




Faculty of Manufacturing Engineering



**PERFORMANCE OF CARBIDE INSERT IN TURNING OF
TITANIUM ALLOY UNDER CARBON DIOXIDE CRYOGENIC
COOLING**

Siti Asiyah binti Mat

Master of Science in Manufacturing Engineering

2021

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UNDER CARBON DIOXIDE CRYOGENIC COOLING**

SITI ASiyAH BINTI MAT

**A thesis submitted
in fulfilment of the requirements for the degree of Master of Science
in Manufacturing Engineering**



UNIVERSITI TEKNIKAL MALAYSIA MELAKA

2021

DECLARATION

I declare that this thesis entitled “Performance of Carbide Insert in Turning of Titanium Alloy under Carbon Dioxide Cryogenic Cooling” 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.



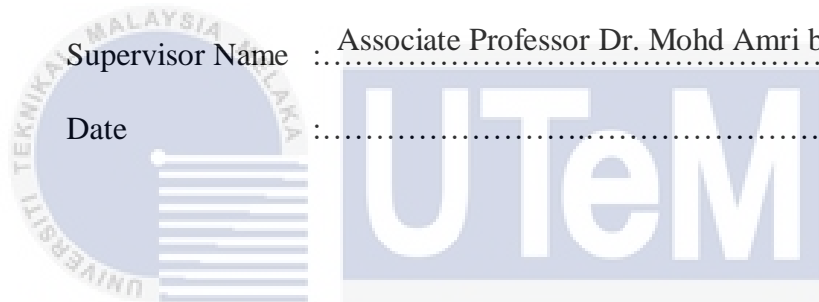
APPROVAL

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 Science in Manufacturing Engineering.

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Date :



اونيورسيتي تيكنيكل مليسيا ملاك

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DEDICATION

To my beloved father, mother, my family, my supervisor and my supportive friends that accompanying me along the difficult pathway in my university life.



ABSTRACT

In manufacturing industries, such as aerospace, automotive, chemical and medical, the application of titanium alloys has received more attention, especially in dental implant and orthopedic implant. Although this titanium alloy has a unique characteristics, such as difficulties to machining due to high hardness, lower thermal conductivity and higher chemical reactivity, this material is always in high demand. During machining of titanium alloy, the major issues frequently discussed are rapid cutting tool wear and generation of high cutting temperature. The proper cooling method needs to be used in order to reduce high cutting temperature that causes rapid tool wear thus increases the tool life of the cutting tool during machining titanium alloy. Many studies have been reported by researchers of cryogenic cooling in machining titanium. In this research, an attempt has been made to investigate the effect of cryogenic cooling using carbon dioxide (CO₂) liquid, when it is applied to the workpiece and cutting tool during turning of titanium alloy Ti-6Al-4V ELI. The operation process was carried out using a 3-axis CNC Haas ST-20 lathe machine. Response Surface Methodology (RSM) has been used to design the experiment in determining the effect of the cutting parameters: cutting speed, feed rate and depth of cut towards tool life of the uncoated carbide insert. From RSM, Box-Behnken design has been selected to arrange the cutting parameters of cutting speed with range of 120 to 220 m/min, feed rate with 0.1 to 0.2 mm/rev and depth of cut is 0.4 to 0.6 mm. The flank wear was measured using tool maker microscope. The cutting time values were recorded for each 20 mm on the workpiece until flank wear (V_b) reaches the tool life criterion followed by JIS B4011-1971 standard. From the experiment, the longest tool life recorded is 17.58 minutes obtained at cutting speed 120 m/min, feed rate 0.15 mm/rev and depth of cut 0.40 mm. The shortest tool life is 0.45 minutes obtained at the cutting speed 220 m/min, feed rate 0.15 mm/rev and depth of cut 0.6 mm. The ANOVA analysis showed that for tool life, cutting speed is the most significant factor followed by feed rate and depth of cut to determine and optimise the tool life values. From the detailed observation using SEM, it can be concluded the tool failure mode presents at the cutting tool are flank wear and crater wear. In addition, the observed dominant wear mechanism at the cutting tool is abrasion and adhesion.

PRESTASI MATA ALAT KARBIDA DALAM PELARIKAN ALOI TITANIUM DI BAWAH PENYEJUKAN KRIOGENIK KARBON DIOKSIDA

ABSTRAK

Di dalam industri pembuatan seperti aeroangkasa, automotif, bahan kimia dan perubatan, aloi titanium selalu mendapat perhatian yang lebih terutamanya dalam implan pergigian dan implan ortopedik. Walaupun aloi titanium ini mempunyai ciri-ciri yang unik seperti sukar dimesin disebabkan kekerasan yang tinggi, keberaliran terma yang rendah dan mudah bertindak balas secara kimia terhadap bahan mata alat, bahan ini sentiasa dalam permintaan yang tinggi. Semasa pemesinan aloi titanium, isu utama yang sentiasa dibincangkan ialah haus mata alat yang cepat dan suhu pemotongan yang tinggi. Kaedah yang betul perlu digunakan dalam mengurangkan haus yang cepat dan meningkatkan hayat mata alat semasa pemesinan aloi titanium. Banyak kajian telah dilaporkan oleh penyelidik tentang penyejukan kriogenik dalam pemesinan titanium. Dalam penyelidikan ini, kajian telah dilakukan untuk menyiasat kesan penyejukan kriogenik menggunakan cecair karbon dioksida (CO₂) apabila digunakan terhadap bahan kerja dan mata alat semasa pelarikan aloi titanium Ti-6Al-4V ELI. Proses operasi dijalankan menggunakan mesin larik 3-paksi CNC Haas ST-20. Kaedah sambutan permukaan (RSM) telah digunakan dalam mereka bentuk ujikaji untuk mengkaji kesan parameter pemotongan seperti kelajuan pemotongan, kadar suapan dan kedalaman pemotongan terhadap hayat mata alat karbida yang tidak bersalut. Daripada RSM, reka bentuk Box-Behnken telah dipilih untuk mengatur parameter pemotongan untuk laju pemotongan dengan kadar 120 hingga 220 m/min, kadar suapan dengan 0.1 hingga 0.2 mm/pusingan dan kedalaman pemotongan adalah 0.4 hingga 0.6 mm. Haus rusuk diukur menggunakan mikroskop. Nilai haus direkod pada setiap 20 mm pemesinan sehingga haus rusuk (Vb) mencapai kriteria hayat mata alat berdasarkan piawai JIS B4011-1971. Daripada ujikaji, hayat mata alat yang paling lama direkodkan ialah 17.58 minit diperolehi pada laju pemotongan 120 m/min, kadar suapan 0.15 mm/pusingan dan kedalaman pemotongan 0.40 mm. Hayat mata alat yang paling singkat ialah 0.45 minit diperolehi pada laju pemotongan 220 mm/min, kadar suapan 0.15 mm/pusingan dan kedalaman pemotongan 0.6 mm. Analisis ANOVA menunjukkan bahawa untuk hayat mata alat, parameter pemotongan yang paling penting ialah kelajuan pemotongan diikuti dengan kadar suapan dan kedalaman pemotongan dalam menentukan dan mengoptimumkan nilai hayat alat. Berdasarkan pemerhatian yang terperinci dengan menggunakan SEM, dapat disimpulkan mod kegagalan alat yang hadir pada mata alat ialah haus rusuk dan haus kawah. Di samping itu, mekanisme haus dominan yang diperhatikan pada mata alat adalah lelasan dan lekatan.

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TABLE OF CONTENTS

	PAGE
DECLARATION	
APPROVAL	
DEDICATION	
ABSTRACT	i
ABSTRAK	ii
ACKNOWLEDGEMENTS	iii
TABLE OF CONTENTS	iv
LIST OF TABLES	vii
LIST OF FIGURES	ix
LIST OF ABBREVIATIONS	xiii
LIST OF SYMBOLS	xv
LIST OF PUBLICATIONS	xvii
CHAPTER	
1. INTRODUCTION	1
1.1 Research background	1
1.2 Problem statement	3
1.3 Research objectives	4
1.4 Scope of research	4
1.5 Significant of research	5
1.6 Organization of thesis	5
2. LITERATURE REVIEW	6
2.1 Turning	6
2.2 High speed machining	7
2.3 High speed turning of titanium alloy using carbide tool	8
2.4 Titanium alloy	9
2.5 Cutting parameter for titanium alloy	10
2.6 Heat generation during turning titanium alloy	12
2.7 Cutting tool material	15
2.7.1 Cemented carbide	17
2.8 Tool failure mode	18
2.8.1 Flank wear	18
2.8.2 Crater wear	19
2.9 Tool life	21
2.10 Wear mechanism	23
2.10.1 Abrasion	24
2.10.2 Adhesion	25
2.10.3 Diffusion	26
2.10.4 Plastic deformation	28
2.10.5 Chemical reaction	29

2.11	Cutting fluid	30
2.12	Cryogenic cooling	31
2.12.1	Cryogenic process	33
2.12.2	Advantages of cryogenic cooling	33
2.12.3	Disadvantages of cryogenic cooling	34
2.12.4	Carbon dioxide	34
2.13	Design of experiment	36
2.13.1	Response surface methodology	36
2.14	Summary	39
3.	METHODOLOGY	40
3.1	Project flow chart	40
3.2	Experimental equipment	42
3.2.1	CNC lathe Haas ST-20	42
3.2.2	Toolmaker microscope	44
3.2.3	Scanning electron microscopy	44
3.2.4	X-ray diffraction	45
3.2.5	Thermal imaging camera	46
3.2.6	Cryogenic carbon dioxide	48
3.3	Workpiece material	49
3.4	Cutting tool	50
3.5	Tool holder	52
3.6	Experimental procedure	53
3.6.1	Initial preparation	53
3.6.2	Cutting parameter	54
3.6.3	Procedure experiment	55
3.6.4	CO ₂ cryogenic cooling setup	57
3.6.5	Working process of CO ₂ cryogenic cooling	58
3.7	Data collection	59
3.7.1	Tool wear measurement	59
3.7.2	Wear mechanism measurement	60
3.7.3	Elemental composition	60
3.8	Summary	61
4.	RESULT AND DISCUSSION	62
4.1	Tool life	62
4.1.1	The effect of cutting parameter on tool life	64
4.1.2	Response surface methodology analysis of tool life	67
4.1.3	ANOVA analysis of the response surface quadratic model tool life	67
4.1.4	Diagnose of the tool life	70
4.1.5	Determination of significant factors influencing tool life	71
4.1.6	The equation in term actual factors in tool life model	76
4.2	Validation on model equation	76

4.3	Optimization of tool life	77
4.4	Confirmation test (validation)	78
4.5	Tool failure mode	78
4.6	Wear mechanism of cutting tool	82
4.7	Tool wear progression	91
4.8	Summary	95
5.	CONCLUSION AND RECOMMENDATION	96
5.1	Conclusion	96
5.2	Recommendation	97
	REFERENCES	98



LIST OF TABLES

TABLE	TITLE	PAGE
2.1	Summarizing from literature for turning Ti-6Al-4V under cryogenic cooling	12
2.2	Physical properties of CO ₂ (Jerold and Kumar, 2011)	35
2.3	Cutting parameter combinations arranged by Box-Behnken (Sulaiman et al., 2014a)	39
3.1	Specification and capabilities of the machine	43
3.2	Chemical composition of Ti-6Al-4V ELI	50
3.3	Mechanical properties of Ti-6Al-4V ELI	50
3.4	Dimension geometry of CNGG 120408-SGF insert (Sandvik, 2009)	52
3.5	Dimension of tool holder DCLNR 2525M 12	53
3.6	The level of parameter for turning Ti-6Al-4V ELI	55
3.7	Design of experiment using Box-Behnken for machining Ti-6Al-4V ELI	55
4.1	Tool life value obtained from experiment	63
4.2	Sequential model sum of squares for tool life model	67
4.3	Analysis of ANOVA for tool life before eliminate the insignificant terms	68
4.4	Analysis of ANOVA for tool life after eliminate the insignificant terms	69

4.5	Statistical summary of model for tool wear	70
4.6	Cutting parameter for validation	76
4.7	Result of confirmation test	77
4.8	Setup of factors and responses in order to find the optimum tool life in RSM	77
4.9	Optimization parameters suggested by RSM	77
4.10	Result of validation test	78
4.11	The percentage composition extracted from XRD pattern	89



LIST OF FIGURES

FIGURE	TITLE	PAGE
2.1	Turning process (Groover, 2010)	7
2.2	Microstructure of $\alpha + \beta$ Ti-6Al-4V ELI (Sulaiman et al., 2014b)	10
2.3	Research analysis in turning Ti-6Al-4V in various cutting parameters	11
2.4	Heat generation and temperature prediction in metal cutting (Abukhshim et al., 2006)	14
2.5	Typical flank wear (Wang, 2012)	19
2.6	Location of the crater wear and other wear that take places on the tool (Lim et al., 2001)	21
2.7	Abrasion wear on the cemented carbide tool (Melo et al., 2006)	25
2.8	Adhesion wear mechanism (Da Silva et al., 2013)	26
2.9	(A) The diffusion mechanism (B) melted titanium alloy (Ghani et al., 2016)	28
2.10	Cryogenic machining images (Pereira et al., 2015b)	32
2.11	The cube for Box-Behken design (Ferreira et al., 2007)	38
3.1	Flowchart of the study	41
3.2	CNC Lathe Haas ST-2	43
3.3	Mitutoyo toolmaker microscope	44
3.4	Scanning electron microscope (SEM) machine	45

3.5	XRD machine	46
3.6	Thermal imaging camera	47
3.7	Position of thermal imaging camera at lathe machine	47
3.8	Liquid CO ₂ tank	48
3.9	Position of nozzle CO ₂ on the machine	49
3.10	Ti-6Al-4V ELI	49
3.11	Cutting insert (CNGG 120408-SGF)	51
3.12	Schematic geometry of CNGG 120408-SGF insert (Sandvik, 2009)	51
3.13	Tool holder DCLNR 2525M 12	52
3.14	Schematic diagram of tool holder DCLNR 2525M 12	53
3.15	The workpiece that set up on the CNC lathe machine	56
3.16	Flow of overall experiment in this study	57
3.17	Cryogenic CO ₂ setup	58
3.18	Position sample at XRD machine	61
4.1	Tool life value from experiment, minutes	63
4.2	The tool life values at constant cutting speed (170 m/min) and various feed rate and depth of cut values	64
4.3	The tool life values at constant feed rate (0.15 mm/rev) and various cutting speed and depth of cut values	65
4.4	The tool life values at constant depth of cut (0.5 mm) and various cutting speed and feed rate values	66
4.5	Normal probability plot for tool life	70
4.6	The cutting speed influenced on tool life	72
4.7	The feed rate influenced on tool life	73

4.8	The depth of cut influenced on tool life	74
4.9	3D response effect of cutting speed and feed rate on tool life	75
4.10	3D response effects of depth of cut and cutting speed on tool life	75
4.11	Flank wear, crater wear and notch wear that formed at uncoated carbide H13A under cryogenic cooling CO ₂	79
4.12	Flank wear, $V_b=0.079$ mm and cutting time 0.09 minutes were recorded at the start of the cutting process and cutting speed = 170m/min	80
4.13	The direction of the chip at the crater wear area due to the attraction of hot chip (cutting speed = 120m/min)	81
4.14	The crater wear formed on the uncoated carbide (H13A)	82
4.15	SEM image show the wear at the flank face and tip of the cutting tool	84
4.16	Abrasion wear at the flank face	85
4.17	The crater wear that formed on the rake face	86
4.18	Adhesion wear mechanism that observed at medium cutting speed	88
4.19	The rough area on the rake face	88
4.20	Evidence of Ti elements present on cutting tool used	89
4.21	Focus area for XRD testing	89
4.22	The maximum temperature generated 276.2 °C was recorded during machining Ti-6Al-4V ELI	90
4.23	Wear progressions on the cutting tool for run number 5 ($v=120$ m/min, $f=0.15$ mm/rev, $d_{oc}=0.4$ mm)	92

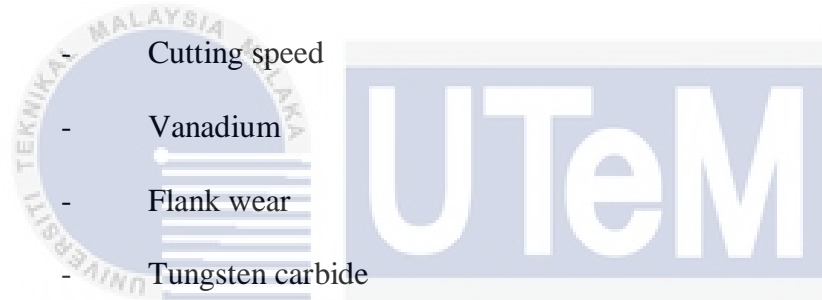
4.24	Wear progressions for run number 14 ($v=170$ m/min, $f=0.15$ mm/rev, $doc=0.5$ mm)	93
4.25	Wear progressions for run number 6 ($v=220$ m/min, $f=0.15$ mm/rev, $doc=0.4$ mm)	94



LIST OF ABBREVIATIONS

Al	-	Aluminum
ANOVA	-	Analysis of variance
C	-	Carbon
CBN	-	Cubic boron nitride
CNC	-	Computer numerical control
Co	-	Cobalt
CO ₂	-	Carbon dioxide
CVD	-	Chemical vapour deposition
d	-	Depth of cut
Df	-	Degree of freedom
DOE	-	Design of experiment
ELI	-	Extra low interstitial
f	-	Feed rate
Fe	-	Iron
H	-	Hydrogen
HSM	-	High speed machining
ISO	-	International standard organization
JIS	-	Japanese industrial standard
LN ₂	-	Liquid nitrogen
MQL	-	Minimum quantity lubrication

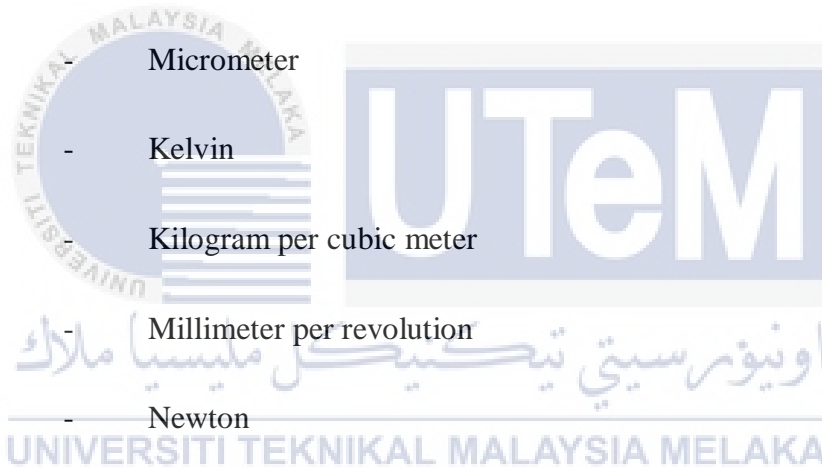
N	-	Nitrogen
O	-	Oxygen
PCBN	-	Polycrystalline cubic boron nitride
PCD	-	Polycrystalline diamond
PVD	-	Physical vapour deposition
RSM	-	Response surface methodology
S	-	Sulfur
SEM	-	Scanning electron microscopy
Si	-	Silicon
Ti	-	Titanium
v	-	Cutting speed
V	-	Vanadium
VB	-	Flank wear
WC	-	Tungsten carbide
Y	-	Yttrium



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LIST OF SYMBOLS

m/min	-	Meter per minute
%	-	Percent
°C	-	Degree celsius
mm	-	Millimeter
μm	-	Micrometer
K	-	Kelvin
kg/m ³	-	Kilogram per cubic meter
mm/rev	-	Millimeter per revolution
N	-	Newton
kW	-	Kilowatt
rpm	-	Revolution per minute
Nm	-	Newton meter
L/min	-	Liter per minute
HRC	-	Rockwell C hardness
HV	-	Vickers hardness
MPa	-	Megapascal



W/ m.K	-	Watts per meter per kelvin
J/ g.K	-	Joule per gram per kelvin
GPa	-	Gigapascal
Psi	-	Pound per square inch



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Journal

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CHAPTER 1

INTRODUCTION

This chapter describes the background of the study and briefly explains the problem statement, objectives, scope and significance of the research.

1.1 Research background

Nowadays, the demand for super-alloys of titanium alloy has been increased day by day because of the large utilization in the industries sector. These materials are extensively used in aerospace, medical instrument, and automotive because of their high specific strength (strength-to-weight ratio), which is retained at elevated temperatures, as well as their fracture resistance and exceptional corrosion resistance (Ramesh et al., 2012; Sartori et al., 2017). Besides, these materials give a superior challenge to some machining operation like turning, drilling and milling, as well as a high temperature producing during machining. These materials are well known to be difficult to machine material (Ezugwu, 2005; Elshwain et al., 2013). According to Che-Haron and Jawaid (2005), the machinability of titanium and other titanium alloy is generally known as poor owing because of the existence of some inherent properties of materials. In fact, this material was low thermal conductivity and high chemical reactivity with cutting tool materials. The properties of titanium alloy with low thermal conductivity causes the temperature to increase at the cutting edge of tool. Due to that, the tool will wear out very fast and hence poor surface finish is generated.