTIGATION OF TOOL WEAR
PROGRESSION IN TURNING OF NIMONIC C-263
ALLOY



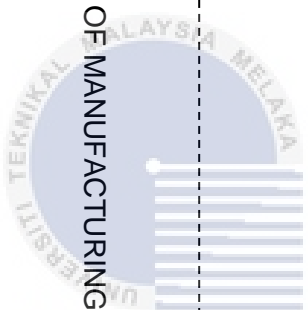
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UNIVERSITI TEKNIKAL MALAYSIA MELAKA



EXPERIMENTAL INVESTIGATION OF TOOL WEAR PROGRESSION IN TURNING OF NIMONIC C-263 ALLOY

This report is submitted in accordance with requirement of the University Teknikal Malaysia Melaka (UTeM) for Bachelor Degree of Manufacturing Engineering (Hons.)



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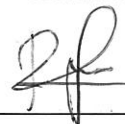
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I hereby, declared this report entitled “Experimental Investigation of Tool Wear Progression in Turning of Nimonic C-263 Alloy” is the result of my own research except as cited in references.

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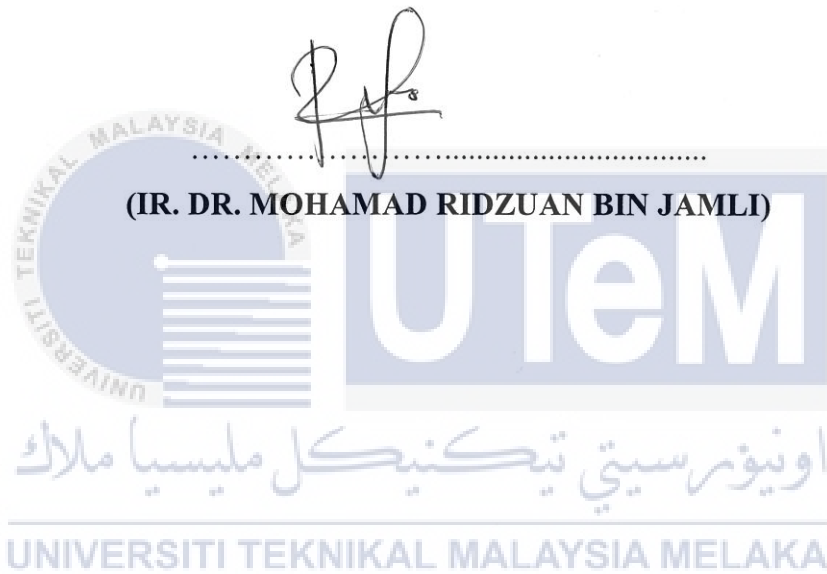
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APPROVAL

This report is submitted to the Faculty of Manufacturing Engineering of Universiti Teknikal Malaysia Melaka as a partial fulfilment of the requirement for Degree of Manufacturing Engineering (Hons). The member of the supervisory committee is as follow:



ABSTRACT

Because of its unique qualities, Nimonic C-263 Alloy is widely utilised in aircraft, gas turbine blades, power generators, and heat exchangers, among other applications. The materials are finding new uses in the fabrication of essential components for high-performance aviation gas turbine engines, partly because of their outstanding mechanical qualities that stay stable at high temperatures. According to a prior study, the most prevalent issue other researchers have run across while examining Nimonic C-263 Alloy is the cutting tool's short life cycle and thermal degradation. Besides, the cutting tool's wear is the most common problem encountered throughout this procedure. This study aims to conduct an experimental investigation of the wear characteristics of tools when turning Nimonic C-263 Alloy. This research will focus on the experimental investigation and analysis of machining parameters while turning Nimonic C-263 Alloy with PVD coated inserts to predict their optimal values. Cutting speed, feed rate, and depth of cut were the parameters that were considered for the parameters. The indication of process performance, the cutting temperature, and tool wear will be monitored and recorded. Using Response Surface Methodology (RSM), an empirical model will be developed for predicting tool wear and heat generation. From the results, the highest tool life documented in the research is 19.25 minutes, while the least is 1.97 minutes. By comparing the experimental result with the theoretical value with an error of less than 10 per cent demonstrates that the mathematical model accurately predicted the tool life.

ABSTRAK

Kerana kualitinya yang unik, Nimonic C-263 Alloy digunakan secara meluas dalam pesawat, bilah turbin gas, penjana kuasa dan penukar haba, antara aplikasi lain. Bahan-bahan tersebut menemui kegunaan baharu dalam fabrikasi komponen penting untuk enjin turbin gas penerbangan berprestasi tinggi, sebahagiannya kerana kualiti mekanikalnya yang cemerlang yang kekal stabil pada suhu tinggi. Menurut kajian terdahulu, isu paling lazim yang dihadapi oleh penyelidik lain semasa memeriksa Nimonic C-263 Aloi ialah kitaran hayat pendek alat pemotong dan degradasi haba. Selain itu, kehausan alat pemotong adalah masalah yang paling biasa dihadapi sepanjang prosedur ini. Kajian ini bertujuan untuk menjalankan penyiasatan eksperimen tentang ciri haus alatan semasa memusing Nimonic C-263 Aloi. Penyelidikan ini akan memberi tumpuan kepada penyiasatan eksperimen dan analisis parameter pemesinan sambil memutarkan Nimonic C-263 Aloi dengan sisipan bersalut PVD untuk meramalkan nilai optimumnya. Kelajuan pemotongan, kadar suapan, dan kedalaman pemotongan adalah parameter yang dipertimbangkan untuk parameter tersebut. Petunjuk prestasi proses, suhu pemotongan, dan kehausan alatan akan dipantau dan direkodkan. Menggunakan Metodologi Permukaan Tindak Balas (RSM), model empirikal akan dibangunkan untuk meramalkan haus alat dan penjana haba. Daripada keputusan, jangka hayat alat tertinggi yang didokumenkan dalam penyelidikan ialah 19.25 minit, manakala paling sedikit ialah 1.97 minit. Dengan membandingkan keputusan eksperimen dengan nilai teori dengan ralat kurang daripada 10 peratus menunjukkan bahawa model matematik meramalkan hayat alat dengan tepat.

DEDICATION

Only

My beloved father, Ahmad Faudzi Bin Ramli

My appreciated mother, Noorliza Binti Ismail

Fauzan, Fasihah, Fahim, Fakhirah, and Fawwaz are some of my most cherished family members.

Thank you for your moral and financial support, as well as your cooperation and understanding.

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TABLE OF CONTENT

Abstract	i
Abstrak	ii
Dedication	iii
Acknowledgement	iv
Table of Content	v
List of Tables	ix
List of Figures	x
List of Abbreviations	xii
List of Symbols	xiii
CHAPTER 1: INTRODUCTION	1
1.1 Background of Study	1
1.2 Problem Statement	2
1.3 Objective	3
1.4 Scope	3
1.5 Significant of Study	4
1.6 Organization of Report/ Thesis	4
1.7 Summary	5
CHAPTER 2: LITERATURE REVIEW	6
2.1 Turning	6

2.2 Nickel-Based Alloy	9
Nimonic C-263 Alloy	10
2.3 Tool Wear Failure	11
2.3.1 Flank Wear	11
2.3.2 Crater Wear	12
2.4 Tool life	13
2.5 Cutting Fluids	14
2.5.1 Minimal Quantity Lubrication (MQL)	14
2.5.2 High-Pressure Coolant (HPC)	15
2.5.3 Cryogenic Cooling CO ₂	16
2.5.4 Dry Machining	17
2.5.5 Flood Condition	18
2.6 Cutting Tool Material	18
2.6.1 Cemented Carbide	19
2.6.2 Coated and Uncoated Carbide	19
2.6.3 PVD and CVD	21
2.7 Wear mechanism	22
2.7.1 Abrasion and Adhesion Wear	22
2.8 Design of Experiment	25
2.8.1 Response Surface Methodology (RSM)	25
2.9 Summary	27
CHAPTER 3: METHODOLOGY	28
3.1 Process Flowchart	28
3.2 Equipment of Experiment	30

3.2.1 CNC Lathe Haas ST-20	30
3.2.2 Toolmaker microscope	31
3.2.3 Flood Coolant System	32
3.3 Workpiece Material	33
3.4 Cutting Tool	34
3.5 Tool Holder	35
3.6 Experimental Procedure	37
3.6.1 Initial Preparation	37
3.6.2 Cutting parameter	37
3.6.3 Experimental Procedure	38
3.7 Data collection	39
3.7.1 Tool Wear Measurement	39
3.8 Summary	40
CHAPTER 4: RESULT AND DISCUSSION	41
4.1 Tool life	41
4.1.1 The Influence of Cutting Parameter on Tool Life	43
4.1.2 Analysis of the Response Surface Methodology for tool life.	45
4.1.3 ANOVA analysis of the quadratic model's response surface.	46
4.1.4 Model Diagnostic Plot for tool life.	48
4.1.5 Model graph	49
4.1.6 The equation in terms of actual factors	53
4.2 Model Validation	53
4.3 Tool Wear Progression	54
4.4 Summary	56

CHAPTER 5: CONCLUSION AND RECOMMENDATION	57
5.1 Conclusion	57
5.2 Recommendation	58
5.3 Sustainable Development	58
REFERENCES	59



LIST OF TABLES

Table 2.1: The elements and properties of nickel-based superalloys (Mali & Unune, 2017)	10
Table 2.2: Cutting parameter generated by Box-Behnken (Manohar et al., 2013)	27
Table 3.1: CNC lathe Haas ST-20 capacities and specifications	31
Table 3.2: Nimonic C-263 Alloy Element	34
Table 3.3: Nimonic C-263 Alloy Properties	34
Table 3.4: Specifications of the cutting tool (Sandvik Coromant, 2010)	35
Table 3.5: Dimensions of the tool holder DCLNR 2020K 12	36
Table 3.6: Cutting parameter for Nimonic C-263 Alloy	37
Table 3.7: DOE for the experiment.	39
Table 4.1: Tool life results	42
Table 4.2: Sum of squares sequential model for tool life.	46
Table 4.3: ANOVA for tool life before eliminating the insignificant terms.	47
Table 4.4: ANOVA for tool life after eliminating the insignificant terms.	48
Table 4.5: Statistical summary for tool wear.	48
Table 4.6: Cutting parameter for validation.	53
Table 4.7: The outcome of the confirmation test	54

LIST OF FIGURES

Figure 2.1 Turning Operation (Alojali & Benyounis, 2016)	7
Figure 2.2 Cutting Parameters of Turning (Yang & Tarn, 1998)	8
Figure 2.3: Cutting tool with flank wear and its profile (Siddhpura & Paurobally, 2013)	12
Figure 2.4: Classification of a worn cutting tool (Fallqvist, 2012)	13
Figure 2.5: Tool wear curve (Memarianpour et al., 2021)	14
Figure 2.6: Tool life and surface finishes in MQL, wet and dry cutting (Kamata & Obikawa, 2007)	15
Figure 2.7: High-pressure coolant toward tool flank face (Magri et al., 2018)	16
Figure 2.8: Tool flank wear after cryogenic machining (Fernández et al., 2014)	16
Figure 2.9: Results of SEM and EDS in dry cutting condition (Günay et al., 2020)	17
Figure 2.10: Flank wear and notch wear of HPC and Flood cooling conditions (A. Suárez et al., 2016)	18
Figure 2.11: Uncoated tool wear is affected by machining process parameters (Ramana et al., 2021).	20
Figure 2.12: PVD coated tool wear is affected by machining process parameters (Ramana et al., 2021).	20
Figure 2.13: CVD-coated (TiN/Al ₂ O ₃ /TiC) tool ((Gao et al., 2012)	21
Figure 2.14: PVD-coated (TiAlN) tool (Gao et al., 2012)	21
Figure 2.15: Flood, MQL, CO ₂ , and CMQL SEM pictures of tool inserts (K et al., 2021)	23
Figure 2.16: Abrasive and adhesive wear on Inconel 600 cutting edge (M. A. Khan & Gupta, 2019)	24
Figure 2.17: SEM images of abrasion and adhesion wear on the cutting tool's flank and rake faces (Kamdani et al., 2019)	24
Figure 2.18: Cube for Box-Behnken design (Ferreira et al., 2007)	26
Figure 3.1: Experiment flow chart	29
Figure 3.2: CNC lathe Haas ST-20	30

Figure 3.3: Mitutoyo toolmaker's microscope	32
Figure 3.4: Flood coolant for CNC machine.	33
Figure 3.5: Nimonic C-263 Alloy in a cylindrical form	33
Figure 3.6: Generic representation of the cutting tool and its geometry CNGG 120408-SGF 1105 (Sandvik Coromant, 2010)	35
Figure 3.7: Cutting Tool holder DCLNR 2020K 12	36
Figure 3.8: Schematic illustration of DCLNR 2020K 12	36
Figure 3.9: Workpiece setup on CNC lathe machine	38
Figure 4.1: Result of tool value.	42
Figure 4.2: the lifespan of coated carbide tools with varying feed rates and cut depths at a constant cutting speed of 90 mm/min.	43
Figure 4.3: The tool life values for various cutting speeds and depths of cut at a constant feed rate of 0.1 mm	44
Figure 4.4: The tool life values at varying cutting speeds and feed rates with a constant depth of cut of 0.4 mm.	45
Figure 4.5: Normal plot of residuals for tool life.	49
Figure 4.6: One-factor plot of cutting speed vs tool life.	50
Figure 4.7: The feed rate influenced tool life.	51
Figure 4.8: The effect of cutting speed and feed rate on tool life in 3D	52
Figure 4.9: The effect of cutting speed and depth of cut on tool life in 3D	52
Figure 4.10: Tool wear progression for run no 3	55
Figure 4.11: Tool wear progression at run no 16	56

LIST OF ABBREVIATIONS

PVD	-	Physical Vapor Deposition
CVD	-	Chemical Vapour Deposition
CNC	-	Computerized Numerical Control
(Ti,Al)N	-	Titanium Aluminum Nitride
SEM	-	Scanning Electron Microscope
XRD	-	X-Ray Diffraction
PCBN	-	Polycrystalline Cubic Boron Nitride
WC	-	Tungsten Carbide
IR	-	Infrared
EDX	-	Energy Dispersive X-Ray
DOE	-	Design of Experiments
RSM	-	Response Surface Methodology
ISO	-	International Organization for Standardization,
GAXRD	-	Glancing Angle X-ray Diffraction
MQL	-	Minimal Quantity Lubrication
HPC	-	High-Pressure Coolant
BUE	-	Built Up Edge
ANOVA	-	Analysis of Variance

LIST OF SYMBOLS

V_b	-	Average flank wear
$V_{b \max}$	-	Maximum flank wear
$^{\circ}C$	-	Degree Celsius
Mm	-	Milimeter
m	-	Meter
μm	-	Micrometer



CHAPTER 1

INTRODUCTION

Chapter 1 of this research will explain the background of the study regarding the investigation. Besides that, the problem statement, objective, scope, the significance of this study and organization of the report will also be explained in this chapter.

1.1 Background of Study

Due to their better mechanical qualities maintained at increased temperatures, nickel-based superalloys are finding expanded uses in producing essential components for high-performance aviation gas turbine engines (Ezilarasan et al., 2013). Nimonic C-263 is one of the most important alloys in nickel-based superalloys. Nimonic C-263 Alloy is a nickel-chromium-cobalt-molybdenum alloy that excels at high temperatures and has excellent strength. Precipitation hardening is another option for this metal. To avoid rusting, it shows its resistance to chemical degradation induced by the surrounding environment or other gas chemicals. However, because superalloys are very hot, the cutting tool is subjected to considerable pressure and strain and roughness from the material.

When cutting nickel alloys, the first consideration is whether cooling or lubrication is more important. When heat removal is critical, soluble water-based fluids are used in high-metal-removal-rate turning operations. Cutting fluid use saves money on tools and makes it simpler to maintain tight tolerances and preserve the surface qualities of the workpiece without causing damage (Sales et al., 2001). Flood coolant was used as the cutting fluid in this experiment converting nickel-based alloy. The use of flood coolant increased the tensile stress in the near-

surface layer and created a bigger compressive stress zone underneath it (Sharman et al., 2008). When machining at slower rates with lower cutting temperatures, flood cooling is an excellent way to extend tool life. However, when cutting temperatures rise over a certain point, the fluid may evaporate and create a high-temperature steam barrier, preventing most of the fluid from entering the cutting zone. Aside from tool wear, the heat produced during cutting affects machining productivity, processed surface quality, accuracy, and other machining output characteristics (Nedic´ & Eric´, 2014). As a result, it is critical to investigate, measure, and understand the levels and distributions of cutting temperature inside the tool and workpiece. Based on this information, optimal settings, working regimes, process quality, productivity, and economy, as well as tool stability, may be determined.

1.2 Problem Statement

According to a prior study, the most prevalent issue other researchers have run across while examining Nimonic C-263 Alloy is the cutting tool's short life cycle and thermal degradation. Demand for super-finished components in aviation has led aircraft manufacturers to investigate innovative machining methods for superalloys at a fast cutting rate, with excellent surface quality, and at a cheap cost (Bisaria & Shandilya, 2019). Cutting procedures are often used in the manufacturing business, and they need the use of cutting instruments, workpieces, and chips. The cutting tool's wear is the most common problem encountered throughout this procedure. Tool wear is the gradual degradation of cutting tools due to prolonged usage. Tool wear impacts the machining process because it affects the surface roughness of the cutting tool. This impact will cause crater wear, flank wear, and cutting-edge chipping, among other forms of wear. Aside from that, the wear of the cutting tool will impair the workpiece's dimensional correctness. As a consequence, the size of the generated component may be changed, and the element's geometry may be jeopardized. Tapered workpieces may result from cylindrical turning, for example, due to excessive cutting tool wear.

Because most mechanical energy utilised to remove materials is heat, machining produces high temperatures in the cutting zone (Ghani et al., 2016). When the cutting speed is increased, the temperature reading increases as well. This is because the heat generated during

the operation is swiftly increased. Besides that, the microstructure of alloy will also change due to high heat generated while machining generated residual stresses cause a further reduction in the component's fatigue life (Seleznev et al., 2021). Utilizing heat and wear-resistant cutting tool materials, such as carbides, coated carbides, and high-performance ceramics, as well as the careful selection of process parameters and application of cutting fluid, it is possible to reduce the damaging effects of high cutting temperatures in an industrial setting.

1.3 Objective

The objectives of this study are:

- i. To evaluate parameter effect on tool life while turning the Nimonic C-263 Alloy using PVD coated inserts.
- ii. To predict the tool life progression of the cutting tool using the mathematical model from the ANOVA analysis.
- iii. To validate the cutting parameter of the statistical model of the tool life

1.4 Scope

The experimental investigation is turning the Nimonic C-263 Alloy using Physical Vapour Deposition (PVD) coated inserts. Besides that, the objective of this study is to examine the impact of flood coolant in machining Nimonic C-263 alloys and tool wear on various cutting speeds and cutting tool life. Furthermore, this study only involves in Nickel-based alloy family. These experiments were performed under flood coolant conditions by using water-based fluids. While turning machining in coolant, the performance of cutting tools that have been coated, tool wear progressions of the tool life will be investigated. Cutting speed, feed rate, and cut depth

were analyzed as machining parameters for this experiment. Response surface methodology (RSM) was utilized to determine the best cutting parameter in this investigation.

1.5 Significant of Study

The outcomes of this study will help to solve the current industry problem. Studying tool wear characteristics on Nimonic C-263 Alloy is an essential component in the operations of many manufacturing companies. By showing the type of wear that will occur when machining the superalloy, the manufacturing company will provide a careful procedure and step to reduce the wear of the cutting tool and increase its lifespan. Besides that, this study is also critical because it will investigate the cutting speed, feed rate and depth of cut for the material so that the manufacturing companies can make a guideline to their worker about the machining parameters when cutting the Nimonic C-263 Alloy.

1.6 Organization of Report/ Thesis

The performance of coated carbide inserts in turning Nickel Based Alloy under flood conditions was the main focus of this paper. The introduction of the Nickel-based alloy will be discussed in Chapter 1 of this study, as well as the study's research background, problem statement, research purpose, the scope of research, and thesis structure. Chapter 2 covers the turning process, the nickel-based alloy, the cutting tool material, the tool failure mechanism, the reasons of tool wear, the processes of tool wear, the tool life, the cutting fluid, the experimental design, the most recent literature reviews, and previous research studies. Chapter 3 discusses the equipment, experimental methodologies, and cutting conditions used in Nickel-based Alloy turning. Chapter 4 discusses the effect of coated carbide on tool wear and life. Additionally, this chapter discusses tool wear processes and ANOVA analysis. Finally, Chapter 5 contains a summary and conclusion to this study.

1.7 Summary

In summary, nickel-based alloy is one of the alloy that is difficult to machine alloy which many manufacturing companies discover while machining this sort of material. Therefore, it will limit the lifespan of the cutting instrument. By completing this investigation, this problem could marginally lessen the tool wear. This is crucial since it will enhance the output of the material by the firm, especially in the manufacturing industries.

