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Analytical Review on Acquiring Knowledge of Machining Capacities for Abrasive Flow

Kanapala Rajendra Prasad and Dr.G.R. Selokar

Abstract--- *The abrasive flow machining technique utilizes a self-deforming device, an abrasive loaded media that is passed to and from in the entry geometry of the empty work piece with the help of two using pressurized water operated cylinders put inverse to one another. In the present work, the machining capacities of the abrasive flow machining and attractive abrasive flow machining have been analysed for Aluminium tubes using precisely alloyed attractive abrasives. It has been discovered that the percentage improvement in surface finish (PISF) is better in attractive abrasive flow machining when contrasted with abrasive flow machining.*

Keywords--- *Machining, Abrasives, Technique, Surface Finish*.

I. Introduction

The Abrasive Flow Machining process is originally created by Extrude Hone Corporation, USA in 1970. Abrasive Flow Machining is a non-customary machining process that wherein an abrasive-loaded viscoelastic polymer is constrained over the work piece surface. In any case, abrasive flow machining has a few disadvantages like low material expulsion rate, Surface inconsistencies, for example, scratches, knocks, progressively number of cycles is required for high material evacuation rate and so forth. To conquer these downsides, a mixture Abrasive Flow Machining known as Magnetic abrasive flow machining is introduced in which Magnetic field is utilized around the Abrasive Flow Machining arrangement. Abrasive Flow machining is a non-conventional machining technique that can be utilized to deburr, chamfer, clean, evacuate recast layers, and to deliver compressive lingering stresses.

Abrasive Flow Finishing Machining (AFFM) is a non-conventional finishing process wherein number of cutting edges at randomized orientations results in material removal with smaller chip sizes compared to traditional methods. Rhoades (1988) Finishing is aided by the hydraulically forced flow of shear thickening polymer loaded with definite quantity of abrasives or abrasive mixtures between two cylinders. The work piece is held in position by a fixture designed, engineered and tailor made to suit the specific finishing requirements.

Abrasive Flow Machining is reasonable for machining outer just as internal work piece surfaces that are regularly perplexing and distant. Notwithstanding, the effectiveness of the Abrasive Flow Machining procedure relies upon number of procedure parameters, the polishing media parameters, the AFM procedure (Figure 1) parameters and the work piece parameters.

Kanapala Rajendra Prasad, Research Scholar, Dept. of Mechanical Engineering, Sri Satya Sai University of Technology & Medical Sciences, Sehore, Bhopal-Indore Road, Madhya Pradesh, India. E-mail: kraja1454@gmail.com

Dr.G.R. Selokar, Supervisor, Dept. of Mechanical Engineering, Sri Satya Sai University of Technology & Medical Sciences, Sehore, Bhopal Indore Road, Madhya Pradesh, India. E-mail: selokar1960dr@gmail.com

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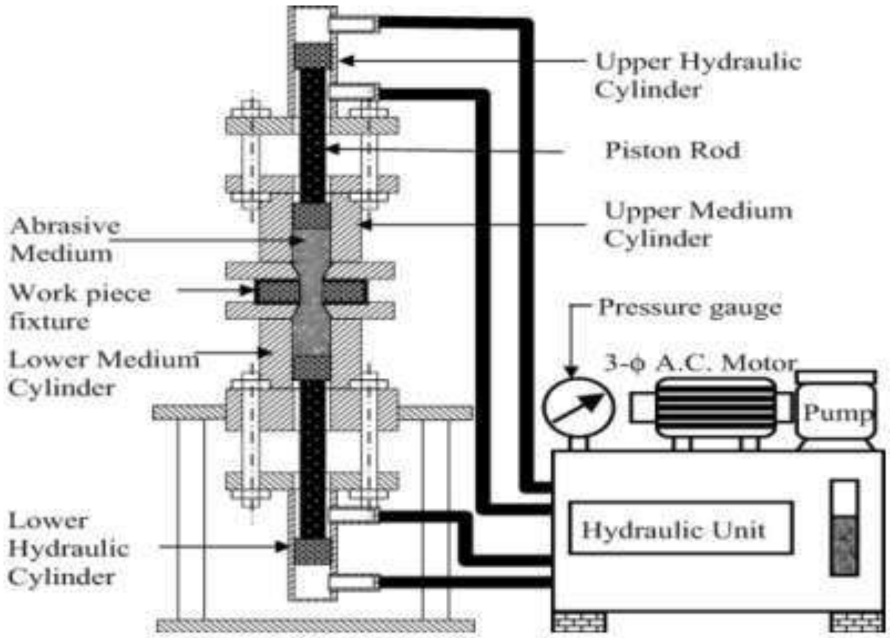

Figure 1: Scheme of the Abrasive Flow Machining Process

The main preferred position of Abrasive flow machining contrasted and different procedure is that of the self-deformable device or the abrasive media that changes shape according to the geometry of the work piece. Abrasive media is a blend of abrasives and a semi-gooey bearer that flows through a prohibitive section shaped by a work-tooling combination or work piece. The abrasive media has irregular cutting edges with indefinite direction and geometry for compelling evacuation of material.

II. Literature Review

Palwinder Singh, Lakhvir Singh, Sehijpal Singh (2018), the on-going increase in the utilization of hard, high quality and temperature safe materials in engineering required the advancement of more current machining forms. Abrasive flow machining (AFM) is a non-customary finishing process in which an abrasive-loaded viscoelastic polymer is constrained over the work piece surface though attractive abrasive flow machining (MAFM) is a mixture AFM process which uses the attractive vitality for finishing. It has been discovered that the percentage improvement in surface finish (PISF) is better in attractive abrasive flow machining when contrasted with abrasive flow machining.

T.S. Kavithaa, N. Balashanmugam, P.V. Shashi Kumar (2014) The emergence of Abrasive Flow Finishing/Machining (AFFM) as an advanced fine finishing process is attributed towards the need for relaxation of tool limitations, relative motion of work piece with respect to tool and precise finishing of complex geometries and internal passages in components. Herein, the abrasive laden polymer media conforms to the work piece geometry overcoming shape limitation inherent in conventional finishing processes. The paper outlines the various functionalities of the AFFM system developed and the experimentation carried out for finishing and deburring of modular head of a hip joint, extrusion die and shuttle valve used in bio-medical, aerospace and pharmaceutical industries respectively are discussed.

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Pankaj, Gurinder Singh, Rahul Vaishya (2014) Abrasive Flow machining is an exactly controlled and rehashed strategy for material evacuation which is utilized to deburr, clean and span hard to reach. In Electrochemical helped abrasive flow machining a polymeric electrolyte is added to the readied media. It is a cross breed procedure of Electrochemical Machining and Abrasive Flow Machining. The key segments of Electrochemical Machining2 FM process are the machine, tooling, voltage controller and abrasive medium. One genuine constraint of this procedure is its low efficiency as far as pace of improvement in surface unpleasantness. In the present work, the intensified machining activity has been seen because of the collaboration among AFM and ECM forms.

J. Kenda, F. Pusavec, G. Kermouche, J. Kopac (2011) The abrasive flow machining (AFM) is an on-going manufacturing technique that uses the flow of a pressurized abrasive media for removing work piece material. In correlation with hand polishing, AFM is productive procedure, appropriate for machining of complex surfaces. It shows that AFM is competent to expel EDM harmed surface and fundamentally improve surface harshness. In addition, it is equipped for inducing high compressive remaining worries to the machined surface, in an extremely thin sub-layer of ~10 µm, thus demonstrate that AFM offers an option machining process, helpful from the surface integrity and efficiency point of view.

Manjot S Cheema, Gudipadu Venkatesh, Akshay Dvivedi & Apurbba K Sharma (2012) The abrasive flow machining (AFM) technique utilizes a self-deforming apparatus, an abrasive loaded media that is passed to and fro in the section geometry of the empty work piece with the help of two using pressurized water operated cylinders set inverse to one another. The material is evacuated by scraped area generating finer surfaces in the zone where flow is confined. As the time progresses different variations of AFM have been created by various specialists to increase the profitability and improve the surface finish. In this manner a combination of AFM and its procedure variations were created to increase material evacuation rate and surface finish.

III. RESEARCH METHODOLOGY

Right off the bat, surface roughness is estimated by profilometer MAHR Mar Surf XR 20. Slice off length is set to 0.8 mm, the assessment length is equivalent to ln = 2.4 mm and chose statures (Ra, Rz, Rt) were estimated. After, the roughness measures, 3D roughness estimations are done with a SURFASCAN profilometer. Here, the zone of estimations is set to 1 mm2, separation between points in X (parallel with AFM flow) and Y (opposite to Abrasive Flow Machine) heading is 5 µm. Estimated are Sa, Sz and St attributes. Consequences of roughness estimations are likewise broke down with SPIP 5.1.5 surface programming, to accomplish increasingly delegate 3D plots on a similar scale: from 6 µm to - 12 µm (Figure 3).

In this investigation leftover worry with two parts, along ($\sigma 11$) and transverse to the work piece ($\sigma 22$) (Figure 2), are estimated using the X-beam diffraction strategy (XRD). The estimations are performed at 20 kV strain, 4 mA current (0.08 kW) using CrKα cylinder and edge of Bragg 156.1º. Leftover anxieties are estimated at the surface and at various profundities underneath the surface, by progressive etching off ultra-thin focused on layers.

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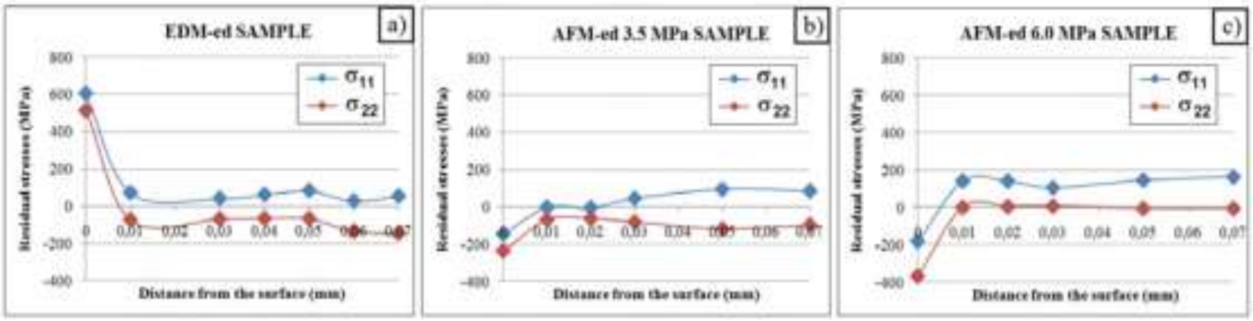

Figure 2: Distributions of residual stresses on and beneath the surface: a) Electrical Discharge Machining, b) Electrical Discharge Machining + Abrasive Flow Machining with polishing media under pressure of 3.5 MPa & c) Electrical Discharge Machining + Abrasive Flow Machining with polishing media pressure 6.0 Mpa

IV. Data Analysis & Result

The progressions of the chose roughness parameters Ra, Rz, Rt, resulting from various machining forms, are exhibited in (Table 1). The qualities are the normal estimations of a few measures. The corresponding 3D surface surfaces are appeared in (Figure 3). It very well may be seen that surface obtained by Electrical Discharge Machining display surface with no noteworthy direction or pattern. Interestingly, the Abrasive Flow Machining altered surfaces contain scratches in heading of machining, with huge lower amplitudes.

Table 1: Roughness Measurements

Workpiece	Direction	Ra[µm]	Rz[µm]	Rt[µm]
EDM	Along	1.67	10.66	15.54
	Transverse	1.69	10.59	13.80
AFM – 3.5MPa	Along	0.470	1.97	2.24
	Transverse	0.94	5.16	6.40
AFM – 6.0MPa	Along	0.23	1.02	1.37
	Transverse	0.55	3.15	3.88

From a quantitative point of view, apparently Electrical Discharge Machining produces surface with normal estimation of Ra parameter of roughly 1.68 µm. Then again, Abrasive Flow Machining diminishes it to the incentive somewhere in the range of 0.94 and 0.23 µm. The Rz and Rt portray a similar pattern.

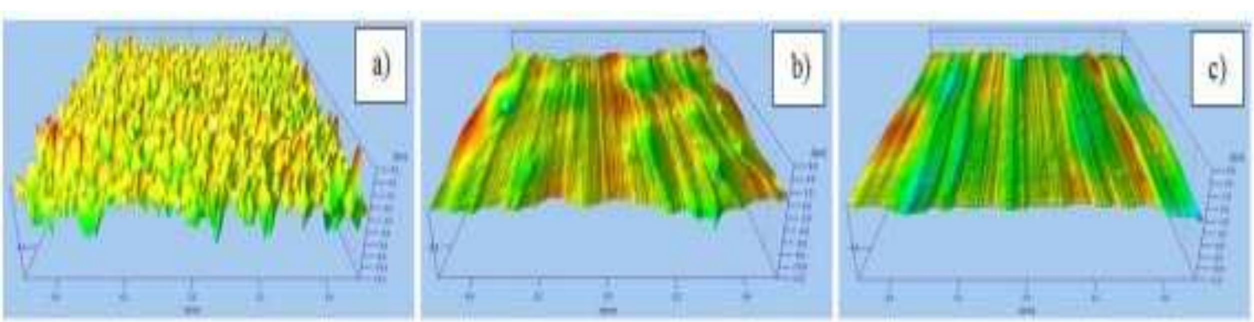

Figure 3: Surface texture obtained after various manufacturing procedures, a) Electrical Discharge Machining, b) Electrical Discharge Machining + Abrasive Flow Machining with polishing media under pressure of 3.5 MPa & c) Electrical Discharge Machining + Abrasive Flow Machining with polishing media pressure 6.0 Mpa

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From the estimations of surface roughness, it very well may be seen that Abrasive Flow Machining changed surface has not a similar roughness. Roughness along the work piece is lower than the transverse one that relates to the flow course of polishing media. Along the media, Ra arrives at values somewhere in the range of 0.47 and 0.23 µm, while in transverse course, values are higher (Ra is somewhere in the range of 0.94 and 0.55 µm).

V. Conclusion

To beat a portion of the downsides, for example, low machining rate and incapability to address the structure geometry, investigators have proposed different sorts of AFM machines condensed as Orbital AFM, MRAFM, UAAFM, AFMmm, R-AFM, Spiral polishing and so on. There is a major need of a procedure which improves the surface finish remotely just as internally at the same time. Abrasive flow machining is a potential contender for this course. AFM is a prominent non-customary machining process for machining intricate profiles of both internal and outer surfaces. Media acting as a deformable apparatus is the key component for the AFM procedure; numerous endeavors are made to create proficient, ecological cordial, financially savvy media and hybridisation. Additionally we show the work that the scraped area of the material is increases because of the option of electrochemical disintegration with the abrasives cutting in the Abrasive Flow Machining process. At higher operating voltages the surfaces are rough due to more material electrolytic dissolution resulting in the deeper scratches on the surface. The material removal continuously increases with the increase in the applied voltage.

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