METALLURGY AND MECHANICS OF SOLIDS LABORATORY

Academic Year	**:**	**2018 - 2019**
Course Code	**:**	**AME104**
Regulations	**:**	**IARE - R16**
Class	**:**	**B. Tech. III Semester (ME/AE)**

Prepared

By

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INSTITUTE OF AERONAUTICAL ENGINEERING

(Autonomous)

Dundigal, Hyderabad-500 043

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Program Outcomes	
PO 1	**Engineering Knowledge:** Capability to apply knowledge of Mathematics, Science Engineering in the field of Mechanical Engineering
PO 2	**Problem Analysis:** An ability to analyze complex engineering problems to arrive at relevant conclusion using knowledge of Mathematics, Science and Engineering.
PO 3	**Design/ Development of solution:** Competence to design a system, component or process to meet societal needs within realistic constants.
PO 4	**Conduct investigation of complex problems:** To design and conduct research oriented experiments as well as to analyze and implement data using research methodologies.
PO 5	**Modern Tool usage:** An ability to formulate solve complex engineering problems using modern engineering and information technology tools.
PO 6	**The Engineer society:** To utilize the engineering practices, techniques, skills to meet needs of health, safety legal, cultural and societal issues.
PO 7	**Environment and Sustainability:** To understand the impact of engineering solution in the societal context and demonstrate the knowledge for sustainable development.
PO 8	**Ethics:** An understanding and implementation of professional and Ethical responsibilities.
PO 9	**Individual Team work:** To function as an effective individual and as a member or leader in multi-disciplinary environment and adopt in diverse teams.
PO 10	**Communication:** An ability to assimilate, comprehends, communicate, give and receive instructions to present effectively with engineering community and society.
PO 11	**Project Management and Finance:** An ability to provide leadership in managing complex engineering project at multi-disciplinary environment and to become a professional engineer.
PO 12	**Life-Long learning:** Recognition of the need and an ability to engage in lifelong learning to keep abreast with technological changes.
Program Specific Outcomes	
PSO 1	**Professional Skills:** To produce engineering professional capable of synthesizing and analyzing mechanical system including allied engineering streams.
PSO 2	**Design/ Analysis:** An ability to adapt and integrate current technologies in the design and manufacturing domain to enhance the employability.
PSO 3	**Successful Career and Entrepreneurship:** To build the nation by imparting technological inputs and managerial skills to become Technocrats.

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Certificate

This is to certify that Mr. / Ms. ____

*bearing roll no*__________________________*of B. Tech*__________________*semester*

____ *branch has satisfactorily*

completed____laboratory during the academic

year_________________________________.

Signature of HOD **Signature of Faculty**

Signature of Internal Examiner **Signature of External Examiner**

METALLURGY AND MECHANICS OF SOLIDS LABORATORY

III Semester: ME								
Course Code	**Category**	**Hours / Week**			**Credits**	**Maximum Marks**		
AME104	**Core**	**L**	**T**	**P**	**C**	**CIA**	**SEE**	**Total**
		-	-	3	2	30	70	100
Contact Classes: Nil	**Tutorial Classes: Nil**	**Practical Classes: 32**				**Total Classes: 32**		

OBJECTIVES:

The course will enable the students to:

I. Determination of mechanical properties of different materials.
II. Establish the constitutive relations in metals using destructive methods.
III. Understand the behavior of members during twisting and transverse loading.
IV. Familiarize with standard test specimens.
V. Prepare samples for investigating micro structure of different materials.

LIST OF EXPERIMENTS

Week-1 MICROSTRUCTURE OF PURE METALS

Preparation and study of the micro Structure of pure metals like iron, cu and al.

Week-2 MICROSTRUCTURE OF STEELS

Preparation and study of the microstructure of mild steels, low carbon steels, high–C steels.

Week-3 MICROSTRUCTURE OF CAST IRON

Study of the micro structures of cast irons.

Week-4 MICROSTRUCTURE OF NON FERROUS ALLOYS

Study of the micro structures of non-ferrous alloys.

Week-5 MICROSTRUCTURE OF HEAT TREATED STEELS

Study of the micro structures of heat treated steels.

Week-6 HARDENABILITY OF STEELS

Hardenability of steels by jominy end quench test.

Week-7 HARDNESS OF STEELS

To find out the hardness of various treated and untreated steels.

Week-8	TENSION TEST
To Find % of elongation and young's modulus of a material.	
Week-9	**TORSION TEST**
To find the torsional rigidity of a material.	
Week-10	**HARDNESS TEST**
a) Brinell's hardness test. b) Rockwell hardness test.	
WeeK-11	**SPRING TEST**
Testing on compressive and elongation springs.	
Week-12	**COMPRESSION TEST**
Compression test on springs.	
Week-13	**IMPACT TEST**
a) Charpy. b) Izod test.	
Week-14	**SHEAR TEST**
Punch shear test on aluminum sheet.	

Text Books:

1. Sidney H Avner, "Introduction to Physical Metallurgy", McGraw Hill Education, 2nd Edition, 2008.
2. William, Callister, "Material Science and Engineering", Wiley, 9th Edition, 2014.
3. V Raghavan, "Elements of Material Science", PHI Learning Company Pvt Ltd, 6th Edition, 2015.
4. Er.Amandeep Singh Wadhva, "Engineering Materials and Metallurgy", Laxmi Publications, 1st Edition, 2008.
5. Traugott Fisher, "Material Science", 1st Edition, Academic Press Elsevier, 2013.

Web References:

1. http://www.iare.ac.in

ATTAINMENT OF PROGRAM OUTCOMES & PROGRAM SPECIFIC OUTCOMES

Exp .No	Experiment	Program Outcomes Attained	Program Specific Outcomes Attained
1	Preparation and study of the micro Structure of pure metals like iron, cu and al.	PO1,PO12	PSO1, PSO12
2	Preparation and study of the microstructure of mild steels, medium carbon steels, high–C steels.	PO1,PO12	PSO1, PSO12
3	Study of the micro structures of cast irons.	PO1,PO12	PSO1, PSO12
4	Study of the micro structures of non-ferrous alloys.	PO1,PO12	PSO1, PSO12
5	Study of the micro structures of heat treated steels	PO1,PO12	PSO1, PSO12
6	Hardenability of steels by jominy end quench test.	PO1,PO12	PSO1, PSO12
7	To find out the hardness of various treated and untreated steels	PO1,PO4,PO12	PSO1, PSO12
8	To Find % of elongation and young’s modulus of a material.	PO1,PO4,PO12	PSO1, PSO12
9	To find the torsional rigidity of a material	PO1,PO4,PO12	PSO1, PSO12
10	Hardness test	PO1,PO4,PO12	PSO1, PSO12
11	Testing on compressive and elongation springs.	PO1,PO4,PO12	PSO1, PSO12
12	Compression test on springs.	PO1,PO4,PO12	PSO1, PSO12
13	Impact test	PO1,PO4,PO12	PSO1, PSO12
14	Punch shear test on aluminum sheet	PO1,PO4,PO12	PSO1, PSO12

INDEX

S.NO.	NAME OF EXPERIMENT	PAGE NO.	DATE	REMARK	SIGN
1	Preparation and study of the micro Structure of pure metals like iron, cu and al.				
2	Preparation and study of the microstructure of mild steels, low carbon steels, high–C steels.				
3	Study of the micro structures of cast irons.				
4	Study of the micro structures of non-ferrous alloys.				
5	Study of the micro structures of heat treated steels				
6	Hardenability of steels by jominy end quench test.				
7	To find out the hardness of various treated and untreated steels				
8	To Find % of elongation and young’s modulus of a material.				
9	To find the torsional rigidity of a material				
10	Hardness test				
11	Testing on compressive and elongation springs.				
12	Compression test on springs.				
13	Impact test				
14	Punch shear test on aluminum sheet				

METALLURGICAL LAB PRACTICE

Aim: To study about the metallurgical lab practice.

Theory: Metallography consists of the microscopic study of the structural characteristics of metal or an alloy. The microscopes by far the most important tool of the metallurgist from both the scientific and technical stand points. It is possible to determine grain size and the size, shape and distribution of various phases and inclusions which have a great effect on the mechanical properties of the metal. The microstructure will reveal the mechanical and thermal treatment of the metal and it may be possible to predict its expected behavior under a given set of conditions.

Tools Used In Lab Practice:

1) **Geomet Cut-Off Machine:** Fig (1) The specimen is cut into a small piece in order to facilitate easy mounting. The specimen is held in between two jaws in the job-vice firmly and is cut using a circular blade connected to a pump. The circular blade is fixed inside the machine in a vertical position and is lowered on to the horizontally held sample by means of a handle. To avoid excess heating up of the blade and the sample, a recalculated (coolant (water with small amount of oil) is applied over the cutting area through a pipe placed near the blade.

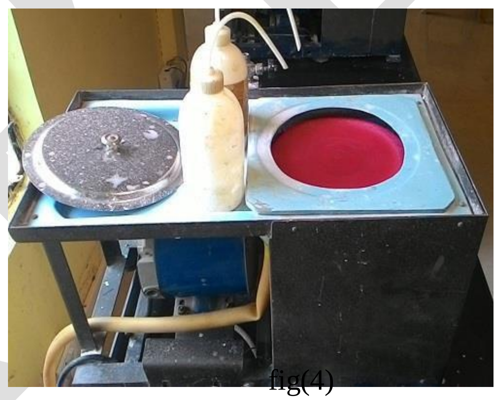

Fig (1)


fig(2)

2) **Geomet Mounting Press:** fig (2) specimens that are small or awkwardly shaped should be mounted to facilitate easy handling during metallography. The specimen to be mounted is placed on the bottom die surface and 2 spoons of Bakelite powder is poured over it. Then the upper die is brought down to complete the die setup. Then the temperature is set a 120^{o}C, i.e. the curing temperature of Bakelite and the hydraulic pressure is released to compact the powder between the two dies. Pressure is to be applied once again at 90^{0}C to remove possible air gaps. Once 120^{0}C is reached, power is to be turned off after minutes. The sample is ejected out of the die and let to cool. The other mounting materials generally used are Lucite and araldite, but these do not need a mounting machine as they set at room temperature itself.

3) **Geomet Belt Grinding:** Fig (3) the sample surface after mounting is rather uneven. Therefore the sample is polished on Belt grinder in one single direction to make the surface flat enough for further polishing. The machine consists of a belt sander of grit 18, which moves circularly over a pair of rolls, and when the specimen is kept on it, the belt grinder removes the surface irregularities.

Fig(3)



fig(4)

4) **Sand Paper Polishing:** Belt grinding is followed by polishing on sand papers of grade 180, 220, 320, 400, 600, numbered in the order of decreasing abrasive particle (SiC) size. Starting with 180 papers, polishing is done in a direction perpendicular to those of the scratches made by belt grinder. After 180 grades, polishing is done on subsequent sand paper changing the direction by 90^{o}C every time the paper is changed.

5) **Emery Paper Polishing:** The sample is then polishing on emery papers (1/0, 2/0,3/0,4/0) following the same procedure as for sand papers.

6) **Geomet Disc Polishing:** fig (4) Fine polishing is done on Geomet variable speed tabletop single disc polishing machine. The machine consists of brass topped A1 disc of 8" ϕ over which a Micro cloth 240 (Billiard or Slyveth cloth) is fastened firmly. Then the cloth is charged with alumina suspension in distilled water (1:5). Sample is polished on the disc rotating at slow speed. Once a mirror like surface is obtained the sample is cleaned with distilled water.

7) Etching: fig (5) on completion of polishing the sample is dabbed with the appropriate etchant. Etchant is a combination of chemicals that attacks the various phases and regions of a microstructure to a different extent, thus making them distinctly visible under the microscope. Phases attacked to a greater extent will appear darker than those lightly attacked as they will reflect light to a greater extent. This is called etching contrast. For example, grain boundaries being regions of instability and of high free energy, will be

fig(5)

attacked to a larger extent and will appear dark. Similarly, in a multi-phase structure, each phase will appear differently depending on its etching properties. However, even in a single-phase structure, some of the grain will appear dark. This is due to the orientation difference between various grains. Some of the etchants and their uses are given below.

Etchant	Composition	Materials Etched
Nital	4% HNO_3 + 96% C_2H_5OH	All steels (except stainless steels)
$FeCl_3$	$FeCl_3$ + HCl + Water	Brass
Aqua Regia	60% HCl + 20% HNO_3 +20% H_2O	Stainless steel
HF	% HF + 98% H_2O	AL & its alloys
Kellars Reagent	1% HF + 1.5% HCl + 2.5% HNO_3+95% H_2O	Duralumin
H_2O_2	5% H_2O_2+5% NH_3OH+90% H_2O	Cu, Brass, Bronze

8) Sample Leveler: The etched sample is held onto on to a glass plate with a piece of clay and is leveled with the sample leveler. Bottom surface of the punch should not be in direct contact with the metal piece, therefore a clean white paper is to be placed on the top of the sample.

9) Observing Under Microscope: fig (6) Then the microstructure is studied under microscope, and then the picture of the microstructure is transferred on to the computer screen through a CCD camera and saved.

Fig (6)

Precautions:

1. While cutting the sample, excess down feed force should not be applied on the cutting wheel and that the sample gets sufficient amount of coolant.
2. Before and after mounting clean the die walls only with a soft cloth or cotton so as to not damage the surface and use a thin smear of lubricant (grease).
3. Do not apply pressure while belt grinding, paper polishing or fine polishing the specimen.
4. Before and after disc polishing wash the sample neatly under running water.
5. After use the disc polisher must be cleaned carefully to avoid contamination of grit.
6. Over-etching or insufficient etching must be avoided.

Result:

The general procedure of metallurgy lab practice has been studied and followed.

1. PREPARATION AND STUDY OF THE MICRO STRUCTURE OF PURE METALS

1.1 MICROSTRUCTURE OF ALUMINUM

Aim: To Study The Microstructure of The Given Specimen.

Apparatus:

- Cutoff machine
- Mounting press
- Disc polisher
- Belt polisher
- Sand (180, 220, 320, 400, 600)
- emery paper(1/10, 2/10, 3/10, 4/10, grade)
- Microscope
- Etchant
- Magnification
- Specimen

Sample:

Etchants:

Magnification:

Theory:

Aluminium is a chemical element in the boron group with symbol Al and atomic number 13. It is a silvery-white, soft, nonmagnetic, ductile metal. Aluminium is the third most abundant element (after oxygen and silicon), and the most abundant metal in the Earth's crust. It makes up about 8% by weight of the crust, though it is less common in the mantle below. Aluminium metal is so chemically reactive that native specimens are rare and limited to extreme reducing environments. Instead, it is found combined in over 270 different minerals. The chief ore of aluminum is bauxite.

Aluminium is remarkable for the metal's low density and for its ability to resist corrosion due to the phenomenon of passivation. Structural components made from aluminum and its alloys are vital to the aerospace industry and are important in other areas of transportation and structural materials. The most useful compounds of aluminum, at least on a weight basis, are the oxides and sulfates.

Applications:

- Transportation (automobiles, aircraft, trucks, railway cars, marine vessels, bicycles, etc.) as sheet, tube, castings, etc.
- Packaging (cans, foil, frame of etc.)
- Construction (windows, doors, siding, building wire, etc.).
- A wide range of household items, from cooking utensils to baseball bats, watches.
- Street lighting poles, sailing ship masts, walking poles, etc.
- Electrical transmission lines for power distribution
- Super purity aluminum (SPA, 99.980% to 99.999% Al), used in electronics and CDs, and also in wires/cabling.
- Heat sinks for electronic appliances such as transistors and CPUs.
- Powdered aluminum is used in paint, and in pyrotechnics such as solid rocket fuels and thermite.
- Aluminium reacts with hydrochloric acid or with sodium hydroxide to produce hydrogen gas.

➢Aluminium is used to make food containers, because of its resistance to corrosion.
➢Aluminium with magnesium [alloy] is used to make body of aircraft.
➢Aluminium with other metals, used to make railway tracks.
➢Aluminium is used to make cooking utensils, because it is resistant to corrosion, and light-weight.

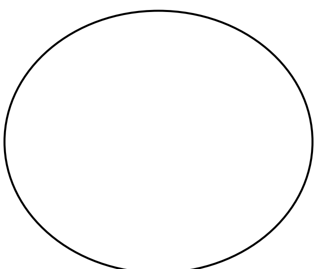
Procedure:

1. Cut the specimen into required shape by using cutoff machine.
2. Mount the specimen in mounting press by adding 2 spoons of Bakelite powder.
3. Polish the specimen on belt polisher to make the surface even.
4. Then polish the specimen again by using sand and emery papers.
5. After polishing the specimen is again polish on the belt polisher by adding 2-3 drops of water.
6. Observe the micro-structure of specimen under microscope and note it down.
7. Apply approximate etchant to the specimen.
8. Observe the micro scope structure and note it down.

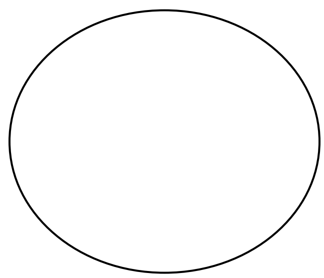
Precautions:

i. Wear tight overalls and shoe for safety.
ii. Be wear about mounting press and the time of etching process.
iii. Don't touch the specimen when it is so hot and use tongs for hold it.
vi. Be away at the time of belt polishing and disc polishing.

Result:



Before Etching



After Etching

Viva Questions:

1. What are the important properties of Non-Ferrous metals and alloys?
2. List out some important Non-Ferrous metals?
3. What is melting point temperature of Aluminium?
4. What is the crystal structure of Aluminium?
5. FCC metals are usually ductile and have high strain hardening tendency. Explain why?

1.2 MICROSTRUCTURE OF COPPER

Aim: To Study The Microstructure of The Given Specimen.

Apparatus:

- Cutoff machine
- Mounting press
- Bakelite
- Belt polisher, Disc polisher
- Sand (180, 220, 320, 400, 600), Emery paper(1/10, 2/10, 3/10, 4/10, grade)
- Microscope
- Etchant
- Specimen

Sample:

Etchants:

Magnification:

Theory:

Copper is a chemical element with symbol Cu (from Latin: cuprum) and atomic number 29. It is a ductile metal with very high thermal and electrical conductivity. Pure copper is soft and malleable; a freshly exposed surface has a reddish-orange color. It is used as a conductor of heat and electricity, a building material, and a constituent of various metal alloys.

The metal and its alloys have been used for thousands of years. In the Roman era, copper was principally mined on Cyprus. Architectural structures built with copper corrode to give green verdigris (or patina). Art prominently features copper, both by itself and as part of pigments.

Applications:

Wire and cable, Electronics and related devices, Electric motors windings, Architecture, Antimicrobial applications, Copper is commonly used in jewelry, and folklore says that copper bracelets relieve arthritis symptoms. Copper is used as the printing plate in etching, engraving and other forms of intaglio (printmaking) printmaking. Copper oxide and carbonate is used in glassmaking and in ceramic glazes to impart green and brown colors.

Procedure:

1. Cut the specimen into required shape by using cutoff machine.
2. Mount the specimen in mounting press by adding 2 spoons of Bakelite powder.
3. Polish the specimen on belt polisher to make the surface even.
4. Then polish the specimen again by using sand and emery papers.
5. After polishing the specimen is again polish on the belt polisher by adding 2-3 drops of water.
6. Observe the micro-structure of specimen under microscope and note it down.
7. Apply approximate etchant to the specimen.

8. Observe the micro scope structure and note it down.

Precautions:

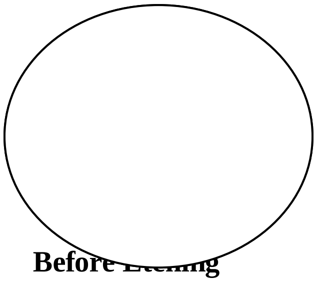
i. Wear tight overalls and shoe for safety.

ii. Be wear about mounting press and the time of etching process.

iii. Don’t touch the specimen when it is so hot and use tongs for hold it.

vi. Be away at the time of belt polishing and disc polishing.

Result:



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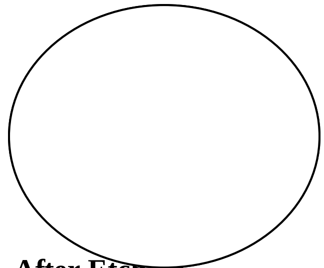


After Etching

Viva Questions:

1. What are the important properties of copper?
2. What is the crystal structure of copper?
3. What are different types of copper alloys?
4. List out etchants that are used for copper.

2. PREPARATION AND STUDY OF THE MICRO STRUCTURE OF CARBON STEELS

2.1 MICROSTRUCTURE OF LOW CARBON STEEL

Aim: To Study The Microstructure of The Given Specimen.

Apparatus:

- Cutoff machine
- Mounting press
- Disc polisher
- Belt polisher
- Sand (180, 220, 320, 400, 600)
- Emery paper(1/10, 2/10, 3/10, 4/10, grade)
- Microscope
- Etchant
- Magnification
- Specimen

Sample:

Etchants:

Magnification:

Theory:

Carbon steel is steel in which the main interstitial alloying constituent is carbon in the range of 0.12–2.0%.

Low-carbon steel contains approximately 0.05–0.15% carbon making it malleable and ductile. Mild steel has a relatively low tensile strength, but it is cheap and easy to form; surface hardness can be increased through carburizing.

It is often used when large quantities of steel are needed, for example as structural steel. The density of mild steel is approximately 7.85 g/cm^3 (7850 kg/m^3 or 0.284 lb/in^3) and the Young's modulus is 210 GPa (30,000,000 psi).

Applications:

Low carbon steels offer many applications. Truck bed floors, automobile doors, domestic appliances. The automobile industry employs a considerable amount of this steel for making parts that require simple bending or moderate forming. Truck cab backs, tailgate access covers, floor pans, and bed floors are often made of this steel.

Procedure:

1. Cut the specimen into required shape by using cutoff machine.
2. Mount the specimen in mounting press by adding 2 spoons of Bakelite powder.
3. Polish the specimen on belt polisher to make the surface even.
4. Then polish the specimen again by using sand and emery papers.
5. After polishing the specimen is again polish on the belt polisher by adding 2-3 drops of water.
6. Observe the micro-structure of specimen under microscope and note it down.
7. Apply approximate etchant to the specimen.

8. Observe the micro scope structure and note it down.

Precautions:

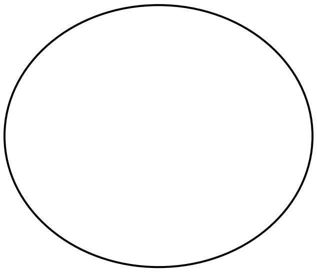
i. Wear tight overalls and shoe for safety.

ii. Be wear about mounting press and the time of etching process.

iii. Don't touch the specimen when it is so hot and use tongs for hold it.

vi. Be away at the time of belt polishing and disc polishing.

Result:



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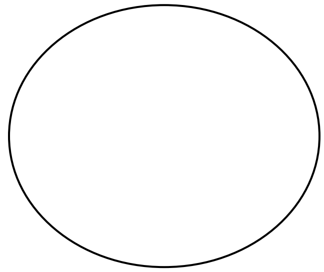


After Etching

Viva Questions:

1. What is the percentage of Carbon in low Carbon steels?
2. What are the important mechanical properties of low Carbon steels?
3. What are applications of low carbon steels?
4. What are the different phases present in low carbon steel?
5. What is the maximum solubility of carbon in ferrite?
6. What is the maximum solubility of carbon in Austenite?

2.2 MICROSTRUCTURE OF MEDIUM CARBON STEEL

Aim: To Study The Microstructure of The Given Specimen.

Apparatus:

- Cutoff machine
- Mounting press
- Disc polisher
- Belt polisher
- Sand (180, 220, 320, 400, 600)
- Emery paper(1/10, 2/10, 3/10, 4/10, grade)
- Microscope
- Etchant
- Magnification
- Specimen

Sample:

Etchants:

Magnification:

Theory:

Medium carbon steel is carbon steel that contains between 0.30 and 0.60 percent carbon. It also has manganese content between 0.6 and 1.65 percent. This type of steel provides a good balance between strength and ductility, and it is common in many types of steel parts.

Additional carbon makes the steel harder but also more brittle, so manufacturing carbon steel requires a balance between hardness and ductility. The most common uses of medium carbon steel are in heavy machinery, such as axles, crankshafts, couplings and gears. Steel with carbon content between 0.4 and 0.6 percent is commonly used in the railroad industry to make axles, rails and wheels.

Applications:

M.C.S used in manufacturing and making of Gears, Pins, Rams, Shafts, Axles, Rolls, Sockets, Spindles, Bolts, Ratchets, Light gears, Guide rods, Hydraulic clamps, Studs, Connecting rods, Crankshafts, Torsion bars etc.

Procedure:

1. Cut the specimen into required shape by using cutoff machine.
2. Mount the specimen in mounting press by adding 2 spoons of Bakelite powder.
3. Polish the specimen on belt polisher to make the surface even.
4. Then polish the specimen again by using sand and emery papers.
5. After polishing the specimen is again polish on the belt polisher by adding 2-3 drops of water.
6. Observe the micro-structure of specimen under microscope and note it down.
7. Apply approximate etchant to the specimen.
8. Observe the micro scope structure and note it down.

Precautions:

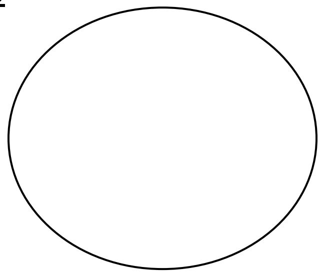
i. Wear tight overalls and shoe for safety.

ii. Be wear about mounting press and the time of etching process.

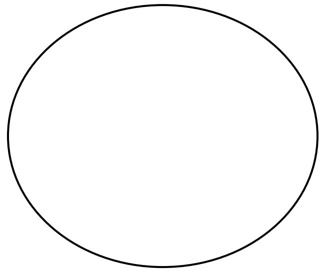
iii. Don’t touch the specimen when it is so hot and use tongs for hold it.

vi. Be away at the time of belt polishing and disc polishing.

Result:



Before Etching



After Etching

Viva Questions:

1. What is the percentage of Carbon in medium Carbon steels?
2. What are the important mechanical properties of medium Carbon steels?
3. What are applications of medium carbon steels?
4. What are the different phases present in medium carbon steel?
5. What are the properties & applications of Eutectoid steel?
6. What are the properties & applications of hyper eutectoid steel?
7. What are the properties & applications of hypo eutectoid steel?

2.3 MICROSTRUCTURE OF HIGH CARBON STEEL

Aim: To Study The Microstructure of The Given Specimen.

Apparatus:

- Cutoff machine
- Mounting press
- Disc polisher
- Belt polisher
- Sand (180, 220, 320, 400, 600)
- emery paper(1/10, 2/10, 3/10, 4/10, grade)
- Microscope
- Etchant
- Magnification
- Specimen

Sample:

Etchants:

Magnification:

Theory:

High carbon steel will be any type of steel that contains over 0.8% carbon but less than 2.11% carbon in its composition. The average level of carbon found in this metal usually falls right around the 1.5% mark. High carbon steel has a reputation for being especially hard, but the extra carbon also makes it more brittle than other types of steel. This type of steel is the most likely to fracture when misused.

Applications:

Depending on the specific needs of the person using it, high carbon steel can have many advantages over other options. This type of steel is excellent for making cutting tools or masonry nails. The hardness levels and metal wear resistance of high carbon steel is also rated very highly. High carbon steel is also preferred by many manufacturers who create metal cutting tools or press machinery that must bend and form metal.

High carbon steel remains popular for a wide variety of uses. This type of steel is preferred in the manufacturing of many tools such as drill bits, knives, masonry nails, saws, metal cutting tools, and woodcutting tools.

Procedure:

1. Cut the specimen into required shape by using cutoff machine.
2. Mount the specimen in mounting press by adding 2 spoons of Bakelite powder.
3. Polish the specimen on belt polisher to make the surface even.
4. Then polish the specimen again by using sand and emery papers.
5. After polishing the specimen is again polish on the belt polisher by adding 2-3 drops of water.

6. Observe the micro-structure of specimen under microscope and note it down.

7. Apply approximate etchant to the specimen.

8. Observe the micro scope structure and note it down.

Precautions:

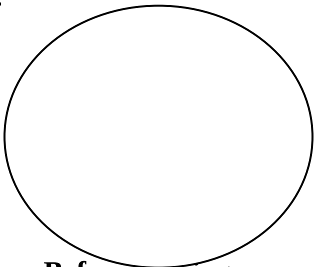
i. Wear tight overalls and shoe for safety.

ii. Be wear about mounting press and the time of etching process.

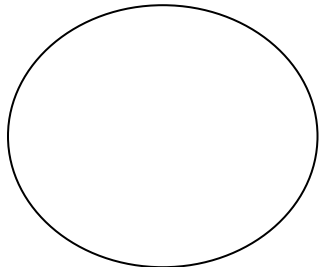
iii. Don’t touch the specimen when it is so hot and use tongs for hold it.

vi. Be away at the time of belt polishing and disc polishing.

Result:



Before Etching



After Etching

Viva Questions:

1. What is the percentage of Carbon in high Carbon steels?
2. What are the important mechanical properties of high Carbon steels?
3. What are applications of high carbon steels?
4. What are the different phases present in high carbon steel?
5. What is peritectic reaction?
6. What is peritectoid reaction?
7. What is the percentage of carbon in cementite?
8. What are the different phases in Fe- Fe_3c equilibrium diagram?

2.4 MICROSTRUCTURE OF HIGH SPEED STEEL

Aim: To Study The Microstructure of The Given Specimen.

Apparatus:

- Cutoff machine
- Mounting press
- Disc polisher
- Belt polisher
- Sand (180, 220, 320, 400, 600)
- emery paper(1/10, 2/10, 3/10, 4/10, grade)
- Microscope
- Etchant
- Magnification
- Specimen

Sample:

Etchants:

Magnification:

Theory:

It is often used in power-saw blades and drill bits. It is superior to the older high-carbon steel tools used extensively through the 1940s in that it can withstand higher temperatures without losing its temper (hardness). This property allows HSS to cut faster than high carbon steel, hence the name *high-speed steel*. At room temperature, in their generally recommended heat treatment, HSS grades generally display high hardness (above HRC60) and abrasion resistance (generally linked to tungsten and vanadium content often used in HSS) compared with common carbon and tool steels.

Applications:

The main use of high-speed steels continues to be in the manufacture of various cutting tools: drills, taps, milling cutters, tool bits, gear cutters, saw blades, planer and jointer blades, router bits, etc., although usage for punches and dies is increasing.

High speed steels also found a market in fine hand tools where their relatively good toughness at high hardness, coupled with high abrasion resistance, made them suitable for low speed applications requiring a durable keen (sharp) edge, such as files, chisels, hand plane blades, and high quality kitchen, pocket knives, and swords.

High speed steel tools are the most popular for use in woodturning, as the speed of movement of the work past the edge is relatively high for handheld tools, and HSS holds its edge far longer than high carbon steel tools can.

Procedure:

1. Cut the specimen into required shape by using cutoff machine.
2. Mount the specimen in mounting press by adding 2 spoons of Bakelite powder.
3. Polish the specimen on belt polisher to make the surface even.
4. Then polish the specimen again by using sand and emery papers.
5. After polishing the specimen is again polish on the belt polisher by adding 2-3 drops of water.
6. Observe the micro-structure of specimen under microscope and note it down.
7. Apply approximate etchant to the specimen.
8. Observe the micro scope structure and note it down.

Precautions:

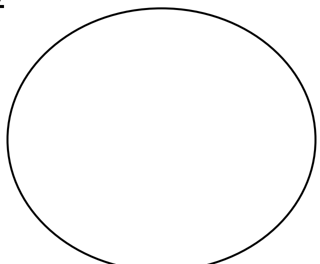
i. Wear tight overalls and shoe for safety.

ii. Be wear about mounting press and the time of etching process.

iii. Don’t touch the specimen when it is so hot and use tongs for hold it.

vi. Be away at the time of belt polishing and disc polishing.

Result:



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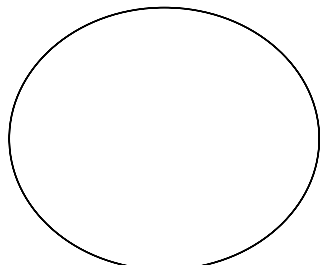


After Etching

Viva Questions:

1. Why alloying elements are added to steels?
2. How negative effects of sulphur in steels will be neutralized?
3. What is the composition of HSS?
4. What makes High Carbon high chromium steel suitable for making dies?
5. How do you classify alloying elements?
6. What are the effects of alloying elements?
7. Name some important alloying elements which can be added to alloy steels.

3. STUDY OF MICRO STRUCTURES OF CAST IRON

3.1 MICROSTRUCTURE OF WROUGHT IRON

Aim: To study the microstructure of the given specimen.

Apparatus:

- Cutoff machine
- Mounting press
- Disc polisher
- Belt polisher
- Sand (180, 220, 320, 400, 600)
- Emery paper(1/10, 2/10, 3/10, 4/10, grade)
- Microscope
- Etchant
- Magnification
- Specimen

Sample:

Etchants:

Magnification:

Theory:

Wrought iron is an iron alloy with a very low carbon (less than 0.08%) and has fibrous inclusions known as slag up to 2% by weight. Wrought iron is tough, malleable, ductile, corrosion-resistant and easily welded.

Applications:

It is used to make home decor items such as baker's racks, wine racks, pot racks, etageres, table bases, desks, gates, beds, candle holders, curtain rods, bars and bar stools. The vast majority of wrought iron available today is from reclaimed materials. Old bridges and anchor chains dredged from harbors are major sources. The greater corrosion resistance of wrought iron is due to the siliceous impurities (naturally occurring in iron ore), namely ferric silicate. Because of limited availability, the use of wrought iron today is usually reserved for special applications, such as fine carpentry tools and historical restoration for objects of great importance.

Procedure:

1. Cut the specimen into required shape by using cutoff machine.
2. Mount the specimen in mounting press by adding 2 spoons of Bakelite powder.
3. Polish the specimen on belt polisher to make the surface even.
4. Then polish the specimen again by using sand and emery papers.
5. After polishing the specimen is again polish on the belt polisher by adding 2-3 drops of water.
6. Observe the micro-structure of specimen under microscope and note it down.
7. Apply approximate etchant to the specimen.
8. Observe the micro scope structure and note it down.

Precautions:

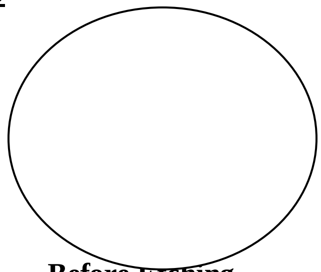
i. Wear tight overalls and shoe for safety.

ii. Be wear about mounting press and the time of etching process.

iii. Don't touch the specimen when it is so hot and use tongs for hold it.

vi. Be away at the time of belt polishing and disc polishing.

Result:



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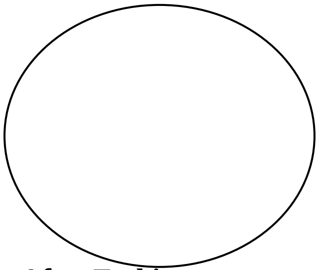


After Etching

Viva Questions:

1. How Cast iron and steel are distinguished with respect to carbon percentage?
2. What are the different types of cast irons?
3. What are the important properties of Wrought irons?
4. What are the applications of Wrought irons?
5. What are the phases present in Wrought iron?

3.2 MICROSTRUCTURE OF GREY CAST IRON

Aim: To Study The Microstructure of The Given Specimen.

Apparatus:

- Cutoff machine
- Mounting press
- Disc polisher
- Belt polisher
- Sand (180, 220, 320, 400, 600)
- emery paper(1/10, 2/10, 3/10, 4/10, grade)
- Microscope
- Etchant
- Magnification
- Specimen

Sample:

Solution:

Etchants:

Magnification:

Theory:

Gray iron, or grey cast iron, is a type of cast iron that has a graphitic microstructure. It is named after the gray color of the fracture it forms, which is due to the presence of graphite. It is the most common cast iron and the most widely used cast material based on weight.

It is used for housings where the stiffness of the component is more important than its tensile strength, such as internal combustion engine cylinder blocks, pump housings, valve bodies, electrical boxes, and decorative castings. Grey cast iron's high thermal conductivity and specific heat capacity are often exploited to make cast iron cookware and disc brake rotors.

Applications:

Gray iron is a common engineering alloy because of its relatively low cost and good machinability, which results from the graphite lubricating the cut and breaking up the chips. It also has good galling and wear resistance because the graphite flakes self lubricate. The graphite also gives gray iron an excellent damping capacity because it absorbs the energy

Procedure:

1. Cut the specimen into required shape by using cutoff machine.
2. Mount the specimen in mounting press by adding 2 spoons of Bakelite powder.
3. Polish the specimen on belt polisher to make the surface even.
4. Then polish the specimen again by using sand and emery papers.
5. After polishing the specimen is again polish on the belt polisher by adding 2-3 drops of water.
6. Observe the micro-structure of specimen under microscope and note it down.

7. Apply approximate etchant to the specimen.

8. Observe the micro scope structure and note it down.

Precautions:

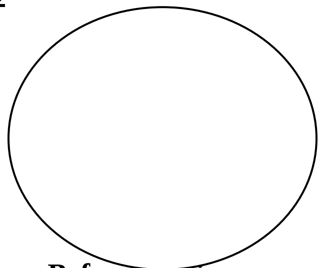
i. Wear tight overalls and shoe for safety.

ii. Be wear about mounting press and the time of etching process.

iii. Don’t touch the specimen when it is so hot and use tongs for hold it.

vi. Be away at the time of belt polishing and disc polishing.

Result:



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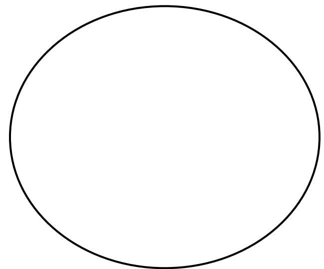


After Etching

Viva Questions:

1. Why Gray cast iron has got that name?
2. Why Gray cast iron is so brittle?
3. What are the important properties of Gray cast irons?
4. What are the applications of Gray cast irons?
5. What are the phases present in Gray cast iron?

3.3 MICROSTRUCTURE OF MALLEABLE CAST IRON

Aim: To Study The Microstructure of The Given Specimen.

Apparatus:

- Cutoff machine
- Mounting press
- Disc polisher
- Belt polisher
- Sand (180, 220, 320, 400, 600)
- emery paper(1/10, 2/10, 3/10, 4/10, grade)
- Microscope
- Etchant
- Magnification
- Specimen

Sample:

Solution:

Etchants:

Magnification:

Theory:

Malleable iron is cast as white iron, the structure being Meta stable carbide in a pearlitic matrix. Through an annealing heat treatment, the brittle structure as first cast is transformed into the malleable form. Carbon agglomerates into small roughly spherical aggregates of graphite leaving a matrix of ferrite or pearlite according to the exact heat treatment used. Three basic types of malleable iron are recognized within the casting industry: blackheart malleable iron, white heart malleable iron and pearlitic malleable iron.

Applications:

It is often used for small castings requiring good tensile strength and the ability to flex without breaking (ductility). Uses include electrical fittings, hand tools, pipe fittings, washers, brackets, fence fittings, power line hardware, farm equipment, mining hardware, and machine parts.

Procedure:

1. Cut the specimen into required shape by using cutoff machine.
2. Mount the specimen in mounting press by adding 2 spoons of Bakelite powder.
3. Polish the specimen on belt polisher to make the surface even.
4. Then polish the specimen again by using sand and emery papers.
5. After polishing the specimen is again polish on the belt polisher by adding 2-3 drops of water.
6. Observe the micro-structure of specimen under microscope and note it down.
7. Apply approximate etchant to the specimen.
8. Observe the micro scope structure and note it down.

Precautions:

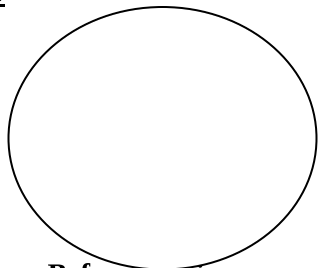
i. Wear tight overalls and shoe for safety.

ii. Be wear about mounting press and the time of etching process.

iii. Don't touch the specimen when it is so hot and use tongs for hold it.

vi. Be away at the time of belt polishing and disc polishing.

Result:



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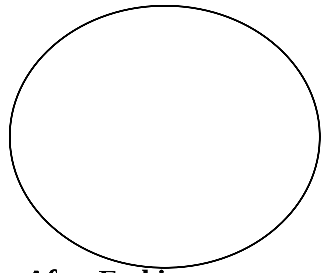


After Etching

Viva Questions:

1. What is the difference between White cast iron and Grey cast iron?
2. Why White cast iron has limited applications?
3. Why White cast iron has got that name?
4. What are the applications of White cast irons?
5. What are the phases present in White cast iron?

4. STUDY OF THE MICRO STRUCTURES OF NON FERROUS ALLOYS

4.1 MICROSTRUCTURE OF BRASS

Aim: To study the microstructure of the given specimen.

Apparatus:

- Cutoff machine
- Mounting press
- Disc polisher
- Belt polisher
- Sand (180, 220, 320, 400, 600)
- emery paper(1/10, 2/10, 3/10, 4/10, grade)
- Microscope
- Etchant
- Magnification
- Specimen

Sample:

Etchants:

Magnification:

Theory:

Brass is an alloy made of copper and zinc; the proportions of zinc and copper can be varied to create a range of brasses with varying properties. It is a substitution alloy: atoms of the two constituents may replace each other within the same crystal structure.

By comparison, bronze is principally an alloy of copper and tin. However, the common term "bronze" may also include arsenic, phosphorus, aluminum, manganese, and silicon. The term is also applied to a variety of brasses, and the distinction is largely historical. Modern practice in museums and archaeology increasingly avoids both terms for historical objects in favor of the all-embracing "copper alloy".

Applications:

Brass is used for decoration for its bright gold-like appearance; for applications where low friction is required such as locks, gears, bearings, doorknobs, ammunition casings and valves; for plumbing and electrical applications; and extensively in brass musical instruments such as horns and bells where a combination of high workability (historically with hand tools) and durability is desired. It is also used in zippers. Brass is often used in situations in which it is important that sparks not be struck, such as in fittings and tools around explosive gases.

Procedure:

1. Cut the specimen into required shape by using cutoff machine.
2. Mount the specimen in mounting press by adding 2 spoons of Bakelite powder.
3. Polish the specimen on belt polisher to make the surface even.
4. Then polish the specimen again by using sand and emery papers.
5. After polishing the specimen is again polish on the belt polisher by adding 2-3 drops of water.

6. Observe the micro-structure of specimen under microscope and note it down.

7. Apply approximate etchant to the specimen.

8. Observe the micro scope structure and note it down.

Precautions:

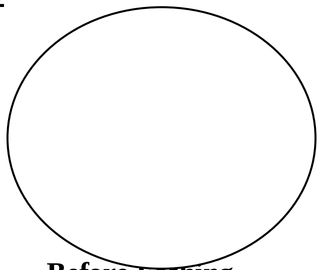
i. Wear tight overalls and shoe for safety.

ii. Be wear about mounting press and the time of etching process.

iii. Don’t touch the specimen when it is so hot and use tongs for hold it.

vi. Be away at the time of belt polishing and disc polishing.

Result:



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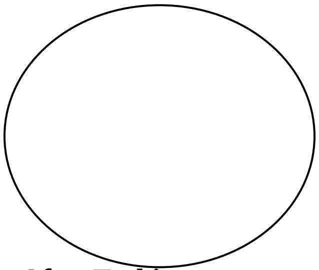


After Etching

Viva Questions:

1. What are the major alloying elements of Brass?
2. What are the applications of brass?
3. What are important properties of brass?
4. What are the different phases present in brass?
5. What is the crystal structure of Brass?
6. What is the composition of Cartridge Brass?

4.2 MICROSTRUCTURE OF PHOSPHOR BRONZE

Aim: To study the microstructure of the given specimen

Apparatus:

- Cutoff machine
- Mounting press
- Disc polisher
- Belt polisher
- Sand (180, 220, 320, 400, 600)
- Emery paper(1/10, 2/10, 3/10, 4/10, grade)
- Microscope
- Etchant
- Magnification
- Specimen

Sample:

Etchants:

Magnification:

Theory:

Phosphor bronze is an alloy of copper with 3.5 to 10% of tin and a significant phosphorus content of up to 1%. The phosphorus is added as deoxidizing agent during melting. These alloys are notable for their toughness, strength, low coefficient of friction, and fine grain. The phosphorus also improves the fluidity of the molten metal and thereby improves the cast ability, and improves mechanical properties by cleaning up the grain boundaries.

Procedure:

1. Cut the specimen into required shape by using cutoff machine.
2. Mount the specimen in mounting press by adding 2 spoons of Bakelite powder.
3. Polish the specimen on belt polisher to make the surface even.
4. Then polish the specimen again by using sand and emery papers.
5. After polishing the specimen is again polish on the belt polisher by adding 2-3 drops of water.
6. Observe the micro-structure of specimen under microscope and note it down.
7. Apply approximate etchant to the specimen.
8. Observe the micro scope structure and note it down.

Precautions:

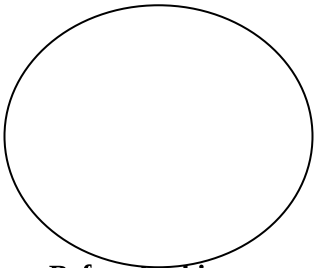
i. Wear tight overalls and shoe for safety.

ii. Be wear about mounting press and the time of etching process.

iii. Don’t touch the specimen when it is so hot and use tongs for hold it.

vi. Be away at the time of belt polishing and disc polishing.

Result:



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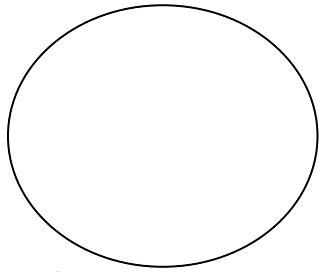


After Etching

Viva Questions:

1. What are the important properties of phosphor bronze?
2. What are the major alloying elements in Phosphor bronze?
3. What is the crystal structure of Phosphor bronze?
4. Name some applications of phosphor bronze.
5. What are the important alloys of Copper & Zinc?
6. What is composition of Muntz metal?
7. What is a Bronze?
8. What is composition of Gun metal?
9. What are the important applications of Gun metal?
10. What is a Bell metal?
11. What is melting point of Tin?
12. What is use of Babbit metals?
13. What is the microstructure of Tin based Babbit?

5. STUDY OF THE MICRO STRUCTURES OF HEAT TREATED STEELS

Aim: To Study The Microstructure of The Given Specimen.

Apparatus:

- Cutoff machine
- Mounting press
- Disc polisher
- Belt polisher
- Sand (180, 220, 320, 400, 600)
- Emery paper(1/10, 2/10, 3/10, 4/10, grade)
- Microscope
- Etchant
- Magnification
- Specimen

Sample:

Etchants:

Magnification:

Theory:

Heat treatment is a process of heating the metal below its melting point and holding it at that temperature for sufficient time and cooling at the desired rate to obtain the required Properties. The various heat treatment processes are annealing, normalizing, tempering, hardening, mar tempering, and austempering.

The final mechanical properties depend on the microstructure formed due to various heat treatment processes (due to various cooling rates). An annealed specimen was cooled in the furnace or any good heat insulating material; it obtains the coarse grain structure of ferrite and pearlite in case of hypo eutectoid steels and coarse grain structure of ferrite and cementite in case of hyper eutectoid steel. It possesses high ductility.

A normalized specimen was cooled in the presence of air so cooling rate increases, it obtains the fine grain structure of ferrite and pearlite in case of hypo eutectoid steels and fine grain structure of ferrite and cementite in case of hyper eutectoid steel. It possesses high ductility. A hardened specimen was quenched in oil (in case of alloy steels) or in water (in case of carbon steel).due to faster cooling rate martensite (hard steel) structure was formed.

Procedure:

1. Cut the specimen into required shape by using cutoff machine.
2. Mount the specimen in mounting press by adding 2 spoons of Bakelite powder.
3. Polish the specimen on belt polisher to make the surface even.
4. Then polish the specimen again by using sand and emery papers.
5. After polishing the specimen is again polish on the belt polisher by adding 2-3 drops of water.
6. Observe the micro-structure of specimen under microscope and note it down.
7. Apply approximate etchant to the specimen.
8. Observe the micro scope structure and note it down.

Precautions:

i. Wear tight overalls and shoe for safety.

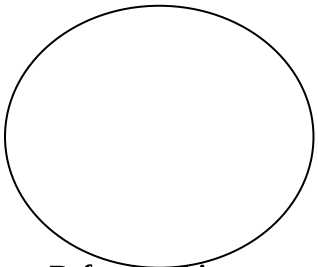
ii. Be wear about mounting press and the time of etching process.

iii. Don’t touch the specimen when it is so hot and use tongs for hold it.

vi. Be away at the time of belt polishing and disc polishing.

v. Polishing should be slow, smooth and flat. Uniform pressure is applied throughout the polishing.

<u>Result:</u>



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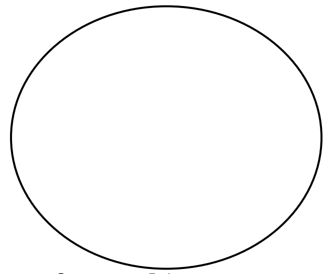


After Etching

<u>Viva Questions:</u>

1. What is Curie temperature?
2. What is heat treatment?
3. What are various types of heat treatments?
4. What are the needs of performing annealing and normalizing on steels?
5. Name some components which are produced by case hardening process. Where do we apply this?
6. Why do the hardness of steel increase after quench hardening?
7. What are the melting points of steel and CI? Which factor influence their melting point?

6. HARDENABILITY OF STEELS BY JOMINY END QUENCH TEST

Aim: to estimate the harden ability and hardness variation upon quenching of the given sample

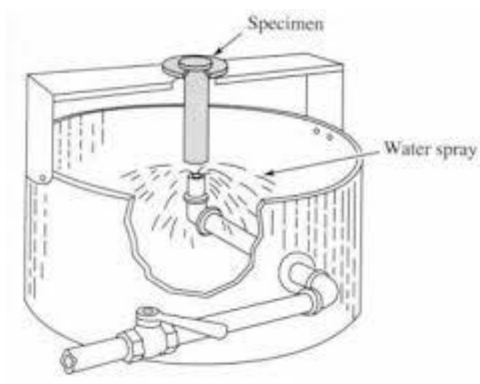
Apparatus:

- Muffle furnace,
- Jominy nature,
- Jominy quench,
- Harden ability test apparatus and
- Rockwell hardness tester

Indenter: Diamond

Procedure:

1. Out the given steel bar, the standard sample is to be prepared as per the dimensions shone in figure.
2. The austeniting temperature and time for the given steel is to be determined depending on its chemical composition.
3. The furnace is setup on the required temperature and sample is kept in the furnace
4. The sample is to be kept in furnace of a predetermined time (based on the chemical composition of steel) then it is taken out of the furnace and is kept fixed in the test apparatus.
5. The water flow is directed into the bottom end of the sample. The water flow is adjusted such that it obtains shape of umbrella over bottom of the sample.
6. The quenching is to be continued for approximately 15 min.
7. A flat near about 0.4mm deep is grounded on the specimen.
8. The hardness of the sample can be determined at the various points sterling from the quenched end and the results are tabulated.
9. The graph is plotted with hardness values verses distance from quenched end from the results and graph plotted the depth of the hardness of the given sample can be determined.



Jominy End Quench Test Setup

Precautions:

i. Wear tight overalls and shoe for safety.

ii. Don’t touch the specimen when it is so hot and use tongs for hold it.

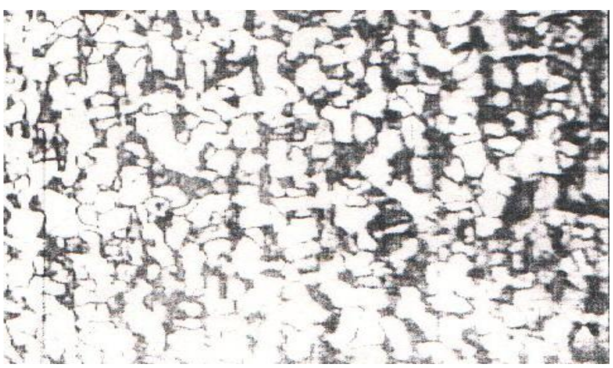
Result:

Before Etching **After Etching**

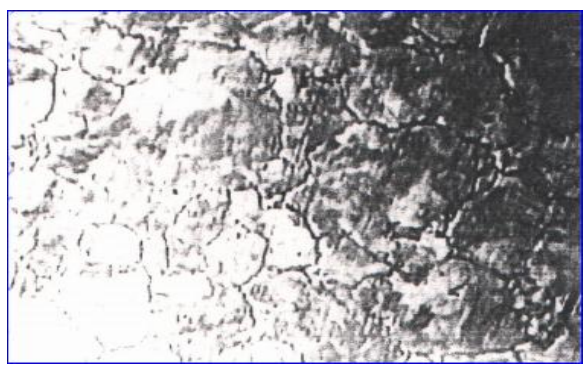
Viva Questions:

1. What is the difference between Hardness & Hardenability?
2. What is severity of quench?
3. What is critical diameter?
4. What is the ideal critical diameter?
5. What is the quenching medium employed in the test?
6. What are the important precautions to be observed in the test?
7. Why a flat is to be ground on the test specimen?
8. What is the equipment used to measure the hardness of specimen in the experiment?

MATERIAL MICRO STRUCTURE



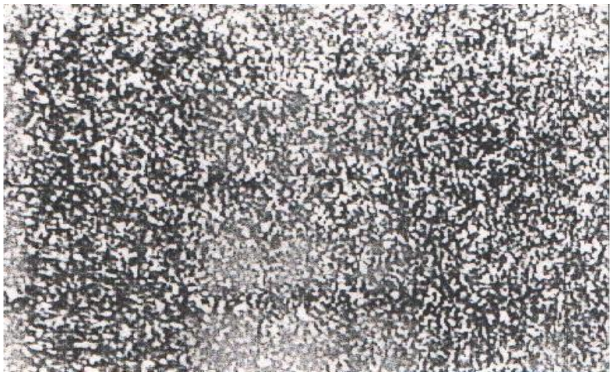
LOW CORBON STEEL

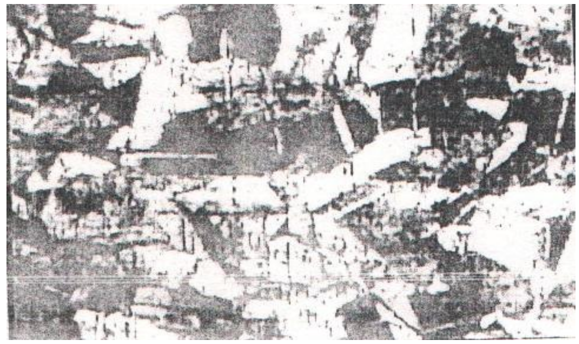


MEDIUM CARBON STEEL

HIGH SPEED STEEL

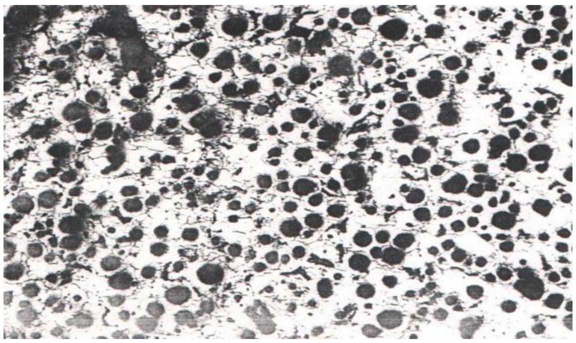
HARDEND STEEL

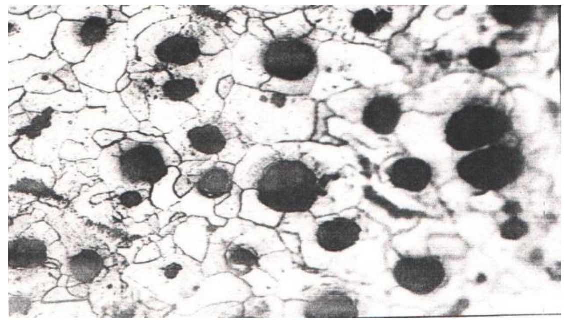




HIGH CORBON AND HIGH CROMIUM STEEL

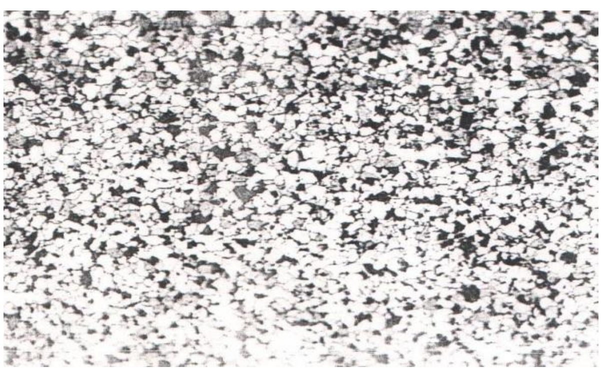
AUSTENETIC STAIN LESS STEEL





SPHEROIDAL GARY CAST IRON 50×

SPHEROIDAL GARY CAST IRON 200×



PERALITE AND FERROITE 100×

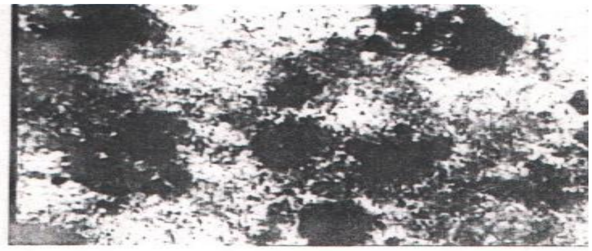
PERALITE AND FERROITE 500×

As Polished: Magnification: 100X

As Etched: Magnification: 100X

GRAY CAST IRON

As Polished: Magnification: 100X



As Etched: Magnification: 100X

MALLEABLE CAST IRON

Case: Magnification: 100X

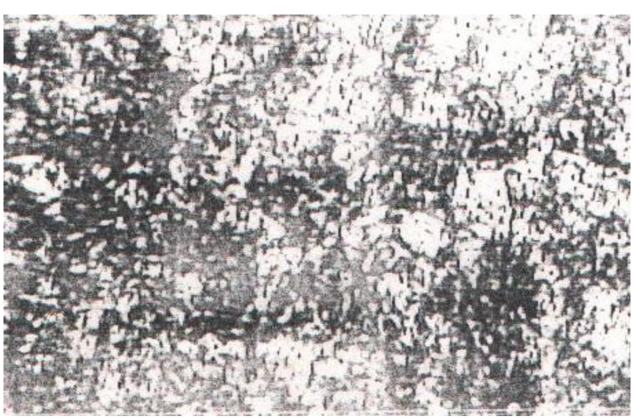
Core: Magnification: 100X

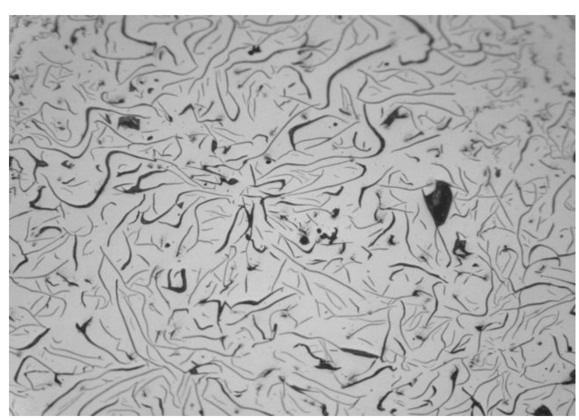
CARBURISED STEEL

As Polished: Magnification: 100X

As Etched: Magnification: 100X

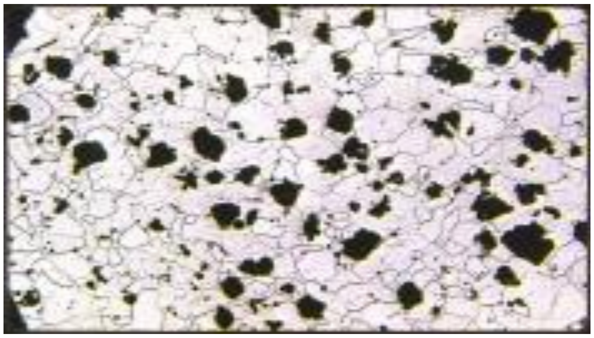
SPHEROIDAL STEEL

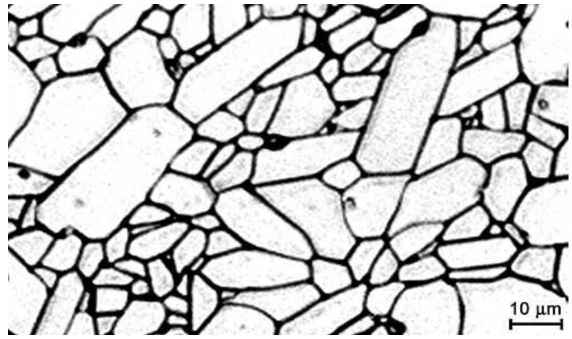




COPPER ALLOY

GRAY CAST IRON

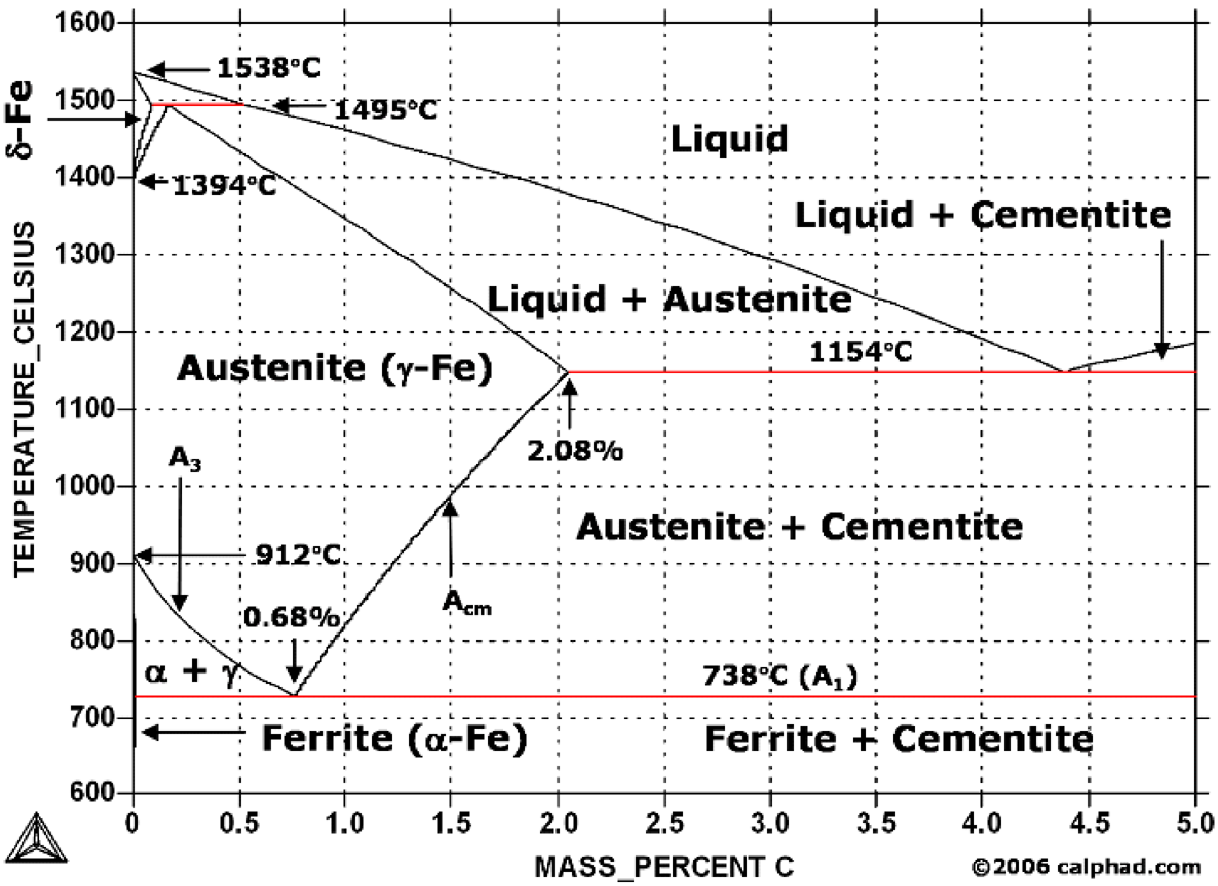




WHITE CAST IRON

ALUMINUM

Iron Carbon Phase Diagram



Part II
Mechanics of Solids

INTRODUCTION:

One of the principle concerns of an engineer is the analysis of materials used in structural applications. The term structure refers to any design that utilizes materials that support loads and keeps deformation within acceptable limits. Designing machines, structures, and vehicles, which are reliable as well as safe and cost effective, requires a proper knowledge of engineering as well as material selection.

Elementary mechanics of materials or strength of materials is the physical science that looks at the reaction of a body to movement and deformation due to mechanical, thermal, or other loads. The basis of virtually all mechanical design lies in how the material reacts to outside forces. Mechanics is the core of engineering analysis and is one of the oldest of the physical sciences. An in-depth understanding of material properties as well as how certain materials react to outside stimulus is paramount to an engineering education.

The basis of structural design is simply to design a component where the stress does not exceed the strength of the material, causing failure. These failures may include additional complexities such as stresses that act in more than one direction, where the state of stress may be biaxial or triaxial. Failure may also be due to components or materials containing flaws and / or cracks that will propagate failure. Still other failure mechanisms may involve stresses applied for extended periods of time causing Creep, or stresses that are repeatedly applied and removed leading to cyclical type failure.

Material failures may be time dependant such as creep or fatigue failure due to cyclical loading, or failures may be time independent where static loading causes rapid fracturing of the material. Time independent fracture or failure due to static loading may be brittle, where very little deformation in the material takes place, or ductile, where significant plastic deformation takes place before failure.

Elastic and Plastic deformations are quantified in terms of normal and shear strain in elementary strength of materials studies. The effects of strains in a component are due to deformations such as bending, twisting or stretching. Some members rely on deformations to function, such as a spring, but excessive amounts causing permanent changes are typically avoided. Materials capable of sustaining large amounts of plastic deformation are said to behave in a ductile manner, those that fracture without much plastic deformation are said to behave in a brittle manner.

In this laboratory, students will have the opportunity to apply loads to various materials under different equilibrium conditions. The student will perform tests on materials in tension, torsion, bending, and buckling. These conditions and/or constraints are designed to reinforce classroom theory by having the student perform required tests, analyze subsequent data, and present the results in a professionally prepared report.

The machines and equipment used to determine experimental data include universal testing machines,

torsion equipment, spring testing machine, compression testing machine, impact tester, hardness tester, etc.

Data will be collected using Dial indicators, extensometers, strain gages and strain indicator equipment, as well as load and strain readouts on the machinery and graphing capabilities to print relevant plots for analysis.

It is important to recognize that much of the testing performed in a typical mechanics lab involves a great deal of visual interpretation. Material behaviour can be clearly observed during testing and for any type of destructive testing, fracture zone and material behaviour observations are key elements to a clear and professional lab write up.

EXPERIMENT NO – 01: DIRECT TENSION TEST

AIM: To determine tensile test on a metal.

OBJECTIVE: To conduct a tensile test on a mild steel specimen and determine the following:

(i) Limit of proportionality

(ii) Elastic limit

(iii) Yield strength

(iv) Ultimate strength

(v) Young's modulus of elasticity

(vi) Percentage elongation

(vii) Percentage reduction in area.

APPARATUS:

(i) Universal Testing Machine (UTM)

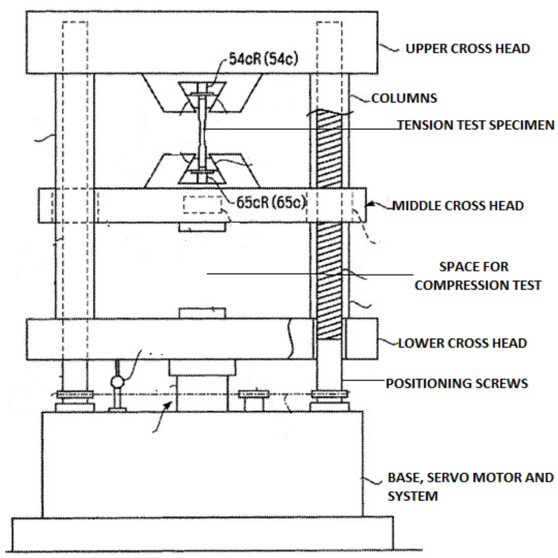
(ii) Mild steel specimens

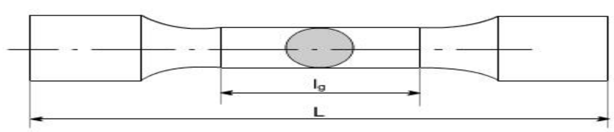
(iii) Graph paper

(iv) Scale

(v) Vernier Caliper

DIAGRAM:





[specimen with circular X-section]

M/C SPECIFICATIONS:
Capacity: 400 KN.
Model: UTK-40.
SR.No: 2013/1073.
Mfd. By: Krystal Equipments, Ichalkaranji, M.H, India.

THEORY:-The tensile test is most applied one, of all mechanical tests. In this test ends of test piece are fixed into grips connected to a straining device and to a load measuring device. If the applied load is small enough, the deformation of any solid body is entirely elastic. An elastically deformed solid will return to its original from as soon as load is removed. However, if the load is too large, the material can be deformed permanently. The initial part of the tension curve which is recoverable immediately after unloading is termed. As elastic and the rest of the curve which represents the manner in which solid undergoes plastic deformation is termed plastic. The stress below which the deformations essentially entirely elastic is known as the yield strength of material. In some material the onset of plastic deformation is denoted by a sudden drop in load indicating both an upper and a lower yield point. However, some materials do not exhibit a sharp yield point. During plastic deformation, at larger extensions strain hardening cannot compensate for the decrease in section and thus the load passes through a maximum and then begins to decrease. This stage the “ultimate strength”’ which is defined as the ratio of the load on the specimen to original
cross-sectional area, reaches a maximum value. Further loading will eventually cause ‘neck’ formation and rupture.

PROCEDURE:-

1) Measure the original length and diameter of the specimen. The length may either be length of gauge section which is marked on the specimen with a preset punch or the total length of the specimen.
2. Insert the specimen into grips of the test machine and attach strain-measuring device to it.
3. Begin the load application and record load versus elongation data.
4. Take readings more frequently as yield point is approached.
5. Measure elongation values with the help of dividers and a ruler.
6. Continue the test till Fracture occurs.
7. By joining the two broken halves of the specimen together, measure the final length and diameter of specimen.

DESCRIPTION OF UTM AND EXTENSOMETER:

LOADING UNIT:-

It consists of main hydraulic cylinder with robust base inside. The piston which moves up and down. The chain driven by electric motor which is fitted on left hand side. The screw column maintained in the base can

be rotated using above arrangement of chain. Each column passes through the main nut which is fitted in the lower cross head. The lower table connected to main piston through a ball & the ball seat is joined to ensure axial loading. There is a connection between lower table and upper head assembly that moves up and down with main piston. The measurement of this assembly is carried out by number of bearings which slides over the columns. The test specimen each fixed in the job is known as ‘Jack Job’. To fix up the pecimen tightly, the movement of jack job is achieved helically by handle.

CONTROL PANEL:-

It consists of oil tank having a hydraulic oil level sight glass for checking the oil level. The pump is displacement type piston pump having free plungers those ensure for continuation of high pressure. The pump is fixed to the tank from bottom. The suction & delivery valve are fitted to the pump near tan Electric motor driven the pump is mounted on four studs which is fitted on the right side of the tank. There is an arrangement for loosing or tightening of the valve. The four valves on control panel control the oil stroke in the hydraulic system. The loading system works as described below. The return valve is close, oil delivered by the pump through the flow control valves to the cylinder & the piston goes up. Pressure starts developing & either the specimen breaks or the load having maximum value is controlled with the base dynameters consisting in a cylinder in which the piston reciprocates. The switches have upper and lower push at the control panel for the downward & upward movement of the movable head. The on & off switch provided on the control panel & the pilot lamp shows the transmission of main supply.

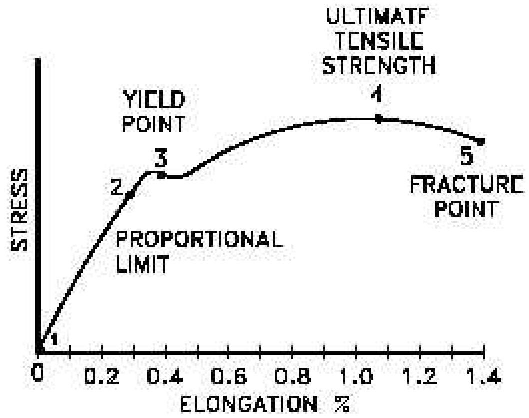
METHOD OF TESTING:-

Initial Adjustment: - before testing adjust the pendulum with respect to capacity of the test i.e. 8 Tones; 10 Tones; 20 Tones; 40 Tones etc. For ex: - A specimen of 6 tones capacity gives more accurate result of 10 Tones capacity range instead of 20 Tones capacity range. These ranges of capacity are adjusted on the dial with the help of range selector knob. The control weights of the pendulum are adjusted correctly. The ink should be inserted in pen holder of recording paper around the drum & the testing process is started depending upon the types of tests.

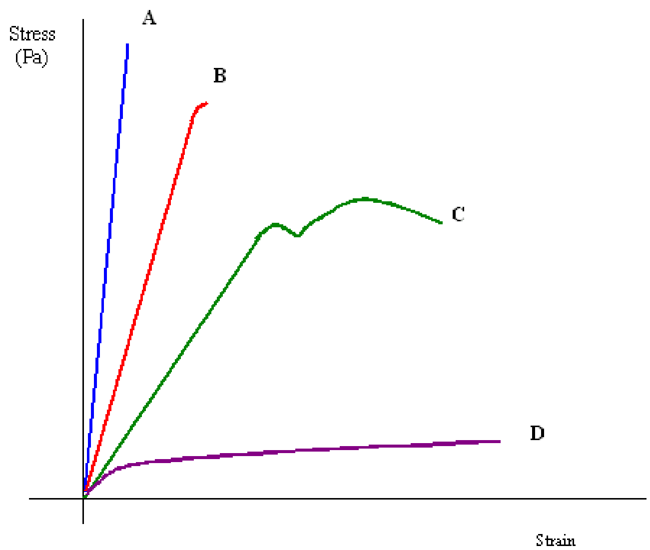
EXTENSOMETER:-

This instrument is an attachment to Universal / Tensile Testing Machines. This measures the elongation of a test place on load for the set gauge length. The least count of measurement being 0.01 mm, and maximum elongation measurement up to 3 mm. This elongation measurement helps in finding out the proof stress at the required percentage elongation.

WORKING OF THE INSTRUMENT:-The required gauge length(between 30to 120) is set by adjusting the upper knife edges (3) A scale (2) is provided for this purpose . Hold the specimen in the upper and lower jaws of Tensile / Universal Testing Machine. Position the extensometer on the specimen. Position upper clamp (4) to press upper knife edges on the specimen. The extensometer will be now fixed to the specimen by spring pressure. Set zero on both the dial gauges by zero adjust screws (7). Start loading the specimen and take the reading of load on the machine at required elongation or the elongation at required load. Force setter accuracies mean of both the dial gauge (8) readings should be taken as elongation. It is very important to note & follow the practice of removing the extensometer from the specimen before the specimen breaks otherwise the instrument will be totally damaged. As a safety, while testing the instrument may be kept hanging from a fixed support by a slightly loose thread.



A) Stress-strain graph of Mild Steel



A) Stress-strain graphs of different materials.

• Curve **A** shows a **brittle** material. This material is also strong because there is little strain for a high stress. The fracture of a brittle material is sudden and catastrophic, with little or no plastic deformation. Brittle materials crack under tension and the stress increases around the cracks. Cracks propagate less under

compression.

• Curve **B** is a **strong** material which is not ductile. Steel wires stretch very little, and break suddenly. There can be a lot of elastic strain energy in a steel wire under tension and it will "whiplash" if it breaks. The ends are razor sharp and such a failure is very dangerous indeed.

• Curve **C** is a **ductile** material

• Curve **D** is a **plastic** material. Notice a very large strain for a small stress.The material will not go back to its original length.

OBESERVATIONS:

A) Original dimensions

Gauge Length = ------------

Diameter = ---------

Area = --------------

B) Final Dimensions:

Gauge Length = -------------------

Diameter = -----------------

Area = ------------------------

TABULATION:- (Cross check 'E' with reference table 1.0)

S.No.	Extension (mm)		Load, N		Average Load	Young's Modulus E, N/mm^2
	Left	Right	Left	Right		
1						
2						
3						
4						
5						

(i) **Limit of proportion =** $\frac{\text{Load at limit of proportionality}}{\text{Original area of cross-section}}$ N/mm^2

(ii) Elastic limit = $\frac{\text{load at elastic limit}}{\text{Original area of c/s}}$ N/mm^2

(iii) Yield strength = $\frac{\text{Yield load}}{\text{Original area of cross-section}}$ N/mm^2

(iv) Ultimate strength = $\frac{\text{Maximum tensile load}}{\text{Original area of cross-section}}$ N/mm^2

(v) Young's modulus, E = $\frac{\text{stress below proportionality limit}}{\text{Corresponding strain}}$ N/mm^2

(vi) % of elongation = $\frac{\text{Final length (at fracture) – original length}}{\text{Original length}}$ %

(vii) **% of reduction in area** = $\frac{\text{Original area-area at fracture}}{\text{Original area}}$ %

RESULT:-

i) Average Breaking Stress =

ii) Ultimate Stress =

iii) Average % Elongation =

GRAPH:

1. Stress Vs Strain

PRECAUTIONS:-

1. If the strain measuring device is an extensometer it should be removed before necking begins.
2. Measure deflection on scale accurately & carefully.

Reference Table 1.0: Properties of Materials (Ref. Adopted from MIT)

MATERIAL	Type	Cost ($/kg)	Density (ρ, Mg/m^3)	Young's Modulus (E, GPa)	Shear Modulus (G, GPa)	Poisson's Ratio (μ)	Yield Stress (σ_y, MPa)	UTS (σ_f, MPa)	Breaking strain (ϵ_f, %)	Fracture Toughness (K_c, $MN\,m^{-3/2}$)	Thermal Expansion (α, 10^{-6}/C)
Alumina (Al_2O_3)	ceramic	1.90	3.9	390	125	0.26	4800	35	0.0	4.4	8.1
Aluminum alloy (7075-T6)	metal	1.80	2.7	70	28	0.34	500	570	12	28	33
Beryllium alloy	metal	315.00	2.9	245	110	0.12	360	500	6.0	5.0	14
Bone (compact)	natural	1.90	2.0	14	3.5	0.43	100	100	9.0	5.0	20
Brass (70Cu30Zn, annealed)	metal	2.20	8.4	130	39	0.33	75	325	70.0	80	20
Cermets (Co/WC)	composite	78.60	11.5	470	200	0.30	650	1200	2.5	13	5.8
CFRP Laminate (graphite)	composite	110.00	1.5	1.5	53	0.28	200	550	2.0	38	12
Concrete	ceramic	0.05	2.5	48	20	0.20	25	3.0	0.0	0.75	11
Copper alloys	metal	2.25	8.3	135	50	0.35	510	720	0.3	94	18
Cork	natural	9.95	0.18	0.032	0.005	0.25	1.4	1.5	80	0.074	180
Epoxy thermoset	polymer	5.50	1.2	3.5	1.4	0.25	45	45	4.0	0.50	60
GFRP Laminate (glass)	composite	3.90	1.8	26	10	0.28	125	530	2.0	40	19
Glass (soda)	ceramic	1.35	2.5	65	26	0.23	3500	35	0.0	0.71	8.8
Granite	ceramic	3.15	2.6	66	26	0.25	2500	60	0.1	1.5	6.5
Ice (H_2O)	ceramic	0.23	0.92	9.1	3.6	0.28	85	6.5	0.0	0.11	55
Lead alloys	metal	1.20	11.1	16	5.5	0.45	33	42	60	40	29
Nickel alloys	metal	6.10	8.5	180	70	0.31	900	1200	30	93	13
Polyamide (nylon)	polymer	4.30	1.1	3.0	0.76	0.42	40	55	5.0	3.0	103
Polybutadiene elastomer	polymer	1.20	0.91	0.0016	0.0005	0.50	2.1	2.1	500	0.087	140
Polycarbonate	polymer	4.90	1.2	2.7	0.97	0.42	70	77	60	2.6	70
Polyester thermoset	polymer	3.00	1.3	3.5	1.4	0.25	50	0.7	2.0	0.70	150

Polyethylene (HDPE)	polymer	1.00	0.95	0.7	0.31	0.42	25	33	90	3.5	225
Polypropylene	polymer	1.10	0.89	0.9	0.42	0.42	35	45	90	3.0	85
Polyurethane elastomer	polymer	4.00	1.2	0.025	0.0086	0.50	30	30	500	0.30	125
Polyvinyl chloride (rigid PVC)	polymer	1.50	1.4	1.5	0.6	0.42	53	60	50	0.54	75
Silicon	ceramic	2.35	2.3	110	44	0.24	3200	35	0.0	1.5	6
Silicon Carbide (SiC)	ceramic	36.00	2.8	450	190	0.15	9800	35	0.0	4.2	4.2
Spruce (parallel to grain)	natural	1.00	0.60	9	0.8	0.30	48	50	10	2.5	4
Steel, high strength 4340	metal	0.25	7.8	210	76	0.29	1240	1550	2.5	100	14
Steel, mild 1020	metal	0.50	7.8	210	76	0.29	200	380	25	140	14
Steel, stainless austenitic 304	metal	2.70	7.8	210	76	0.28	240	590	60	50	17
Titanium alloy (6Al4V)	metal	16.25	4.5	100	39	0.36	910	950	15	85	9.4
Tungsten Carbide (WC)	ceramic	50.00	15.5	550	270	0.21	6800	35	0.0	3.7	5.8

EXPERIMENT NO – 02: TORSION TEST

AIM: To conduct torsion test on mild steel or cast iron specimen to determine modulus of rigidity.

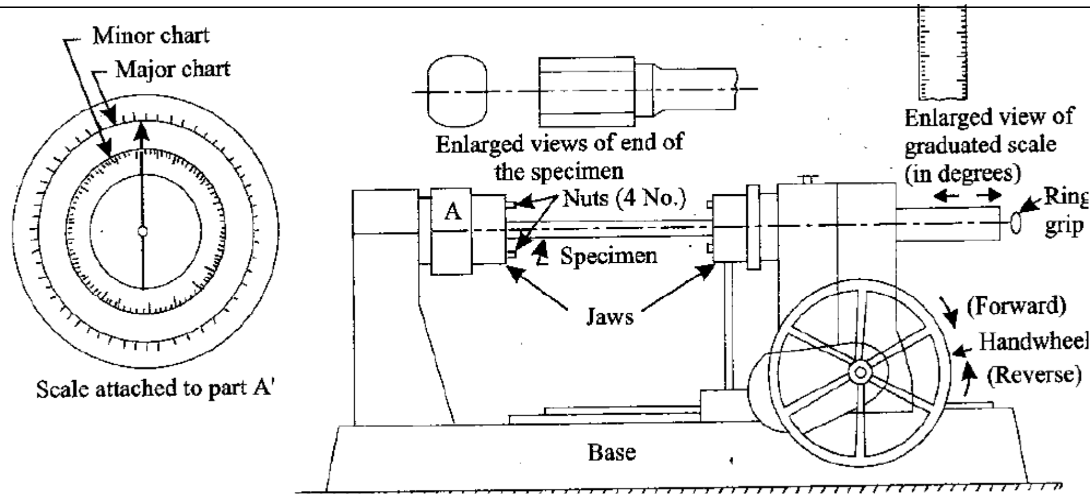
APPARATUS:

1. A torsion test machine along with angle of twist measuring attachment.
2. Standard specimen of mild steel or cast iron.
3. Steel rule.
4. Vernnier caliper or a micrometer.

Torsion testing machine:

M/C SPECIFICATIONS:

Capacity: Torque Range: 0-10 Kg-m.
Model: TTM-10..
SR.No: 2001/1012.
Mfd. By: Macro Testing Machines, Ichalkaranji, M.H, India.



THEORY:

For transmitting power through a rotating shaft it is necessary to apply a turning force. The force is applied tangentially and in the plane of transverse cross section. The torque or twisting moment may be calculated by multiplying two opposite turning moments. It is said to be in pure torsion and it will exhibit the tendency of shearing off at every cross section which is perpendicular to the longitudinal axis.

Torsion equation:

Torsion equation is given by below

$\mathbf{T/J = \tau/R = G\theta/L}$

$\mathbf{G = T\,L/J\,\theta}$ N/mm^2

T= maximum twisting torque (N mm)

J = polar moment of inertia (mm^4) = π d^4/32

τ = shear stress (N/mm^2)

G = modulus of rigidity (N/mm^2)

θ = angle of twist in radians

L= length of shaft under torsion (mm)

Assumptions made for getting torsion equation

1. The material of the shaft is uniform throughout.
2. The shaft, circular in section remain circular after loading.
3. Plane sections of shaft normal to its axis before loading remain plane after the torque have been applied.
4. The twist along the length of the shaft is uniform throughout.
5. The distance between any two normal-sections remains the same after the application of torque.
6. Maximum shear stress induced in the shaft due to application of torque does not exceed its elastic limit.

PROCEDURE:-

1. Select the driving dogs to suit the size of the specimen and clamp it in the machine by adjusting the length of the specimen by means of a sliding spindle.
2. Measure the diameter at about three places and take the average value.
3. Choose the appropriate range by capacity change lever
4. Set the maximum load pointer to zero.
5. Set the protractor to zero for convenience and clamp it by means of knurled screw.
6. Carry out straining by rotating the hand wheel in either direction.
7. Load the machine in suitable increments.
8. Then load out to failure as to cause equal increments of strain reading.
9. Plot a torque- twist (T- θ) graph.
10. Read off co-ordinates of a convenient point from the straight line portion of the torque twist (T- θ) graph and calculate the value of G by using relation.

OBESERVATIONS:-

Gauge length of the specimen, L = ………

Diameter of the specimen, d = ………

Polar moment of inertia, $J = \pi d^4/32$ = ...

TABULATION: (Cross check 'G' with reference table 1.0)

Sl. No.	Torque, Kg-cm	Torque, N - mm	Angle of twist		Modulus Rigidity, G N/mm^2	Average G, N/mm^2
			Degrees	Radians		

RESULT :-

Thus the torsion test on given mild steel specimen is done and the modulus of rigidity is ------------- N/mm^2

GRAPH:

1. Torque Vs Angle of Twist

PRECAUTIONS:-

1) Measure the dimensions of the specimen carefully

2) Measure the Angle of twist accurately for the corresponding value of Torque.

3) The specimen should be properly to get between the jaws.

4) After breaking specimen stop to m/c.

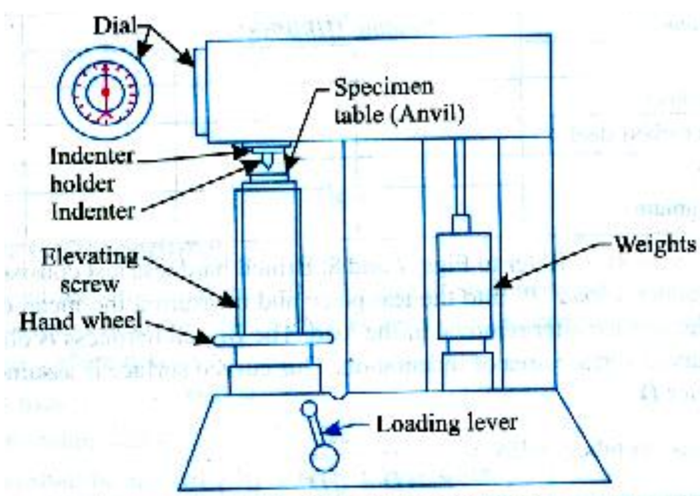
EXPERIMENT NO – 03: HARDNESS TEST

AIM: - To conduct hardness test on mild steel, carbon steel, brass and aluminum specimens.

APPARATUS:- Hardness tester, soft and hard mild steel specimens, brass, aluminum etc.

DIAGRAM:-

Nomenclature	Specifications
Loads	60,100,150,187.5, 250 (kgf)
Initial Load	10 (kgf)
Max. Test Height	230 (mm)
Depth of Throat	133 (mm)
Max. Depth of elevating screw below base	240 (mm)
Size of Base (approx)	171 x 423 (mm)
Machine Height	635 (mm)
Net. weight (Approx)	75 Kg



THEORY: - The hardness of a material is resistance to penetration under a localized pressure or resistance to abrasion. Hardness tests provide an accurate, rapid and economical way of determining the resistance of materials to deformation. There are three general types of hardness measurements depending upon the manner in which the test is conducted:

a. Scratch hardness measurement,

b. Rebound hardness measurement

c. Indention hardness measurement.

In scratch hardness method the material are rated on their ability to scratch one another and it is usually used by mineralogists only. In rebound hardness measurement, a standard body is usually dropped on to the material surface and the hardness is measured in terms of the height of its rebound. The general means of judging the hardness is measuring the resistance of a material to indentation. The indenters usually a ball cone or pyramid of a material much harder than that being used. Hardened steel, sintered tungsten carbide or diamond indenters are generally used in indentation tests; a load is applied by pressing the indenter at right angles to the surface being tested. The hardness of the material depends on the resistance which it exerts during a small amount of yielding or plastic. The resistance depends on friction, elasticity, viscosity and the intensity and distribution of plastic strain produced by a given tool during indentation.

BRINELL'S HARDNESS

AIM :-

To determine the Brinell hardness of the given test specimen.

APPARATUS:-

1. Brinell Hardness testing machine,
2. Specimen of mild steel / cast iron/ non ferrous metals
3. Brinell microscope.

THEORY: -

Hardness represents the resistance of material surface to abrasion, scratching and cutting, hardness after gives clear identification of strength. In all hardness testes, a define force is mechanically applied on the test piece for about 15 seconds. The indentor, which transmits the load to the test piece, varies in size and shape for different testes. Common indenters are made of hardened steel or diamond. In Brinell hardness testing, steel balls are used as indentor. Diameter of the indentor and the applied force depend upon the thickness of the test specimen, because for accurate results, depth of indentation should be less than $1/8^{th}$ of the thickness of the test pieces. According to the thickness of the test piece increase, the diameter of the indentor and force are changed. A hardness test can be conducted on Brinell testing m/c, Rockwell hardness m/c or vicker testing m/c. the specimen may be a cylinder, cube, thick or thin metallic sheet. A Brinell- cum-Rockwell hardness testing m/c along with the specimen is shown in figure. Its specification are as follows:

1. Ability to determine hardness upto 500 HB.
2. Diameter of ball (as indentor) used D = 2.5mm, 5mm, 10mm.
3. Maximum application load = 3000kgf.
4. Method of load application = Lever type
5. Capability of testing the lower hardness range = 1 HB on application of 0.5D2 load.

Indentation Hardness-A number related to the area or to the depth of the impression made by an indenter or fixed geometry under a known fixed load. This method consists of indenting the surface of the metal by a hardened steel ball of specified diameter D mm under a given load F kgf and measuring the average diameter d mm of the impression with the help of Brinell microscope fitted with a scale.

The Brinell hardness is defined, as the quotient of the applied force F divided by the spherical area of the impression.

HB = Load Applied (kgf.)/ Spherical surface area indentation (in mm.)

$= 2F / \pi D (D-\sqrt{D^2 - d^2})$ kg/mm^2

PROOF:-

For any sphere of diameter "D" the surface area between any two parallel planes with distance "h" between them = ΠD x h

The spherical indentation in the Brinell hardness test is indicated by the portion A-C-B

A = Surface area of potion ACB of spheres = ΠD x CE

But CE = OC-OE

$= D/2 - \sqrt{(OA)^2 - (AE)}^2$

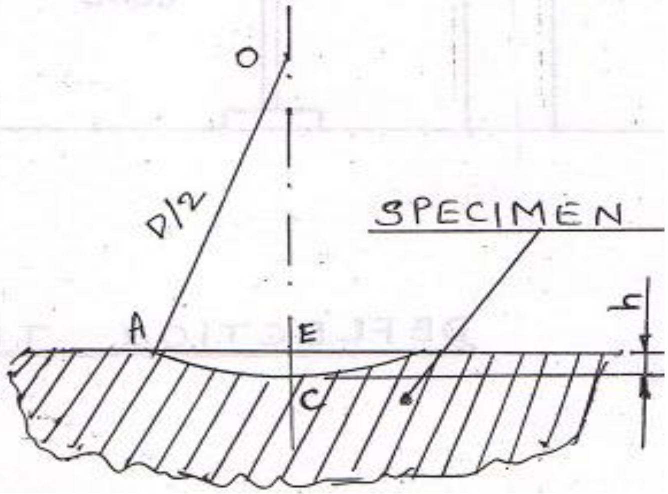
$= D/2 - \sqrt{(D/2)^2 - (d/2)^2}$

$= 1/2(D - \sqrt{(D^2 - d^2)}$

Area(A) = ΠD x CE

$= (\frac{\pi D}{2})(D - \sqrt{D^2 - d^2})$

Hardness =F/A= $2F/_{\pi D}$ $(D - \sqrt{D^2 - d^2})$



PROCEDURE:

1. Select the proper size of the ball and load to suit the material under test.
2. Clean the test specimen to be free from any dirt and defects or blemishes.
3 . Mount the test piece surface at right angles to the axis of the ball indenter plunger.
4. Turn the platform so that the ball is lifted up.
5. By shifting the lever applies the load and waits for some time.
6. Release the load by shifting the lever.
7. Take out the specimen and measure the diameter of indentation by means of the Brinell microscope.
8. Repeat the experiments at other positions of the test piece.
9. Calculate the value of HB.

OBSERVATIONS:

Test piece material =

Diameter of the ball, D =

Load section, P/D^2 =

Test load =

Load application time =

Least count of Brinell Microscope =

TABULATION: (Cross check with reference tables)

S. No.	Impression Diameter			Load Applied, Kg	Diameter of Ball, D mm	Average HB Kg/mm^2
	d_1	d_2	$(d_1 + d_2)/2$			
1						
2						
3						

RESULT:-

The Brinell hardness number of the specimen is --------

PRECAUTIONS:-

1. The surface of the test piece should be clean.
2. The testing machine should be protected throughout the test from shock or vibration.
3. The test should be carried out at room temperature.
4. The distance of the center of indentation from the edge of test piece should be at least 2.5 times the diameter of the indentation and the distance between the centres of the two adjacent indentations should be at least 4 times the diameter of the indentation.
5. The diameter of each indentation should be measured in two directions at right angles and the mean value readings used the purpose of determining the hardness number.

ROCKWELL HARDNESS TEST

AIM :

To study the Rockwell Hardness testing machine and perform the Rockwell hardness test.

APPARATUS: -

1. Rockwell Hardness testing machine,
2. Specimen of mild steel or other material.

THEORY: -

Hardness represents the resistance of material surface to abrasion, scratching and cutting, hardness after gives clear indication of strength. In all hardness tests, a define force is mechanically applied on the piece, varies in size and shape for different tests. Common indentors are made of hardened steel or diamond. Rockwell hardness tester presents direct reading of hardness number on a dial provided with the m/c. principally this testing is similar to Brinell hardness testing. It differs only in diameter and material of the indentor and the applied force. Although there are many scales having different combinations of load and size of indentor but commonly 'C' scale is used and hardness is presented as HRC. Here the indentor has a diamond cone at the tip and applied force is of 150 kgf. Soft materials are often tested in 'B' scale with a 1.6mm dia. Steel indentor at 60kgf. A hardness test can be conducted can be conducted on Brinell testing m/c, Rockwell hardness m/c or vicker testing m/c. The specimen may be a cylinder, cube, thick or thin metallic sheet. A Brinell-cum-Rocwell hardness testing m/c along with the specimen is shown in figure.

Various scales in Rockwell hardness test are given below:-

	Scale Symbol	Indenter Type. If a ball, diameter in millimeters (diameter in inches)	Preliminary force in newtons (kg-force)	Total force newtons (kgf)	Typical Applications
Regular Rockwell Scales	A	Spheroconical diamond	98.07 (10)	588.4 (60)	Cemented carbides, thin steel, and shallow case hardened steel.
	B	Ball 1.588 (1/16")	98.07 (10)	980.7 (100)	Copper alloys, soft steels, aluminum alloys, malleable iron, etc.
	C	Spheroconical diamond (120^0)	98.07 (10)	1471 (150)	Steel, hard cast irons, pearlitic malleable iron, titanium, deep case hardened steel, and other materials harder than 100 on the Rockwell B scale.
	D	Spheroconical diamond	98.07 (10)	980.7 (100)	Thin steel and medium case hardened steel, and pearlitic

					malleable iron.
	E	Ball 3.175 (1/8)	98.07 (10)	980.7 (100)	Cast iron, aluminum and magnesium alloys, and bearing metals.
	F	Ball 1.588 (1/16)	98.07 (10)	588.4 (60)	Annealed copper alloys, and thin soft sheet metals.
	G	Ball 1.588 (1/16)	98.07 (10)	1471 (150)	Malleable irons, copper-nickel-zinc and cupronickel alloys.
	H	Ball 3.175 (1/8)	98.07 (10)	588.4 (60)	Aluminum, zinc, and lead.
	K	Ball 3.175 (1/8)	98.07 (10)	1471 (150)	Bearing metals and other very soft or thin materials. Use smallest ball and heaviest load that does not give anvil effect.
	L	Ball 6.350 (1/4)	98.07 (10)	588.4 (60)	
	M	Ball 6.350 (1/4)	98.07 (10)	980.7 (100)	
	P	Ball 6.350 (1/4)	98.07 (10)	1471 (150)	
	R	Ball 12.70 (1/2)	98.07 (10)	588.4 (60)	
	S	Ball 12.70 (1/2)	98.07 (10)	980.7 (100)	
	V	Ball 12.70 (1/2)	98.07 (10)	1471 (150)	
Superficial Rockwell Scales	15N	Spheroconical diamond	29.42 (3)	147.1 (15)	Similar to A, C and D scales, but for thinner gage material or case depth.
	30N	Spheroconical diamond	29.42 (3)	294.2 (30)	

	45N	Spheroconical diamond	29.42 (3)	441.3 (45)	
	15T	Ball 1.588 (1/16)	29.42 (3)	147.1 (15)	Similar to B, F and G scales, but for thinner gage material.
	30T	Ball 1.588 (1/16)	29.42 (3)	294.2 (30)	
	45T	Ball 1.588 (1/16)	29.42 (3)	441.3 (45)	
	15W	Ball 3.175 (1/8)	29.42 (3)	147.1 (15)	Very soft material.
	30W	Ball 3.175 (1/8)	29.42 (3)	294.2 (30)	
	45W	Ball 3.175 (1/8)	29.42 (3)	441.3 (45)	
	15X	Ball 6.350 (1/4)	29.42 (3)	147.1 (15)	
	30X	Ball 6.350 (1/4)	29.42 (3)	294.2 (30)	
	45X	Ball 6.350 (1/4)	29.42 (3)	441.3 (45)	
	15Y	Ball 12.70 (1/2)	29.42 (3)	147.1 (15)	
	30Y	Ball 12.70 (1/2)	29.42 (3)	294.2 (30)	
	45Y	Ball 12.70 (1/2)	29.42 (3)	441.3 (45)	

The table is adopted from Table 1 of Samuel R. Low. *Rockwell Hardness Measurement of Metallic Materials.* NIST Recommended Practice Guide. Special Publication 960-5. Washington: U.S.G.P.O. *2001*.

Standards

ASTM E 18 - 2000, Standard Test Methods for Rockwell Hardness and Rockwell Superficial Hardness of

Metallic Materials.

ISO 6508-1 Metallic Materials - Rockwell hardness test (scales A, B, C, D, E, F, G, H, K, N, T) - Part 1: Test method, 1999-09-01

ISO 6508-2 Metallic Materials - Rockwell hardness test (scales A, B, C, D, E, F, G, H, K, N, T) - Part 2: Verification of testing machines, 1999-09-01

ISO 6508-3 Metallic Materials - Rockwell hardness test (scales A, B, C, D, E, F, G, H, K, N, T) - Part 3: Calibration of reference blocks, 1999-09-01

Tensile strength and hardness for steels and non ferrous metals:

See Reference Tables (1-4)

Rockwell-cum-Brinell's hardness tester

PROCEDURE:-

1. Insert ball of dia. 'D' in ball holder of the m/c.
2. Make the specimen surface clean by removing dust, dirt, oil and grease etc.
3. Make contact between the specimen surface and the ball by rotating the jack adjusting wheel.
4. Push the required button for loading.
5. Pull the load release lever wait for minimum 15 second. The load will automatically apply gradually.
6. Remove the specimen from support table and locate the indentation so made.
7. Repeat the entire operation, 3-times.

OBSERVATIONS:

Material of the specimen =

Thickness of test specimen =

Hardness scale used =

TABULATION: (Cross check with reference tables)

S. No.	**Material**	**Rockwell Scale**			**Rockwell Number**			**Average**
		Scale	**Load**	**Indent**	**1**	**2**	**3**	
1								
2								
3								
4								

RESULT:-

Rockwell hardness of given specimen is --------

PRECAUTIONS:

1. For testing cylindrical test specimens use V-type platform.
2. Calibrate the machine occasionally by using standard test blocks.
3. For thin metal prices place another sufficiently thick metal piece between the test specimen and the platform to avoid any damage, which may likely occur to the platform.
4. After applying major load wait for some time to allow the needle to come to rest. The waiting time may vary from 2 t0 8 seconds.
5. The surface of the test piece should be smooth and even and free from oxide scale and foreign matter.
6. Test specimen should not be subjected to any heating of cold working.

7. The distance between the canters of two adjacent indentation should be at least 4 times the diameter of the indentation and the distance from the center of any indentation to the edge of the test piece should be at least 2.5 times the diameter of the indentation.

Reference Tables:

TENSILE STRENGTH & HARDNESS FOR STEELS AND NONFERROUS METALS

Tensile strength and hardness in various scales for steel

Condition: Normalised or Annealed											
Tensile strength kgf/mm^2	Dia. of ball impression *mm.*	Brinell hardness	Vickers hardness	Rockwell hardness scale *B*	Rockwell hardness scale *C*	Tensile strength kgf/mm^2	Dia. of ball impression *mm.*	Brinell hardness	Vickers hardness	Rockwell hardness scale *B*	Rockwell hardness scale *C*
σ_t	*d*	*HB*	*HV*	*HRB*	*HRC*	σ_t	*d*	*HB*	*HV*	*HRB*	*HRC*
34	6	95.5		53		71	4.27	199	203	93.5	
35	5.92	98.4		56		72	4.24	202	206	94	
36	5.85	101		58		73	4.21	206	208	95	15
37	5.77	104		61		74	4.19	208	210	95	16
38	5.7	107		63		75	4.16	211	213	96	16
39	5.64	110		64.5		76	4.13	214	216		17
40	5.57	113		66		77	4.1	217	220	97	18
41	5.51	115		67.5		78	4.08	219	222		
42	5.45	118		69		79	4.05	223	225	98	19
43	5.39	121		70.5		80	4.03	225	227		
44	5.33	124		71.5		81	4.01	228	230	99	20
45	5.28	127		73		82	3.98	231	233		21
46	5.23	129		73.5		83	3.96	234	236	100	
47	5.18	132		74.5		84	3.94	236	238		22
48	5.13	135		75.5		85	3.92	239	240	101	
49	5.08	138		76.5		86	3.9	241	243		23
50	5.03	141		77.5		87	3.87	245	247	102	
51	4.98	144		78.5		88	3.85	248	249		24
52	4.94	146		79.5		89	3.83	250	252		
53	4.9	149		80		90	3.81	253	254	103	25
54	4.85	152		81		91	3.79	256	257		
55	4.81	155		82		92	3.77	259	260	104	26
56	4.77	158		83		93	3.75	262	263	104	
57	4.73	161		84		94	3.73	265	265		27
58	4.7	163		84.5		95	3.71	268	268	105	27
59	4.66	166		85		96	3.69	271	271		
60	4.62	169	173	86		97	3.67	274	274		28
61	4.58	172	176	87		98	3.66	275	276	106	
62	4.55	174	178	87.5		99	3.64	278	279		29
63	4.52	177	181	88		100	3.62	282	282		
64	4.48	180	184	89		101	3.6	285	285	107	
65	4.45	183	187	89.5		102	3.59	287	287		30
66	4.42	185	139	90.5		103	3.57	290	290		
67	4.39	188	192	91		104	3.55	293	293		31
68	4.36	191	194	91.5		105	3.54	295	295	108	
69	4.33	194	197	92		106	3.52	298	298		
70	4.3	197	200	93		107	3.51	300	300		32

Table 3.0

Tensile strength and hardness in various scales for steel (Contd.)

Condition: Normalised or annealed

Tensile strength kgf/mm^2 σ_t	Dia. of ball impression *mm.* d	Brinell hardness HB	Vickers hardness HV	Rockwell hardness scale *B* HRB	Rockwell hardness scale *C* HRC
108	3.49	304	303		32
109	3.47	307	307	109	
110	3.46	309	309		33
111	3.44	313	312		
112	3.43	315	314		
113	3.41	319	318		34
114	3.4	321	320	110	
115	3.38	325	323		
116	3.37	327	325		35
117	3.36	329	327		
118	3.34	333	331		
119	3.33	335	333		36
120	3.31	339	337	111	
121	3.3	341	339		
122	3.29	343	341		
123	3.28	345	343		37
124	3.26	350	348		
125	3.25	352	350		
126	3.24	354	352	112	38
127	3.23	356	354		
128	3.21	361	359		
129	3.2	363	361		
130	3.19	366	363	112.5	39

Condition: Hardened & tempered or only hardened

Tensile strength kgf/mm^2 σ_t	Dia. of ball impression *mm.* d	Brinell hardness HB	Vickers hardness HV	Rockwell hardness scale *B* HRB	Rockwell hardness scale *C* HRC
60	4.53	176	190	87.5	
61	4.49	179	194		
62	4.46	182	197	89	
63	4.42	185	200	90	
64	4.38	189	204	91	
65	4.35	192	207	92	
66	4.32	195	209	92	
67	4.29	198	212	93	
68	4.25	201	216	94	
69	4.22	204	219	95	
70	4.19	208	223		15
71	4.16	211	226	96	16
72	4.13	214	229	96	17
73	4.11	216	231	97	17
74	4.08	219	235	97	18
75	4.05	223	238	98	
76	4.02	226	242		19
77	4	229	244	99	20
78	3.97	232	248		21
79	3.95	235	251	100	
80	3.92	239	254		22
81	3.9	241	257	101	23
82	3.87	245	261		23
83	3.85	248	264	102	24
84	3.83	250	266		
85	3.81	253	269	103	25
86	3.78	257	273		
87	3.76	260	276	104	26
88	3.74	263	279		
89	3.72	266	282		27
90	3.7	269	285	105	28
91	3.68	272	289		28
92	3.66	275	292	106	29
93	3.64	278	295	106	29
94	3.62	282	298		30
95	3.6	285	302	107	30
96	3.58	288	305		
97	3.56	292	308		31
98	3.54	295	312	108	31
99	3.53	297	314	108	
100	3.51	300	317		32
101	3.49	304	321		
102	3.47	307	325	109	
103	3.46	309	327		33
104	3.44	313	330		
105	3.42	317	334		34
106	3.41	319	336	110	
107	3.39	323	340	110	
108	3.38	325	342		35
109	3.36	329	346		35
110	3.35	331	348		

Table 3.1

Tensile strength and hardness in various scales for steel (Contd.)

Condition: Hardened & tempered or only hardened											
Tensile strength kgf/mm^2	Dia. of ball impression *mm.*	Brinell hardness	Vickers hardness	Rockwell hardness scale *B*	Rockwell hardness scale *C*	Tensile strength kgf/mm^2	Dia. of ball impression *mm.*	Brinell hardness	Vickers hardness	Rockwell hardness scale *B*	Rockwell hardness scale *C*
σ_t	*d*	*HB*	*HV*	*HRB*	*HRC*	σ_t	*d*	*HB*	*HV*	*HRB*	*HRC*
111	3.34	333	350			150	2.92	438	463		
112	3.32	337	354	111	36	151	2.91	441	467		
113	3.31	339	357			152	2.9	444	470		46
114	3.3	341	359			153					
115	3.28	345	363		37	154	2.89	448	474		
116	3.27	347	365			155	2.88	451	478		
117	3.26	350	368			156	2.87	454	482		
118	3.25	352	370	112		157					47
119	3.23	356	374		38	158	2.86	457	486		
120	3.22	359	377			159	2.85	461	490		
121	3.21	361	379			160					
122	3.2	363	382			161	2.84	464	494		
123	3.19	366	384		39	162	2.83	467	498		48
124	3.17	370	389			163					
125	3.16	373	391	113		164	2.82	471	502		
126	3.15	375	394		40	165	2.81	474	506		
127	3.14	378	396			166	2.8	477	511		
128	3.13	380	399			167	2.8	477	511		
129	3.12	383	401			168	2.79	481	515		49
130	3.11	385	404		41	169	2.78	485	520		
131	3.1	388	407		41	170	2.78	485	520		
132	3.09	390	410			171	2.77	488	524		
133	3.07	395	415	114		172					
134	3.06	398	418		42	173	2.76	492	529		
135	3.05	401	421			174	2.75	495	533		50
136	3.04	404	424			175					
137	3.03	406	427			176	2.74	499	538		
138						177					
139	3.02	409	431		43	178	2.73	503	543		
140	3.01	412	434			179	2.72	507	548		51
141	3	415	437	115		180	2.72	507	548		51
142	2.99	417	440			181	2.71	510	553		
143	2.98	420	443		44	182					
144	2.97	423	446			183	2.7	514	558		
145	2.96	426	450			184					
146	2.95	429	453			185	2.69	518	564		
147						186					52
148	2.94	432	457		45	187	2.68	522	570		
149	2.93	435	460			188					

Table 3.2

Tensile strength and hardness in various scales for steel (Contd.)

Condition: Hardened & tempered or only hardened											
Tensile strength kgf/mm^2	Dia. of ball impression *mm.*	Brinell hardness	Vickers hardness	Rockwell hardness scale *B*	Rockwell hardness scale *C*	Tensile strength kgf/mm^2	Dia. of ball impression *mm.*	Brinell hardness	Vickers hardness	Rockwell hardness scale *B*	Rockwell hardness scale *C*
σ_t	*d*	*HB*	*HV*	*HRB*	*HRC*	σ_t	*d*	*HB*	*HV*	*HRB*	*HRC*
111	3.34	333	350			150	2.92	438	463		
112	3.32	337	354	111	36	151	2.91	441	467		
113	3.31	339	357			152	2.9	444	470		46
114	3.3	341	359			153					
115	3.28	345	363		37	154	2.89	448	474		
116	3.27	347	365			155	2.88	451	478		
117	3.26	350	368			156	2.87	454	482		
118	3.25	352	370	112		157					47
119	3.23	356	374		38	158	2.86	457	486		
120	3.22	359	377			159	2.85	461	490		
121	3.21	361	379			160					
122	3.2	363	382			161	2.84	464	494		
123	3.19	366	384		39	162	2.83	467	498		48
124	3.17	370	389			163					
125	3.16	373	391	113		164	2.82	471	502		
126	3.15	375	394		40	165	2.81	474	506		
127	3.14	378	396			166	2.8	477	511		
128	3.13	380	399			167	2.8	477	511		
129	3.12	383	401			168	2.79	481	515		49
130	3.11	385	404		41	169	2.78	485	520		
131	3.1	388	407		41	170	2.78	485	520		
132	3.09	390	410			171	2.77	488	524		
133	3.07	395	415	114		172					
134	3.06	398	418		42	173	2.76	492	529		
135	3.05	401	421			174	2.75	495	533		50
136	3.04	404	424			175					
137	3.03	406	427			176	2.74	499	538		
138						177					
139	3.02	409	431		43	178	2.73	503	543		
140	3.01	412	434			179	2.72	507	548		51
141	3	415	437	115		180	2.72	507	548		51
142	2.99	417	440			181	2.71	510	553		
143	2.98	420	443		44	182					
144	2.97	423	446			183	2.7	514	558		
145	2.96	426	450			184					
146	2.95	429	453			185	2.69	518	564		
147						186					52
148	2.94	432	457		45	187	2.68	522	570		
149	2.93	435	460			188					

Table 3.3

EXPERIMENT NO – 04: SPRING TEST

AIM: - To determine the stiffness and modulus of rigidity of the spring wire.

APPARATUS: -

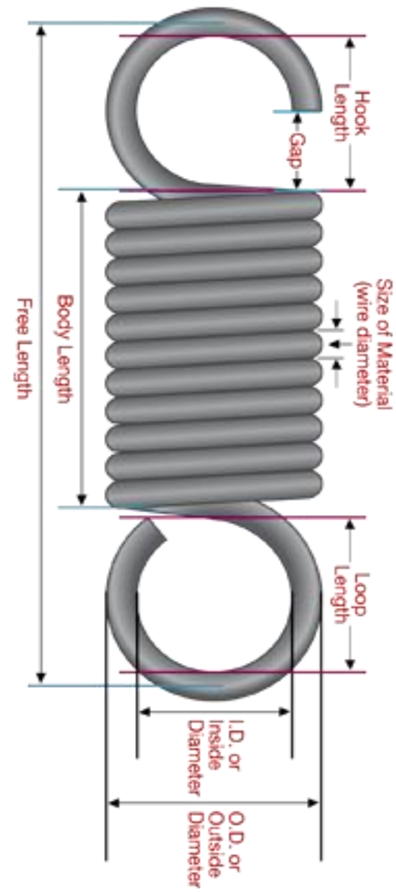
i) Spring testing machine.

ii) A spring

iii) Vernier caliper, Scale.

iv) Micrometer.

DIAGRAM:-



M/C SPECIFICATIONS:
Capacity: 0-250 Kgf.
Model: MX-250
SR.No: 2001/1001.
Mfd. By: Macro Testing Machines, Ichalkaranji, M.H, India.

THEORY: -

Springs are elastic member which distort under load and regain their original shape when load is removed. They are used in railway carriages, motor cars, scooters, motorcycles, rickshaws, governors etc. According to

their uses the springs perform the following Functions:

1) To absorb shock or impact loading as in carriage springs.

2) To store energy as in clock springs.

3) To apply forces to and to control motions as in brakes and clutches.

4) To measure forces as in spring balances.

5) To change the variations characteristic of a member as in flexible mounting of motors.

The spring is usually made of either high carbon steel (0.7 to 1.0%) or medium carbon alloy steels. Phosphor bronze, brass, 18/8 stainless steel and Monel and other metal alloys are used for corrosion resistance spring. Several types of spring are available for different application. Springs may classified as helical springs, leaf springs and flat spring depending upon their shape. They are fabricated of high shear strength materials such as high carbon alloy steels spring form elements of not only mechanical system but also structural system. In several cases it is essential to idealise complex structural systems by suitable spring.

PROCEDURE:

1) Measure the outer diameter (D) and diameter of the spring coil (d) for the given compression spring.
2) Count the number of turns i.e. coils (n) in the given compression specimen.
3) Place the compression spring at the centre of the bottom beam of the spring testing machine.
4) Insert the spring in the spring testing machine and load the spring by a suitable weight and note the corresponding axial deflection in tension or compression.
5) Note down the initial reading from the scale in the machine.
6) Increase the load and take the corresponding axial deflection readings.
7) Find the actual deflection of the spring for each load by deducting the initial scale reading from the corresponding scale reading.
8) Calculate the modulus of rigidity for each load applied.
9) Plot a curve between load and deflection. The shape of the curve gives the stiffness of the spring.

FORMULA:

Modulus of rigidity, $G = \dfrac{64WR^3 n}{\delta\, d^4}$

Where,

i. W = Load in N

ii. R = Mean radius of the spring in mm (D –d /2)

iii. d = Diameter of the spring coil in mm

iv. δ = Deflection of the spring in mm

v. D = Outer diameter of the spring in mm.

OBESERVATIONS:

1) Material of the spring specimen =
2) Least count of micrometer = ……...mm
3) Diameter of the spring wire, d =………mm

   (Mean of three readings)
4) Least count of Vernier Caliper = ……...mm
5) Diameter of the spring coil, D = ……...mm

   (Mean of three readings)
6) Number of turns, n =
7) Initial scale reading = ……...mm

TABULATION: (Refer Tables)

S.No.	Applied Load		Scale Reading, mm	Actual Deflection, mm	Modulus of Rigidity, N/mm^2	Stiffness, N/mm
	Kg	N				
1						
2						
3						
4						
5						

RESULT:

The modulus of rigidity of the given spring = ------------------- N/mm^2

The stiffness of the given spring = -------------------N/mm^2

GRAPH:

1. **Load Vs Deflection**

PRECAUTIONS:-

1) Dimensions should be measure accurately with the help of Vernier Calipers.

2) Deflection from the scale should be noted carefully and accurately.

Properties of common spring materials (Adopted from ace wire spring and form company)

	Material	Nominal Analysis	Tensile Properties: Minimum Tensile Strength psi x 10^3 (MPa)	Tensile Properties: Modulus of Elasticity E psi x 10^6 (MPa x 10^3)	Torsional Properties: Design Stress % Min. Tensile	Torsional Properties: Modulus in Torsion G psi x 10^6 (MPa x 10^3)	Max. Operating Temp. °F	Max. Operating Temp. °C	Rockwell hardness>	Method of Manufacture Chief uses Special Properties
High Carbon Spring Wire	Music Wire ASTM A 228	C 0.70-1.00% Mn 0.20-0.60%	230-399 (1586-2751)	30 (207)	45	11.5 (79.3)	250	121	C41-60	Cold drawn high and uniform tensile. High quality springs and wire forms. Suitable for cyclic applications
	Hard Drawn ASTM A 227	C 0.45-0.85% Mn 0.60-1.30%	CLI 147-283 (1014-1951) CLII 171-324 (1179-2234)	30 (207)	40	11.5 (79.3)	250	121	C31-52	Cold drawn. Average stress applications. Lower cost springs and wire forms.
	High Tensile Hard Drawn ASTM A 679	C 0.65-1.00% Mn 0.20-1.30%	238-350 (1641-2413)	30 (207)	45	11.5 (79.3)	250	121	c31-52	Cold Drawn. Higher Quality springs and wire forms.
	Oil Tempered ASTM A 229	C 0.55-0.85% Mn 0.60-1.20%	CLI 165-293 (1138-2020) CLII 191-324 (1317-2234)	30 (207)	45	11.5 (79.3)	250	121	C42-55	Cold drawn and heat treated before fabrication. General purpose spring wire.
	Carbon Valve ASTM A 230	C 0.60-0.75% Mn 0.60-0.90	215-240 (1482-1655)	30 (207)	45	11.5 (79.3)	250	121	C45-49	Cold drawn and heat treated before fabrication. Good surface conditionand uniform tensile. Suitable for cyclic applications
Alloy Steel Wire	Chrome Vanadium ASTM A 231	C 0.48-0.53% Cr 0.80-1.10% V 0.15 min %	190-300 (1310-2069)	30 (207)	45	11.5 (79.3)	425	218.5	C41-55	Cold drawn and ehat treated before fabrication. Used for shock loads and moderately elevated temperature.
	Chrome Silicon ASTM A 401	C 0.51-0.59% Cr 0.60-0.80% Si 1.20-1.60%	235-300 (1620-2069)	30 (207)	45	11.5 (79.3)	475	246	C48-55	Cold drawn and heat treated before fabrication. Used for shock loads and moderately elevated temperature.
Stainless Steel Wire	AISI 302/304 ASTM A 313	Cr 17.-19.% Ni 8.-10.%	125-325 (862-2241)	28 (193)	35	10 (69.0)	550	288	C35-45	Cold drawn general purpose corrosion and heat resistant. Magnetic in spring tempor.
	AISI 316 ASTM A 313	Cr 16.-18% Ni 10.-14.% Mo 2.-3.%	110-245 (758-1689)	28 (193)	40	10 (69.0)	550	288	C35-45	Cold drawn. Heat resistant and better corrosion resistance than 302. Magnetic in spring tempor.
	17-7 PH ASTM A 313 (631)	Cr 16.-18.% Ni 10.-14.% Al 0.75-1.5%	Cond CH 235-335 (1620-2310)	29.5 (203)	45	11 (78.5)	650	343	C38-57	Cold drawn and precipitation hardened afeter fabrication. High strength and general purpose corrosion resistance. Slightly magnetic in spring tempor.
Non-Ferrous Alloy Wire	Phosphor Bronze Grade A ASTM B 159	Cu 94.-96.% Sn 4.-6.%	105-145 (724-1000)	15 (103)	40	6.25 (43.1)	200	93.3	B98-104	Cold drawn. Good corrosion resistance and electrical conductivity.
	Berylium Copper ASTM B 197	Cu 98% Be 2%	150-230 (1034-1586)	18.5 (128)	45	7.0 (48.3)	400	204	C35-42	Cold drawn and may be mill hardened before fabrication. Good corrosion resistance and electrical conductivit. High physicals.
	Monel 400 AMS 7233 Monel K 500 QQ-N-286[3]	Ni 66% Cu 31.5% C/Fe Ni 65.0% Cu 29.5% C/Fe/Al/Ti	145-180 (1000-1241) 160-200 (1103-1379)	26 (179) 26 (179)	40 40	9.5 (65.5) 9.5 (65.5)	450 550	232 28	C23-32 C23-35	Cold drawn. Good corrosion resistance at moderately elevated termperature. Excellent corrosion resistance at moderately elevated temperature.
High temperature Alloy Wire	A 286 Alloy	Ni 26.% Cr 15.% Fe 53.%	160-200 (1103-1379)	29 (200)	35	10.4 (71.7)	950	510	C35-42	Cold drawn and precipitation hardened after fabrication. Good corrosion resistance at elevated temperature.
	Inconel 600 QQ-W-390[3]	Ni 76.% Cr 15.8% Fe 7.2%	170-230 (1172-1586)	31 (214)	40	11.0 (75.8)	700	371	C35-45	Cold drawn. Good corrosion resistance at elevated temperature.
	Inconel 718	Ni 52.5% Cr 18.6% Fe 18.5%	210-250 (1448-1724)	29 (200)	40	11.2 (77.2)	1100	593	C45-50	Cold drawn and precipitation hardened after fabrication. Good corrosion resistance at elevated temperature.
	Inconel x 750 AMS 5698, 5699	Ni 73.% Cr 15.% Fe 6.75%	No. IT 155 Min. 1069 Spg T 190-230 (1310-1586)	31 (214)	40	12 (82.7)	750-1100	399-593	C34-39 C42-48	Cold drawn and precipitation hardened after fabrication. Good corrosion resistance at elevated temperature.

EXPERIMENT NO – 05: COMPRESSION TEST ON CUBE

AIM:- To perform compression test on UTM.

APPARATUS:-

1. UTM or A compression testing m/c,
2. Cylindrical or cube shaped specimen,
3. Vernier caliper,
4. Liner scale.

DIAGRAM:-

THEORY:-

Bricks are used in construction of either load bearing walls or in portion walls incase of frame structure. In bad bearing walls total weight from slab and upper floor comes directly through brick and then it is transversed to the foundation. In case the bricks are loaded with compressive nature of force on other hand in case of frame structure bricks are used only for construction of portion walls, layers comes directly on the lower layers or wall. In this case bricks are loaded with compressive nature of force. Hence for safely measures before using the bricks in actual practice they have to be tested in laboratory for their compressive strength.

PROCEDURE: -

1. Select some brick with uniform shape and size.
2. Measure its all dimensions. (LxBxH)
3. Now fill the frog of the brick with fine sand. And
4. Place the brick on the lower platform of compression testing machine and lower the spindle till the upper motion of ram is offered by a specimen the oil pressure start increasing the pointer start returning to zero leaving the drug pointer that is maximum reading which can be noted down.

TABULATION:- (Refer Tables)

S. No.	L x B x H, Cm^3	Area, L x B, Cm^2	Load (P), N	Compressive Strength (P/A), N/mm^2	Avg. Compressive Strength (P/A), N/mm^2
1					
2					
3					
4					
5					

CALCULATION:-

$$\text{Compressive Strength} = \frac{\text{Max. Load at failure}}{\text{Loaded Area of brick}}$$

RESULT:- The average compressive strength of new brick sample is found to be ………. Kg/sq.cm.

PRECAUTIONS:-

1) Measure the dimensions of Brick accurately.
2) Specimen should be placed as for as possible in the of lower plate.
3) The range of the gauge fitted on the machine should not be more than double the breaking load of specimen for reliable results.

Compressive and tensile strength of some common materials:

Material	Compression Strength		Tension Strength	
	(psi)	*(kPa)*	*(psi)*	*(kPa)*
Bricks, hard	12000	80000	400	2800
Bricks, light	1000	7000	40	280
Brickwork, common quality	1000	7000	50	350
Brickwork, best quality	2000	14000	300	2100
Granite	19000	130000	700	4800
Limestone	9000	60000	300	2100
Portland Cement, less than one month old	2000	14000	400	2800
Portland Cement, more than one year old	3000	21000	500	3500
Portland Concrete	1000	7000	200	1400
Portland Concrete, more than one year old	2000	14000	400	2800
Sandstone	9000	60000	300	2100
Slate	14000	95000	500	3500
Trap rock	20000	140000	800	5500

Image credit: http://www.engineeringtoolbox.com/compression-tension-strength-d_1352.html

EXPERIMENT NO – 06: a) IMPACT TEST (IZOD)

AIM: - To Determine the impact strength of steel by Izod impact test

APPARATUS: - 1.Impact testing machine

2. A steel specimen 75 mm X 10mm X 10mm

DIAGRAM:-

M/C SPECIFICATIONS:

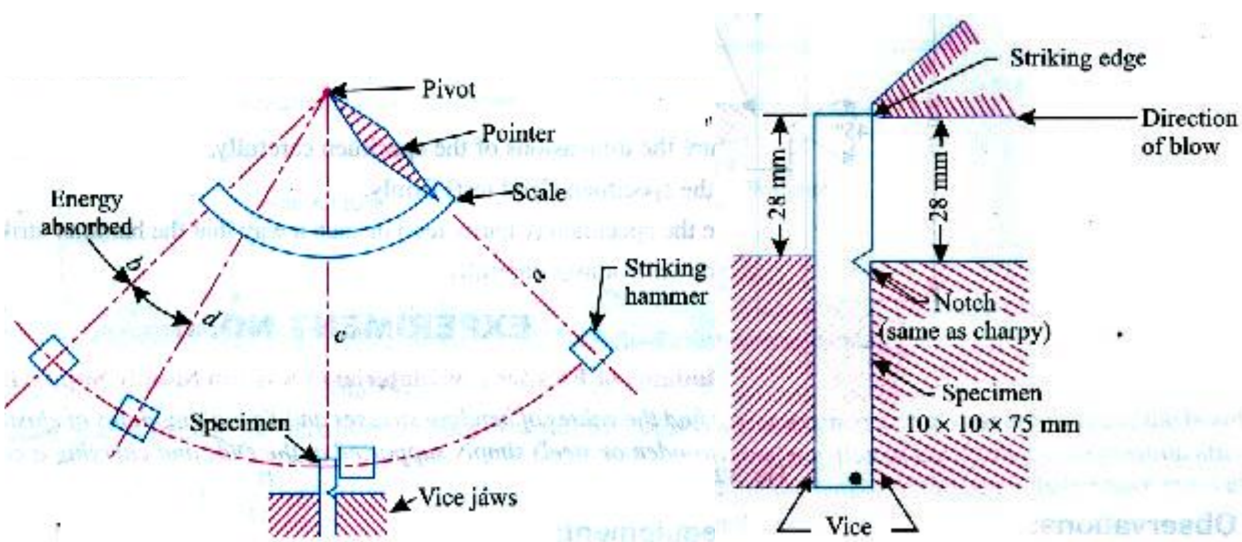
Capacity: Energy range: i. Charpy: 0-300 J.

ii. Izod: 0-168 J.

Model: ITM-300

SR.No: 2001/1016.

Mfd. By: Macro Testing Machines, Ichalkaranji, M.H, India.



THEORY:-

An impact test signifies toughness of material that is ability of material to absorb energy during plastic deformation. Static tension tests of unnotched specimens do not always reveal the susceptibility of a metal to

brittle fracture. This important factor is determined by impact test. Toughness takes into account both the strength and ductility of the material. Several engineering materials have to withstand impact or suddenly applied loads while in service. Impact strengths are generally lower as compared to strengths achieved under slowly applied loads. Of all types of impact tests, the notch bar tests are most extensively used. Therefore, the impact test measures the energy necessary to fracture a standard notch bar by applying an impulse load. The test measures the notch toughness of material under shock loading. Values obtained from these tests are not of much utility to design problems directly and are highly arbitrary. Still it is important to note that it provides a good way of comparing toughness of various materials or toughness of the same material under different condition. This test can also be used to assess the ductile brittle transition temperature of the material occurring due to lowering of temperature.

PROCEDURE:-

(a) lzod test

1. With the striking hammer (pendulum) in safe test position, firmly hold the steel specimen in impact testing machine's vice in such a way that the notch face the hammer and is half inside and half above the top surface of the vice.
2. Bring the striking hammer to its top most striking position unless it is already there, and lock it at that position.
3. Bring indicator of the machine to zero, or follow the instructions of the operating manual supplied with the machine.
4. Release the hammer. It will fall due to gravity and break the specimen through its momentum, the total energy is not absorbed by the specimen. Then it continues to swing. At its topmost height after breaking the specimen, the indicator stops moving, while the pendulum falls back. Note the indicator at that topmost final position.
5. Again bring back the hammer to its idle position and back

OBESERVATIONS:-

Izod Test.

1. Impact value of - Mild Steel ------------N-m
2. Impact value of - Brass ------------N-m
3. Impact value of - Aluminum ------------N-m

RESULT:-

i. The energy absorbed for Mild Steel is found out to be ----------------Joules.

ii. The energy absorbed for Brass is found out to be ------------------- Joules.

iii. . The energy absorbed for Aluminum is found out to be ------------------ Joules

PRECAUTIONS:-

1. Measure the dimensions of the specimen carefully.

2. Hold the specimen (lzod test) firmly.

3. Note down readings carefully.

EXPERIMENT NO – 06: b) IMPACT TEST (CHARPY)

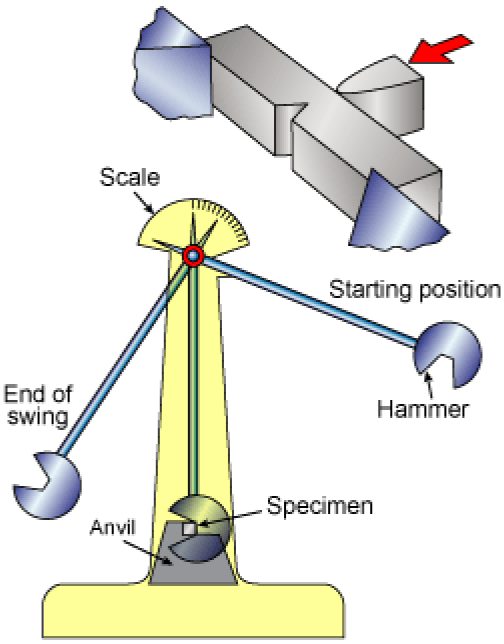
AIM: -To determined impact strength of steel**.**

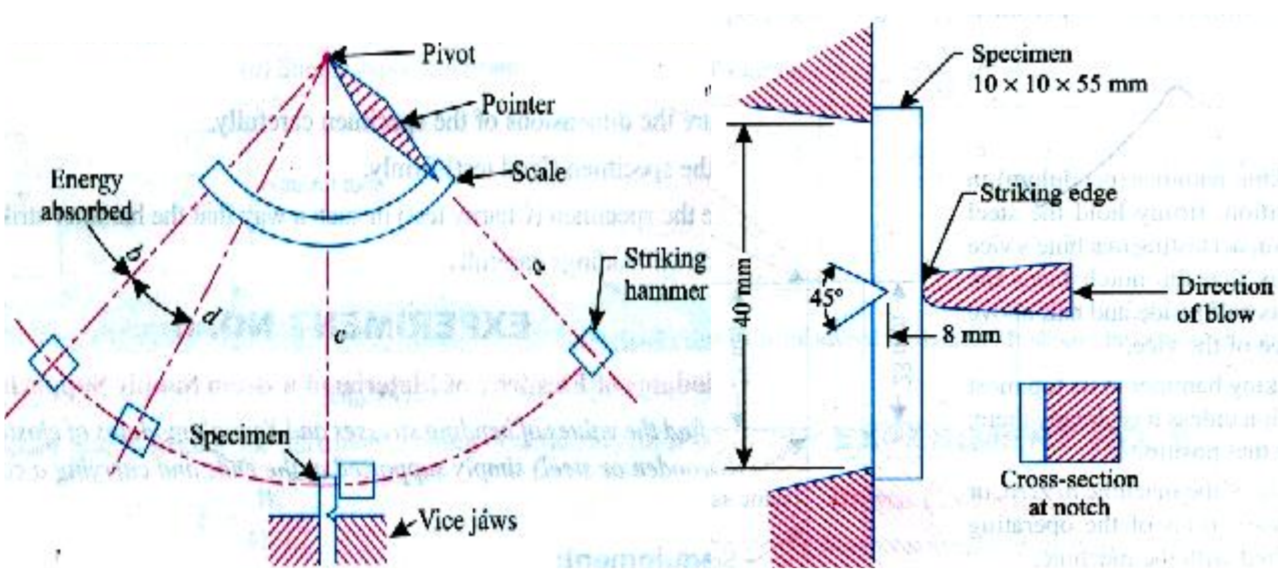
OBJECT: -To Determine the impact strength of steel by (Charpy test)

APPARATUS: -1. Impact testing machine

2. A steel specimen 10 mm x 10 mm X 55mm

DIAGRAM:-





THEORY:-

An impact test signifies toughness of material that is ability of material to absorb energy during plastic deformation. Static tension tests of unmatched specimens do not always reveal the susceptibility of a metal to brittle fracture. This important factor is determined by impact test. Toughness takes into account both the strength and ductility of the material. Several engineering materials have to withstand impact or suddenly applied loads while in service. Impact strengths are generally lower as compared to strengths achieved under

slowly applied loads. Of all types of impact tests, the notch bar tests are most extensively used. Therefore, the impact test measures the energy necessary to fracture a standard notch bar by applying an impulse load. The test measures the notch toughness of material under shock loading. Values obtained from these tests are not of much utility to design problems directly and are highly arbitrary. Still it is important to note that it provides a good way of comparing toughness of various materials or toughness of the same material under different condition. This test can also be used to assess the ductile brittle transition temperature of the material occurring due to lowering of temperature.

PROCEDURE :-

(b) Charpy Test

1. With the striking hammer (pendulum) in safe test position, firmly hold the steel specimen in impact testing machines vice in such a way that the notch faces s the hammer and is half inside and half above the top surface of the vice.
2. Bring the striking hammer to its top most striking position unless it is already there, and lock it at that position.
3. Bring indicator of the machine to zero, or follow the instructions of the operating manual supplied with the machine.
4. Release the hammer. It will fall due to gravity and break the specimen through its momentum, the total energy is not absorbed by the specimen. Then it continues to swing. At its topmost height after breaking the specimen, the indicator stops moving, while the pendulum falls back. Note the indicator at that topmost final position.
5. The specimen is placed on supports or anvil so that the blow of hammer is opposite to the notch.

OBESERVATIONS:-

Charpy test

1. Impact value of - Mild Steel ------------N-m
2. Impact value of - Brass ------------N-m
3. Impact value of - Aluminum ------------N-m

RESULT:-

i.The energy absorbed for Mild Steel is found out to be -------------Joules.

ii. The energy absorbed for Brass is found out to be------------ Joules.

iii. . The energy absorbed for Aluminum is found out to be -------------Joules

PRECAUTIONS:-

1. Measure the dimensions of the specimen carefully.
2. Locate the specimen (Charpy test) in such a way that the hammer, strikes it at the middle.
3. Note down readings carefully.

EXPERIMENT NO – 07: PUNCH SHEAR TEST

AIM: -To find the shear strength of given specimen

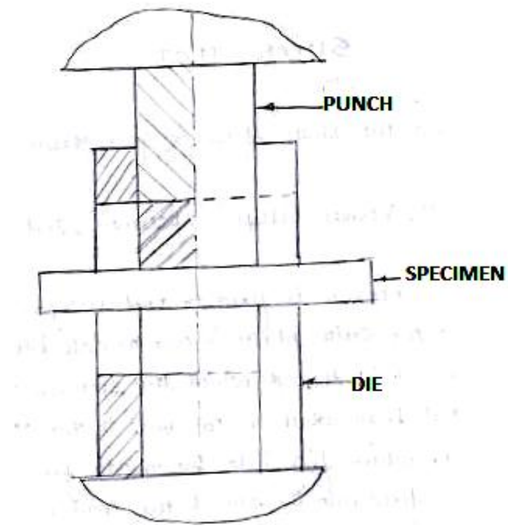
APPARATUS: -

i) Universal testing machine.

ii) Shear test attachment.

iii) Specimens.

DIAGRAM:-



THEORY:-

Place the shear test attachment on the lower table, this attachment consists of cutter. The specimen is inserted in shear test attachment & lift the lower table so that the zero is adjusted, then apply the load such that the specimen breaks in two or three pieces. If the specimen breaks in two pieces then it will be in single shear & if it breaks in three pieces then it will be in double shear.

PROCEDURE:

1. Insert the specimen in position and grip one end of the attachment in the upper portion and one end in the lower portion.

2. Switch on the main switch of universal testing machine machine.

3. The drag indicator in contact with the main indicator.

4. Select the suitable range of loads and space the corresponding weight in the pendulum and balance it if necessary with the help of small balancing weights.

5. Operate (push) buttons for driving the motor to drive the pump.

6. Gradually move the head control level in left-hand direction till the specimen shears.

7. Down the load at which the specimen shears.

8. Stop the machine and remove the specimen

Repeat the experiment with other specimens.

OBESERVATIONS:-

Diameter of the Rod, D = ….. mm

Cross-section area of the Rod (in double shear) = 2x π/4x d^2 =.. mm^2

Load taken by the Specimen at the time of failure , W = N

Strength of rod against Shearing = fx2x π/4x d^2

f = **W / 2.π/4.d^2** N/mm^2

RESULT:

The Shear strength of mild steel specimen is found to be = ……………… N/mm^2

PRECAUTIONS:-

1. The measuring range should not be changed at any stage during the test.

2. The inner diameter of the hole in the shear stress attachment should be slightly greater than that of the specimen.

3. Measure the diameter of the specimen accurately.