

<<第16届国际电加工会议论文集>>

图书基本信息

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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 International Academy for Production Engineering (previously known as International Institution for Production Engineering Research and also CIRP, from the French name Collige International pour la Recherche en Productique') . It serves as a platform for the dissemination of the latest scientific and technological accomplishments that represent the state-of-the-art in nontraditional machining processes. The ever increasing diversity of the geographical locations of participants and the wide spectrum 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 most internationalized metropolitan city in China. Shanghai has given the birth to China's modern industry, and witnessed the great changes in China's modern history. Over thirty years of economic reform, Shanghai has metamorphosed into an economic power house in China. The city as a whole is on the way towards an international center for finance, logistics and transformation which is expected to be accomplished by the year 2020.

内容概要

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书籍目录

Keynote Lectures Part and Material Properties in Selective Laser Melting of Metals
Advancements in Fundamental Studies on EDM Gap Phenomena
Electrical Discharge Machining (EDM) On the Characterization of the Heat Input for Thermal Modelling of the EDM Process
Optimization of EDM Parameters on Nonconductive Ceramics Using Grey Relational Analysis
Time Estimation for Sinking EDM Operations
Study of High Efficient Discharge Cutting Solar Silicon and Texturing Directly
Influence of Additives in Dielectric Fluids for Electrical Discharge Machining
Performance Characteristics of Dry EDM
EDM Characteristics of Carbon Fiber Reinforced Plastic
Research of the Rosin in Machining Fluid for Electrical Discharge Machining
The Methodology of Detecting Dynamical Properties of Electrical Discharge Machining (EDM) Process towards Building a Timely Varied Linear Predictive Model
Powder Mixed Near Dry Electrical Discharge Machining
Experimental Study on Single-pulse Discharge in Gas Dielectric
A New Discharge State Recognition Method of EDM Based on Pulse Edge Detection
Simultaneous Electrical Discharge Machining of Rectilinear Holes Using Electrodes of Various Diameters
Modeling of Workpiece Removal Rate on EDM
Mist-jetting Electrical Discharge Truing and Dressing Technology Combined with Mechanical Method on Metal-bonded Diamond Grinding Wheel
Electrical Discharge Truing for Micro Electroplated Diamond Tool
About the Static Gap Pressure in Electro Discharge Drilling Process
Observation of Flying Debris Scattered from Discharge Point in EDM Process
Verification of Basic Performance of Size-Reduced Automatic Discharge Gap Controller for Curved Hole Electrical Discharge Machining
Electrical Discharge Machining Properties of Insulating Si₃N₄ Ceramics with Added Al₂O₃
Effects of Process Parameters on Single Discharge Forces
Investigation on Dynamic Gas Bubble Formation by Using a High-Speed-Camera System
Study of Gap States in Bunched-electrode EDM
Numerical Simulation of Uneven Wear of Shaped Electrode in EDM
Surface Modification Using Electrical Discharge in Air Gap
Advanced Strategies for Improving the Surface Integrity in Electroerosion Machining
Characteristics of Electrical Discharge Machining for Magnetic Material
Effective Pulses Discriminator and Direct-Drive Jump Control for High Efficiency Electrical Discharge Machining (EDM) Processes
Response Surface Methodology Approach to Process Modeling and Optimization of Powder Mixed Electrical Discharge Machining (PMEDM)
The Study and Application of Pulse Generator in EDM Mirror Machining
Advancement in High Speed Electro-Erosion Processes for Machining Tough Metals
Experiment Research of the Electrical Discharge Machining Parameters Effected on Microstructure of Polycrystalline Diamond
Research on EDM Mechanism of Polycrystalline Diamond
High-Speed Electroerosion Milling of Superalloys
Monitoring of EDM Gap Discharge Status with Wavelet Transform Method
Investigations on High Speed Electroerosion Machining of Forged Carbon Steel
Wire Electrical Discharge Machining (WEDM) Measurement of Wire Deflection in Wire-cut EDM Machining
Mechanism of High Efficient Discharge Cutting on Low Doped Silicon
Development of On-the-Machine Surface Modification Technology in WEDMA
A New Additive and Application System for Wire-EDM
Wire EDM of WC-ZrO₂ Composites
Influence of Needle Pulse Shifting on the Basis Pulse for Wire-EDM of Hard Metals
On-line Estimation of Workpiece Height in WEDM
Trajectory Planning for the Four Axis WEDM Machine Tool and Its Implementation
Parameter Optimization for Surface Roughness of Multiple Cut on HS-WEDM Based on Genetic Algorithm
Monitoring Technology of Gap Discharge Status Based on Floating Threshold for WEDMA
Novel Discharging Status Distinguish Method on Machining Si₃N₄ by HS-WEDM
Investigations on the Influence of Powder Suspended Dielectrics in Wire-EDM
WEDM of Aerospace Alloys Using 'Clean Cut' Generator Technology
Electrochemical Machining (ECM, Electro forming) Experimental Study of Hydrodynamic Bearing Groove Machining Using Fixed Position Cathode Pulse ECM
Selected Problems of Pulse Electrochemical Machining
Fundamental Research on Electrochemical Micro-machining by Using Water as the Electrolyte
Preparation and Analysis of Two-dimensional Nickel Dendrite with Fractal Structure
Research on Electrochemical Dissolution Localization in Case of Micro Machining with Ultra Short Pulses
Material Structure Influence on Surface Roughness in Nanofinishing Electrochemical Process
Research on Porous Metal Nickel in Jet Electrodeposits
Research on Micro Electrode Fabrication Based on ECM
Research on Micro ECM Using Micro Array Electrode
Aspects of Improving

of Electrochemical Machining Accuracy Study on Electrolyte Jet Turning Mechanism and Process Study of Ultrasonical Vibration Combined Synchronizing Pulse Electrochemical Micro-Machining Development of Gap-width Controlling System for Micro-ECM Surface Improvement and Status Simulation of Alloy Tool Steel by Electrochemical Polishing Experimental Study on Numerical Control Electrochemical Machining with BaU-end Tool-electrode Design and Optimization of Process Parameters in Electrochemical Machining of Inconel 625 Alloy Using Taguchi Method Research on NC Electrochemical Mechanical Machining Carbide Alloy Micro Electrochemical Machining and Its Influencing Factors Process Control and Power Systems for Electrochemical-Erosion Sinking (ELESIN) Electrochemical Machining of Micro-profile on Copper Ultrasonic Machining (USM) Effect of Feed Velocity on Cutting Characteristics of Polycarbonate Sheet Subjected to a Two-line Wedge Indentation Experimental Study on Ultrasonic Face Machining of Glass Investigation of Micro Hole Drilling in Bovine Rib Using Micro Rotary Ultrasonic Machining Laser Beam Machining (LBM) Energy Attenuation Modelling for Laser Cladding Process with Coaxial Powder Nozzles Fundamental Study on High-quality Dicing Method for Semiconductor Package by Fiber Laser Fundamental Study on Micro-welding of Thin Stainless Steel Sheet by Fiber Laser Erosion Behavior of Plasma-sprayed and Laser-remelted Ceramic Coatings on TiAl Intermetallic Surface Research on Laser Micromachining at Medical Stents Manufacturing Other High-Density Beam Machining (EBM, IBM, Plasma Processing) Surface Finishing of Cemented Carbide by Large-area EB Irradiation Abrasive/Water Jet Machining (A/WJM) Unconventional Methods of Cutting of Bone and Tissue Other Non-Traditional Machining Methods (Direct writing, PVM) Optimization of Machining Parameters of a Novel Friction Drilling Process Efficiency Improvement of Electrochemical Discharge Machining by a Magnetic Field-assisted Approach Factor Influencing the Gas Film Performance of Electrochemical Discharge Machining Hybrid Processes Intelligent Control of Ultrasonic Vibration Assisted Grinding Combined with EDM Optimization of Electrochemical Discharge Machining Process Investigation on Ultrasound-assisted Electro-spark Deposition Processing A Novel Hybrid Process for Fabricating the Micro Holes Array A Hybrid Process of Micro EDM and Micro ECM for 3D Micro Structures Passivating Film at the Electrochemical Discharge Drilling Electro-discharge Grinding, Energy Consumption and Internal Stresses in the Surface Layer Hybrid EDM: Ultrasonic Vibration Assisted EDM Applied to Micro-Holes..... Rapid Manufacturing Micro and Nano Machining by Nontraditional Methods Process Modeling and Simulation Author Index

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 cover a variety of industries such as mould and tool making, automotive medical and micromechanics. In spite of the mentioned popularity of this process, its use has been largely based on empirical knowledge and on the experience of EDM machine users. As a result, accurate predictions of material removal rate, surface finish and surface integrity have only been achieved after costly trial-error approaches. The existing lack of scientific knowledge can be attributed to two main reasons: First, there exist great difficulties when it comes to experimentally measuring magnitudes related to the discharge process; second, EDM involves several physical phenomena, including thermal, electrical, mechanical and metallurgical processes. Determining the complex relationships amongst parameters is a difficult task, and makes modelling of EDM a challenge. In recent years, efforts have been put on modelling of the process, both numerical and analytical. As said before, 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, being other aspects such as the electrical forces less significant when it comes to the material removal mechanism. This is why thermal modelling of EDM is one promising alternative, since a deep knowledge of the mechanisms involved in this process can be acquired. If the discharge channel formed during erosion, together with the material ejection are adequately represented by a thermal model, it will be possible to make predictions of the material removal rate, surface finish and surface integrity, but it is at this point when difficulties concerning the experimental characterization of the discharge process arise. The dispersion found in published models suggests that more research has 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 the actual discharge process. In this sense, special care has to be taken when defining the heat input, and also when determining 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 [1-81], and the other is focussed on the discharge location algorithm, as a tool for predicting the shape of both workpiece and electrode after an EDM operation. The main drawbacks concerning thermal simulation of single discharges are related to the fact that process conditions when carrying out single discharge experiments differ substantially from those occurring during continuous EDM. Three are the arguments to consider that those situations have relevant differences. The first of them is that single discharge experiments are performed on workpieces whose surfaces do not show the roughness profiles characteristic of EDM-ed surfaces. The absence of those irregularities may have effect on the discharge process 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 big percentage 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 in liquid dielectric. And finally, the third argument to consider is the effect that the debris generated during erosion has on the process. This debris reduces the insulating properties of the dielectric medium and therefore influences the discharge generation mechanism and location. It also increases the gap width, which affects the geometrical precision of the manufactured pieces. On the other hand, those models focussed on the evolution of the geometries of both workpiece and electrode during EDM operations, through simulation of discharge location algorithms give useful information about process features at macroscopic scale, but cannot deal with the generation of surface roughness profiles, nor with the thermally induced damages, such as white layer formation, heat affected zones, residual stresses or microcrack formation. As previously mentioned, when developing a thermal model of EDM, the definition of discharge characteristics must 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 the workpiece material, growth law and size of the plasma channel, and the material ejection mechanism.

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