

A Study on Dry Sliding Wear Behavior of Metal Matrix Composites using Taguchi Technique

B. P. Darshan¹, G. S. Shivashankar², B. Lathashankar³,

^{1,2} Department of Mechanical Engineering, Siddaganga Institute of Technology, Tumkur-572103, Karnataka, India.

³ Department of Industrial Engineering and Management, Siddaganga Institute of Technology, Tumkur-572103, Karnataka, India.

Abstract

In today's industrial scenario, use of Metal Matrix composites for tribological applications have been increasing. In this regard, a study on MMC's was carried out. The tribological behavior of MMC's, including different types and amounts of filler materials were examined. Effects of operating parameters such as Load, Speed and Sliding distance on tribological performance of MMC's were studied. Wear tests were performed on a pin-on-disc set up using plan of experiments based on Taguchi's technique. Analysis of variance has been carried out to establish the relative significance of the individual factors on wear performance. An empirical relation between wear and operating parameters were established for all composite materials using linear regression analysis. The Load, Speed and sliding distance duration plays an important role on tribological performance of MMC's. It was observed that MMC's reinforced with Nano MgO, B₄C and MoS₂ could effectively improve the tribological performance.

Key words - MMC, Tribology, Load, Speed, Sliding distance, Wear test.

I. INTRODUCTION

Many modern technologies require materials with an unusual combination of properties that cannot be met by conventional materials. This is especially in materials for aerospace, automotive and space applications. The materials available for engineers include metal, ceramic and plastic. The use of composite materials, which is a combination of two and more metals, ceramics and polymers, is another class of materials that increases rapidly. Composite materials are likely to provide engineers with materials that are impossible to obtain in conventional materials.

A composite material is a material consisting of two or more constituent materials with significantly different physical or chemical properties which, when combined, produce a material with different characteristics from the individual components. The physical properties of composite materials are non isotropic (regardless of the application direction force) in nature, but are typically anisotropic (different depending on the direction of

applied force or load). The compounds are appreciated for their lightness, high resistance, corrosion resistance, design flexibility, low thermal conductivity and non-conductivity, non-magnetic, durable. In the design of composite materials, engineers and scientists combined various metals, ceramics and polymers to produce a new generation of high performance materials. Most of the composite materials have been created to improve the combination of mechanical properties such as hardness, rigidity, toughness and resistance to room temperature and high temperature. Many composite materials are composed of only two phases; one makes a phase of the "matrix", which is continuous and surrounds the other phase called "reinforcement". The properties of the composite materials depend on the type of reinforcement; its quantities, the orientation and the geometry of the reinforcement. The MMCs are made with high strength to weight ratio, creep resistance, high resistance to abrasion and corrosion, good dimensional stability and high temperature operability. Commonly, aluminum is used as a metal matrix

II. TAGUCHI TECHNIQUE

Taguchi's experimental design method is a simple, efficient and systematic approach to optimizing the design of the experiment. It is considered better than the traditional design of experiments which reduces the number of tests, times and costs. A series of standard orthogonal matrix (OA) is used for many other experimental situations and therefore the results of the experiments are analyzed. The selection of OA depends on the number of parameters, their levels of operation and interaction. The number of columns in a matrix indicates the maximum number of parameters and the number of rows indicates the number of tests that will be performed. The experimental values are analyzed using the analysis of variance to identify the influence of each parameter on the response.

III. EXPERIMENTAL DETAILS

Table 1. Material Composition of MMC's

Combination	MgO (%)	B ₄ C (%)	MoS ₂ (%)
M1	3	0	3

M2	3	3	3
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A. Material Details

To improve the performance of pure MMCs, Nano MgO, B₄C and MoS₂ have been selected as fillers. The compositions of all these materials are listed in Table 1. All these materials were available in the form of bars from which small samples were cut. The samples were cut into a cylindrical pin with a diameter of 10 mm and a length of 30 mm.

B. Test Set Up and Wear Runs

Tribological tests were performed using the Pin-On-Disc machine according to ASTM G99-95. The Pin-On-Disc test setting is commonly used to evaluate tribological properties in laboratories. A pin was used in the disk unit (Figure 1) to perform dry sliding wear tests. The samples were worked in the form of a pin. The height and diameter of the samples were 30 mm and 10 mm respectively. The steel disc (class EN 31) of 120 mm diameter was used as a surface. The chemical composition (% by weight) of the steel disc was as follows: C: 0.15%, Mn: 0.8%, Si: 0.26%, S and P: 0.04%. The tensile strength, hardness and roughness of the disc surface were 430 MPa, 62 HRc and 1.6 Ra, respectively.

All wear tests were performed without lubrication. The ASTM G 99-05 standard was followed for dry sliding wear tests. After each analysis, the samples were cleaned with ultrasonic acetone, dried and weighed in a digital balance (METTLER, precision: 0.01 mg). The specific wear rate (mm³ Nm⁻¹) of the compounds was calculated by taking the ratio between the mass loss (g) and the density (g mm⁻³), the applied load (N) and the sliding distance (m)). The morphology of the wear surface of the composite material is characterized with the help of SEM with energy dispersive spectroscopy (EDS) (GEMINI ULTRA 55) to understand the possible mechanisms operating at different speeds and load conditions.

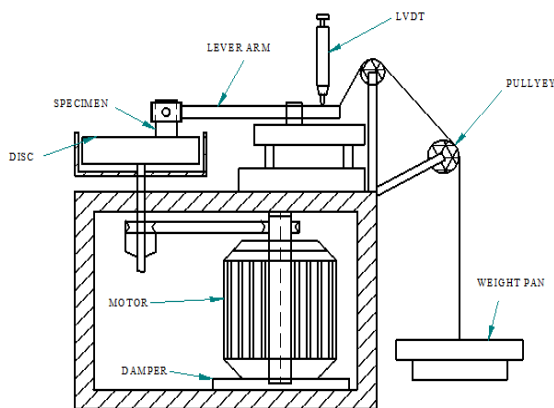


Fig.1. Pin-On -Disc set up.

The initial weight of each composite sample was measured using an electronic scale. During the test, the pin sample was pressed against the rotating disk by applying the load. Wear tests were performed

under various levels of process parameters. After each experiment, the samples were weighed to determine the wear rate in terms of weight loss. The wear tests were performed with variable sliding speed, pressure and duration of the test. The levels of the process parameters are shown in Table 2. The experiments were performed according to the orthogonal L9 matrix.

Table 2: Level of operating parameters

Factors Levels	Speed (rpm)	Load (kg)	Distance (m)
1	200	3	500
2	300	5	1000
3	400	7	1500

IV. RESULTS AND DISCUSSION

The experiments were conducted to know the influence of the operating parameters such as load, speed and sliding distance under dry running conditions. Table 3 shows the results of all composite materials.

A. Signal-to-Noise ratio

The change in the quality characteristics of a product under investigation, in response to a factor introduced in the experimental design, is a "signal" of the desired effect. However, when performing an experiment, there are numerous external factors not designed in experiments that influence the result (response). These external factors are called noise factors and their effect on the test result is called "noise". The signal-to-noise ratio measures the sensitivity of the quality characteristics that are investigated in a controlled manner, to external factors of influence (noise) not under control. The interaction diagrams for the S / N ratios of all composite materials are shown in Figures 2, 3 and 4. In the present study, the wear rate must be lower, so the S / N ratio is considered as "lower is better" and S / N ratio is calculated using the equation shown below.

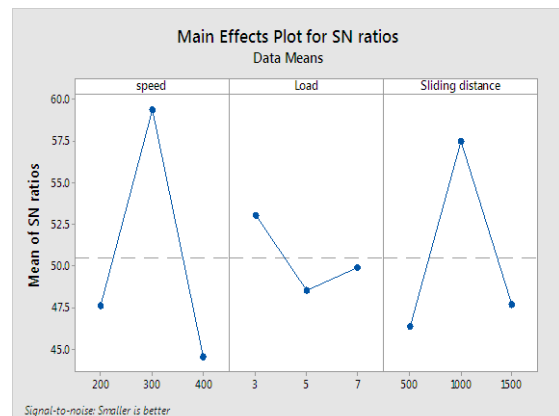


Fig.2. Interaction plot for S/N ratios of M1.

Table 3: Orthogonal Array with Experimental Results and S/N Ratio.

Sl. No	Speed (rpm)	Load (kg)	Sliding Distance (m)	Wear rate for M1 (mm ³ /m)	Wear rate for M2 (mm ³ /m)	SNRA1 For M1	SNRA1 For M2	Speed (rpm)
1	200	3	500	0.0043973	0.06206	45.5420	24.1438	200
2	200	5	1000	0.0029179	0.00264463	50.5286	51.5527	200
3	200	7	1500	0.0054385	0.229306	33.7056	12.7917	200
4	300	3	1000	0.00031593	0.000300182	49.1617	70.4523	300
5	300	5	1500	0.0017128	0.011592	54.4405	38.7168	300
6	300	7	500	0.0022919	0.0017149	54.2529	55.3152	300
7	400	3	1500	0.0076912	0.10933	50.1692	19.2252	400
8	400	5	500	0.0105	0.000026363	61.8835	91.3799	400
9	400	7	1000	0.002623	0.09005	79.8060	20.9103	400

B. Analysis of Variance

Analysis of variance (ANOVA) is commonly used to establish the relative importance of individual parameters in response response behavior. In the present study, ANOVA is used to analyze the influence of operational parameters, such as pressure, flow rate and duration of the test, on the wear characteristics of composite materials. The analysis was performed for a significance level of 5% with a confidence level of 95%. The percentage of influence factor contributions was calculated based on the sum of the square. The greater the value of the sum of the square, the more influential the parameter will be in the response. These sum values of the squares are used to find the percentage contribution of the parameters. Tables 4 and 5 show the results of ANOVA for the wear performance of composite materials.

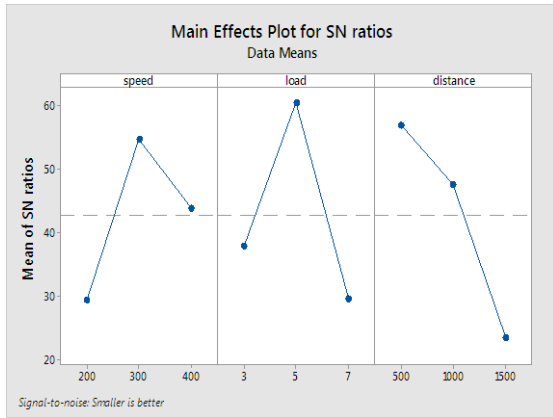


Fig. 3. Interaction plot for S/N ratio of M2.

Table 4. ANOVA for S/N ratios of M1.

Source	DF	Adj SS	Adj MS	F-Value	P-value	P (%)
Load	1	0.000006	0.000006	17.79	0.008	31.3%
Speed	1	0.000010	0.000007	26.89	0.004	52.6%
Sliding Distance	1	0.000001	0.000010	0.41	0.548	5.26%
Error	5	0.000002	0.000000			
Total	8	0.000019	0.000000			

The ANOVA result for the wear performance of M1 is shown in Table 4. It shows that the wear test speed (P = 52.6%) is the most influencing factor, where the load (P = 31, 3%) and

the sliding distance V (P = 5.26%) has a great influence on wear performance. It has been observed that when the velocity and the sliding pressure are increased, the wear rate under dry running conditions also increases. An increase in sliding speed leads to an increase in the contact area temperature due to frictional heating. Therefore, an increase in the contact region occurs due to the softening of the matrix material. This softening of the material led to a higher wear rate.

Table 5. ANOVA for M2.

Source	DF	Adj SS	Adj MS	F-Value	P-value	P (%)
Load	1	0.000006	0.000006	17.79	0.008	22.07%
Speed	1	0.000010	0.000007	26.89	0.004	50.15%
Sliding Distance	1	0.000001	0.000010	0.41	0.548	5.2%
Error	5	0.000002	0.000000			
Total	8	0.000019	0.000000			

Table 5 shows the ANOVA for M2, the speed (P = 50.15. %) And the load (P = 22.07%) has a significant effect on wear performance. It has been examined that with the addition of filling materials in the matrix material, the wear rate decreases considerably. However, all interactions have a negligible influence on wear performance, so they are neglected. Nano MgO is commonly used as filler and MoS₂ is used as a lubricating material. Therefore, adding MgO to the matrix material results in less wear compared to other composite materials.

V. REGRESSION ANALYSIS

Regression analysis was performed for all composite materials to study wear performance under dry run conditions. The empirical equation for wear performance in terms of load, speed and sliding distance was obtained. The linear regression equation for the wear rate of all materials under examination can be expressed as follows

Regression equation for M1 is

$$\text{Wear rate} = 0.00209 + 0.000013 \text{ speed} - 0.000188 \text{ Load} - 0.000001 \text{ Sliding distance} \dots\dots\dots 1$$

$$\text{Regression equation for M2 is} \\ \text{Wear rate} = -0.054 - 0.000158 \text{ speed} + 0.0124 \text{ load} + 0.000095 \text{ Sliding distance} \dots\dots\dots 2$$

VI. CONCLUSION

The Taguchi analysis method has helped to successfully analyze the wear performance of MMC in dry run conditions. The effects of the operating parameters were examined, such as load, speed and sliding distance on wear performance. The following conclusions drawn from the study:

- The ANOVA for the wear performance of composite materials shows that the duration of the wear test that is considered more like the distance traveled is the factor that most affects when the speed and load have a more significant effect on the performance of the wear.
- Analysis of linear regression analysis successfully used to develop the correlation between the percentage of wear and the selected operating parameters.
- The reinforcement of the filler fiber in the matrix material has a great influence on the wear behavior of the material. MMC reinforced with special fillers such as Nano MgO and MoS₂ can improve the wear rate.
- MMC reinforced with Nano MgO and MoS₂ presented the best material compared to other composite materials. He exhibited less wear in all experimental conditions.

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