

Contents

<i>Foreword</i> by Prof Vinay Kumar Pathak	<i>vi</i>
<i>Foreword</i> by Prof Uday S Dixit	<i>vii</i>
<i>Foreword</i> by Prof Rupinder Singh	<i>viii</i>
<i>Preface</i>	<i>ix</i>
Introduction	1–9
1. Abrasive Jet Machining	11–16
Abstract	11
1.1 Introduction	11
1.2 Working Principle	11
1.3 Description of AJM Setup	12
1.3.1 Gas propulsion system	12
1.3.2 Abrasive feeder	12
1.3.3 Machining chamber	12
1.3.4 AJM nozzle	12
1.3.5 Abrasives	13
1.4 Parametric Analysis	13
1.5 Process Capabilities and Applications	14
1.6 Advantages and Disadvantages	14
<i>Summary</i>	15
<i>Acronyms</i>	15
<i>Practice Questions</i>	15
<i>References</i>	16
2. Water Jet Machining	17–21
Abstract	17
2.1 Introduction	17
2.2 Working Principle	17
2.3 Description of WJM Setup	17
2.4 Process Characterization and Performance	19
2.5 Process Capabilities and Applications	19
2.5.1 Advantages	19
2.5.2 Disadvantages	20
2.5.3 Applications	20
<i>Summary</i>	20
<i>Acronyms</i>	20
<i>Practice Questions</i>	21
<i>References</i>	21

3. Abrasive Water Jet Machining	22–27
Abstract	22
3.1 Introduction	22
3.2 Working Principle	22
3.3 Description of AWJM Setup	23
3.4 Process Characterization and Performance	24
3.5 Process capabilities and Applications	25
3.6 Advantages and Disadvantages	26
Summary	26
Acronyms	26
Practice Questions	26
References	27
4. Ultrasonic Machining	28–38
Abstract	28
4.1 Introduction	28
4.2 Working Principle	28
4.3 Description of USM Setup	29
4.4 Mechanics of Cutting in USM	34
4.5 Parametric Analysis	35
4.6 Process Capabilities and Applications	35
4.7 Advantages and Disadvantages	36
Summary	36
Acronyms and Symbols	36
Practice Questions	37
References	37
5. Electrical Discharge Machining	39–63
Abstract	39
5.1 Introduction	39
5.1.1 Brief historical background of the EDM process	41
5.2 Fundamentals of the EDM Process	41
5.2.1 Pre-breakdown phase	41
5.2.2 Phase of discharge	42
5.2.3 Interval phase	43
5.3 Spark Energy Distribution	43
5.4 Discharge Classifications	43
5.5 Constituent Elements of the EDM Process	44
5.5.1 Workpiece electrode	45
5.5.2 Tool electrode	45
5.5.3 Dielectric fluid	45
5.5.4 Power generators	46
5.5.5 Servo-system	46
5.6 Electrodes Polarity in the EDM Process	46
5.7 EDM: Process Parameters and Output Responses	47

5.8 Analysis of Power Generators	50
5.8.1 R-C circuits	50
5.8.2 Transistor circuits	53
5.9 Process Variants of the EDM	53
5.9.1 Die-sinking EDM	54
5.9.2 Electrical discharge-drilling (ED-drilling)	54
5.9.3 Electrical discharge-milling (ED-milling)	55
5.9.4 Wire-electrical discharge machining (Wire-EDM)	55
5.10 Electrical Discharge Micromachining (EDMM)	56
5.11 Advancements Towards Performance Enhancement	57
5.12 EDM Machined Surface Investigation	58
5.13 Applications	59
5.14 Advantages and Limitations	60
5.14.1. Advantages	60
5.14.2. Limitations	60
<i>Summary</i>	60
<i>Acronyms and Symbols</i>	61
<i>Practice Questions</i>	61
<i>References</i>	62
 6. Laser Beam Machining	 64–83
Abstract	64
6.1 Introduction	64
6.1.1 Properties of laser beam	64
6.2 Principle of LBM	65
6.2.1 Population inversion	66
6.3 Components of the LBM System	66
6.4 Types of Lasers	67
6.4.1 Solid-state laser	67
6.4.2 Gas laser	67
6.4.3 Semiconductor laser	67
6.4.4 Liquid dye lasers	68
6.5 Laser-material Interaction	68
6.5.1 Heat conduction	69
6.5.2 Melting	70
6.5.3 Vaporization	70
6.5.4 Laser ablation	70
6.5.5 Plasma formation	71
6.5.6 Chemical-based LBM	72
6.6. Material Removal Rate in LBM	73
6.7. Laser Machining Techniques	74
6.7.1 Direct writing method	74
6.7.2 Mask projection method	74
6.8 Beam Intensity Distribution	75

6.9 Focusing of the Laser Beam	75
6.10 Gas-assisted Laser Machining	75
6.11 LBM: Mode of Operation	76
6.12 LBM: Applications	77
6.12.1 Laser drilling	77
6.12.2 Laser cutting	78
6.12.3 Laser texturing	78
6.12.4 Laser-assisted conventional machining	78
6.12.5 Miscellaneous applications	79
6.13. LBM: Advantages	80
6.14. LBM: Limitations	80
Summary	81
Acronyms and Symbols	81
Practice Questions	82
References	82
7. Plasma Arc Machining	84–94
Abstract	84
7.1 Introduction	84
7.2 Principle of Plasma Generation	84
7.2.1 Working mechanism of PAM	85
7.3 Components of the PAM	86
7.4 Modes of PAM	86
7.4.1 Non-transferred arc system	86
7.4.2 Transferred arc system	87
7.5 Process Parameters and Output Responses	88
7.6 Gas Selection in PAM	88
7.7 Various PAM Processes	89
7.8 Capabilities of PAM	90
7.9 PAM: Applications	92
7.10 PAM: Advantages	92
7.11 PAM: Limitations	92
Summary	92
Acronyms and Symbols	92
Practice Questions	93
References	93
8. Electron Beam Machining	95–104
Abstract	95
8.1 Introduction	95
8.2 Principle of EBM	96
8.3 Components of the EBM	98
8.3.1 Electron gun	99
8.3.2 Magnetic lens	99
8.3.3 Deflection coil	99

8.3.4 Vacuum chamber	99
8.3.5 On-site visualization equipment	99
8.3.6 Control panel	100
8.4 Process parameters and Output Responses	100
8.5 Analysis of Erosion Depth Per Pulse	101
8.6 Process Capabilities	101
8.7 EBM: Applications	102
8.8 EBM: Advantages	102
8.9 EBM: Limitations	102
<i>Summary</i>	103
<i>Acronyms and Symbols</i>	103
<i>Practice Questions</i>	103
<i>References</i>	104
9. Ion Beam Machining	105–114
Abstract	105
9.1 Introduction	105
9.2 Working Principle of IBM	105
9.2.1 Mechanism of ion-atom collision	107
9.3 Components of IBMg Process	108
9.4 Comparison of IBM with the Other Thermal Machining Processes	109
9.5 Rate of Material Removal in IBM	110
9.6 IBM: Applications	111
9.6.1 Polishing	111
9.6.2 Texturing	111
9.6.3 Cleaning	112
9.6.4 Milling	112
9.7 IBM: Advantages	112
9.8 IBM: Limitations	112
<i>Summary</i>	112
<i>Acronyms</i>	113
<i>Practice Questions</i>	113
<i>References..</i>	113
10. Electrochemical Machining	115–138
Abstract	115
10.1 Introduction	115
10.2 Principle of Electrolysis	116
10.3 Theory of ECM	117
10.3.1 Mechanics of Machining	117
10.3.2 Electrochemical equivalent of alloys	120
10.3.3 Equivalent density of alloys	120
10.4 Process Parameters	120
10.5 ECM Equipment	121
10.6 Electrolytes in ECM	121
10.6.1 Role of electrolytes	121

10.6.2	Types of electrolytes	123
10.6.3	Different electrolyte flow configurations	123
10.7	Power Supplies in ECM	125
10.8	Applications	126
10.9	Advantages and Limitations of ECM	126
11.9.1	Advantages	126
11.9.2	Limitations	126
10.10	Methods of Minimizing Stray Current Effect in ECM	127
11.10.1	Tool insulation	127
11.10.2	Workpiece insulation using a mask	127
10.11	Anode Shape Prediction in ECM	128
10.12	Environmental and Health Hazards	129
10.13	Some Variants of ECM	129
10.13.1	Electrochemical drilling	130
10.13.2	Shaped tube electrolytic machining	130
10.13.3	Electrostream (capillary) drilling	131
10.13.4	Electrochemical jet drilling (ECJD)	132
10.13.5	Wire electrochemical machining	132
10.13.6	Electrochemical polishing	134
	<i>Summary</i>	135
	<i>Acronyms and Symbols</i>	135
	<i>Practice Questions</i>	137
	<i>References</i>	137
11.	Chemical Machining	139–143
	Abstract	139
11.1	Introduction	139
11.2	Working Principle	139
11.3	Description of ChM Setup	140
11.4	Process Capabilities and Applications	142
11.5	Advantages and Disadvantages	142
	<i>Summary</i>	142
	<i>Acronyms</i>	143
	<i>Practice Questions</i>	143
	<i>References</i>	143
12.	Surface Integrity in Non-conventional Machining	144–154
	Abstract	144
12.1	Introduction	144
12.2	Background	145
12.3	Classification of Surface Integrity Techniques	145
12.3.1	X-ray diffraction (XRD)	145
12.3.2	Scanning electron microscopy (SEM)	146
12.3.3	Magnetic Barkhausen emission (MBE)	147
12.3.4	3D optical profilometry	147

12.3.5 Acoustic methods (scanning acoustic microscopy)	149
12.3.6 Drop shape analyser	149
12.3.7 Particle image velocimetry (PIV)	150
12.3.8 Phase Doppler interferometry (PDI)	150

Summary 152

Acronyms 152

Practice Questions 152

References 153

Index

155–158