Dry Sliding Friction of Al-Si-B_4C Composites Prepared Through Powder Metallurgy using Taguchi Design

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***Abstract**: This research paper discuss about the friction behavior of Al-12Si-xB_4C composites prepared through powder metallurgy method by varying the weight percentage of reinforcement (x = 2, 4, 6, 8, and 10) content. The samples were prepared by using die and punch assembly and the lubricant used to eject the sample from the die was molybdenum disulfide. The compaction was done by using compression testing machine by applying a pressure of 800MPa. The dry sliding friction behavior of the sample was conducted on Pin-on-Disc machine and the experimental values of friction were calibrated. Taguchi design experiment was done by applying L25 orthogonal array for 3 factors at 5 levels for the response parameter coefficient of friction. Analysis of Variance demonstrated by Mean and S/N ratio table for coefficient of friction was discussed and from the table it can be seen that the reinforcement plays a main role, when the compared with load and sliding distance. The normal probability plot shows that the residuals falls near to the red line, it indicate that the error values were less in the model.*

Keywords: Al-Si-B_4C, ANOVA, P/M, Taguchi design, CoF.

I. INTRODUCTION

Aluminium based composites is commonly utilized in manufacturing to variety appropriates variations to improve the tribolgical in addition to mechanical properties. Al based composites is strengthened to afford extra strength to metal [1]. The light weight metal Al alloy is strengthened by some of carbide or oxide materials. Among Al alloy is the best utilized matrix metal for the planning of light weight commercial products [2]. The CoF have been conceded out in this effort. Taguchi technique is utilized for optimization of factors and ANOVA is conceded out [4]. The friction behaviour on Al based composites utilizing Taguchi technique with load, reinforcement, sliding distance as input and output as CoF. ANOVA demonstrates the significant factors for controlling the friction. This research work the friction behavior of Al-12Si-xB4C composites prepared through powder metallurgy method by varying the weight percentage of reinforcement (x = 2, 4, 6, 8, and 10) content. Taguchi design experiment was done by applying L25 orthogonal array for 3 factors at 5 levels for the response parameter coefficient of friction. Analysis of Variance demonstrated by Mean and S/N ratio table for coefficient of friction was discussed and from the table it can be seen that the reinforcement plays a main role, when the compared with load and sliding distance. The normal probability plot shows that the residuals falls near to the red line, it indicate that the error values were less in the model.

II. EXPERIMENTAL PROCEDURE

The aluminium and silicon powder was purchased from metal powder company, Thirumagalam, Madurai, Tamilnadu, India. The particle sizes of the two powders were 40µm with purity 99.5%. The powders were mixed in high energy ball mill for 30min for homogenous mixing. The mixed powder were compacted in die and punch assembly with a pressure of 800MPa in compression testing machine. The samples with 10mm diameter and 30mm height were used for the dry sliding friction and wear on pin-on-disc machine.

III. TAGUCHI DESIGN

The influence of input parameters on the friction parameters was deliberate utilizing the Taguchi's method. Next leading the trial test, it was obvious to select the levels of experiments. For the current circumstance, process parameters deliberated are reinforcement, load, and SD changing at 5 levels. Friction trials were showed in agreement to say trial plan and response was measured as specified in Table 1. The input parameters such as reinforcement (A), load (B) and SD (C) at 5 levels were deliberated for this current work. With the design plan of L25 orthogonal array, the trial levels were obvious and revealed in Table 2.

Table 1 trials and levels

Factors	Levels				
	1	2	3	4	5
wt.% B_4C	2	4	6	8	10
Load (N)	8	16	24	32	40
SD (m)	400	800	1200	1600	2000

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Table 2 experimental run and response parameters

wt.% B_4C	Load (N)	SD (m)	CoF	S/N ratio
2	8	400	0.46452	6.65991
2	16	800	0.51484	5.76650
2	24	1200	0.54194	5.32098
2	32	1600	0.57129	4.86279
2	40	2000	0.61293	4.25172
4	8	800	0.4877	6.23694
4	16	1200	0.5235	5.62167
4	24	1600	0.553	5.14550
4	32	2000	0.58333	4.68162
4	40	400	0.54954	5.19995
6	8	1200	0.49033	6.19010
6	16	1600	0.54020	5.34888
6	24	2000	0.57621	4.78826
6	32	400	0.52565	5.58593
6	40	800	0.56721	4.92509
8	8	1600	0.4977	6.06065
8	16	2000	0.53404	5.44852
8	24	400	0.474	6.48443
8	32	800	0.5135	5.78919
8	40	1200	0.54954	5.19995
10	8	2000	0.48441	6.29564
10	16	400	0.41712	7.59478
10	24	800	0.45883	6.76693
10	32	1200	0.48664	6.25584
10	40	1600	0.52382	5.61624

IV. ANOVA FOR COEFFICIENT OF FRICTION OF S/N RATIO

The ANOVA for coefficient of friction of S/N ratio was discussed in Table 3 the most influencing factor that influences the CoF were reinforcement B_4C compared to load and SD with the confidence level 95% for the S/N ratio ANOVA. The F-test value was 2.7763 which is less than the F-table value therefore all the input factors are significant. The response table for S/N ratio of CoF was discussed in Table 4. Figure 1 shows the S/N ratio plot for CoF.

Table 3 Analysis of Variance for SN ratios of CoF

Source	DF	Seq SS	Adj SS	Adj MS	F	P
Wt.% B_4C	4	4.8976	4.8976	1.22439	60.04	0.000
Load (N)	4	4.5922	4.5922	1.14804	56.29	0.000
SD (m)	4	4.2903	4.2903	1.07257	52.59	0.000
Residual Error	12	0.2447	0.2447	0.02039	-	-
Total	24	14.0247	-	-	-	-

Table 4 Response Table for Signal to Noise Ratios of CoF Smaller is better

Level	Wt.% B_4C	Load (N)	SD (m)
1	5.372	6.289	6.305
2	5.377	5.956	5.897
3	**5.368**	5.701	5.718
4	5.797	5.435	5.407
5	6.506	**5.039**	**5.093**
Delta	1.138	1.250	1.212
Rank	3	1	2

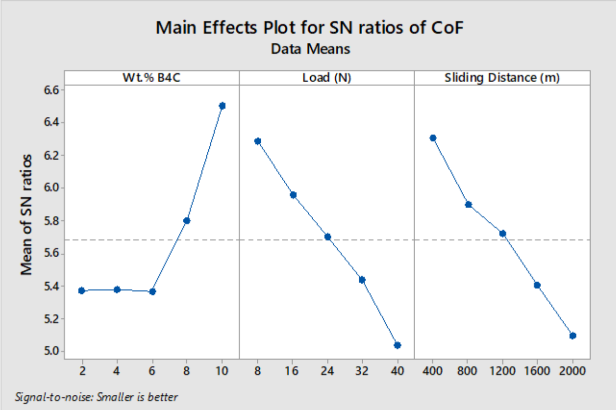


Figure1 shows the S/N ratio plot for CoF

V. ANOVA FOR COEFFICIENT OF FRICTION OF MEANS

The ANOVA for coefficient of friction of means was discussed in Table 5 the most influencing factor that influences the CoF were reinforcement B_4C compared to load and SD with the confidence level 95% for the means ANOVA. The F-test value was 2.7763 which are less than the F-table value therefore all the input factors are significant. The response table was discussed in Table 6. Figure 2 shows the mean plot for CoF

Table 5 Analysis of Variance for Means

Source	DF	Seq SS	Adj SS	Adj MS	F	P
Wt.% B_4C	4	0.01672	0.01672	0.00418	95.87	0.000
Load (N)	4	0.01661	0.01661	0.00415	95.21	0.000
SD (m)	4	0.01510	0.01510	0.00377	86.60	0.00
Residual Error	12	0.00052	0.00052	0.00004	-	-
Total	24	0.04896	-	-	-	-

Table 6 Response Table for Means of CoF

Level	Wt.% B_4C	Load (N)	SD (m)
1	0.5411	**0.4849**	**0.4862**
2	0.5394	0.5059	0.5084
3	0.5399	0.5208	0.5184
4	0.5138	0.5361	0.5372
5	**0.4742**	0.5606	0.5582
Delta	0.0669	0.0757	0.0720
Rank	3	1	2

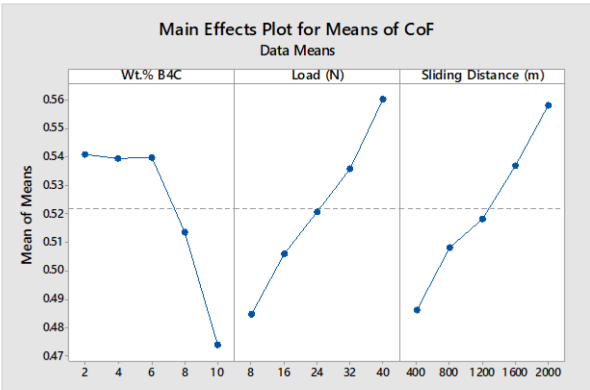


Figure 2 shows the mean plot for CoF

VI. INTERPRETATION OF RESIDUAL GRAPHS

The normal probability plot of the residuals to check the normality of the S/N ratio and means CoF of figures 3(i) & 4(i) show the normal probability plot for Al-Si-B_4Ccomposite. This probability plots evidently specifies that the perceived trial values lies very close to the red line deducing that the errors are ignored and the model is sufficient. The dissemination of residuals for all the elucidation (25 runs) is demonstrated in the histogram. Nearly bell formed symmetrical histogram could be incidental from Figs. 3(ii) & 4(ii). The residuals versus the fitted values for the S/N ratio and means CoF are plotted in Figs. 3(iii) & 4(iii). The sprinkling of the residuals are arbitrarily about zero which designates that the errors are negligible having constant variance. Figures 3(iv) & 4(iv) demonstrate the plots of the residual value and the order of the conforming trial values. The outcomes are effect by the order of the runs that takes place when a line order is utilized to gather the data.

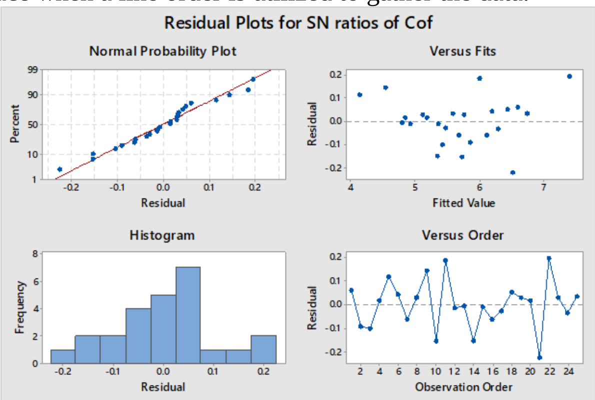


Figure 3 demonstrates the S/N ratio of CoF for normal probability, residual vs fits, histogram and Residual vs order

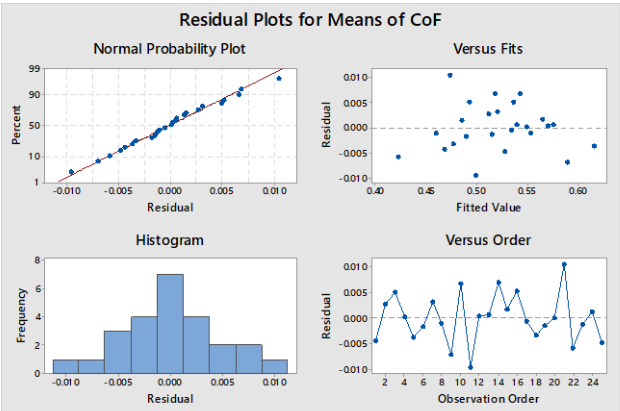
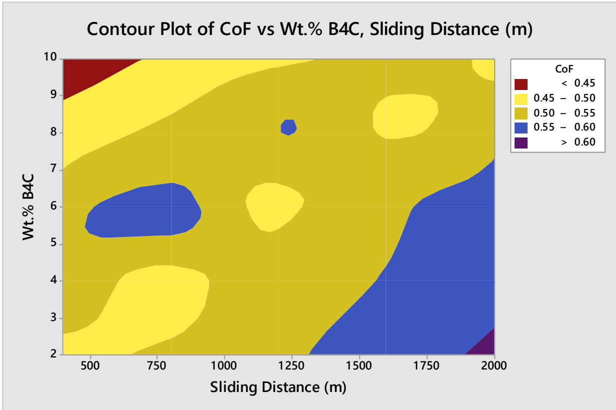


Figure 4 demonstrates the Means of CoF for normal probability, residual vs fits, histogram and Residual vs order

VII. INTERACTION EFFECT OF COEFFICIENT OF FRICTION

Figure 5(a–c) demonstrates the collaborating influence of B_4C wt% and the loads of 8, 16, 24, 32 and 40 N on CoF. Figure 5(a) is the CoF map for reinforcement vs load. The perceived CoF region was low and medium, the violet distribution was dominant. While increasing the B_4C wt% at loads, the CoF is less for the 400 m SD and marginally rises in CoF for all SD. Figure 5(b) demonstrates the map for reinforcement vs SD, the brown and violet distributions are identified. In lower sliding distance and higher reinforcement the brown region was identified, which confirms that increasing the SD, CoF also improved. Figure 5(c) shows the joined influence of load and SD on CoF for map at all reinforcements, the violet and brown region performed. Higher CoF for lower wt% of B_4C at different loads is owing to the rise in SD. This another time authorizes that the B_4C is the main supervisory factor on the CoF of the composites. For the entire Al-Si- B_4C composite samples the CoF improved with the rise in the SD and load.



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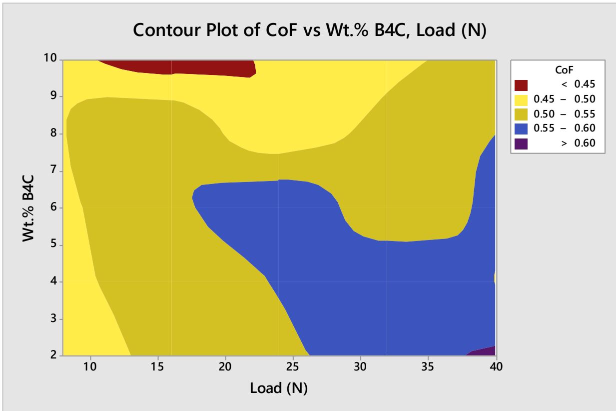

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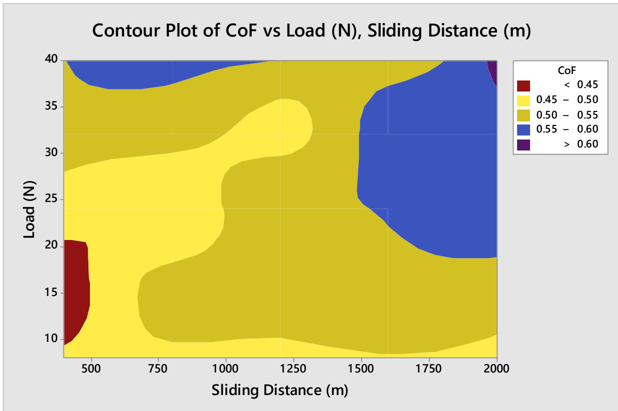

C

VIII. CONCLUSION

This current research work was focused on the dry sliding wear and friction of Al-Si-B_4C composites under powder metallurgy method using Taguchi method.

Analysis of Variance demonstrated by Mean and S/N ratio table for coefficient of friction was discussed and from the table it can be seen that the reinforcement plays a main role, when the compared with load and sliding distance. The normal probability plot shows that the residuals falls near to the red line, it indicate that the error values were less in the model.

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