图书基本信息

- 书名: <<第16届国际电加工会议论文集>>
- 13位ISBN编号:9787313056306
- 10位ISBN编号:7313056303
- 出版时间:1970-1
- 出版时间:上海交通大学出版社
- 作者:赵万生,叶军,朱荻编
- 页数:724

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前言

The International Symposium on Electromachining (ISEM) is a triennial meeting of academia and industry that specializes in electro-physical and electro-chemical machining. This event is conducted under the auspices of the InternationalAcademy for Production Engineering (previously known as International Institution for Production Engineering Researchand also CIRP, from the French name Collige International pour la Recherche en Productique'). It serves as a platformfor the dissemination of the latest scientific and technological accomplishments that represent the state-of-the-art innontraditional machining processes. The ever increasing diversity of the geographical locations of participants and the widerspectrum of topics covered since the beginning of ISEM in 1960's is a testimony of the growing success and popularity of this international symposium. The 16th International Symposium on Electromachining (ISEM XVI) is held in Shanghai China, just 11 days before the World EXPO 2010. Situated in the Yangtze River Delta on China's eastern coast, Shanghai is renowned as the mostinternationalized metropolitan city in China. Shanghai has given the birth to China's modern industry, and witnessed thegreat changes in China's modern history. Over thirty years of economic reform, Shanghai has metamorphosed into aeconomic power house in China. The city as a whole is on the way towards an international center for finance, logisticsand transformation which is expected to be accomplished by the year 2020.

内容概要

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书籍目录

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章节摘录

插图: The EDM process has been used in industry for decades, and it is, by far, the most common amongst the non-conventional machining processes. Its applications covera variety of industries such as mould and tool making, automotive medical and micromechanics. In spite of thementioned popularity of this process, its use has beenlargely based on empirical knowledge and on the experience of EDM machine users. As a result, accuratepredictions of material removal rate, surface finish and surface integrity have only been achieved after costly trial-error approaches. The existing lack of scientific knowledgecan be attributed to two main reasons: First, there existgreat difficulties when it comes to experimentally measuring magnitudes related to the discharge process; second, EDM involves several physical phenomena, including thermal, electrical, mechanical and metallurgicalprocesses. Determining the complex relationshipsamongst parameters is a difficult task, and makesmodelling of EDM a challenge. In recent years, efforts have been put on modelling of the process, both numerical and analytical I. As saidbefore, during the discharge process effects of very distinct nature merge together, but it is commonly accepted that the thermal effect is the most important of them 2101, being other aspects such as the electrical forces less significant when it comes to the material removal mechanism. This is why thermal modelling ofEDM is one promising alternative, since a deepknowledge of the mechanisms involved in this process canbe acquired. If the discharge channel formed duringerosion, together with the material ejection are adequately represented by a thermal model, it will be possible tomake predictions of the material removal rate, surfacefinish and surface integrity, but it is at this point whendifficulties concerning the experimental characterization of the discharge process arise. The dispersion found inpublished models suggests that more researchhas to be carried out on this field. No doubt, the validity of thermal modelling tool relies on the similarity between the modelled heat source and theactual discharge process. In this sense, special care hasto be taken when defining the heat input, and also whendetermining the discharge location criteria. In literature, two approaches to simulation can be found, one is centred in solving the thermal problem associated to the erosion caused by a single discharge E 1 - 81, and the other isfocussed on the discharge location algorithm, as a tool forpredicting the shape of both workpiece and electrode afteran EDM operation The main drawbacks concerning thermal simulation ofsingle discharges are related to the fact that processconditions when carrying out single discharge experiments differ substantially from those occurring during continuousEDM. Three are the arguments to consider that thosesituations have relevant differences. The first of them is that single discharge experiments are performed onworkpieces whose surfaces do not show the roughnessprofiles characteristic of EDM-ed surfaces. The absence of those irregularities may have effect on the dischargeprocess as well as on the material removal mechanism. The second reason is the presence of gas bubbles in the interelectrode gap. Some researches reveal that a bigpercentage of the gap volume is filled with bubbles after the first instants of erosion, and that discharges developed in a gaseous medium differ from those that take place inliquid dielectric And finally, the third argumentto consider is the effect that the debris generated duringerosion has on the process. This debris reduces theinsulating properties of the dielectric medium and therefore influences the discharge generation mechanism and location. It also increases the gap width, which affects thegeometrical precision of the manufactured pieces. On theother hand, those models focussed on the evolution of thegeometries of both workpiece and electrode during EDM operations, through simulation of discharge locationalgorithms give useful information about process featuresat macroscopic scale, but cannot deal with the generation of surface roughness profiles, nor with the thermally induced damages, such as white layer formation, heataffected zones, residual stresses or microcrack formation. As previously mentioned, when developing a thermalmodel of EDM, the definition of discharge characteristicsmust be as realistic as possible, in order to obtain results that can reflect the process outputs accurately. These characteristics can be summarized in three parameters: the amount of energy involved in the heating of theworkpiece material, growth law and size of the plasmachannel, and the material ejection mechanism.

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