



Faculty of Manufacturing Engineering

**FINITE ELEMENT SIMULATION OF ALUMINIUM
SILICON CARBIDE METAL MATRIX COMPOSITE
MACHINING**

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Master of Manufacturing Engineering (Quality System Engineering)

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**FINITE ELEMENT SIMULATION OF ALUMINIUM SILICON CARBIDE
METAL MATRIX COMPOSITE MACHINING**

MUHAMMAD AKMAL BIN AHMAD ADLI

**A thesis submitted in fulfilment of the requirements for the degree of Master
of Manufacturing Engineering (Quality System Engineering)**

Faculty of Manufacturing Engineering

UNIVERSITI TEKNIKAL MALAYSIA MELAKA

2020

DECLARATION

I declare that this thesis entitled “Finite Element Simulation of Machining Aluminium Silicon Carbide” is the result of my own research except as cited in the references. The thesis has not been accepted for any degree and is not concurrently submitted in candidature of any other degree.

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APPROVAL

I hereby declare that I have read this thesis and in my opinion this thesis is sufficient in terms of scope and quality for the award of Master of Manufacturing Engineering (Quality System Engineering).

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APPROVAL

I hereby declare that I have read this dissertation/report and in my opinion this dissertation/report is sufficient in terms of scope and quality as a partial fulfillment of Master of Manufacturing Engineering (Quality System Engineering).

Signature :

Supervisor Name : Assoc. Prof. Dr. Raja Izamshah bin Raja Abdullah

Date :

DEDICATION

In the name of Allah, The Most Beneficient, The most Merciful

Every challenging work needs self-efforts as well as guidance of elders especially those who were very close to our heart.

My humble effort I dedicate to my caring & loving
Father and Mother,
Ahmad Adli bin Abdullah and Alawiyatun bt Ab Muttalib

Whose affection, love, encouragement and prays of day and night make me able to have such success and honour.

Along with helpful and supportive Supervisor

Assoc. Prof. Dr. Raja Izamshah bin Raja Abdullah

ABSTRAK

Aluminium silikon karbida adalah salah satu daripada komposit matriks logam. Penggerudian dan penggunaan semula komposit Al / SiC sangat mencabar. Strategi pengoptimuman proses keseluruhan sangat diperlukan untuk pengeluaran sebenar. Ini mesti berdasarkan pemahaman mendalam mengenai mekanisme pemotongan. Geometri gerudi yang berlainan akan memberi kesan penjanaan haba dan daya tujah paksi. ketebalan mata gerudi, titik sudut dan helix sudut adalah factor geometry gerudi yang dikaji. Jadi, Pemodelan proses penggerudian tulang dijalankan dengan ANSYS untuk menjangka kesan daya tujah paksi dan penjanaan haba pada tulang untuk mengelakkan osteonecrosis terma. Simulasi unsur terhingga digunakan kerana ia mampu menjangka ubahan yang susah diukur ataupun yang susah memperolehinya daripada proses tersebut. Terdapat dua peringkat metodologi Semasa peringkat 1, tujuannya adalah untuk mengesahkan simulasi sama ada model itu sah atau tidak dengan menguji simulasi dengan bit gerudi yang tersedia dengan batang lurus. Selepas itu, simulasi dijalankan dengan pelbagai kombinasi geometri gerudi bersama dengan model yang telah divalidasi dalam peringkat 1 Metodologi permukaan balas (RSM) digunakan untuk mengalpasti saiz eksperimen dan kaedah ANOVA digunakan untuk analisis data. Kesan haba dijumpa mempunyai kesan yang besar berbanding dengan kesan daya tujah paksi yang menunjuk kesan yang tidak menonjolkan. Terdapat 10 jenis reka bentuk dicadangkan dalam kajian ini, Reka bentuk pertama (31.92% untuk ketebalan mata gerudi, 90° untuk titik sudut, 31.32° untuk helix sudut) dan reka bentuk kedua (32% untuk ketebalan mata gerudi, 90° untuk titik sudut, 31.33° untuk helix sudut) adalah cadangan jangkaan yang paling sesuai dalam kajian ini.

ABSTRACT

Aluminium Silicon Carbide is one of the metal matrix composite. Drilling and reaming of Al/SiC composites is very challenging. An overall process optimization strategy is very needed for the actual production. This must be based on a deep understanding of the cutting mechanism. Different drill geometry may give different effect on the heat generation and thrust force on bone. Web thickness, point angle and helix angle are the drill geometry factors studied. So, modeling of Al/SiC drilling process by ANSYS to simulate the effect of axial thrust force and heat generation on bone in order to prevent thermal osteonecrosis. Finite element simulation is applied because the process variables are difficult to measure and directly measurable from the cutting process. There are 2 stages of methodology. During stage 1, the purpose is to validate the simulation whether the model valid or not by testing the simulation with available drill bit with straight shank. During stage 2, simulation is preceded with the drill geometry by using the validated model setting. Response surface methodology is used to design the experiment and ANOVA method is used to analysis the data. It was found that there is significant effect on temperature by the drill geometry involved, and not significant effect on thrust force. There are 10 optimized solutions suggested in this study. First solution (31.92% web thickness, 90° point angle, 31.32° helix angle) and second solution (32% web thickness, 90° point angle, 31.33° helix angle) are predicted as highly desirable for the study.

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TABLE OF CONTENT

DECLARATION	iii
APPROVAL	iv
DEDICATION	v
ABSTRAK	vi
ABSTRACT	vii
ACKNOWLEDGEMENT	viii
TABLE OF CONTENT	ix
LIST OF TABLES	xiii
LIST OF FIGURES	xiv
LIST OF ABBREVIATIONS	xvi
LIST OF SYMBOLS	xvii
INTRODUCTION	19
1. INTRODUCTION	19
1.1 Background	19
1.2 Problem Statement	22
1.3 Objective	23
1.4 Scope	24
1.5 Expected Result	24
2. LITERATURE REVIEW	25
2.0 Introduction	25
2.1 Cutting Mechanism	25

2.2	Heat Generation	26
2.2.1	Factors that Affects the Heat Generation.	28
2.3	Thermal Osteonecrosis	29
2.4	Mechanical Properties of AlSiC MMCs	31
2.5	Types of Drill Bit	35
2.6	Drill Material	36
2.7	Drilling Parameter	37
2.7.1	Feed Rate	37
2.7.2	Drill Speed	38
2.7.3	Axial Thrust Force	39
2.7.4	Drilling Energy, Power and Efficiency	40
2.8	Drill Bit Geometry	41
2.8.1	Drill Bit Diameter	42
2.8.2	Drill Web	43
2.8.3	Point Angle	44
2.8.4	Cutting Edge	46
2.8.5	Chisel Edge	47
2.8.6	Flutes	48
2.8.7	Helix Angle	49
2.9	Drilling Depth	50
2.10	Effect of Irrigation	51
2.11	Modeling	52
2.12	Finite Element Method	53
3.	METHODOLOGY	55
3.0	Introduction	55

3.1	Flow of Methodology	55
3.1.1	Numerical model of drill machining	59
3.1.1.1	Finite element model	59
3.1.1.2	Material properties	61
3.1.1.3	Boundary conditions	66
	3.1.1.4 Material model	68
3.1.1.5	Contacts during machining	70
3.1.2	Stage 2	71
3.2	Design of Experiment	72
3.3	Response Surface Methodology	72
3.4	Data Collection and Analysis	74
4.	RESULTS AND DISCUSSIONS	75
4.0	Introduction	75
4.1	Experimental validation.	75
4.2	Thrust force signals from various cutting speeds.	76
4.2.1	Thrust force results.	79
4.3	Effect of the cutting speed and feed rate on drill force.	80
4.3.1	Von Mises equivalent stress distribution.	84
4.4	Particle fracture and debonding in details during machining of Al/SiC	86
4.4.1	Particles at primary deformation zone	86
4.4.2	Particles at secondary deformation zone	87
4.4.3	Particles at tertiary deformation zone	88
4.5	Analysis of Variance for Thrust Force	90
4.5.1	Fit Summary	90

4.5.2	Model Graph Analysis for Web Thickness	92
4.5.3	Model Graph Analysis for Point Angle	93
4.5.4	Model Graph Analysis for Helix Angle	94
4.6	Optimization by Design of Experiment	95
4.6.1	Constraints of the Factors and Responses	96
4.6.2	Optimization	96
5.	CONCLUSION AND RECOMMENDATION	98
5.0	Introduction	98
5.1	Conclusions	98
5.2	Recommendations	100
	REFERENCES	102
	APPENDICES	122
A	122	
B	122	

LIST OF TABLES

2.1	Elements affecting heat generation during implant site drilling.	27
2.2	Comparison of mechanical properties between the stainless steel.	35
2.3	Comparisons between Abaqus, AdvantEdge and DEFORM.	53
3.1	Available drill geometry parameter.	56
3.2	The dimensional and mechanical properties of the drilling tool.	59
3.3	Material parameters applied in the FE computational analysis.	61
3.4	Johnson–Cook parameters.	61
3.5	Johnson–Cook damage law parameters.	61
3.6	Properties of the materials.	62
3.7	Level of numeric factors.	72
3.8	Total run of experiment.	72
4.1	Sequential model sum of squares.	89
4.2	Analysis of variance table.	90
4.3	Constraints of the factors and responses.	95
4.4	Optimization.	96

LIST OF FIGURES

2.1	Cutting process in drilling.	25
2.2	Status of osteocytes.	30
2.3	Relationship graph.	38
2.4	Drill bit geometry.	41
2.5	Relationship between flank and point angle.	44
2.6	Comparison between standard point and split-point.	45
2.7	Cutting edge.	46
2.8	Spiral drill design.	48
2.9	Helix angle, wedge angle and clearance angle.	49
2.10	Types of spiral drill.	49
2.11	Cooling system.	51
3.1	Flow chart for methodology (stage 1).	56
3.2	Flow chart for methodology (stage 2).	57
3.3	Finite-element model of drilling of MMCs	59
3.4	Material response during drilling.	63
3.5	Typical machining process of particle reinforced MMC.	66
4.1	Simulated thrust force signals.	76
4.2	Thrust force signal for cutting speed.	77
4.3	Comparison between experimental and FE model results.	78
4.4	Drill force at cutting speed of.	81
4.5	Torque at cutting speed of.	83
4.6	Effects of the cutting speed and feed rate on thrust force.	83
4.7	Images from the start and end of a finite element simulation.	84
4.8	Initial stages of machining.	87
4.9	Final stages of machining.	87

4.10	Model graph for web thickness versus thrust force.	92
4.11	Model graph for web thickness versus thrust force.	94
4.12	Model graph for helix angle versus thrust force.	94

LIST OF ABBREVIATIONS

ANSYS	-	Analysis System
AIISI	-	American Iron and Steel Institute
AMG	-	Automatic Mesh Generation
ANOVA	-	Analysis of Variance
BMD	-	Bone Mineral Density
CAD	-	Computer-Aided Design
CNC	-	Computer Numerical Control
CT	-	Computed Tomography
DF	-	Degree of Freedom
FI	-	Factor interaction
FEM	-	Finite Element Method
MR	-	Magnetic Resonance
P	-	Probability
PMMA	-	Poly (methyl methacrylate)
RSM	-	Response surface methodology
rpm	-	Revolution per minute
STL	-	StereoLithography

LIST OF SYMBOLS

$^{\circ}$	-	Degree
%	-	Percent
$^{\circ}\text{C}$	-	Degree Celsius
ε	-	Plastic strain
$\dot{\varepsilon}$	-	Plastic strain rate
$\dot{\varepsilon}_0$	-	Reference strain rate
σ	-	Stress
σ_y	-	Yield stress
B	-	Hardening modulus
C	-	Strain rate sensitivity coefficient
e	-	Power of ten
GPa	-	GigaPascal
g	-	Gram
g/cm^3	-	Gram per centimeter cube
J/kgK	-	Joule per kilogram Kelvin
J/m^2	-	Joule per meter square
kg/m^3	-	Kilogram per meter cube
$\text{MN/m}^{3/2}$	-	Mega Newton per meter power of three over two
MPa	-	MegaPascal
mm	-	Millimeter
mm/min	-	Millimeter per minute
mm/rev	-	Millimeter per revolution
m^2/s	-	Meter square per second
N	-	Newton
$\text{N/s/mm}^{\circ}\text{C}$	-	Newton per second per millimeter per degree Celcius
n	-	Strain hardening exponent
W/mK	-	Watt per meter Kelvin

rev/min	-	Revolution per minute
s	-	Second
T_{melt}	-	Melting temperature
T_{room}	-	Room temperature

CHAPTER 1

INTRODUCTION

1.0 Introduction

This chapter contains the background, problem statement, objective and scope of research. Background of MMC, drill and parameter will briefly describe in the background section. Problem encountered before the study, objective and scope of the study will stated in this chapter.

1.1 Background

Composite material with at least two component elements is a metal matrix (MMC) composite material, the first one being a metal and the second one a metal or a substance other than a plastic such as a ceramic or organic compound. When there are at least three components, the composite is considered a blend. MMCs are formed when a hardened substance is spread into a metal matrix. To avoid a chemical reaction with

the material, the hardened surface should be sealed. For example, in aluminium matrix carbon fibres are used to synthesise low density and high strength composites. Carbon reacts on the fibre surface with aluminium to create Al_4C_3 as a porous and water-lösable material. In order to stop this reaction, nickel or titanium boride protect the carbon fibres.

During MMC machining, very hard hardened particles are broken and debonded, which play a vital role in the production of surfaces, tool wear and chip. Especially fractures and decomposition are regulated by contact between tool and material, as well as by tension, strain and strain at various machining zone locations. Study on MMC fracture in tensile and compression testing has investigated, but a great deal of phenomenon, such as particulate fracture and debonding process, is still unknown although major research in this area is under way.

Al / SiC composites have a broader scope and common use in the areas of aerospace, naval, vehicle and sports equipment (Ozben, Kilickap, & Çakir 2008) due to their substantial advantages over traditional materials including lightweight , high physical strength , rigidity and a low thermal expansion factor (Singh, Singh, & Dvivedi, 2013). SiCp / Al composites, particularly suited to thermal management applications, such as electronic packaging, with high refurbishment volume fractions. DEM, spinning, milling, crushing, drilling and reaming are essential processes for the manufacture of such SiCp / Al composites. Drilling and reaming small-hole SiCp / Al composites with large percentages of volume is very difficult. For the actual output, an overall process

optimisation approach is important. This must be based on a thorough awareness of the process of cutting.

At present, the most successful means for speeding the development of the analysis of the mechanism of cutting is the integration of laboratory, theoretical and simulation approaches. The simulation based on the finite element principle (FEM) has made significant progress in recent decades. Cutting power, temperatures and residual stress to tool wear are estimated for the chip forming processes in processing different materials with typical or advanced mechanical technology and many main global and field variables were forecast (Iwata, Osakada & Terasaka, 1984). The main focus is on 2D FE modelling (Zhou, Huang, Wang, & Yu, 2011). However, the simplification of drilling process as a 2D problem would lead to a significant deviation from the reality in view of the inadequate geometry of the workpiece and the joint effects of chisel tip, lips and margins in chip shape or flow, only 3D FE simulation can describe correctly the drill process.

With the decrease of the hole size, issues such as cooling and elimination of the chip become more severe. Many thin, discontinuous chips are shaped and liable to go down to the bottom of the hole rather than flute out. The wear of instruments thus increases dramatically when dangerous abrasive particles occur. Furthermore the trapped chips fill the distance between the void and the instrument and raise the torque such that the torque is easier to break.

1.2 Problem Statement

Drilling small hole percentages and reaming Al / SiC composites in large volume is particularly problematic. For the actual output, an overall process optimisation approach is important. This must be based on a thorough awareness of the process of cutting. For example, when the tool cut surface is in contact with hard SiC particles during the drilling of Al / SiC MMCs, the SiC particle acts as small cutting edge, contributing to rapid tool wear, low surface finish, high drilling forces and burr forming.

Study on MMC fracture in tensile and compression testing has investigated, but a great deal of phenomenon, such as particulate fracture and debonding process, is still unknown although major research in this area is under way.

To predict the drilling behaviour of MMCs, it is important to create a generic finite element (FE) model. Research into improving the FE model for predicting the driving force in boring MMCs is unusual. The final result is however changed such that a better solution to a particular problem is presented.

1.3 Objective

The primary objective is to research the reduction of tool wear and lower the thrust force. Therefore, the report lists three objectives.

- i. To contemplate an FE model for predicting the magnitude of thrust force generated and signal during the drilling of Al/SiC.

A significant feature of drilling is the thrust force generated, as the consistency of the drill hole in terms of burr formation is determined much of the time.

- ii. To examine the effects of feed rate and drilling speed on the stress distribution of the drill bit and drill force during the cutting of Al/SiC.

The drilling process and geometries are explored from the simulation model. This is done to verify if the cutting speed and feed rate have an impact on the thrust force.

- iii. To evaluate the particle fracture and debonding in details during machining of Al/SiC in primary, secondary and tertiary deformation zones.

Debonding and particle fracture are regulated by contact between tool and material, as well as by stress, strain and strain at different machining zone locations.