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EFFECT OF HEAT TREATMENT PROCESS OF TITANIUM FOR WATCH
MANUFACTURING APPLICATION

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“I hereby the author, declare this report entitled “ EFFECT OF HEAT TREATMENT
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To my dearest parent

Mr Abdullah Sani bin Salam and Mr Nafsiah binti Mat Wali

My sibling,

Masni binti Abdullah Sani

Mazlan bin Abdullah Sani

Mohd Fahmi bin Abdullah Sani

Thanks for all the support

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ABSTRACT

High strength, low density, and excellent corrosion resistance are the main properties that make titanium attractive for a variety of applications. Examples include aircraft (high strength in combination with low density), aero engines (high strength, low density, and good creep resistance), biomedical devices (corrosion resistance and high strength) and components in chemical processing equipment (corrosion resistance). Titanium also has been an attraction in everyday wear accessories like watch. The advantages of titanium use in watch application are such as it is light, comfortable, hypoallergenic which is free from nickel, durable and have corrosion resistance feature. To give a better quality of titanium in watch application, heat treatment procedure is applied to it. Many methods are use in titanium heat treating. There are such as annealing, quenching, tempering, solution treating and aging and isothermal transformation. Heat treatment process generally execute is to improve the materials properties. The amount of phase present in titanium is control by heat treatment process. The phases that have in titanium are alpha, beta, alpha-beta, near-alpha and near beta. Mechanical test is then executed to prove the quality of heat treatment process in term of its parameter use. The suitable mechanical testing has been choosing for this research and they are Rockwell Hardness Test and Charpy Impact Test. For microscopic analysis Optical Microscope is use to analyze the microstructure of specimen that not undergo heat treatment and specimen that undergo heat treatment process. Data obtain from experimental and testing process will be statistically analyzed by F-Test and T-test method.

ABSTRAK

Kekuatan yang tinggi, ketumpatan yang rendah dan daya tahan karat yang sangat baik adalah ciri-ciri atau sifat-sifat utama yang menjadikan titanium satu tarikan untuk diaplikasikan di dalam pelbagai bidang. Antara bidang-bidang yang mengaplikasikan penggunaan titanium adalah seperti pembuatan pesawat udara (kombinasi kekuatan yang tinggi dan ketumpatan yang rendah), enjin kapal angkasa (kekuatan yang tinggi, ketumpatan yang rendah dan daya tahan kesotan yang baik), alatan bio-perubatan (daya tahan karat yang baik dan kekuatan yang tinggi) dan komponen alatan pemprosesan bahan kimia (daya tahan karat yang baik). Titanium juga telah menjadi satu daya tarikan dalam penggunaan dan pemakaian harian seperti jam. Kelebihan penggunaan titanium dan titanium aloi dalam aplikasi jam adalah ianya ringan, selesa dipakai, hipoalergik iaitu bebas dari nikel, tahan lama dan mempunyai ciri-ciri daya tahan karat. Untuk memberikan mutu yang baik ke atas titanium di dalam penghasilan jam, proses rawatan haba di aplikasikan. Terdapat banyak cara dalam rawatan haba titanium. Antaranya adalah menyepuh lindap, melindap, pembajaan, rawatan larutan dan penuaan dan transformasi isoterma. Proses rawatan haba pada umumnya dilakukan untuk mempertingkatkan sifat-sifat bahan. Di dalam perawatan haba titanium, jumlah fasa alpha, beta, alpha-beta, hampir-alpha and hampir-beta akan dikawal. Setelah perawatan haba selesai, ujian mekanikal dilakukan untuk menunjukkan parameter yang digunakan adalah bagus. Ujian mekanikal seperti Ujian Kekerasan Rockwell dan Ujian Hentaman Charpy turut dijalankan di dalam kajian ini. Mikrostruktur titanium sebelum dan selepas rawatan haba akan di analisa menggunakan Mikroskop Optik. Data yang dikeluarkan daripada semua kaedah yang digunakan akan dianalisa secara statistik menggunakan kaedah Ujian F dan T.

CONTENT

CHAPTER	TOPIC	PAGE
	ACKNOWLEDGEMENT	i
	ABSTRACT	ii
	ABSTRAK	iii
	CONTENT	iv
	LIST OF TABLE	viii
	LIST OF FIGURES	x
	LIST OF ABBREVIATIONS AND SYMBOLS	xii
	LIST OF APPENDICES	xv
1	INTRODUCTION	
	1.1 Background of Study	1
	1.2 Objectives	3
	1.3 Scopes	3
	1.4 Problem Statement	4
2	LITERATURE REVIEW	
	2.1 Titanium	5
	2.2 Titanium alloys and its classification	7
	2.2.1 Alpha and near-alpha titanium alloys	8
	2.2.2 Alpha-beta titanium alloys	9
	2.2.3 Beta, near-beta and metastable-beta Ti alloys	9

CHAPTER	TOPIC	PAGE
	2.3 Properties of titanium and titanium alloys	10
	2.4 Phase diagram	12
	2.5 Grade of titanium	14
	2.6 Heat treatment process	17
	2.6.1 Heat treatment process of titanium and Titanium alloys	18
	2.6.2 Annealing process	19
	2.6.3 Quenching and tempering process	21
	2.6.3.1 Quenching process	21
	2.6.3.2 Tempering process	22
	2.6.4 Solution treating and aging process	22
	2.6.5 Isothermal transformation	25
	2.7 Destructive testing	26
	2.7.1 Hardness test	27
	2.7.1.1 Measurement of hardness	29
	2.7.1.2 Principal of hardness test methods	29
	2.7.1.2.1 Rockwell Hardness Test	29
	2.7.1.2.2 Brinell Hardness Test	31
	2.7.1.2.3 Vickers Hardness Test	31
	2.7.2 Charpy impact test	33
	2.8 Microstructure analysis	37
3	METHODOLOGY	
	3.1 Experimental and mechanical testing process flow	38
	3.2 Material specimen selection and preparation	40
	3.2.1 Material selection	40
	3.2.2 Specimen preparation	41
	3.3 Annealing heat treatment process	42

CHAPTER	TOPIC	PAGE
	3.4 Hardness test	43
	3.5 Charpy impact test	45
	3.5.1 Charpy impact test procedure	46
	3.6 Microstructure Investigation	48
4	RESULT AND ANALYSIS	
	4.1 Hardness Test	52
	4.1.1 Experimental Result	52
	4.1.2 Result Analysis of Hardness Test	54
	4.2 Impact Test	58
	4.2.1 Experimental Result	58
	4.2.2 Result Analysis of Impact Test	59
	4.3 Summary of hardness and impact test comparison of specimen wit 30 minutes and 60 minutes of heat treatment process	63
	4.4 Microstructure Analysis	64
5	DISCUSSION	
	5.1 Hardness effect on the CP Titanium Grade 2 specimens	67
	5.1.1 Effect of temperature an time to the hardness of CP Titanium Grade 2 specimens	69
	5.2 Effect of temperature and time to impact energy of CP Titanium Grade 2	72
	5.3 Microstructure Grain Size of CP Titanium Grade 2 specimens	74

6 CONCLUSION AND RECOMMENDATION

75

CHAPTER	TOPIC	PAGE
	REFERENCE	77
	APPENDICES	

LIST OF TABLE

QTY	TITLE	PAGE
1.1	Commercial and semi commercial grades and alloys of titanium	2
2.1	Properties of titanium and titanium based alloys as compared to other structural metallic materials	12
2.2	Commercial and semi commercial grades of titanium and titanium alloys	16
2.3	The application of titanium and titanium alloy in several field or industry	16
2.4	Recommended solution and aging treatments for titanium alloy	23
2.5	The examples of mechanical tests	27
2.6	Typically Rockwell Hardness test scales	30
2.7	General characteristics of hardness testing methods and formulas for calculating hardness	33
2.8	Characteristics of test piece and testing machine	34
2.9	Standard specification of ASTM E23 for the Charpy impact test	36
3.1	Composition of CP Titanium Grade 2	40
3.2	Heat treatment data table	42

QTY	TITLE	PAGE
4.1	Hardness test data for specimens without heat treatment process and specimens wit heat treatment process for 30 minutes period	52
4.2	Hardness test data for specimens without heat treatment process and specimens wit heat treatment process for 60 minutes period	53
4.3	Average hardness value in Brinell scale for each specimens	54
4.4	Experiment data for impact test specimens with 30 minutes and 60 minutes of heat treatment	59
4.5	Statistical data for impact test specimens	59
4.6	Summary data of F-test and t-test for hardness of 30 minutes heat treatment's specimen and 60 minutes heat treatment's specimen	63
4.7	Summary data of F-test and t-test for impact test of 30 minutes heat treatment's specimen and 60 minutes heat treatment's specimen	64

LIST OF FIGURE

QTY	TITLE	PAGE
2.1	Unit cell of alpha phase	7
2.2	Unit cell of beta phase	7
2.3	Neutral phase diagram	13
2.4	<i>Alpha</i> , α phase diagram	13
2.5	<i>Beta</i> , β phase diagram	13
2.6	Rockwell hardness test principle	30
2.7	Vickers Hardness Test indenter	33
2.8	Charpy Impact Test	35
2.9	Test specimen dimension for Charpy impact test	36
3.1	The flow chart of the process methodology	39
3.2	The dimension of the specimens	41
3.3	CP Titanium Grade 2 specimens	41
3.4	Rockwell Hardness Test Machine	44
3.5	Impact head is position in -120°	47
3.6	Material information is set in the software	47
3.7	The material condition after impact test is apply	48
3.8	Mounting die machine	49
3.9	Grinding process	50
3.10	Ultrasonic water bath machine	50
3.11	Electromagnetic stir machine	51

QTY	TITLE	PAGE
4.1	Microstructure of CP Titanium Grade 2 specimens for non anneal and 30 minutes of annealing process	65
4.2	Microstructure of CP Titanium Grade 2 specimens for non anneal and 60 minutes of annealing process	66
5.1	Graph hardness value against temperature	67
5.2	Statistic of hardness value for each specimen heat treated in 30 minutes	69
5.3	Statistic of hardness value for each specimen heat treated in 60 minutes	69
5.4	Grain size of specimens at heat treated at 700°C of specimens for 30 minutes	71
5.5	Grain size of specimens at heat treated at 700°C of specimens for 60 minutes	71
5.6	The effect of temperature on the energy absorbed upon impact test	72
5.7	Surface of the CP Titanium Grade 2 show ductile fibrous fracture	73

LIST OF ABBREVIATIONS AND SYMBOLS

Al	=	Aluminium
ASM	=	American Society for Metals
ASTM	=	American Standard of Testing and Material
BHN	=	Brinell Hardness Number
BCC	=	Body centered cubic
B120VCA	=	Titanium alloys sheet
CP	=	Commercially pure
C	=	Carbon
CNC	=	Computer Numerical Control
Cr	=	Chromium
CRT	=	Cathode Ray Tube
E	=	Modulus of Elasticity
F	=	Load
Fe	=	Ferum
FE	=	Field Emission
FeTiO ³	=	Ilminite
g/cm ³	=	Gram per cubic centimeter

GPa	=	Giga Pascal
H	=	Hydrogen
HCP	=	Hexagonal closed-packed
HDH	=	Hydrogenation or dehydrogenation
HF	=	Hydrofluoric
HNO ₃	=	Acid nitric
HRB	=	Rockwell Hardness B scale
HRC	=	Rockwell Hardness C scale
HV	=	Hardness Vickers Number
I	=	Iron
J	=	Joules
kV	=	Kilovolts
kg	=	Kilograms
kg-f	=	Kilograms-Force
mm	=	Millimeters
Mpa	=	Mega Pascal
m ²	=	Square millimeters
N	=	Nitrogen
Ni	=	Nickel
O ²	=	Oxygen
ppm	=	Parts per million
SEM	=	Scanning Electron Microscopy

Si	=	Silicon
S_1	=	Standard deviation
S_1^2	=	Variance
Ti	=	Titanium
TiO ²	=	Titanium oxide or rutile
Ti-3Al-8V-6Cr- 4Mo-4Zr	=	Titanium 3% Aluminium 8% Vanadium 6% Chromium 4% Molybdenum 4% Zirconium
Ti-6Al-4V	=	Titanium 6% Aluminium 4% Vanadium
Ti-6Al-2Sn-4Zr- 2Mo+Si	=	Titanium 6% Aluminium 2% Sn 4% Zirconium 2% Molybdenum + Silicon
Ti-6V-2Sn-2Zr- Cr-2Mo+Si	=	Titanium 6% Vanadium 2% Sn 2% Zirconium 1% Chromium 2% Molybdenum + Silicon
Ti-8Al-1Mo-1V	=	Titanium 8% Aluminium 1% Molybdenum 1% Vanadium
Ti-10V-2Fe-3Al	=	Titanium 10% Vanadium 2% Ferum 3% Aluminium
Ti-15-3	=	Titanium alloys
α	=	Alpha
β	=	Beta
α - β	=	Alpha-beta
°C	=	Degree Celsius
°F	=	Degree Fahrenheit
\bar{x}_1	=	Mean

LIST OF APPENDICES

QTY	TITLE	PAGE
A	Gant Chart for PSM 1	80
B	Flow Chart for PSM 1	81
C	Gant Chart for PSM 2	82
D	Flow Chart for PSM 2	83
E	Corrosion-Resistant Titanium Alloys	84
F	Titanium Grade 2	85
G	Microstructure of Ti-6Al-4V	86
H	Microstructure of Ti-6Al-4V after heat treatment process in different condition	87
I	Schematic representation of microstructures developed after solution treatment of casted Ti-6Al-4V titanium alloy	88
J	Mitutoyo Conversion Table	89
K1	Hypothesis test procedure	90
K2	F-distribution table	91
K3	t- distribution table	92

CHAPTER 1

INTRODUCTION

1.1 Background of Study

Titanium metal was first discovered by the English chemist William Gregor in 1791 in the black magnetic sand ilmenite. The name of the titanium is referring to the titans of Greek mythology which is mean a symbol of power and strength. Titanium is the fourth most abundant metal in the Earth's crust after aluminium, iron and magnesium. The characteristics of titanium that make it is so attractive to industrial application is such as titanium has low density and high strength, good corrosion and erosion resistance to any medium including the sea water and chlorine, good oxidation resistance and have moderate strength at high temperature. Other characteristic that make it different from other light metals is its physical metallurgy which is complex and interesting. Titanium is an allotropic as an iron and its produces much more similarities in heat treatment compared to steels. Moreover, the presence of alloying elements give special characteristic in which, it can stabilize the low temperature phase, *alpha* or high temperature phase, *beta*. Like steels, titanium and its alloy are characterized by their stable room temperature phases (F. Vander Voort, George, *Materials Characterization & Testing: Microstructure of Titanium and Its Alloys*, 2006 September 14).

In any manufacturing industries and application including watch manufacturing, they have their own specification and criteria on the selection of

titanium grade for their production. Titanium is divide into two application of industrial usage which is corrosion-resistant service and strength-efficient structures. Both applications characteristic are being used in selecting the suitable and exact grade of titanium for different type of manufacturing field. Corrosion resistant service is normally use lower-strength unalloyed titanium and fabricated into tanks, heat exchangers, or reactor vessels for chemical processing or power generation plants. Where as for the strength-efficient structures is use higher-strength titanium alloys. This grade of titanium usually applied in gas turbines, aircraft structures, drilling equipments and submerges components manufacturing field. Table 1.1 below are the several commercial and semi commercial grades for unalloyed and titanium alloys (ASM International, *The Materials Information Society*, 2000).

Designation	Tensile strength (min)		0.2% yield strength (min)		Impurity limits, wt% (max)					Nominal composition, wt%				
	MPa	ksi	MPa	ksi	N	C	H	Fe	O	Al	Sn	Zr	Mo	Others
Unalloyed grades														
ASTM grade 1	240	35	170	25	0.03	0.08	0.015	0.20	0.18
ASTM grade 2	340	50	280	40	0.03	0.08	0.015	0.30	0.25
ASTM grade 3	450	65	380	55	0.05	0.08	0.015	0.30	0.35
ASTM grade 4	550	80	480	70	0.05	0.08	0.015	0.50	0.40
ASTM grade 7	340	50	280	40	0.03	0.08	0.015	0.30	0.25	0.2Pd
ASTM grade 11	240	35	170	25	0.03	0.08	0.015	0.20	0.18	0.2Pd
α and near-α alloys														
Ti-0.3Mo-0.8Ni	480	70	380	55	0.03	0.10	0.015	0.30	0.25	0.3	0.8Ni
Ti-5Al-2.5Sn	790	115	760	110	0.05	0.08	0.02	0.50	0.20	5	2.5
Ti-5Al-2.5Sn-ELI	690	100	620	90	0.07	0.08	0.0125	0.25	0.12	5	2.5
Ti-8Al-1Mo-1V	900	130	830	120	0.05	0.08	0.015	0.30	0.12	8	1	1V
Ti-6Al-2Sn-4Zr-2Mo	900	130	830	120	0.05	0.05	0.0125	0.25	0.15	6	2	4	2	0.08Si
Ti-6Al-2Nb-1Ta-0.8Mo	790	115	690	100	0.02	0.03	0.0125	0.12	0.10	6	1	2Nb, 1Ta
Ti-2.25Al-1.1Sn-5Zr-1Mo	1000	145	900	130	0.04	0.04	0.008	0.12	0.17	2.25	11	5	1	0.2Si
Ti-5.8Al-4Sn-3.5Zr-0.7Nb-0.5Mo-0.35Si	1030	149	910	132	0.03	0.08	0.006	0.05	0.15	5.8	4	3.5	0.5	0.7Nb, 0.35Si
α-β alloys														
Ti-6Al-4V(a)	900	130	830	120	0.05	0.10	0.0125	0.30	0.20	6	4V
Ti-6Al-4V-ELI(a)	830	120	760	110	0.05	0.08	0.0125	0.25	0.13	6	4V
Ti-6Al-6V-2Sn(a)	1030	150	970	140	0.04	0.05	0.015	1.0	0.20	6	2	0.75Cu, 6V
Ti-8Mn(a)	860	125	760	110	0.05	0.08	0.015	0.50	0.20	8.0Mn
Ti-7Al-4Mo(a)	1030	150	970	140	0.05	0.10	0.013	0.30	0.20	7.0	4.0	...
Ti-6Al-2Sn-4Zr-6Mo(b)	1170	170	1100	160	0.04	0.04	0.0125	0.15	0.15	6	2	4	6	...
Ti-5Al-2Sn-2Zr-4Mo-4Cr(b)(c)	1125	163	1055	153	0.04	0.05	0.0125	0.30	0.13	5	2	2	4	4Cr
Ti-6Al-2Sn-2Zr-2Mo-2Cr(c)	1030	150	970	140	0.03	0.05	0.0125	0.25	0.14	5.7	2	2	2	2Cr, 0.25Si
Ti-3Al-2.5V(d)	620	90	520	75	0.015	0.05	0.015	0.30	0.12	3	2.5V
Ti-4Al-4Mo-2Sn-0.5Si	1100	160	960	139	(e)	0.02	0.0125	0.20	(e)	4	2	...	4	0.5Si
β alloys														
Ti-10V-2Fe-3Al(a)(c)	1170	170	1100	160	0.05	0.05	0.015	2.5	0.16	3	10V
Ti-13V-11Cr-3Al(b)	1170	170	1100	160	0.05	0.05	0.025	0.35	0.17	3	11.0Cr, 13.0V
Ti-8Mo-8V-2Fe-3Al(b)(c)	1170	170	1100	160	0.03	0.05	0.015	2.5	0.17	3	8.0	8.0V
Ti-3Al-8V-6Cr-4Mo-4Zr(a)(c)	900	130	830	120	0.03	0.05	0.20	0.25	0.12	3	...	4	4	6Cr, 8V
Ti-11.5Mo-6Zr-4.5Sn(a)	690	100	620	90	0.05	0.10	0.020	0.35	0.18	...	4.5	6.0	11.5	...
Ti-15V-3Cr-3Al-3Sn	1000(b)	145(b)	965(b)	140(b)	0.05	0.05	0.015	0.25	0.13	3	3	15V, 3Cr
	1241(f)	180(f)	1172(f)	170(f)										
Ti-15Mo-3Al-2.7Nb-0.2Si	862	125	793	115	0.05	0.05	0.015	0.25	0.13	3	15	2.7Nb, 0.2Si

(a) Mechanical properties given for the annealed condition; may be solution treated and aged to increase strength. (b) Mechanical properties given for the solution-treated-and-aged condition; alloy not normally applied in annealed condition. (c) Semicommercial alloy; mechanical properties and composition limits subject to negotiation with suppliers. (d) Primarily a tubing alloy; may be cold drawn to increase strength. (e) Combined O₂ + 2N₂ = 0.27%. (f) Also solution treated and aged using an alternative aging temperature (480 °C, or 900 °F)

Table 1.1: Commercial and semi commercial grades and alloys of titanium

Heat treatment is a procedure of heating and cooling a material without melting. Typical objectives of heat treatments are hardening, strengthening, softening, improved formability, improved machinability, stress relief and improved dimensional

stability of the materials. It also determined the microstructure of small crystals called "grains" or crystallites. The orientation of the grain structure will determine how effective its mechanical properties. The better grain orientation, the better its mechanical properties. The suitable choosing of the parameter during heat treatment process like temperature and time is important to get a better result. Followed by the heat treatment process, several testing is needed to prove the effectiveness of heat treatment parameter that is being used. The testing includes hardness test, impact test and microstructure verifying and analyzing. This is due to the specification needed in watch manufacturing application to maintain the watch quality. The testing will be performed on two conditions of the specimen which is specimen undergo heat treatment process and specimen that not undergo heat treatment process. From the result obtained, statistical analysis will be done to provide the analysis of the titanium characteristic that suitable to be used in watch manufacturing application.

1.2 Objective

The objective of this research is to study the effect of heat treatment process of Titanium for watch manufacturing application.

1.3 Scopes

The focus of this technical research is to do a literature study of titanium, heat treatment process of titanium, titanium microscopic structure and its availability to use for watch manufacturing application. This research also will carry out the methodology of heat treatment process of titanium and the testing that performed on it. Data such as laboratory equipment, procedures, parameter use, condition and catalyst will be included in this research. The mechanical testing that will cover in this

research is hardness test and impact test. The data obtain from the testing will be compared between specimen that not undergo heat treatment process and specimen undergo heat treatment process. The comparison result is use to analyze its mechanical properties. This research will also concentrate the comparison of the data obtain from all mechanical testing. The heat treatment process that applied in this research can also be used for student of Mechanical Engineering application.

1.4 Problem Statement

Watch manufacturing is one of the manufacturing fields that widely operate in Europe. This manufacturing field also includes Asia in its territory. One of the most famous watch makers is the Swatch Group. Nowadays, titanium is widely use for watch part manufacturing process, for example is the watch model from TISSOT brands, which are T-Touch Titanium and T-Touch Polished Titanium. The problem occur for material of titanium use in this model is its have defect like a small dotted and its surface finish is not smooth. This problem will cause failure when water resistant testing is executed. Other problem during the manufacturing process is that the quantity of tools use in machining process is issuing too many in one week period of production time. The tool is either broken or its total life is short. Too much total issuing will increase the cost of production process. All of the problem might come from heat treatment process, several testing procedure and drawing process of titanium production.

CHAPTER 2

LITERATURE REVIEW

Literature review is the collective of data or information from reading, references and also information from the experts relating to the projects which will be review in this chapter. From here, we will understand the purpose of the project and how we are going to achieve the result. So it is important to review all the information to make sure it will be useful beneficial for this project.

2.1 Titanium

Titanium is present in the earth's crust at a level of about 0.6% and is therefore the fourth most abundant structural metal after aluminum, iron, and magnesium. The most important mineral sources are ilmenite (FeTiO_3) and rutile (TiO_2) (Lutjering, G., Williams, J.C., Titanium 2nd Edition, Sub chapter 1.2, pg. 2, 2007).

High strength, low density, and excellent corrosion resistance are the main properties that make titanium attractive for a variety of applications. The examples include aircraft which have high strength in combination with low density. Aero-engines are another application that takes the advantage of titanium. The high strength, low density and good creep resistance up to about 550°C that have in titanium attract