MEASUREMENT OF LUBRICANT OIL FILM THICKNESS UNDER MINIMUM QUANTITY LUBRICATION MILLING PROCESS

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MASTER OF SCIENCE

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We hereby declare that we have checked this thesis and in our opinion, this thesis is adequate in terms of scope and quality for the award of the degree of Master of Science.

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I hereby declare that the work in this thesis is based on my original work except for quotations and citations which have been duly acknowledged. I also declare that it has not been previously or concurrently submitted for any other degree at Universiti Malaysia Pahang or any other institutions.

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Thesis submitted in fulfillment of the requirements for the award of the degree of Master of Science

Faculty of Manufacturing & Mechatronic Engineering Technology

UNIVERSITI MALAYSIA PAHANG

AUGUST 2022
ACKNOWLEDGEMENTS

First and foremost, I would like to vent out my gratefulness towards Allah SWT for the rezq and opportunities for me to further study in Masters and finally complete this research although it is tough and quite challenging. I am truly grateful with His blessings Alhamdulillah.

Throughout my study to finish the research, I have received many motivations and supports for being parts in my journey. I would like to express my highest appreciation to my beloved supervisor, Dr. Nurrina Binti Rosli for being the best superior that I ever had. I am beyond my words to thank her for always guiding and assisting me to complete this research. She always continuously put the efforts to teach me even it is very fundamentals, voice out her opinions, recommendations and suggestions to put on this project and dissertation. I am truly thankful for the precious time sacrificed by her as well as the motivational words being expressed by her to keep me pushing forward and completing this challenging journey especially when the experiment is conducted during the outbreak pandemic Covid-19.

Other than that, my sincerely thanks goes to my co-supervisor, Dr. Amiril Sahab Bin Abdul Sani for supervise me to complete the research. I am very grateful for his time in assisting me doing the experimental work in the lab. His expertise in the machining knowledge has been very helpful to me. I am also thankful for the opinions and tips I gained from him in order to improve my work.

Furthermore, I would like to express my sincere appreciation to the staffs of Faculty of Manufacturing and Mechatronics Engineering Technology, Universiti Malaysia Pahang for allowing me to utilize the faculty labs and properties in order to carry out my research successfully. Not to be forgotten, my deepest thankful to my research colleague, Nur Izzati Khoirunnisa Binti Ismail for her greatness guidance, help and cooperations during this study.

Last but not least, I would like to express my highest appreciation to the biggest support system in my life which are my family. They have been very supportive and always understand with my commitment on this project. Besides, they always encouraged and keep me motivated whenever I feel lost or down while doing this study. Without these support systems, I am nowhere to complete my journey. This precious dissertation is a proof that all those pressure, tears, sweats and blood have been finally paid off. Alhamdulillah thank you to those people who took a part with me in completing this journey.
ABSTRAK

daya sebaran minyak pelincir ke jalur pemesinan. Sementara itu, diperhatikan dari pemenuan bahawa ketika kelajuan pemotongan meningkat, purata ketebalan minyak pelincir juga meningkat. Peningkatan kelajuan pemotongan telah meningkatkan penggeseran antara alat pemotong dan benda kerja yang akhirnya memberikan pelinciran yang baik. Untuk menjelaskan hubungan antara tingkah laku minyak pelincir MQL dan prestasi proses pemesinan, pengukuran kekasaran permukaan benda kerja telah dianalisis. Hasil menunjukkan nilai purata kekasaran permukaan adalah menurun dengan peningkatan kelajuan pemotongan dalam proses pemesinan. Ini dapat disokong dengan hasil yang mengesahkan ketebalan filem minyak pelincir di bawah keadaan yang sama, menunjukkan bahawa lebih banyak pelincir yang dibekalkan pada bahan kerja, menghasilkan kelicinan permukaan bahan kerja yang lebih baik. Walau bagaimanapun, purata kekasaran permukaan di analisis dan menunjukkan graf peningkatan dengan penurunan kelikatan minyak, $\eta$. Ini sebaliknya dengan apa yang dicapai pada ketebalan filem minyak pelincir. Walaupun zarah dalam minyak likat rendah lebih mudah untuk menembusi zon pemotongan dan memenuhi laluan pemotongan, minyak tersebut tidak dapat menghalang serpihan besi pemotongan dan dengan itu menyebabkan bahan kerja menjadi kasar.
ABSTRACT

Cutting fluid has been extensively used in the manufacturing fields, especially in the machining areas due to its beneficial outcomes, i.e. the capability to lubricate the cutting process, reduce the cutting temperature as well as to slide away the chips from agglomerated onto the cutting zone. Furthermore, this lubrication approach also has been widely utilised to improve the machining performance such as to minimise the surface roughness of workpiece and enhance the rate of tool life. Traditionally, flood coolant has been used as the lubrication method during the machining process. However, excessive amount of oil being supplied through flood cooling method has caused occupational health hazards, manufacturing cost rising and global environmental damage. To overcome these drawbacks, an improvisation lubrication method known as Minimum Quantity Lubrication (MQL) has been implemented. MQL is an alternative lubrication method for near-dry cutting process using a mixture of compressed air and less amount of lubricant oil. MQL in the machining application proven to minimize friction at the cutting zone, reduce the occupational health hazards as well as lower the manufacturing cost. However, since the usage of oil is very little, the goodness of MQL in the lubrication process highly depends on the ability of the oil to penetrate the narrow cutting. This can be obtained by examining the mechanism of oil while lubricating the cutting zone, where this study is still scarce because most of the past studies were merely focus on the effects of machining or lubrication parameter without showing how the lubricant behaviour related to the cutting performance. The study of fundamental nature of lubricant oil during machining operation is highly important to be observed but nevertheless it is still deficient due to the complexity of experimental setup during the ongoing operation as well as the natural flow of oil cannot be disrupted have caused the limitations to accomplish the study. To cater this issue, an experimental work with the objective to analyse the lubricant oil behaviour in MQL milling process by using a non-intrusive method known as laser induced fluorescence (LIF) was carried out. The study was conducted to investigate the thickness of oil during the MQL milling process under various oil viscosity and cutting speed effects. Four different types of oil, i.e. mixed esters oil, sunflower oil, olive oil, and calophyllum inophyllum oil with dynamic viscosity values at 40°C of 11.075, 35.260, 35.260 and 63.223 mPa.s, respectively were dissolved into a fluorescent dye, i.e. Coumarin 153 as the working fluid. Concurrently, machining cutting speed of 14.514, 19.514, 24.514, and 29.514 m/min were set to observe the average lubricant oil film thickness along the milling path. Calibration procedure was carried out before conducting the milling operation to achieve a linear relation between emitted light intensity and the lubricant oil film thickness. From the study, it was found out that the average lubricant oil film thickness increased as the oil viscosity decreased. This phenomenon is explained due to the smaller particles of low viscous oil that made it easier to penetrate from MQL nozzle which increased the spreadability of lubricant oil onto the milled path. Meanwhile, it was observed that as the cutting speed increased, the average lubricant oil film thickness also increased. The increment in cutting speed has raised the friction between cutting tool and workpiece which eventually led to providing a good lubrication effects. To clarify the relation between MQL lubricant oil behaviour and the performance of milling process, the measurement of surface roughness of workpiece was analysed. The results showed that the average surface roughness decreases with the increasing of machining cutting speed. This is supported by the findings that confirmed the results of lubricant oil film thickness under the same conditions, indicating that more lubricant supplied on the workpiece gives better surface finishing of workpiece.
However, it was found that the average surface roughness increased with the decreasing of dynamic viscosity, $\eta$. This is contradic with what was found in lubricant oil film thickness. Although the small particles of low viscous oil was easier to penetrate the cutting zone and spread along the milled path, the oil unable to repel the flying chips and thus made the workpiece rough. Finally, the findings from this research study was able to fill the gap of knowledge in clarifying the oil film thickness behaviour on the machining performance.
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