

multi-cut with WEDM. Before machined with WEDM, the steel specimens were quenched at 1050°C and then tempered at 200°C, 400°C, and 600°C, respectively. The microstructure and surface morphology of the multi-cut surfaces were examined with scanning and transmission electron microscopes integrated with an energy-dispersive X-ray spectrometer for chemical composition analysis. N.M. Abbas and bahari et al. studied that EDM process is based on thermoelectric energy between the work piece and an electrode. A pulse discharge occurs in a small gap between the work piece and the electrode and removes the unwanted material from the parent metal through melting and vaporizing. The electrode and the work piece must have electrical conductivity in order to generate the spark. mohammadi and karimi et al. The setting of machining parameters relies strongly on the experience of operators and machining parameter tables provided by machine tool builders. It is difficult to utilize the optimal functions of a machine owing to there being too many adjustable machining parameters. H. Singh and Rohit Garg et al. found that the material removal rate (MRR) directly increases with increase in pulse on time and peak current while decreases with increase in pulse off time and servo voltage. They used ELECTRONICA SPRINTCUT WEDM as a machine tool and hot die steel (H-11) as work-piece. Jangra kamal et al presented the optimization of performance characteristics in WEDM using Taguchi Grey relational analysis. Process parameters were investigated using mixed L orthogonal array. GRA was applied to determine optimal L18 process parameters for optimization of multiple performance characteristics which were investigated during rough cutting operation in D-3 tool steel. U. Natarajan and yang et al. focuses RSM for the multiple response optimization in micro-endmilling operation to achieve maximum metal removal rate (MRR) and minimum surface roughness. Aluminium block of 60×40×16 mm is used as the workpiece material and carbide endmill cutter of diameter 1 mm as the cutting tool. N. Sharma and R. Sharma et al. optimized the process parameters for the cutting speed and dimensional deviation for high strength low alloy steel (HSLA) on WEDM. Response surface methodology was used for the modelling and multi-response optimization.

EXPERIMENTAL DETAIL: WEDM machine (S-35, Sparkonix) was used as the experimental machine in this study. A Brass Wire with a diameter of 0.025 mm was used as an electrode to erode a work piece of EN-5 (flat plate). The gap between work piece and electrode was flooded with a moving dielectric fluid.



Fig 1.2: pictorial view of wedm machine

Fig.1.3 shows the arrangement of work piece during pilot experimentation.



Fig 1.3: pilot experimentation

For WEDM, cutting rate is a desired characteristic and it should be as high as possible to give minimum machine cycle time leading to increased productivity. In the present study cutting rate and surface roughness is mainly measures for a evaluation of job. the cutting which is directly displayed on the screen of the machine and is given units is in mm/min (Figure 1.4). And surface roughness is measured with the help of surface roughness testor. The figure shown below is the arrangement of cutting rate on wire cut electric discharge machining process

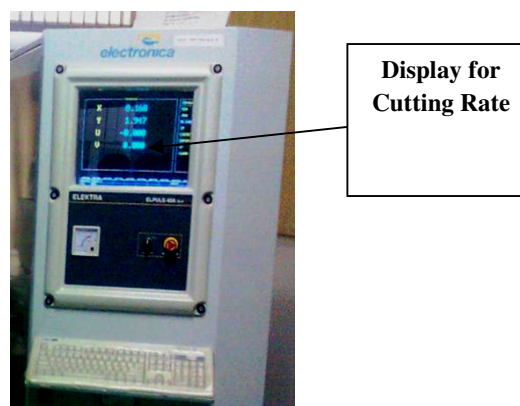


Figure 1.4: Set Up for Cutting Rate and Measurement

The purpose of the pilot experiments is to study the various changes of the WEDM control factors on performance measures such as Cutting Rate and Surface Roughness.

The pilot experiments were performed on ELECTRONICA make SPRINTCUT 734 WEDM machine. Various input control factors varied during the experimentation are pulse on time, pulse off time, spark gap voltage, peak current, wire tension, wire feed. Apart from the parameters mentioned above following parameters were kept constant at a fixed value during the experimentation.

Work piece	:	EN5 Steel
Electrode(tool)	:	0.25mmØ
Work piece height	:	9mm
Cutting length	:	70 mm
Dielectric Conductivity	:	20mho
Dielectric temperature	:	20-240C

II. EXPERIMENTAL SET UP

The purpose of this study is analysing the effect of WEDM process parameters on response variable such as Cutting Rate and Surface Roughness. Also, it is intended to ascertain the ranges of different parameters required for the experimental design methodology used in this work.

Observations are made by using one factor at a time approach i.e fixing some parameters and vary individual parameters one by one with the response variable (cutting rate and surface roughness)

Effect of various control factors are analysed by performing various experiments with variation of input parameters.

First observation is made to check the Effect of Pulse on Time on Response Variable as:

III. RESULT AND DISCUSSION

In the first set of experiment :- The pulse on time (Ton) is varied from 105 machine units to 125 machine units. The values of the other control factors are given as Toff = 31 unit; IP= 115 A SV =50V WT = 8 machine units; WF = 8 m/min; and SF = 2100 unit. The experimentally observed values of the response variables for different values of pulse on time are given in Table 1.1 The scatter plots of pulse on time versus response variables are shown in Figure 1.5.

Pulse on Time (µs)	Cutting Rate (mm/min)	Surface Roughness (µm)
105	1.09	1.25
110	1.88	1.56
116	2.91	1.99

120	2.9	2.39
125	4.4	2.40

Table 1.1 Experimental value of Ton vs CR and

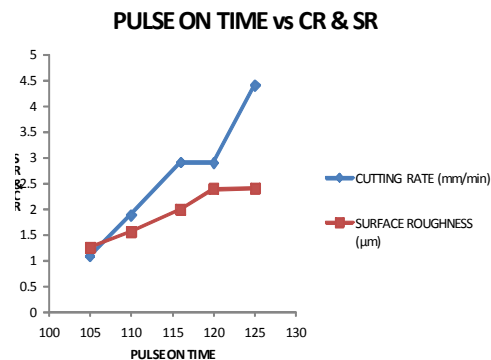


Figure 1.5: Effect of Pulse on Time on Cutting Rate and Surface Roughness.

The cutting rate and surface roughness increases with the increase in the pulse on time. This is due to the fact that with the increase in pulse on time the discharge energy increases, due to which CS and SR increases also with the increase of Ton machining time increase. These findings are in agreement with some of researchers [Tarn, Y. S., Ma, S. C., Chung, L. K. (1995)].

In the second set of experiments: the pulse off time (Toff) is varied from 20 machine units to 60 machine units. The values of the other control factors are given as Ton = 116 unit; IP= 115 A SV =50V WT = 8 machine units; WF = 8 m/min; and SF = 2100 unit. The experimentally observed values of the response variables for different values of pulse off time are given in Table 1.2 The scatter plots of pulse off time versus response variables are shown in Figure 1.6.

Pulse off Time (µs)	Cutting Rate (mm/min)	Surface Roughness (µm)
20	2.99	2.62
25	2.97	2.42
31	2.85	2.25
50	1.65	2.32
60	0.95	2.29

Table 1.2:Effect of Pulse OFF Time on CR & SR

TOFF vs CR and SR

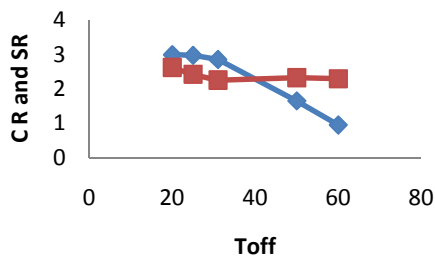


Figure 1.6: Effect of Pulse off Time on Cutting Rate and Surface Roughness.

With the increase in pulse off time, the cutting rate and surface roughness decreases. Due to decrease in spark energy. These findings are in agreement with some of researchers [Gwo-LianqChern and Ying-JengEngin in 2007].

In the third set of experiments: Effect of peak Current on Response Variable is calculated by considering following values:

The Peak Current is varied from 50 units to 180 units. The values of the other control factors are given as Ton=116 unit; Toff=31 unit, SV =50 V, WF=8 m/min, WT=8 machine unit and SF=2100 unit. The experimentally observed values of the response variables for different values of peak current are given in Table 1.3 The scatter plots of Peak Current versus response variables are shown in Figure 1.7

Peak Current	Cutting Rate (mm/min)	Surface Roughness (μm)
50	1.76	1.86
90	2.58	2.19
110	3.07	2.39
150	3.41	2.62
180	3.45	2.78

Table 1.4: Effect of Peak Current on CR & SR

PEAK CURRENT vs CR & SR

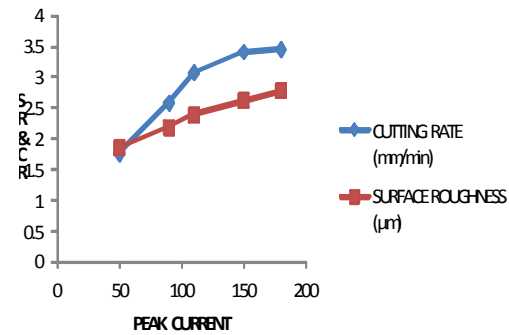


Figure 1.7: Effect of Peak current on Cutting Rate and Surface Roughness.

It has been observed that as the Peak current increases the value of cutting rate and surface roughness. This is in line with one of the researcher [Gwo-LianqChern and Ying-JengEngin IN 2007].

in the fourth set of experiments : In the fourth set of experiments, the servo voltage is varied from 20 units to 80 units. The values of the other control factors are given as Ton = 116 unit; Toff = 31 A Ip = 115 A ;Wt = 8 machine unit ,Wf = 8 machine unit, SF = 2100 unit. The experimentally observed values of the response variables for different values of Servo voltage are given in Table 1.4 The scatter plots of pulse on time versus response variables are shown in Figure 1.8.

Servo voltage (SV)	Cutting Rate (mm/min)	Surface Roughness (μm)
20	3.36	3.50
40	3.13	2.82
50	3.16	2.30
60	2.69	2.29
80	1.86	2.32

Table 1.5: Effect of Serco voltage on CR & SR

SERVO VOLTAGE vs CR & SR

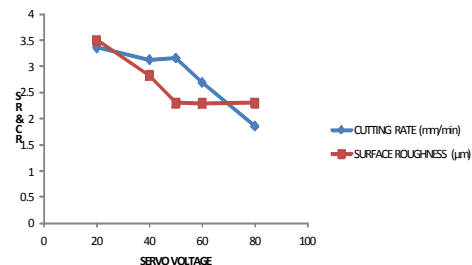


Figure 1.8: Effect of servo voltage on Cutting Rate and Surface Roughness.

It is observed that as the value of servo voltage increases, the value of cutting rate and increases and surface roughness decreases.[Tarang et al (1994)].

In fifth set of experiments: the wire feed is varied from 6 units to 15 units. The values of the other control factors are given as Ton = 116 unit; Toff = 31, Ip= 115 A: SV =50V; WF= 8 machine unit and SF = 2100 unit. The experimentally observed values of the response variables for different values of Wire Feed are given in Table 1.6 The scatter plots of pulse on time versus response variables are shown in Figure 1.9

Wire Feed	Cutting Rate (mm/min)	Surface Roughness (μm)
6	2.68	2.39
8	2.68	2.39
10	2.68	2.39
12	2.68	2.39
15	2.68	2.39

Table 1.6 : Effect of wire feed on CR & SR

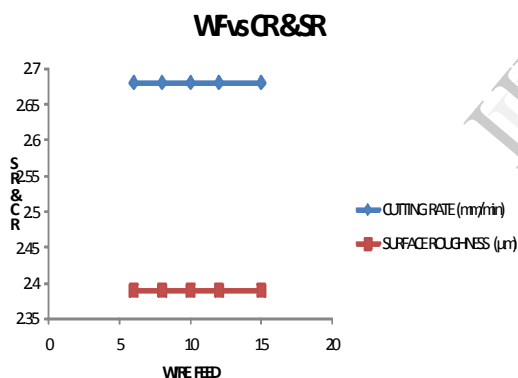


Figure 1.9: Effect of Wire Feed on Cutting Rate and Surface Roughness.

The cutting rate and surface roughness remains practically constant with the increase in wire feed, while the surface roughness decreases with increase in wire feed. These findings are in line with a researcher [Hascalyk, A. and Caydas and U. (2004)]

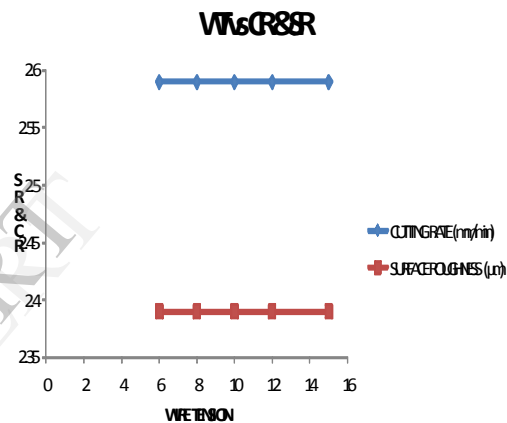
In the sixth set of experiments

the wire tension is varied from 6 units to 15 units. The values of the other control factors are given as Ton = 116 unit; Toff = 31, Ip= 115 A: Sv =50V; Wf= 8 machine unit and Sf = 2100 unit. The experimentally observed values of the response variables for different values of Wire Tension are

given in Table 1.7 The scatter plots of Wire Tension versus response variables are shown in Figure 1.11.

Wire Feed	Cutting Rate (mm/min)	Surface Roughness (μm)
6	2.68	2.39
8	2.68	2.39
10	2.68	2.39
12	2.68	2.39
15	2.68	2.39

Table 1.7: Effect of wire feed on CR & SR



IV. CONCLUSION

From the above study is concluded that :

- Cutting Rate is increase with the increase in pulse on time upto a certain amount of range beyond this limit of pulse on time MRR start decrease. And surface roughness increase with increase.
- CR is decreased with increase of pulse duration because discharge energy reduced which reduced cutting rate and surface roughness
- CR is increased with increase of peak current because increase in discharge energy and at the same time surface roughness is reduced to minimu value.
- CR and SR decreased with increase of servo gap voltage
- The effect of Wire feed and Wire Tension is almost contant on cr and surface roughness.
- Finally the ranges of control factors on are selected

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