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Parameter Selection for Experimental Investigation of Machining Parameters of Inconel -718 for Turning Operation for Green Machining Using AHP

Prasad. P. Kulkarni[1]*, Prasad. P. Kulkarni[1], Dr. S. S. Pawar[2]

*[1]*Research Scholar at Department of Mechanical Engineering, SRK University, Bhopal*
[1]Asst. Prof. at Sandip Institute of Engineering and Management
[2]Professor at Department of Mechanical Engineering, SRK University, Bhopal

***Corresponding Author: -** Prasad. P. Kulkarni*
**Research Scholar at Department of Mechanical Engineering, SRK University, Bhopal*

Abstract:

The most important part in experimental investigation is Parameter selection. The parameter plays crucial role in type of investigation or the performance evaluation. There are many methods to select the parameters. In this research we proposed Analytical Hierarchy Process (AHP) to select the parameter for the experimental investigation of machining parameters of Inconel-718 for turning operation. It will include the structural investigation and questionarie. The Sattey scale is used for the pairwise comparison. There are various parameters we are considering for experimental investigations .These are like Cutting Speed , Feed, Depth of cut, Material removal rate (MRR),surface roughness, tool wear, helix angle etc.

Keywords: Parameter, AHP, Satty Scale

1. Introduction

The parameter selection is an integral and most important thing in experimental investigation. There are Multi Attribute Decision Making and Multi Criteria Decision Making processes used for parameter and criteria selection. The one method we are focusing is Analytical Hierarchy Process (AHP) for parameter selection. There are several methods to select criteria or parameters but generally AHP is most credible decision making method. That’s why naturally AHP is selected for parameter selection. It is also used for criteria selection in performance measurement.

The manufacturing sector is forced to adhere to environmental regulations since we live in a time when environmental concerns are paramount. As a result, green machining is encouraged. An attempt has been made to identify the key parameters in green machining. Energy efficiency (EE), power factor (PF), and energy consumption (EC) are a few of the parameters that play a major role in green machining. Some research focuses on how lowering machine energy usage can lead to green machining. Green manufacturing includes lean manufacturing as well. An attempt has been made to review the literature on the machining of materials similar to Inconel in this work. Additionally, it talks about potential process parameters for Inconel machining optimization. In essence, Inconel 718is essentially a nickel base alloy with low thermal diffusivity, strong strength at high temperatures, and high hardness.

IN For giving prefabricated blocks and other manufactured goods derived from casting or forging their final shape, metal cutting or machining is regarded as one of the most significant and adaptable operations. A

significant amount of components produced globally necessitate machining in order to transform them into final products. This is the only method where the product's final shape is obtained by using a cutting tool to remove superfluous material from the specified work material in the form of chips. The fundamental processes involved in chip generation are drilling, milling, shaping, and turning. Higher strength and heat-resistant materials are becoming more and more in demand, especially for aeronautical applications.
However, because of their mechanical and physical characteristics, such as their great strength and low thermal conductivity, which result in extremely high cutting temperatures and forces and a short tool life, these materials are frequently challenging to process. The three primary categories of high-temperature super alloys are alloys based on nickel, alloys based on cobalt, and alloys based on iron and nickel. The most commonly utilized super alloys are those that are at least 50% nickel based. Because of their high temperature strength, inclination to work harden, and low thermal diffusivity, nickel based super alloys provide quite challenging machinability features. Furthermore, these alloys have an inclination to weld with the tool material at high machining temperatures.
Cutting challenges are further compounded by their great tendency to create built up edge (BUE), as well as the presence of abrasive carbides and hard intermetallic compounds in their microstructure. Titanium alloys make up the remaining 20% of alloys used in aircraft engines, with nickel-based alloys accounting for the majority. Super alloy Because of its exceptional qualities, such as its high heat resistance, strong creep and corrosion resistance, and ability to maintain toughness and strength at high temperatures, Inconel 718 finds extensive use in a variety of manufacturing sectors. The fact that Inconel 718 exhibits outstanding yield strength (550 MPa) even at high temperatures (700–800°C) is crucial. Inconel 718 makes up roughly 70% of the weight of components used in aerospace applications and 50% of the weight of aero-engines.
Additional uses for Inconel 718 include ship engines, nuclear power reactors, and petrochemical facilities in addition to the aerospace industry. Because Inconel 718 alloy is used in such hazardous conditions, it maintains its great resistance to corrosion and fatigue as well as its ability to withstand high temperatures, creeps, and mechanical and thermal shock. Gas turbine blades in aero engines are often made of Inconel-718, which can withstand extremely high temperatures and pressures.

2. Literature Review

2.1 Machining parameter selection based on AHP

Epoxy granite, a novel substitute material, has been created for machine tool structures in order to improve their weight reduction, stability, and damping properties. Because epoxy granite composites (EGCs) are heterogeneous, proper machining is essential. Because characteristics of an optimization problem with various qualities change, choosing the best solution has become a key issue. The Analytical Hierarchy Procedure (AHP), a decision-making process, is used to identify the ideal machining condition for milling EGCs. Evaluation criteria are limited to characteristics that affect the machining process, such as surface roughness, tangential force, and thrust force. According to AHP method computation, experimental run 3 is the ideal solution, with the best machining parameters being 600 rpm and 0.09 m/min of feed rate.
The AHP decision-making model is used in this experimental analysis to establish the best combinations of machining parameters. The research findings are as follows:
By using the decision-making optimization model AHP, experimental option 3 with a machining condition of 600 rpm, feed rate of 0.09 m/min, and fiber content of 4% is found to be the unique ideal answer.

2.2 Analytic Hierarchy Process (AHP)

With options available to the decision maker, the problem structure for choosing a criteria was given in a hierarchical manner by Charan, Shankar in their introduction of the Analytic Hierarchy Process (AHP) based choice model. AHP is a good method for doing both qualitative and quantitative analysis. Unlike previous multi-criteria approaches, this one allows for the easy inclusion of subjective judgments and effectively addresses pertinent contradictions. An optimal pick among available options is the AHP's final result. Thus, the challenge of choosing parameters for experimental investigation is represented in a more accurate and realistic way by the AHP-based approach presented in this study.
A AHP based parameter selection system adoption may not cost a millions of dollars. It may find it easier to execute these because they entail time and operational elements that could ultimately affect the experimenter's success. Furthermore, AHP now engage in competition with one another system. Thus, the decision at hand is not so much whether to pursue it or not as it is which framework to use. In that regard, this research is pertinent. The experiment investigation parameter selection system parameter selection problem was organized hierarchically by the AHP model used in this paper, which also connected the factors

that influence the supply chain performance measurement system and the alternatives available to the decision maker. Therefore, the decision-maker can be given a more accurate and realistic depiction of the problem when choosing appropriate parameters by using the AHP approach described in this study. The difficult chore of prioritizing their selections is made easier for the decision makers by this study. The AHP technique assumes enormous significance in its ability to integrate both quantitative and qualitative features that demand the decision maker's attention in order to arrive at the best potential solution. There are also certain restrictions on the model created in this work. It takes a lot of time and effort to create the pair-wise comparison matrices and get the data. More significantly, the findings presented in this study are predicated on the judgment of the specialists from the case company. Because of this, the user's understanding and acquaintance with the company, its activities, and its sector is always a determining factor in the pairwise comparison of the criteria.

It appears inescapable that we need an organized way to make decisions and collect information relevant to them when a group must decide by laying out all the important factors and negotiating their understanding, beliefs and values. Here are a few examples where the process has been used in practice. The Analytic Hierarchy Process (AHPs) has been used in various settings to make decisions.

Thomas L. Satty is of the opinion that choices need the trade-off of a number of intangibles. In order to achieve this, they must be measured in conjunction with tangibles, the measures of which must also be assessed in terms of how effectively they support the decision maker's goals. The Analytic Hierarchy Process (AHP) is a theory of measurement based on pair wise comparisons that determines priority scales by consulting experts. These scales are used to quantify intangibles in relative terms. A scale of absolute judgments is used to make the comparisons, showing how much more one element dominates another in relation to a particular quality. The decisions could not be consistent, therefore it's important to figure out how to quantify this and, when feasible, enhance the decisions to achieve greater consistency. The AHP is concerned with how to quantify inconsistent judgments and, when feasible, enhance the judgments to achieve greater consistency. By multiplying the derived priority scales by the priority of their parent nodes and adding for each node in the process, the priority scales are synthesized.

In situations where a group must decide by outlining all the pertinent information and negotiating their understanding, views, and values, it seems inevitable that we will require an organized method to make decisions and gather pertinent data. Here are some instances where the procedure has been applied in real-world settings. Decisions have been made using the Analytic Hierarchy Process (AHPs) in a variety of contexts.

The Analytic Hierarchy Process (AHP) was proposed by Jiaqin Yang and Ping Shi as an emerging solution approach to large, dynamic, and complex real-world multi-criteria decision making problems, like the justification of new manufacturing technology and the strategic planning of organizational resources. This paper uses a case study from China to demonstrate the use of the AHP in evaluating a company's long-term overall performance. A crucial part of the company's long-term strategic planning process is an efficient assessment of its entire performance. Because of this, the analytical approach to assessing a firm's total performance has garnered attention recently, particularly for businesses operating in China's particular set of economic, financial, and marketing circumstances. The study's findings demonstrate how an AHP application like this can help managers assess a company's overall performance in their long-term strategic planning process even under complex economic and marketing conditions.

This research has several managerial implications. First, managers can find all the information sources for the necessary input data with the help of the suggested AHP model. The AHP model will tell managers ahead of time about the information they will require under a structured hierarchical organization. Another implication has to do with a more methodical assessment of the performance standards that are oriented toward quality. It is a challenging effort for managers to regularly assess and analyse those qualitative elements in real-world scenarios. One typical criticism is that asking someone to provide a consistent evaluation or comparison on those qualitative elements is unjust or unrealistic because human beings are not capable of offering "absolute" subjective consistency. Because of this, managers will find the suggested AHP model appealing in practice because of its pairwise comparison approach, which restricts managers to providing relative preference assessments on those qualitative characteristics, rather than absolute ones, one at a time. Then, in order to guarantee the consistency of these values, the process will scale these relative comparisons uniquely. To detect any discrepancies at the very beginning of the problem-solving process, the AHP contains a built-in inconsistency checking mechanism.

3. Methodology

3.1 Structural Interview and Discussion

Any performance measuring process should begin with the establishment of the performance assessment criteria, which can be done with the use of structural interviews and literature. The measurements have been determined once the performance measurement criteria have been established. The general traits of the business, the model, or the kind of performance evaluation technique are covered in the structured interview. Internal business processes are chosen as performance evaluation criteria following the structural interview.

3.2 Selection of measures with Analytical Hierarchy Process

The metrics have been chosen once the performance measurement criteria were established. In order to determine internal business process measurements, the case company performed a structural interview. Based on AHP, these measurements have been chosen. These Parameters are listed below.

1) Feed
2) Speed
3) Depth of Cut
4) Nose Radius
5) Environment
6) Tool Clearance

3.2 Analytical Hierarchy Process (AHP) to find the weights of the measures

In this, the % of intensity of factors like material movement, loading time unloading time & operator's efficiencyhave been finalized by discussion in structural interview [10].

To weight and compare pair-wise for all criteria.

The pair wise comparison will be on the base of Satty's scale which is mentioned below:

Table 3.1 Satty'sScale[10]

Verbal judgment or preference	Numerical rating
Extremely preferred	9
Very strongly preferred	7
Strongly preferred	5
Moderately preferred	3
Equally preferred	1
Intermediate values between two adjacent judgments (when compromise is needed)	2, 4, 6, and 8

3.3 Preparation of pair wise comparison matrix. (Mathematical Formulation of problem): -

The pair wise comparison is done on the basis of decision makers views. It may appear as follow:

A1 =

	A	B	C
A	1	R12	R13
B	1/R12	1	R23
C	1/R13	1/R23	1

After preparing the matrix normalize it & find the weight of the each criterion it may appear:-

	Weights
A	X1
B	X2
C	X3

The calculated weights may be consistent or not. If the C.R. is less than 0.10 then the weights are consistent. The consistency ratio (C.R.) for the comparison above is calculated to determine the acceptance of the priority weighting. The consistency test is one of the essential features of the AHP method which aims to eliminate the possible inconsistency revealed in the criteria weights, through the computation of consistency level of each matrix. It is conducted as follows: -
A3= A1 * A2.

3.4 Conduct consistency test.
It is necessary to conduct the consistency test weather
A4= A3/A2.
A5= eig (A4).
C.I.=A5-m\m-1.
C.R.=C.I/R.I.
If C.R < 0.10 then the matrix is consistent.

3.5 Application of AHP for Reamer
The first step of AHP is to find the weights of measures of internal business process

a) Preparation of pair wise comparison matrix. (Mathematical Formulation of problem): -
The pair wise comparison is done on the basis of decision makers views. It may appear as follow:

Table 3.2 Comparison Matrix

	Feed	Speed	Depth of Cut	Nose Radius	Environment	Tool Clearance
Feed	1	1	2	1	3	3
Speed	1	1	4	1	3	3
Depth of Cut	1	1	1	1	1	1
Nose Radius	1/2	1/4	1	1	2	2
Environment	0.333	0.333	0.5	1	1	1
Tool Clearance	0.333	0.333	0.5	1	1	1

Table 3.3 Criteria and weight age

Criteria	Weights
Feed	**24 %**
Speed	**28%**
Depth of Cut	**16%**
Nose Radius	14%
Environment	9%
Tool Clearance	9%

After preparing the matrix normalize it & find the weight of the each criterion it may appear:-
The calculated weights may be consistent or not. If the C.R. is less than 0.10 then the weights are consistent. The consistency ratio (C.R.) for the comparison above is calculated to determine the acceptance of the priority weighting. The consistency test is one of the essential features of the AHP method which aims to eliminate the possible inconsistency revealed in the criteria weights, through the computation of consistency level of each matrix. It is conducted as follows: -

a) Conduct consistency test.

A_1 Matrix =

Table 3.4 Criteria Comparison (A_1 Matrix)

	Feed	Feed	Feed	Feed	Feed	Feed
Feed	1	1	2	1	3	3
Speed	1	1	4	1	3	3
Depth of Cut	1	1	1	1	1	1
Nose Radius	1/2	1/4	1	1	2	2
Environment	0.333	0.333	0.5	1	1	1
Tool Clearance	0.333	0.333	0.5	1	1	1

The above matrix is treated as A1 matrix in case of consistency test. After preparing the matrix normalize it & find the weight of the each criterion is calculated as follow.

A_2 Matrix=

Table 3.5 A_2 Matrix

Feed	**24 %**
Speed	**28%**
Depth of Cut	**16%**

i) Calculate matrices A3 and A4 such that A3=A1 * A2 and A4 = A3 / A2, where A2 = [w1, w2… wj]. These calculations are done in Matlab.

ii) Determine the maximum Eigen Value λmax that is the average of matrix A4.

Λmax = 6.363 (for above A1 and A2 matrix).

iii) Calculate the consistency index CI = (λmax – M) / (M-1). The smaller the value of CI, the smaller is the deviation from the consistency.

CI = (6.363-7) / (6-1) = 0.0726 . . . . . M= 6 number of attributes.

iv) Obtain random index (RI) for the number of attributes used in decision making. Refer below table.

Table 3.6 Random Index Number

Criteria	3	4	5	6	7	8	9	10
RI	0.52	0.89	1.11	1.25	1.35	1.4	1.45	1.49

v) Calculate the consistency ratio CR = CI / RI. Usually, a CR of 0.1 or less is considered as acceptable, and it refers an informed judgment attributable to the knowledge of the analyst.

CR = 0.0726 / 1.25

= 0.05808 ….. < 0.1

If C.R < 0.10 then the matrix is consistent.

As the C.R. is less than the 0.10 hence consistency test result is positive and assigned weight age are confirmed.

After conducting consistency test it is clear that which factor is more intensive & which is less. Also from the above table it is observed that the time require for material movement & loading is more & if it is reduced then the total supply chain cycle time can be reduced. The selected criteria's for performance measurement of internal business process are as follows.

Table 3.7 Criteria and Weight age

Criteria	**Weights**
Feed	**24 %**
Speed	**28%**
Depth of Cut	**16%**

So with the help of consistency test it is proved that weight ages of the selected criteria's are consistent after conducting the consistency test. The most significant criteria of internal business process are Feed, Speed and Depth of Cut.

4. Conclusions

In this paper it is proposed that the one of the most appropriate alternative to select parameter for experimental investigation of machining parameter is Analytical Hierarchy Process (AHP) .There are many parameters like speed, feed, depth of cut, nose radius, environment, machiningtime, tool clearance etc. So it is difficult to choose parameters for experimental investigation. The performance of experimental investigation is depend on right parameters. SoAHP is used to select appropriate parameters. After employing the AHP the speed, feed and depth of cut are selected as parameters for experimental investigation of machining parameters of Inconel-718 for turning operation.

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