MANUFACTURING PROCESS		Semester	III
Course Code	BME302	CIE Marks	50
Teaching Hours/Week (L:T:P: S)	3:0:2:0	SEE Marks	50
Total Hours of Pedagogy	40 hours Theory + 8-10 Lab slots	Total Marks	100
Credits	04	Exam Hours	03
Examination nature (SEE)	Theory		

Course objectives:

- To provide knowledge of various casting process in manufacturing.
- To provide in-depth knowledge on metallurgical aspects during solidification of metal and alloys, also to provide detailed information about the moulding processes.
- To acquaint with the basic knowledge on fundamentals of metal forming processes and also to study various metal forming processes.
- To impart knowledge of various joining process used in manufacturing.
- To impart knowledge about behaviour of materials during welding, and the effect of process
- parameters in welding

Teaching-Learning Process (General Instructions)

These are sample Strategies; that teachers can use to accelerate the attainment of the various course outcomes.

1. Lecturer method (L) does not mean only traditional lecture method, but different type of teaching methods may be adopted to develop the outcomes.
2. Arrange visits to nearby power plants, receiving station and substations to give brief information about the electrical power generation.
3. Show Video/animation films to explain functioning of various machines
4. Encourage collaborative (Group Learning) Learning in the class
5. Ask at least three HOTS (Higher order Thinking) questions in the class, which promotes critical thinking
6. Adopt Problem Based Learning (PBL), which fosters students Analytical skills, develop thinking skills such as the ability to evaluate, generalize, and analyze information rather than simply recall it.
7. Topics will be introduced in a multiple representation.
8. Show the different ways to solve the same problem and encourage the students to come up with their own creative ways to solve them.
9. Discuss how every concept can be applied to the real world - and when that's possible, it helps improve the students' understanding.
10. Individual teacher can device the innovative pedagogy to improve the teaching-learning.

MODULE-1

Introduction & basic materials used in foundry: *Introduction: Definition, Classification of manufacturing processes. Metals cast in the foundry-classification, factors that determine the selection of a casting alloy. Introduction to casting process & steps involved – (Brief Introduction)- Not for SEE*

Patterns: Definition, classification, materials used for pattern, various pattern allowances and their importance.

Sand moulding: Types of base sand, requirement of base sand. Binder, Additive's definition, need and types; preparation of sand moulds. Molding machines- Jolt type, squeeze type and Sand slinger.

Study of important moulding process: Green sand, core sand, dry sand, sweep mould, CO2mould, shell mould, investment mould, plaster mould, cement bonded mould.

Cores: Definition, need, types. Method of making cores,

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Concept of gating (top, bottom, parting line, horn gate) and risers (open, blind) Functions and types.
MODULE-2
Melting furnaces: Classification of furnaces, Gas fired pit furnace, Resistance furnace, Coreless induction furnace, electric arc furnace, constructional features & working principle of cupola furnace. **Casting using metal moulds**: Gravity die casting, pressure die casting, centrifugal casting, squeeze casting, slush casting, thixocasting, and continuous casting processes. Casting defects, their causes and remedies.
MODULE-3
METAL FORMING PROCESSES ***Introduction of metal forming process:*** Mechanical behaviour of metals in elastic and plastic deformation, stress-strain relationships, Yield criteria, Application to tensile testing, train rate and temperature in metal working; Hot deformation, Cold working and annealing. ***Metal Working Processes:*** Fundamentals of metal working, Analysis of bulk forming processes like forging, rolling, extrusion, wire drawing by slab method, ***Other sheet metal processes:*** Sheet metal forming processes (Die and punch assembly, Blanking, piercing, bending etc., Compound and Progressive die), High Energy rate forming processes.
MODULE-4
JOINING PROCESSES ***Operating principle, basic equipment, merits and applications of***: Fusion welding processes: Gas welding - Types – Flame characteristics; Manual metal arc welding – Gas Tungsten arc welding - Gas metal arc welding – Submerged arc welding
MODULE-5
Weldability and thermal aspects: Concept of weldability of materials; Thermal Effects in Welding (Distortion, shrinkage and residual stresses in welded structures); Welding defects and remedies. ***Allied processes***: Soldering, Brazing and adhesive bonding **Advance welding processes:** Resistance welding processes, friction stir welding (FSW).

PRACTICAL COMPONENT OF IPCC

Course objectives:

- Impart fundamental understanding of various casting, welding and forming processes
- To provide in-depth knowledge on metallurgical aspects during solidification of metal and alloys
- Discuss design methodology and process parameters involve in obtaining defect free component

PRACTICAL COMPONENT OF IPCC *(May cover all / major modules)*

Sl.NO	Experiments
1	Preparation of sand specimens and conduction of the following tests: Compression, Shear and Tensile tests on Universal Sand Testing Machine.
2	To determine permeability number of green sand, core sand and raw sand.
3	To determine AFS fineness no. and distribution coefficient of given sand sample.
4	Studying the effect of the clay and moisture content on sand mould properties
5	Use of Arc welding tools and welding equipment Preparation of welded joints using Arc Welding equipment L-Joint, T-Joint, Butt joint, V-Joint, Lap joints on M.S. flats
6	Foundry Practice: Use of foundry tools and other equipment for Preparation of molding sand mixture. Preparation of green sand molds kept ready for pouring in the following cases: 1. Using two molding boxes (hand cut molds). 2. Using patterns (Single piece pattern and Split pattern).
7	Preparation of green sand molds kept ready for pouring in the following cases: 1. Incorporating core in the mold.(Core boxes).
8	Forging Operations: Use of forging tools and other forging equipment. Preparing minimum three forged models involving upsetting, drawing and bending operations.
	Demo experiments for CIE
9	Demonstration of forging model using Power Hammer.
10	To study the defects of Cast and Welded components using Non-destructive tests like: a) Ultrasonic flaw detection b) Magnetic crack detection c) Dye penetration testing
11	Mould preparation of varieties of patterns, including demonstration
12	Demonstration of material flow and solidification simulation using Auto-Cast software

Course outcomes (Course Skill Set):

At the end of the course, the student will be able to:

CO1: Describe the casting process and prepare different types of cast products. Acquire knowledge on Pattern, Core, Gating, Riser system and to use Jolt, Squeeze, and Sand Slinger Moulding machines.

CO2: Compare the Gas fired pit, Resistance, Coreless, Electrical and Cupola Metal Furnaces. Compare the Gravity, Pressure die, Centrifugal, Squeeze, slush and Continuous Metal mold castings.

CO3: Understand the Solidification process and Casting of Non-Ferrous Metals.

CO4: Describe the Metal Arc, TIG, MIG, Submerged and Atomic Hydrogen Welding processes etc. used in manufacturing.

CO5: Describe the methods of different joining processes and thermal effects in joining process

Assessment Details (both CIE and SEE)

The weightage of Continuous Internal Evaluation (CIE) is 50% and for Semester End Exam (SEE) is 50%. The minimum passing mark for the CIE is 40% of the maximum marks (20 marks out of 50) and for the SEE minimum passing mark is 35% of the maximum marks (18 out of 50 marks). A student shall be deemed to have satisfied the academic requirements and earned the credits allotted to each subject/ course if the student secures a minimum of 40% (40 marks out of 100) in the sum total of the CIE (Continuous Internal Evaluation) and SEE (Semester End Examination) taken together.

CIE for the theory component of the IPCC (maximum marks 50)

- IPCC means practical portion integrated with the theory of the course.
- CIE marks for the theory component are **25 marks** and that for the practical component is **25 marks**.
- 25 marks for the theory component are split into **15 marks** for two Internal Assessment Tests (Two Tests, each of 15 Marks with 01-hour duration, are to be conducted) and **10 marks** for other assessment methods mentioned in 22OB4.2. The first test at the end of 40-50% coverage of the syllabus and the second test after covering 85-90% of the syllabus.
- Scaled-down marks of the sum of two tests and other assessment methods will be CIE marks for the theory component of IPCC (that is for **25 marks)**.
- The student has to secure 40% of 25 marks to qualify in the CIE of the theory component of IPCC.

CIE for the practical component of the IPCC

- **15 marks** for the conduction of the experiment and preparation of laboratory record, and **10 marks** for the test to be conducted after the completion of all the laboratory sessions.
- On completion of every experiment/program in the laboratory, the students shall be evaluated including viva-voce and marks shall be awarded on the same day.
- The CIE marks awarded in the case of the Practical component shall be based on the continuous evaluation of the laboratory report. Each experiment report can be evaluated for 10 marks. Marks of all experiments' write-ups are added and scaled down to **15 marks**.
- The laboratory test **(duration 02/03 hours)** after completion of all the experiments shall be conducted for 50 marks and scaled down to **10 marks.**
- Scaled-down marks of write-up evaluations and tests added will be CIE marks for the laboratory component of IPCC for **25 marks**.
- The student has to secure 40% of 25 marks to qualify in the CIE of the practical component of the IPCC.

SEE for IPCC

Theory SEE will be conducted by University as per the scheduled timetable, with common question papers for the course (**duration 03 hours**)

1. The question paper will have ten questions. Each question is set for 20 marks.
2. There will be 2 questions from each module. Each of the two questions under a module (with a maximum of 3 sub-questions), **should have a mix of topics** under that module.
3. The students have to answer 5 full questions, selecting one full question from each module.
4. Marks scored by the student shall be proportionally scaled down to 50 Marks

The theory portion of the IPCC shall be for both CIE and SEE, whereas the practical portion will have a CIE component only. Questions mentioned in the SEE paper may include questions from the practical component.

Suggested Learning Resources:

Books

1. Ghosh, A. and Mallik, A. K., (2017), Manufacturing Science, East-West Press.
2. Parmar R. S., (2007), Welding Processes and Technology, Khanna Publishers.
3. Little R. L. – 'Welding and Welding Technology' – Tata McGraw Hill Publishing Company Limited, New Delhi – 1989
4. Grong O. – 'Metallurgical Modelling of Welding' – The Institute of Materials – 1997 – 2nd Edition
5. Kou S. – 'Welding Metallurgy' – John Wiley Publications, New York – 2003 – 2nd Edition.

6. Serope Kalpakjian and Steven R. Schmid – 'Manufacturing Engineering and Technology' – Prentice Hall – 2013 – 7th Edition
7. Principles of foundry technology, 4th edition, P L Jain, Tata McGraw Hill, 2006.
8. Advanced Welding Processes technology and process control, John Norrish, Wood Head Publishing, 2006.

Web links and Video Lectures (e-Resources):

- (Link:http://www.springer.com/us/book/9781447151784http://nptel.ac.in/courses/112
- 105127/)
- http://www.astm.org/DIGITAL_LIBRARY/MNL/SOURCE_PAGES/MNL11.htm
- http://www.astm.org/DIGITAL_LIBRARY/JOURNALS/COMPTECH/PAGES/CTR10654J.htm
- MOOCs: http://nptel.ac.in/courses/112105126/

Activity Based Learning (Suggested Activities in Class)/ Practical Based learning

Metal Casting: Design pattern/core for a given component drawing and develop a sand mould with optimum gating and riser system for ferrous and non-ferrous materials. Melting and casting, inspection for macroscopic casting defects.

- Welding: TIG and MIG welding processes – design weld joints – welding practice –weld quality inspection.
- Metal Forming: Press working operation - hydraulic and mechanical press -load calculation: blanking, bending and drawing operations – sheet metal layout design.

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