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Authors: M Siti Syazwani, M N. Ervina Efzan, C K Kok, A K. Aeslina, V. Sivaraman

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Pb-based alloys such as AA6262, AA2011 and more recently AA6026 are used as freemachining aluminum alloys for automotive and electronic applications. However, in order to comply with Automotive End of Life Vehicles (ELV) and Restriction of Hazardous Substances (RoHS) directives, Pb-based alloys slowly need to be phased out. A Pb-free machining grade 6xxx aluminum alloy based on Sn was developed and its machinability evaluated. Microstructure analysis of the Al-Mg-Si-Sn-Cu alloy revealed the presence of (98 wt%) Sn-Mg2Sn entectic phases, which have a low melting point of -203 °C, and are responsible for providing good machinability. Homogenized billets of the alloy were extruded and heat treated to T6 temper. Yield strength and ultimate tensile strength of the Pb-free alloy were comparable to those of the conventionally used Pb-based AA6262-T6 alloy. Machinability studies of the alloy were conducted by evaluating the effect of cutting speed, feed rate and depth of cut on surface roughness, chip size and form of chip produced during the turning operation. The machinability of the Sn containing alloy was found to be superior to that of nonmachining grade 6xxx alloys AA6061-T6 and AA6082-T6 and comparable to that of Pb-based free-machining alloy AA6262-T6.

Study on Drilling of Additively Manufactured Inconel 718

V.Sivaraman1*, B.K. Nagesha2, Wang, JC3

¹Professor, E.G.S.Pillay Engineering College (affiliated to Anna University Chennai), India 611001
²Scientist, Gas Turbine and Research Establishment, DRDO, Govt. of India 560093
³Professor, National Taipei University of Technology, Taiwan 10608
* Email: iitmvs@gmail.com

Abstract: Inconel 718 Ni-based super alloy was fabricated through selective laser melting (SLM) technique. Drilling operation was performed on the cylindrical component produced through SLM technique. During drilling process the thrust force was measured by varying the process parameters like drilling speed and feed rate. Near net shape component can be produced through SLM process and in case a need for additional machining operation like drilling is required for assembly purpose, this report will help to understand the behavior of the material and selection of optimum cutting parameters.

A case study is presented, with a view to understand the drilling operation on a Metal Additive Manufactured part analyzing the thrust force with respect to varying two

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