Parametric Optimization Of Electric Discharge Machining On Material Ss308 By Using Design Of Experiments Method Taquchi Method And Anova Analysis

Naimesh Kadiya Head Of The Department of Mechanical Engineering, Narnarayan Shastri Institute Of Techanology, Jetalpur, Gujarat, India.

Dr. Kirit Bhatt Principal, Narnarayan Shastri Institute Of Techanology, Jetalpur, Gujarat, India.

Abstract: EDM has become an important and economical way to machine highly resistant and brittle materials.. It is widely used in the manufacturing process of mould and matrices and sections of complex geometry and complex forms. The material of the work piece was chosen for this experiment is the AISI304 stainless steel taking into account its wide use in industrial applications. In today's world, 304 stainless steel accounts for nearly half of global production and consumption for industrial uses. The parameters for the input variable are the discharge current, the activation time and the inactivity time. The Taguchi method is used to generate an orthogonal array of L18 input variables using the Design of Experiments (DOE). The effect of the above mentioned variable parameters on machining characteristics like material removal rate (MRR), will be performed for optimization and investigative purposes. Tool material will be chosen as a copper electrode with cylindrical shape and size of 10 mm diameter. The workpiece is made of 304 stainless steel with a thickness of 5mm.

Keywords: Taguchi method, MRR, ANOVA ANALYSIS, electrically conductive materials .

1. Introduction

electric discharge machining, generally called EDM, is an unconventional machining approach used to eliminate device by using a number of repetitive electric powered discharges of small duration and high present day density among the work piece and the tool.[2,3] EDM is a huge and price-powerful technique of machining extraordinarily hard and brittle electric conductor materials. In EDM, in view that there is no direct contact among the part to be machined and the electrode, there are therefore no mechanical forces between them. Any sort of conductive fabric may be machined with EDM irrespective of how difficult or hard the fabric is. on this process, the cloth is eliminated from the running part because of erosion because of a

recurrent electric spark discharge among the paintings piece due to erosion as a result of rapidly habitual electric spark discharge between the work piece and the device electrode. there may be a small hole among the tool and the work piece.[4,5] each the work piece and the tool are dipped in a dielectric fluid, usually used are EDM oil, de ionized water and kerosene. Essentially there are two types of EDM: Die-sinking EDM and cord-reduce EDMThe surface roughness of the machined surface was significantly influenced by factors such as the powder concentration, current, and pulse-on time. Furthermore, the two materials showed quite different SR values. The roughness increased with increases in current and pulse-on time, whereas the powder in the dielectric medium improved the surface finish. An increase in current or pulse-on time increases the spark energy, which drives the formation of bigger and deeper craters, leading to a rough machined surface. The addition of powder consistently improved the finish of the machined surfaces; the spark becomes more uniform with increased frequency and widens the spark gap. This reduced the magnitude of the impact forces, resulting in small and shallow craters and lowering the surface roughness[1]

1.1. Die-sinking EDM

Die-sinking EDM, also known as volume EDM or cavity kind EDM consists of an electrode and a work piece that's submerged in an insulating fluid consisting of oil or different dielectric fluids.

1.2. cord-reduce EDM

wire-cut EDM, additionally called Spark EDM is more often than not used whilst low residual stresses are required, as it does no longer desires high cutting forces for removal of cloth.

2. method Used

For fabricating arrayed systems, the output reaction along with MRR was measured. The dimension approach of those output response turned into discussed as under:

2.1. MRR is defined because the ratio of the distinction of weight of the paintings piece before and after machining to the machining time and density of the fabric as shown in under:[6,7]

$$MRR = \frac{W_i - W_f}{D * t} \text{ mm3 /min.}$$

Where,

W_i = weight before machining (gm),

Wf = weight after machining (gm),

D = density of work piece material (gm/mm3)

t = time consumed for machining (min.).

2.2. Performance evaluation using Taguchi's S/N ratio

Taguchi method uses a statistical tool to measure performance characteristics known as signal-to-noise (S/N) ratio to find out the optimum settings for the design parameters and it (S/N ratio) consists of both the mean and the variability of performance characteristics. This method tries to select the design parameter in order to maximize the S/N ratio because higher the S/N ratio the more balanced the adoptable is the performance quality. There are three criterions of signal-to-noise ratios which are lower-the-better (LTB), the higher-the-better (HTB), and nominal-the-best (NTB). In present work one response is considered material removal rate (MRR). Material removal rate is need to be maximize. So, for calculating S/N ratio of material removal rate HTB criterion should be selected. The equation for aforesaid two criterions is given below:

Lower-is-Better (LTB) criterion:[8]

- S/N ratio = $-10 \log(\frac{1}{n}\sum y^2)$

Higher-is-Better (HTB) criterion:

- S/N ratio = $-10 \log(\frac{1}{n}\sum \frac{1}{y^2})$

Here, y is average of all observed value and n is number of observations. So this method is useful only for optimization of a single performance characteristic. Optimization of design parameters with more than one performance characteristics are still an area of research.

3. Experimentation

3.1 Copper Electrode Properties

Copper and copper alloys have better EDM wear resistance than brass, but are more difficult to machine than either brass or graphite. It is also more expensive than graphite. Copper is, however, a common base material because it is highly conductive and strong. It is useful in the EDM machining of tungsten carbide, or in applications requiring a fine finish.

Copper tungsten materials are composites of tungsten and copper. They are produced using powder metallurgy processes. Copper tungsten is very expensive compared to other electrode materials, but is useful for making deep slots under poor flushing conditions and in the EDM machining of tungsten carbide. Copper tungsten materials are also used in resistance welding electrodes and some circuit breaker applications.
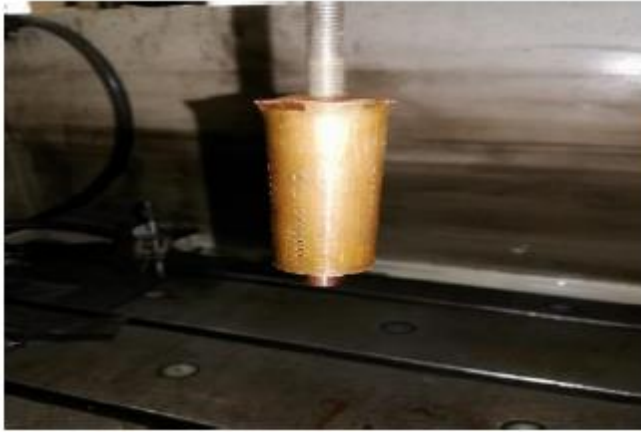

Figure 1: Copper Electrode used in experiment

3.2 Chosen Work-piece Material

AISI304 Stainless Steel is still sometimes referred to by its old name 18/8 which is derived from the nominal composition of type 304 being 18% chromium and 8% nickel. Stainless steel 304 has excellent corrosion resistance in a wide variety of environments and when in contact with different corrosive media. Pitting and crevice corrosion can occur in environments containing chlorides. Stress corrosion cracking can occur at temperatures over 60°C.

Stainless steel 304 has good resistance to oxidation in intermittent service up to 870°C and in continuous service to 925°C. However, continuous use at 425-860°C is not recommended if corrosion resistance in water is required. In this instance 304L is recommended due to its resistance to carbide precipitation.[10,11]

Figure 2: Experimental setup of Copper tool and Workpiece

Figure 3: Display Panel of EDM for taken readings

The above display panel is associated with the control of CNC operated EDM where the values are feed at allocated parameters. And after machining the readings are noted down.

In the current study, the machining was done by choosing discharge current (Ip), pulse-on time (Ton) and pulse-off time (Toff) as input parameters and the other parameters such as duty factor (τau) equal to 80 % and gap voltage of 50 V are kept constant throughout the experiment.

Table 1: Allocated Values of EDM parameters and their levels

Parameters	Units	Level 1	Level 2	Level 3

A	Discharge current (I_p)	Amps.	10	6	3
B	Pulse on time (T_{on})	µs	400	200	100
C	Pulse off time(T_{off})	µs	32	20	10

4. Results and Discussion

Based on the above limitation of EDM the designed experiment is performed and calculation is done. And found that which combination of machined parameters is best suited for industry application to get higher material removal rate over the work-piece.

Table 2: Calculation table by DoE (Design of experiment) Matrix of L18 Orthogonal array (OA)

Sr No.	current (I_p) (Amperes)	(T_{on}) (micro seconds)	(T_{off}) (micro seconds)	Calculation of MRR(mm^3/Min)
1	10	400	32	0.0156
2	10	200	20	0.0105
3	10	100	10	0.0625
4	6	400	32	0.0084
5	6	200	20	0.0083
6	6	100	10	0.0028
7	3	400	20	0.0027
8	3	200	10	0.0018
9	3	100	32	0.0015
10	10	100	10	0.0133
11	10	200	32	0.0041
12	10	400	20	0.0189
13	6	100	20	0.0027
14	6	200	10	0.0055

15	6	400	32	0.0067
16	3	100	10	0.0008
17	3	200	32	0.0004
18	3	400	20	0.0047

Figure 4: Image of work-piece after L18 experiment in EDM

4.1 Influences on MRR

The S/N ratios for MRR are calculated as given in Equation. Taguchi method is used to analysis the result of response of machining parameter for larger is better criteria

4.2 Model Analysis of MRR

The coefficients of model for S/N ratios for MRR are shown in Table 4.4. The parameter R-Sq describes the amount of variation observed in MRR is explained by the input factors. R-Sq = 64.7 % indicate that the model is able to predict the response with high accuracy. R-Sq(sdj) is a modified R-Sq that has been adjusted for the number of terms in the model. If unnecessary terms are included in the model, R-Sq can be artificially high, but R-Sq(sdj) = 38.2 %. may get smaller. The standard deviation of errors in the modeling, S= 0.007752 . Comparing the p-value to a commonly used αlevel = 0.05, it is found that if the p-value is less than or equal to α, it can be concluded that the effect is significant (shown in bold), otherwise it is not significant.

Table 3: Coefficients of model for S/N ratios

A	B	C	MRR	SNRA1

10	400	32	0.0156	-36.1375
10	200	20	0.0105	-39.5762
10	100	10	0.0625	-34.705
6	400	32	0.0084	-42.6066
6	200	20	0.0083	-41.6184
6	100	10	0.0028	-51.0568
3	400	20	0.0027	-49.601
3	200	10	0.0018	-54.8945
3	100	32	0.0015	-56.4782
10	100	10	0.0133	--
10	200	32	0.0041	-47.7443
10	400	20	0.0189	-34.4708
6	100	20	0.0027	-51.3727
6	200	10	0.0055	-45.1927
6	400	32	0.0067	--
3	100	10	0.0008	-61.9382
3	200	32	0.0004	-67.9588
3	400	20	0.0047	--

S=0.007752 R-Sq=64.7% R-Sq(adj)= 38.2%

From the Analysis of variance studied for the effect of factors on MRR is indicating in Table 4 which obviously shows that the discharge current is the most significant factor while machining of AISI 304 SS with copper tool. After that pulse off time is an important parameter and pulse on time is significant factor during machining. Figure shows that the main effects of S/N ratios on MRR by the factor. For this case "higher is better" is chosen.

Table 4: ANOVA Table

Source	DF	Seq SS	Adj SS	Adj MS	F	P
A	2	0.000678	0.000706	0.000353	5.87	0.027

B	2	0.0001	0.000096	0.000048	0.8	0.484
C	2	0.000103	0.000103	0.000051	0.85	0.461
Residual Error	8	0.000481	0.000481	0.00006	--	--
Total	14	0.001362	--	--	--	--

The residual plot of MRR is shown in Fig 5. This design is helpful to determine whether the model meets the assumptions of the analysis. The residual plots in the graph and the interpretation of each residual plot indicate below:

a) Normal probability plot indicates the data are usually distributed and the variables are influencing the response. Outliers don't exist in the data, because standardized residues are between -0.01 and 0.01.

b) Residuals versus fitted values indicate the variance is constant and a nonlinear relationship exists.

c) Histogram proves the data are not skewed.

d) Residuals versus order of the data indicate that there are systematic effects in the data due to time or data collection order
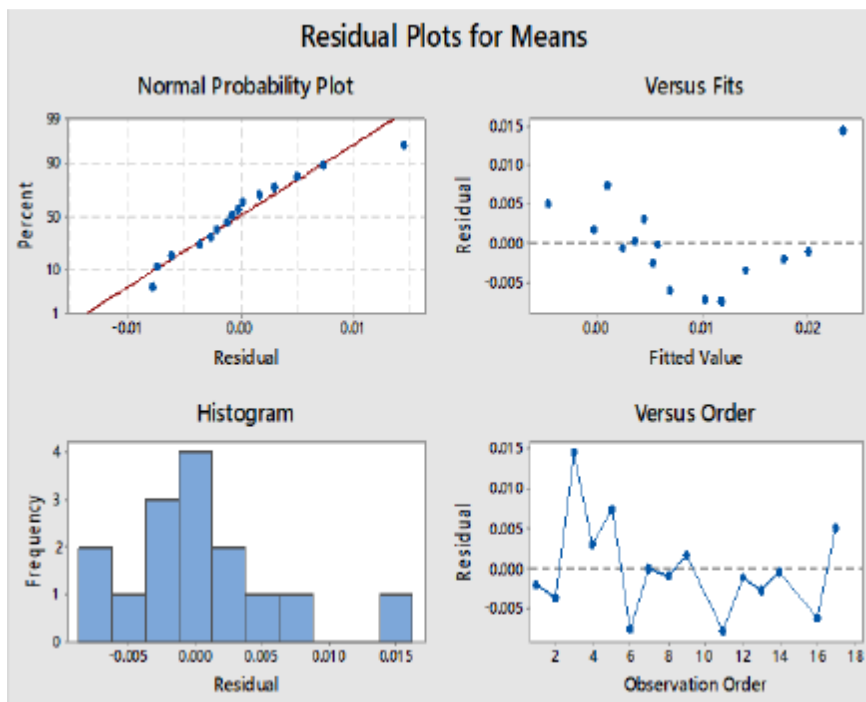

Figure 5: Residual plot of MRR

During the process of Electrical discharge machining, the influence of various machining parameter like Ip, Ton and Toff has significant effect on MRR, as shown in main effect plot for S/N ratio of MRR in Fig 6. The discharge current (Ip) is directly proportional to MRR in the range of 3A to 10A. This is expected because an increase in pulse current produces strong spark, which produces the higher temperature, causing more material to melt and erode from the work piece. Besides, it is clearly evident that the other factor does not influence much as compared to Ip. But, with increase in discharge current from 3A to 10A MRR increases slightly. However, MRR decreases monotonically with the increase in pulse off time.
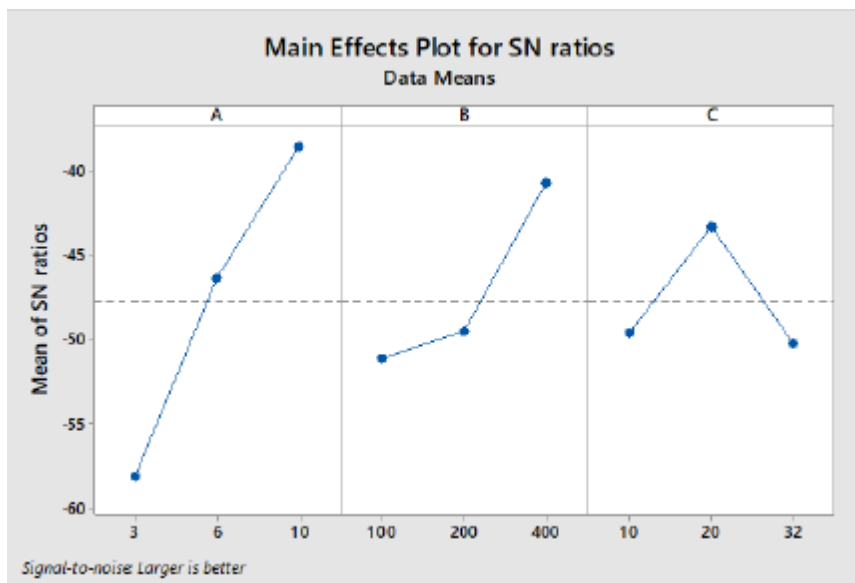

Figure 6: Main effects plot on S/N ratio on MRR by the factor

5. Conclusions

In the current study on the outcome of machining response of MRR of the AISI grade 304 stainless steel plate by means of the cylindrical formed copper tool with external flush system tool has been experimented for EDM process. The experiments were conducted under various parameter set of Discharge Current (Ip), Pulse On-Time (Ton), and Pulse Off-Time (Toff) of the tool. L-18 OA based on Taguchi design was performed for Minitab software was used for examination the result and this response was partially validated experimentally.

1) Finding the result of MRR discharge current is most influencing factor and then pulse duration time. MRR increased with the discharge current (Ip). As the pulse duration extended, the MRR decreases monotonically.

2) The experiment of run number 3 gives the higher material removal rate based on the combination of controlled parameters of discharge current 10 amperes, pulse on time is 100 micro-seconds and pulse off time is 10 microseconds.

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