

LIST OF FIGURES

Contents	Page No.
Figure 2.1 Al-Cu phase diagrams	25
Figure 2.2 Variation of hardness and tensile strength with B ₄ C weight percentage	49
Figure 3.1 Mechanical Stirrers with Speed Controller	73
Figure 3.2 Shaft and Casted Stirrer Blade	74
Figure 3.3 Graphite Crucible	75
Figure 3.4 Furnace	76
Figure 3.5 Schematic diagrams of the Mould Cavities and gating system	77
Figure 3.6 K- type Thermocouple	77
Figure 3.7 Brinell Hardness Test Machine	78
Figure 3.8 Impact test machine with specimen	80
Figure 3.9 Wear Test Apparatus	81
Figure 3.10 Universal Testing Machine and Specimen	82
Figure 3.11 Die Shinking EDM	82
Figure 3.12 Scanning Electron Microscope	84
Figure 4.1 Schematic diagram of the traditional machining process	87
Figure 4.2 Experimental Setup for Varying Pouring speed and Stirring Speed	90
Figure 4.3 Specimen of Brinell Hardness Test	91
Figure 4.4 Specimen of Impact Test	92
Figure 4.5 Specimen of Tensile Test	93

Figure 4.6	Electro Discharge Machining Operation	93
Figure 4.7	Micrographs of Al6061-4% Cu - 5% Sic Composite at Different pouring speeds	95
Figure 4.8	Regression Curve for Pouring speed Vs Hardness for Material 1 and Material 2	98
Figure 4.9	Regression Curve for Pouring speed Vs Impact strength for Material 1 and Material 2	98
Figure 4.10	Regression Curve for Pouring speed Vs Ultimate tensile strength for Material 1 and Material 2	99
Figure 4.11	Regression Curve for Pouring speed Vs Material removal rate of Material 1 and Material 2	100
Figure 4.12	Normal plot of standardized residual for Hardness	101
Figure 4.13	Normal plot of standardized residual for Impact strength	102
Figure 4.14	Normal plot of standardized residual for Ultimate tensile strength	102
Figure 4.15	Normal plot of standardized residual for Material Removal Rate	102
Figure 4.16	Pouring Speed Vs Hardness	103
Figure 4.17	Pouring Speed Vs Impact Strength	104
Figure 4.18	Pouring Speed Vs Ultimate Tensile Strength	104
Figure 4.19	Pouring Speed Vs Material Removal Rate	105
Figure 5.1	Specimen for Brinell Hardness Test	113
Figure 5.2	Specimen of Impact Test	114
Figure 5.3	Tensile Test Specimen	115
Figure 5.4	Electro Discharge Machining	115
Figure 5.5	SEM of MMC at (a) 50 rpm (b)200 rpm (c) 400 rpm (d) 600 and (e)800 rpm at constant pouring Temperature of 725°C	117
Figure 5.6	SEM at Pouring Temperature (a) 675°C (b) 700 °C (c) 725°C (d) 750°C and (e) 775°C at constant Stirring Speed of 400 rpm	118

Figure 5.7	String Speed Vs Hardness	119
Figure 5.8	Pouring Temperature Vs Hardness	119
Figure 5.9	Stirring Speed Vs Impact Strength	119
Figure 5.10	Pouring Temperature Vs Impact Strength	121
Figure 5.11	Stirring Speed Vs Material Removal Rate	122
Figure 5.12	Pouring Temperature Vs Material Removal Rate	122
Figure 5.13	Normal plot of standardized residual for Hardness	125
Figure 5.14	Normal plot of standardized residual for Impact strength	125
Figure 5.15	Normal plot of standardized residual for Material Removal Rate	126
Figure 6.1	Experimental setup for Wear Test	132
Figure 6.2	SEM of MMC at (a) 50 rpm and 700°C (b) 200 rpm and 700°C (c) 400 rpm and 700°C (d) 600 rpm and 700°C (e) 50 rpm and 725°C (f) 200 rpm and 725°C (g) 400 rpm and 725°C (h) 600 rpm and 725°C	133
Figure 6.3	Stirring speed Vs Wear Rate	135
Figure 6.4	Pouring Temperature Vs Wear Rate	135
Figure 6.5	Normal plot of standardized residual for Wear Rate	136