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"TURNING PROCESS PARAMETER OPTIMIZATION OF LATHE MACHINE BY USING TAGUCHI METHOD"

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ABSTRACT

In this venture endeavours on upgrading the turning procedure under different machining boundaries by Taguchi technique to create or actualize the nature of machined item. Taguchi advancement system is applied to advance cutting boundaries in turning EN-9 with covered solidified carbide device under dry cutting condition. The middle machine is utilized to lead tests dependent on the Taguchi plan of examinations (DOE) with symmetrical L9 exhibit. The symmetrical cluster, sign to clamour proportion (S/N) and examination of difference were utilized to locate the greatest material expulsion rate (MRR) and least surface harshness. From the response outline plotted between turning boundaries and hardness of EN 9, it is seen that there is reduced in hardness as the speed is extended at this point when speed is furthermore extended hardness goes extended. The hardness increases when feed rate is changed from 0.15 mm/fire up to 0.3 mm/fire up and 0.3 to 0.45mm/fire up, correspondingly when significance of cut is extended from 0.8mm to 1.0 hardness increases, yet as the significance of cut is furthermore extended to 1.2 mm hardness decrease broadly. Ideal outcomes are at long last checked with the assistance of affirmation tests.

Keyword: *Turning Process, Parameters of machining, EN-9 steel, Taguchi Method, ANOVA.*

I. INTRODUCTION

Turning is utilized to lessen the width of the work piece, typically to a predetermined turned with the goal that contiguous segments have various distances across. Turning is the machining activity that produces tube. shaped parts. In its fundamental structure, it very well may be characterized as the machining of an outside surface:

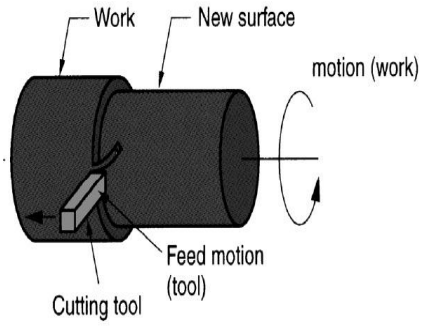

Fig. 1.1 Turning operation

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II. OBJECTIVE OF PROPOSAL WORK

The reason for this investigation is to effectively decide the impact of turning parameters on work piece hardness and ideal parameters for accomplishing the greatest hardness in the scope of parameters. In this work EN 9 material is taken as a work piece and covered carbide device. EN 9 finds wide assortments of utilization in fashioning , axel shaft wrench shafts and associating bar, studs little sticks, machine parts.

III. CONTRIBUTION

Table 3.1 Process parameters and their level

S.No.	Symbol	Process Parameter	Levels		
			Low	Medium	High
1.	**Ss**	Spindle speed (rpm)	700	1100	1400
2.	**F**	Feed Rate (mm/rev)	0.15	0.3	0.45
3.	**D**	Depth of Cut (mm)	0.8	1.0	1.2

A typical strategy to make parts to a particular measurement includes the expulsion of abundance material by machining activity with the assistance of cutting instrument. Turning procedure is the one of the techniques to expel material from tube shaped and non-round and hollow parts.

Turning is the expulsion of metal from the external width of a pivoting round and hollow work piece.

- Study of impact of shaft speed, feed rate, profundity of cut on material hardness.
- Justification of significant reaction worth and investigation of Taguchi procedure for the strategies allude to parameter structure, resilience plan, the quality control, structure of tests utilizing symmetrical clusters and strategy connected to assess estimating impact of parameters on hardness.
- Selection of reaches and levels of procedure factors influencing hardness.
- Implementation of technique and steps of Taguchi parameter plan.
- Analyzing the outcomes and deciding the ideal mix of axle speed, feed rate and profundity of cut.
- Predicting Optimum Performance by Taguchi parameter plan technique. The outcome will be looked at last by Anova strategy.

IV. TAGUCHI METHODOLOGY

Connected In mid 1950's, Dr. Genichi Taguchi, "The Father of Quality Engineering," presented the idea of disconnected quality control strategies known as Taguchi parameter plan. Disconnected quality control are those exercises which were performed during the Product (or Process) Design and Development stage. Genichi Taguchi is a Japanese designer, who has been dynamic in the improvement of Japan's items and procedures since the late 1940's. He has created both a way of thinking and system for the procedure of item quality improvement that depends vigorously on measurable ideas and instruments, particularly factually planned investigations. Numerous Japanese firms have made incredible progress by applying his techniques.

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Fig. 4.1 Experimental setting of the work piece in turning process.

Fig. 4.2 Rockwell hardness testing machine

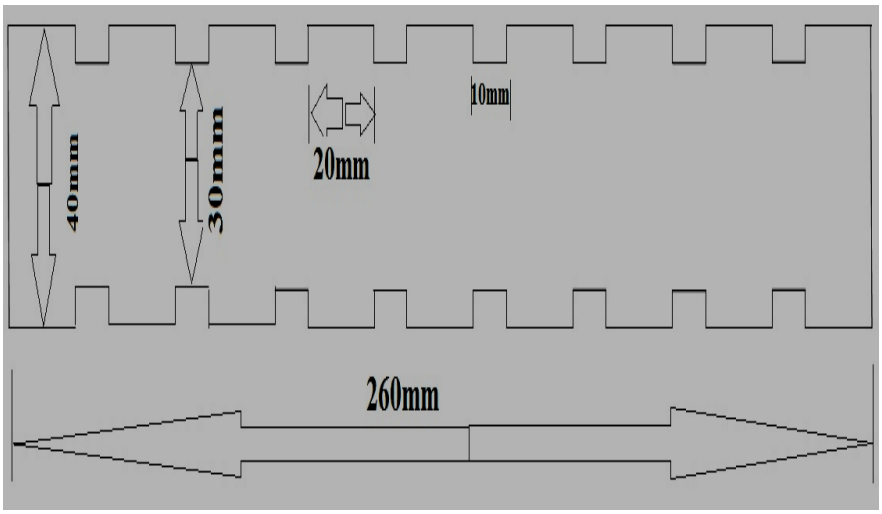

Fig. 4.3 dimensions of work piece

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V. EXPERIMENTATION DATA ANALYSIS AND ANNOVA METHEOD

Table 5.1 consolidated design of experiment Average of hardness (Y) =27 HRC

Exp. No	Spindle speed (rpm) (Ss)	Feed Rate (mm/rev) (F)	Depth of cut (mm) (D)	Hardness (HRC)
1	700	0.15	0.8	24
2	700	0.3	1.0	30
3	700	0.45	1.2	28
4	1100	0.15	1.0	27
5	1100	0.30	1.2	25
6	1100	0.45	0.8	25
7	1400	0.15	1.2	26
8	1400	0.30	0.8	26
9	1400	0.45	1.0	32

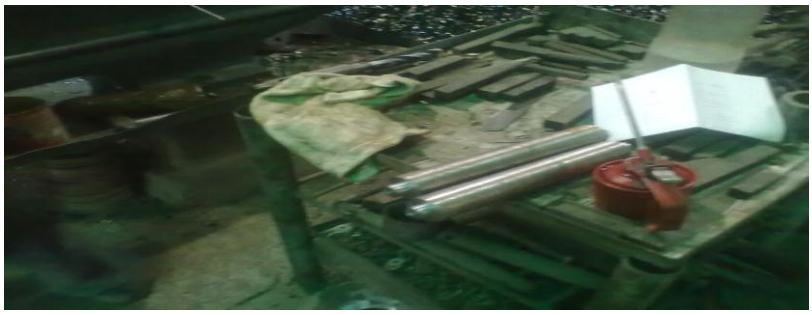

Fig. 5.1 work piece before turning process

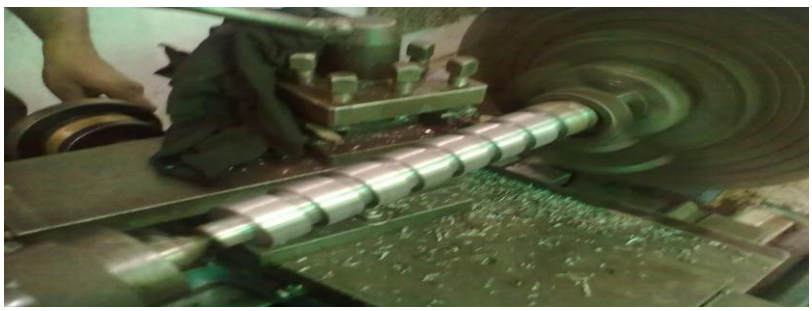

Fig. 5.2 work piece after turning process

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VI. EXPERIMENTAL RESULT

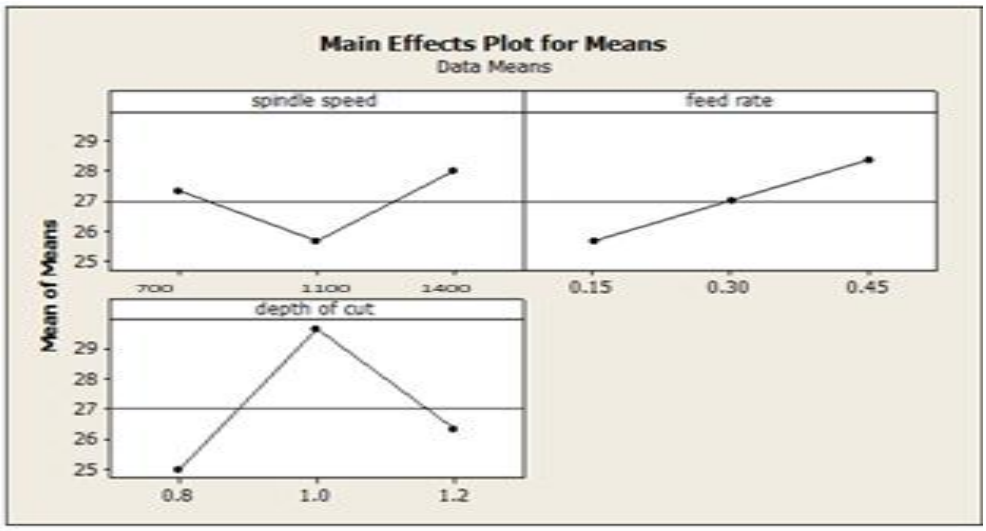

Fig 6.1 Mean response graph for three turning parameter

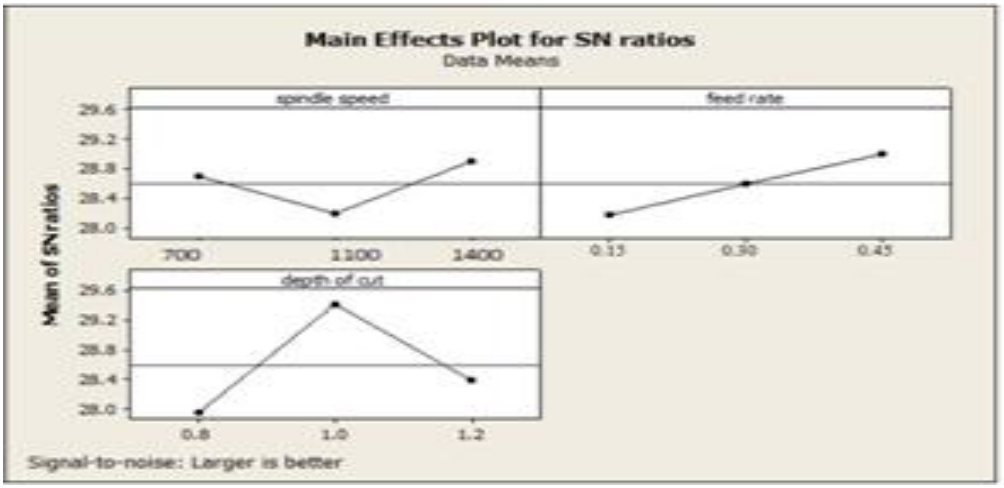

Fig.6.2 Mean S/N graph for Hardness

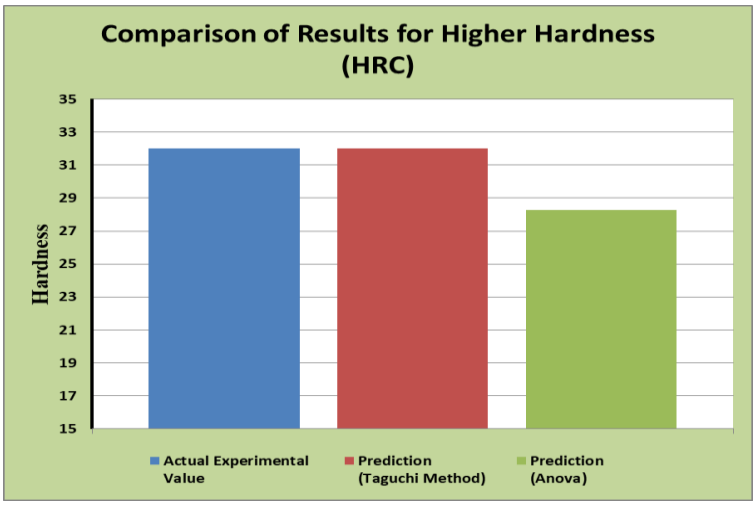

Fig. 6.3 Comparison of result for higher hardness

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VII. CONCLUSION

The postulation has talked about a use of Taguchi technique for enhancing the turning parameters in turning activity and shows that the Taguchi structure of investigation is a compelling method for deciding the ideal turning parameters for Hardness. The result of the count and detailing for the enhancement by the technique for example expectation by Taguchi technique, and utilizing the ideal factor level mix proposed by Taguchi procedure by tests are led and result are condensed. Tests led and consequently examination performed by utilizing the Taguchi technique. The ideal attributes for high hardness in turning activity are distinguished.

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