

CUTTING PERFORMANCE AND WEAR OF ZTA-TiO<sub>2</sub>-  
Cr<sub>2</sub>O<sub>3</sub> MIXED CERAMIC CUTTING TOOLS WHEN  
TURNING STAINLESS STEEL 316L

BY

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## ABSTRACT

The ZTA-TiO<sub>2</sub>-Cr<sub>2</sub>O<sub>3</sub> ceramic cutting tool is a new cutting tool that possesses good hardness and fracture toughness. However, the performance of the ZTA-TiO<sub>2</sub>-Cr<sub>2</sub>O<sub>3</sub> cutting tool is still unknown and needs further study. In this research, the cutting performance and wear of the ZTA-TiO<sub>2</sub>-Cr<sub>2</sub>O<sub>3</sub> mixed ceramic cutting tools in turning stainless steel 316L are investigated. The tool wears of the ZTA-TiO<sub>2</sub>-Cr<sub>2</sub>O<sub>3</sub> cutting tool and the surface roughness of the machined surface of stainless steel 316L are investigated, and the empirical model for predicting the tool wear was generated. Finally, the comparison of the ZTA-TiO<sub>2</sub>-Cr<sub>2</sub>O<sub>3</sub> and Sandvik ceramic cutting tool is investigated. Preliminary experiments are conducted to set the range of machining where the spindle speeds are in the range of 1000 to 1450 rpm, feed rate from 0.1 to 0.15 mm/rev, and depth of cut of 0.2 mm. Measurements of wear were considered in the analysis before the final parameters were designed for machining. In the design of the experiment, the parameters used for the spindle speed are in the range of 907 to 1543 rpm, feed rate from 0.08 to 0.22 mm/rev, and depth of cut of 0.2 mm. Bridgeport ROMI PowerPath CNC lathe machine is utilized to conduct the turning operation for the experiment. Analysis of the flank wear and crater wear were performed by using an optical microscope (NIKON MM-4001L), while the chipping area was observed by scanning electron microscopy, SEM (JEOL JSM-IT100). The surface roughness of the machined surface is measured via portable surface roughness (Mahr MarSurf M3000C). In the preliminary experiment, the flank wear, crater wear, and surface roughness are decreasing when the spindle speed increased from 1000 to 1450 rpm and the feed rate increased from 0.10 to 0.15 mm/rev. The results obtained from the actual experiment are analyzed by using Design Expert 11 software. It is found that the spindle speed is a significant factor that affects the flank wear and the surface roughness of the machined surface, while the crater wear is more affected by the feed rate of the machining parameters. The optimum cutting parameters are when the spindle speed of 1421.38 rpm, and the feed rate of 0.10 mm/rev. It shows that the cutting tool has good potential in high-speed machining. The comparison between the cutting tool produced in this research and the commercial cutting tool shows that the wear performance of the ZTA-TiO<sub>2</sub>-Cr<sub>2</sub>O<sub>3</sub> ceramic cutting tool is lower than the Sandvik commercial ceramic cutting tool. Even though the commercial cutting tool has superior properties, the fabricated ceramic cutting tool shows some promising aspects such as cutting at a higher speed.



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## خلاصة البحث

أداة قطع السيراميك  $ZTA-TiO_2-Cr_2O_3$  هي أداة قطع جديدة تمتلك صلابة جيّدة وصلابة الكسر. ومع ذلك، لا يزال أداء أداة قطع  $ZTA-TiO_2-Cr_2O_3$  مجهولاً ويحتاج إلى المزيد من الدراسة. وفي هذا البحث، يجري التحقيق في أداء القطع وارتداء أدوات قطع السيراميك المختلطة  $ZTA-TiO_2-Cr_2O_3$  في تحويل 316L الفولاذ التي لا تصدأ. ويتم التحقيق في الأداة الخاصة بأداة القطع  $ZTA-TiO_2-Cr_2O_3$  وخشونة سطح 316L الفولاذية التي لا تصدأ، وتم توليد النموذج التجريبي للنتيجة بارتداء الأداة. وأخيراً، تعرض المقارنة بين أداة قطع  $ZTA-TiO_2-Cr_2O_3$  وأداة قطع الخزف الرملي. التجارب الأولية تجرى في وضع نطاق الآلة حيث تتراوح سرعات الاندفاع بين 1000 إلى 1450 rpm، معدل التغذية من 0.1 إلى 0.15 مم/إنش، وعمق القطع من 0.2 مم. تم النظر في قياسات البلى في التحليل قبل البارامترات النهائية المصممة للماكينات. في تصميم التجربة، تكون البارامترات المستخدمة لسرعة الاندفاع في حدود 907 إلى 1543 rpm، ومعدل التغذية من 0.08 إلى 0.22 ملم/إنش، وعمق القطع 0.2 ملم. وتستخدم آلة بريدجوروت ROMI PowerPath CNC لإجراء عملية تحويل التجربة. وقد أجري تحليل لبس الجناح وارتداء الحفرة باستخدام المجهر البصري (NIKON MM-4001L)، في حين لوحظت منطقة القص بواسطة مسح المجهر الإلكتروني، (SEM (JEOL JSM-IT100). ويقاس خشونة السطح الماكينة من خلال خشونة السطح المحمولة (Mahr MarSurf M3000C). وفي التجربة الأولية، حصلت على أنّ مقدار ارتداء الجناح وارتداء الحفرة والخشونة السطحية يقلل حينما زادت سرعة الدوران من 1000 إلى 1450 rpm وزاد معدل التغذية من 0.10 إلى 0.15 rev/mm. والنتائج استقرت من التجربة الحقيقية يتم تحليلها باستخدام برمجيات خبير التصميم 11. ووجد أن سرعة الدوران هي عامل هام يؤثر على ارتداء الجناح وخشونة سطح السطح الماكيني، في حين أن ارتداء الحفرة يتأثر أكثر بمعدل تغذية بارامترات الماكينات. وبارامترات القطع المثلى هي عندما تكون سرعة الاندفاع 1421.38 rpm، ومعدل التغذية 0.10 ملم/rev. وهو يعرض بأن أداة القطع لها إمكانيات جيدة في استخدام الآلات العالية السرعة. وتبين المقارنة بين أداة القطع التي تم إنتاجها في هذا البحث وأداة القطع التجارية أن أداء أداة القطع السيراميكية  $ZTA-TiO_2-Cr_2O_3$  أقل من أداة قطع السيراميك التجارية في سانديك. وعلى الرغم من أن أداة القطع التجارية لها خصائص متفوّقة، إلا أنّ أداة مصنعة لقطع السيراميك تظهر بعض الجوانب الواعدة مثل القدرة على القطع بسرعة أعلى.

## APPROVAL PAGE

I certify that I have supervised and read this study and that in my opinion, it conforms to acceptable standards of scholarly presentation and is fully adequate, in scope, and quality, as a thesis for the degree of Master of Science (Manufacturing Engineering).

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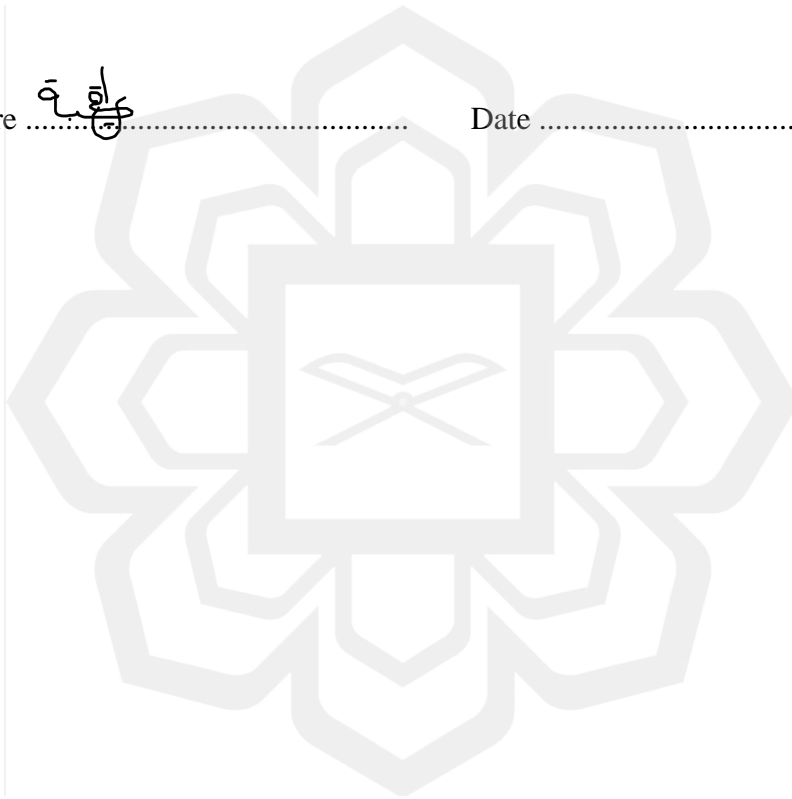
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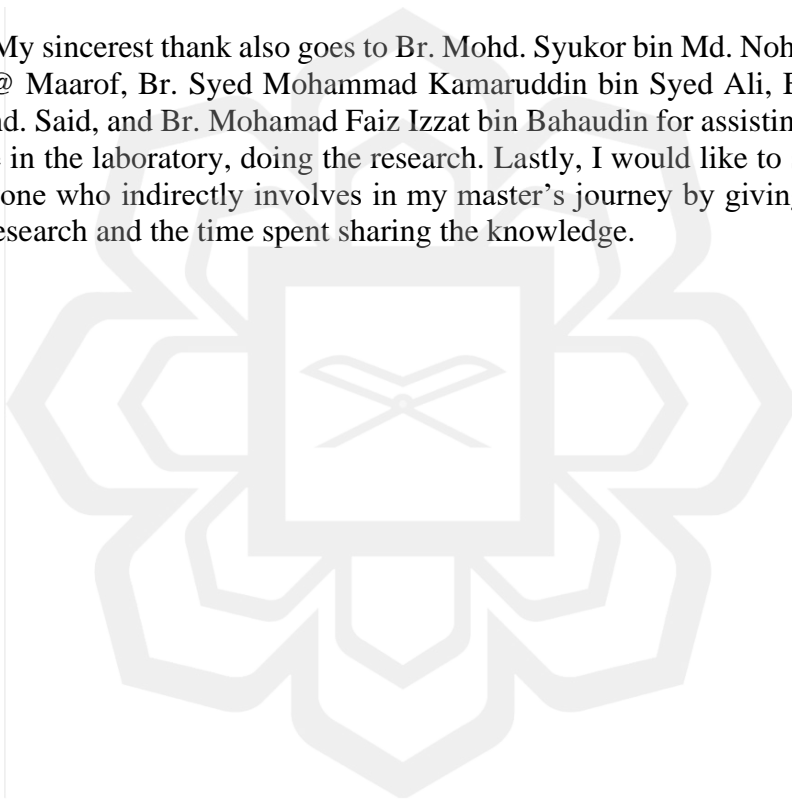
*Thank you for the love, support, and encouragement.*

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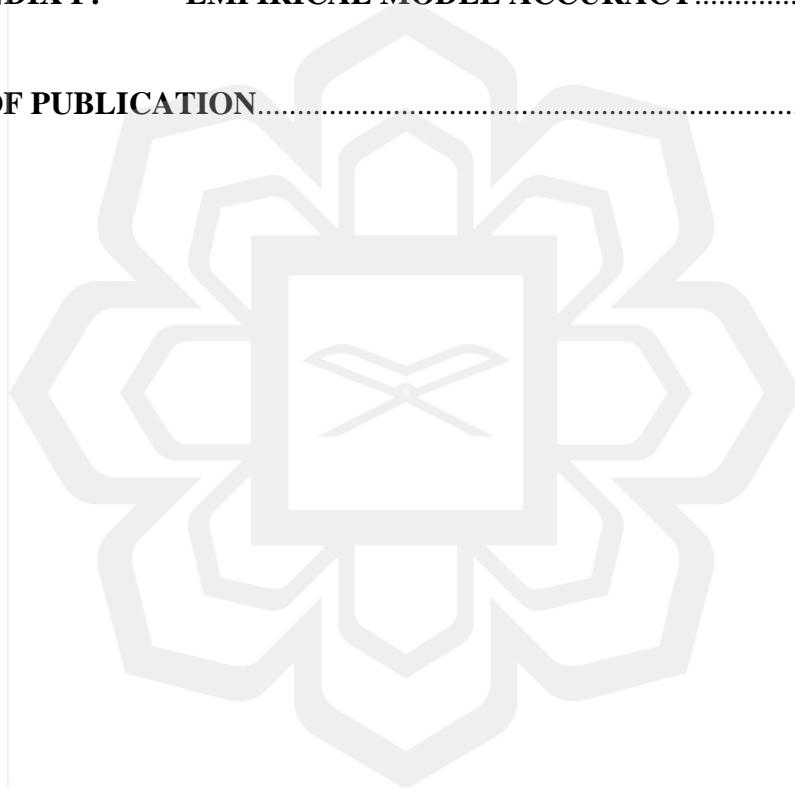
# TABLE OF CONTENTS

Abstract.....	ii
Abstract in Arabic.....	iii
Approval Page.....	iv
Declaration.....	v
Copyright.....	vi
Dedication.....	vii
Acknowledgments.....	viii
Table of Contents.....	ix
List of Tables.....	xiii
List of Figures.....	xv
List of Abbreviations.....	xix
<b>CHAPTER ONE: INTRODUCTION.....</b>	<b>1</b>
1.1 Research Background.....	1
1.2 Problem Statement.....	3
1.3 Research Objectives.....	4
1.4 Scope of the Study.....	4
1.5 Significance of the Study.....	5
<b>CHAPTER TWO: LITERATURE REVIEW.....</b>	<b>6</b>
2.1 Development of the Ceramic Cutting Tool.....	6
2.1.1 Alumina (Al <sub>2</sub> O <sub>3</sub> ) Based Cutting Tool.....	6
2.1.2 Zirconia Toughened Alumina (ZTA) Based Cutting Tool.....	8
2.1.3 Additives Addition.....	10
2.1.3.1 Titania (TiO <sub>2</sub> ).....	10
2.1.3.2 Chromia (Cr <sub>2</sub> O <sub>3</sub> ).....	12
2.2 Tool Wear of the Ceramic Cutting Tool.....	14
2.2.1 Flank Wear.....	15
2.2.2 Crater Wear.....	15
2.2.3 Chipping.....	16
2.3 The Effect of Machining Parameters on Tool Wear of the Ceramic Cutting Tool.....	17
2.4 The Effects of Machining Parameters on Surface Roughness on the Machined Surface.....	20
2.5 The Empirical Model Generated for the Ceramic Cutting Tool using Response Surface Methodology (RSM).....	21
2.6 The Comparison of the Ceramic Cutting Tool Performance to the Commercial Ceramic Cutting Tool.....	22
2.7 Summary.....	23

<b>CHAPTER THREE: METHODOLOGY</b> .....	24
3.1 Introduction.....	24
3.2 Flowcharts.....	24
3.3 Materials and Sample Preparation.....	28
3.3.1 Analysis of the Raw Materials.....	28
3.3.2 Raw Materials Preparation.....	29
3.3.2.1 Calculations.....	29
3.3.2.2 Weighing.....	29
3.3.2.3 Mixing.....	30
3.3.2.4 Drying.....	30
3.3.2.5 Crushing.....	31
3.3.2.6 Pressing.....	32
3.3.2.7 Drying.....	33
3.3.2.8 Sintering.....	34
3.3.3 Properties of the ZTA-TiO <sub>2</sub> -Cr <sub>2</sub> O <sub>3</sub> Cutting Tool.....	34
3.3.3.1 Firing Shrinkage.....	35
3.3.3.2 Bulk Density.....	36
3.3.3.3 Vickers Hardness.....	37
3.3.3.4 Fracture Toughness.....	38
3.3.3.5 XRD.....	39
3.3.3.6 EDX.....	40
3.3.3.7 Microstructure Observation.....	40
3.4 Part 1: The Effects of Machining Parameters on Tool Wear of the ZTA-TiO <sub>2</sub> -Cr <sub>2</sub> O <sub>3</sub> Ceramic Cutting Tool and Surface Roughness on the Machined Surface.....	41
3.4.1 Setup.....	41
3.4.1.1 Cutting Tool.....	42
3.4.1.2 Tool Holder.....	42
3.4.1.3 Workpiece.....	43
3.4.2 Parameter.....	44
3.4.2.1 Preliminary Experiment.....	44
3.4.2.2 Actual Experiment.....	45
3.4.3 Machining.....	46
3.4.4 Tool Wear Analysis.....	46
3.4.4.1 Flank Wear.....	47
3.4.4.2 Crater Wear.....	48
3.4.4.3 Chipping.....	48
3.4.5 Surface Roughness on the Machined Surface.....	49
3.5 Part 2: The Empirical Model for Predicting the Tool Wear of the ZTA-TiO <sub>2</sub> -Cr <sub>2</sub> O <sub>3</sub> Ceramic Cutting Tool and Surface Roughness on the Machined Surface.....	50
3.6 Part 3: The Comparison of the ZTA-TiO <sub>2</sub> -Cr <sub>2</sub> O <sub>3</sub> Ceramic Cutting Tool to the Sandvik Commercial Ceramic Cutting Tool.....	50
3.6.1 Flank Wear.....	51
3.6.2 Chipping.....	51
3.6.3 Surface Roughness on the Machined Surface.....	51
3.7 Summary.....	51

<b>CHAPTER FOUR: RESULT AND DISCUSSION</b> .....	52
4.1 Introduction.....	52
4.2 Characterization of the Raw Materials.....	52
4.3 Properties of ZTA-TiO <sub>2</sub> -Cr <sub>2</sub> O <sub>3</sub> Ceramic Cutting Tool.....	52
4.3.1 Firing Shrinkage.....	53
4.3.2 Bulk Density.....	53
4.3.3 Vickers Hardness.....	53
4.3.4 Fracture Toughness.....	54
4.3.5 X-Ray Diffraction (XRD) Analysis.....	54
4.3.6 Energy dispersive X-ray (EDX) Analysis.....	55
4.3.7 Microstructural Observations.....	56
4.4 Part 1: The Effects of Machining Parameters to the Performance of the ZTA-TiO <sub>2</sub> -Cr <sub>2</sub> O <sub>3</sub> Cutting Tool.....	57
4.4.1 Preliminary Experiment.....	58
4.4.1.1 Flank Wear.....	58
4.4.1.2 Crater Wear.....	62
4.4.1.3 Chipping.....	64
4.4.1.4 Surface Roughness on the Machined Surface.....	66
4.4.2 Actual Experiment.....	68
4.4.2.1 Analysis of Variance Analysis (ANOVA).....	69
4.4.2.1.1 Flank Wear.....	70
4.4.2.1.2 Crater Wear.....	71
4.4.2.1.3 Surface Roughness on the Machined Surface.....	73
4.4.2.2 The Effects of Machining Parameters on Tool Wear and Surface Roughness on the Machined Surface.....	74
4.4.2.2.1 Flank Wear.....	74
4.4.2.2.2 Crater Wear.....	76
4.4.2.2.3 Surface Roughness on the Machined Surface.....	77
4.5 Part 2: The Empirical Model for Predicting the Tool Wear of ZTA-TiO <sub>2</sub> -Cr <sub>2</sub> O <sub>3</sub> Ceramic Cutting Tool and Surface Roughness on the Machined Surface.....	78
4.5.1 Regression Equation.....	81
4.5.1.1 Flank Wear.....	81
4.5.1.2 Crater Wear.....	82
4.5.1.3 Surface Roughness on the Machined Surface.....	83
4.6 Part 3: The Comparison of the ZTA-TiO <sub>2</sub> -Cr <sub>2</sub> O <sub>3</sub> Cutting Tool to the Sandvik Commercial Ceramic Cutting Tool.....	84
4.6.1 Flank Wear.....	85
4.6.2 Chipping.....	87
4.6.3 Surface Roughness.....	89
4.7 Summary.....	90
<b>CHAPTER FIVE: CONCLUSION</b> .....	91
5.1 Conclusion.....	91
5.2 Recommendation.....	92
<b>REFERENCES</b> .....	94

<b>APPENDIX A:</b>	<b>CALCULATION OF MATERIALS COMPOSITION....</b>	<b>100</b>
<b>APPENDIX B:</b>	<b>DENSITY TABLE FOR DISTILLED WATER.....</b>	<b>101</b>
<b>APPENDIX C:</b>	<b>MACHINING WORKS DONE BY PREVIOUS RESEARCHERS.....</b>	<b>102</b>
<b>APPENDIX D:</b>	<b>CHARACTERIZATION OF THE RAW MATERIALS.....</b>	<b>103</b>
<b>APPENDIX E:</b>	<b>LINEAR SHRINKAGE OF ZTA-TiO<sub>2</sub>-Cr<sub>2</sub>O<sub>3</sub> CERAMIC CUTTING TOOL.....</b>	<b>111</b>
<b>APPENDIX F:</b>	<b>EMPIRICAL MODEL ACCURACY.....</b>	<b>112</b>
<b>LIST OF PUBLICATION.....</b>		<b>115</b>



## LIST OF TABLES

Table 3.1	List and characteristic features of the raw materials used to fabricate the ZTA-TiO <sub>2</sub> -Cr <sub>2</sub> O <sub>3</sub> cutting tool	28
Table 3.2	Calculated weight of raw materials used to fabricate the ZTA-TiO <sub>2</sub> -Cr <sub>2</sub> O <sub>3</sub> cutting tool	29
Table 3.3	Properties of workpiece stainless steel 316L	43
Table 3.4	Cutting parameter for the preliminary experiment	44
Table 3.5	Cutting parameter for the actual experiment	45
Table 3.6	Goals in optimizing cutting conditions	50
Table 4.1	EDX weight ratio	56
Table 4.2	Preliminary result for flank wear measurement on the ZTA-TiO <sub>2</sub> -Cr <sub>2</sub> O <sub>3</sub> cutting tool	61
Table 4.3	Preliminary result for crater wear measurement on the ZTA-TiO <sub>2</sub> -Cr <sub>2</sub> O <sub>3</sub> cutting tool	64
Table 4.4	Preliminary result for the chipping area observed on the ZTA-TiO <sub>2</sub> -Cr <sub>2</sub> O <sub>3</sub> cutting tool	65
Table 4.5	Parameters generated in the actual experiment	69
Table 4.6	ANOVA results for flank wear	71
Table 4.7	ANOVA results for crater wear	72
Table 4.8	ANOVA results for surface roughness on the machined surface	74
Table 4.9	Criteria for optimization of cutting conditions	79
Table 4.10	Response optimizations results	79
Table 4.11	Properties of the ZTA-TiO <sub>2</sub> -Cr <sub>2</sub> O <sub>3</sub> ceramic cutting tool and Sandvik commercial ceramic cutting tool	84
Table 4.12	Flank wear measurement of the ZTA-TiO <sub>2</sub> -Cr <sub>2</sub> O <sub>3</sub> cutting tool and Sandvik commercial ceramic cutting tool	86

Table 4.13	Chipping on the ZTA-TiO <sub>2</sub> -Cr <sub>2</sub> O <sub>3</sub> cutting tool and Sandvik commercial ceramic cutting tool	88
Table 4.14	Surface roughness of the machined surface of stainless steel 316L after turning with the ZTA-TiO <sub>2</sub> -Cr <sub>2</sub> O <sub>3</sub> cutting tool and Sandvik commercial ceramic cutting tool	90
Table B.1	Density of distilled water at the different temperatures	101
Table C.1	Summary of machining works done using the ceramic cutting tool by previous researchers	102
Table E.1	Diameter of ZTA-TiO <sub>2</sub> -Cr <sub>2</sub> O <sub>3</sub> cutting tools before and after sintering	111
Table F.1	Sample data for empirical model accuracy validation for flank wear measurement	112
Table F.2	Sample data for empirical model accuracy validation for crater wear measurement	113
Table F.3	Empirical model accuracy validation for surface roughness on the machined surface	114

## LIST OF FIGURES

Figure 2.1	The (a) relative density, (b) hardness of Al <sub>2</sub> O <sub>3</sub> added with ZrO <sub>2</sub> (Hadzley et al., 2019)	8
Figure 2.2	The effect of additives addition on the (a) density, (b) Vickers hardness, (c) fracture toughness of ZTA (Islam et al., 2017)	9
Figure 2.3	The value of (a) bulk density, (b) Vickers hardness, (c) fracture toughness of ZTA with different wt% amounts of TiO <sub>2</sub> content (Manshor et al., 2015)	12
Figure 2.4	The value of (a) bulk density, (b) Vickers hardness, of ZTA-MgO with different wt% amounts of TiO <sub>2</sub> content (Manshor et al., 2016)	12
Figure 2.5	The value of (a) density, (b) Vickers hardness, (c) fracture toughness of ZTA-TiO <sub>2</sub> with different wt% amount of Cr <sub>2</sub> O <sub>3</sub> content (Manshor et al., 2016)	13
Figure 2.6	Examples of SEM images of flank wear and crater wear on the cutting tool (a) (Das et al., 2015), (b) (Lima et al., 2016), (c) (Singh et al., 2016)	14
Figure 2.7	Example of flank wear measurement on the cutting tool (Ali et al., 2015)	15
Figure 2.8	Example of crater wear measurement on the cutting tool (Ali et al., 2016)	16
Figure 2.9	Example of chipping area on the cutting tool (Ali et al., 2018)	17
Figure 2.10	Graph of the flank wear value (mm) vs the (a) cutting speed (rpm) (b) feed rate (mm/rev) (Ali et al., 2015)	18
Figure 2.11	Graph of the flank wear rate vs the cutting speed (Bakar et al., 2018)	18
Figure 2.12	The effect of cutting speed (rpm) on crater wear (mm <sup>2</sup> ) on the cutting tool (a) (Ali et al., 2016), (b) (Ali et al., 2018)	19
Figure 2.13	SEM micrograph of the chipping area at different feed rate (a) 0.1 mm rev, (b) 0.3 mm rev, c) 0.5 mm rev (Ali et al. 2018)	19


Figure 2.14	The effect of cutting speed to the surface roughness on the machined surface, Ra (a) (Ali et al., 2016), (b) (Singh et al., 2016), (c) (Ali et al. 2018)	20
Figure 3.1	Flowchart of the experimental works done in the research	25
Figure 3.2	Flowchart of materials and sample preparation	26
Figure 3.3	Flowchart of machining and analysis process	27
Figure 3.4	Lab Roll ball mill (QM-5)	30
Figure 3.5	Contherm oven (Thermotec 2000)	31
Figure 3.6	Crushed powder by using an agate mortar	31
Figure 3.7	Round mold used for compaction	32
Figure 3.8	Uniaxial hydraulic hand press (Carver)	33
Figure 3.9	ZTA-TiO <sub>2</sub> -Cr <sub>2</sub> O <sub>3</sub> cutting tool arranged on the tray before dry in the oven	33
Figure 3.10	Sintering profile	34
Figure 3.11	Diameter measured on the ZTA-TiO <sub>2</sub> -Cr <sub>2</sub> O <sub>3</sub> sample	35
Figure 3.12	Electronic densimeter (MD-300S)	36
Figure 3.13	Illustration for indentation in Vickers hardness test	37
Figure 3.14	Palmqvist cracks distance measurement	39
Figure 3.15	X-ray diffractometer, XRD (Bruker D2 Phaser)	39
Figure 3.16	SEM-EDX analysis machine	40
Figure 3.17	Scanning electron microscopy, SEM (JEOL JSM-IT100)	41
Figure 3.18	ZTA-TiO <sub>2</sub> -Cr <sub>2</sub> O <sub>3</sub> ceramic cutting tool	42
Figure 3.19	Sandvik Coromant (CRDNN 2525M 09-ID) tool holder	42
Figure 3.20	Stainless steel 316L	43
Figure 3.21	Bridge Port-Romi Powerpath CNC machine	46
Figure 3.22	Optical microscope (NIKON MM-4001L)	47

Figure 3.23	Example of the flank wear measurement	47
Figure 3.24	Example of the crater wear measurement	48
Figure 3.25	Example of the chipping area	49
Figure 3.26	Portable surface roughness (Mahr Marsurf M3000C)	49
Figure 4.1	XRD pattern for ZTA-TiO <sub>2</sub> -Cr <sub>2</sub> O <sub>3</sub> cutting tool	54
Figure 4.2	EDX spectrum for ZTA-TiO <sub>2</sub> -Cr <sub>2</sub> O <sub>3</sub> sample	55
Figure 4.3	Microstructure of ZTA-TiO <sub>2</sub> -Cr <sub>2</sub> O <sub>3</sub> ceramic cutting tool	57
Figure 4.4	Preliminary graph of flank wear (mm) vs spindle speed (rpm) at different feed rate (mm/rev)	59
Figure 4.5	Preliminary graph of flank wear (mm) vs feed rate (mm/rev) at different spindle speed (rpm)	59
Figure 4.6	Preliminary graph of crater wear (mm <sup>2</sup> ) vs spindle speed (rpm) at different feed rate (mm/rev)	63
Figure 4.7	Preliminary graph of crater wear (mm <sup>2</sup> ) vs feed rate (mm/rev) at different spindle speed (rpm)	63
Figure 4.8	Preliminary graph of surface roughness, Ra (μm) of machined surface vs spindle speed (rpm) at different feed rate (mm/rev)	74
Figure 4.9	Preliminary graph of surface roughness Ra (μm) of machined surface vs feed rate (mm/rev) at different spindle speed (rpm)	74
Figure 4.10	Graph of the effect of spindle speed (rpm) and feed rate (mm/rev) on flank wear (mm)	75
Figure 4.11	Graph of the effect of feed rate (mm/rev) and spindle speed (rpm) on crater wear (mm <sup>2</sup> )	76
Figure 4.12	Graph of the effect of feed rate (mm/rev) and spindle speed (rpm) on surface roughness of machined surface (Ra)	78
Figure 4.13	Composite desirability for tool wear and surface roughness of the machined surface	80
Figure 4.14	Graph of predicted vs actual for flank wear on ZTA-TiO <sub>2</sub> -Cr <sub>2</sub> O <sub>3</sub> ceramic cutting tool	82

Figure 4.15	Graph of predicted vs actual for crater wear on ZTA-TiO <sub>2</sub> -Cr <sub>2</sub> O <sub>3</sub> ceramic cutting tool	83
Figure 4.16	Graph of predicted vs actual for surface roughness of the machined surface	84
Figure D.1	XRD pattern for Al <sub>2</sub> O <sub>3</sub> powder	103
Figure D.2	Particle size analysis for Al <sub>2</sub> O <sub>3</sub> powder	104
Figure D.3	Morphology of Al <sub>2</sub> O <sub>3</sub> powder at 20K magnification	104
Figure D.4	XRD pattern for YSZ powder	105
Figure D.5	Particle size analysis for YSZ powder	106
Figure D.6	Morphology of YSZ powder at 20K magnification	106
Figure D.7	XRD pattern for TiO <sub>2</sub> powder	107
Figure D.8	Particle size analysis of TiO <sub>2</sub> powder	108
Figure D.9	Morphology of TiO <sub>2</sub> powder at 30K magnification	108
Figure D.10	XRD pattern for Cr <sub>2</sub> O <sub>3</sub> powder	109
Figure D.11	Particle size analysis of Cr <sub>2</sub> O <sub>3</sub> powder	110
Figure D.12	Morphology of Cr <sub>2</sub> O <sub>3</sub> at 20K magnification	110

## LIST OF ABBREVIATIONS

CNC	Computer Numerical Control
EDX	Energy Dispersive X-Ray
FESEM	Field Emission Scanning Electron Microscope
GPa	Giga Pascal
HV	Vickers Hardness
ICDD	International Centre for Diffraction Data
ISO	International Standards Organization
MPa	Mega Pascal
Ra	Average Roughness
SEM	Scanning Electron Microscope
XRD	X-Ray Diffractometer



# CHAPTER ONE

## INTRODUCTION

### 1.1 RESEARCH BACKGROUND

In the machining of hard materials, ceramic cutting tools are common and widely used. This is due to their outstanding properties such as wear resistance, shock resistance, and high hot hardness as stated in Yin et al. (2015), Wang et al. (2016), Wang et al. (2017), Nandhakumar & Prakash (2017), Islam et al. (2017), Bakar et al. (2018), and Mohamad & Ratnam (2019).

Alumina,  $\text{Al}_2\text{O}_3$  possesses good properties which are ideal for the cutting tool. According to Lee et al. (2016), alumina-based ceramic cutting tools have been a desirable choice for improving the quality of products, minimize the costs of manufacturing and production time. They are also known for operating the cutting process at a high speed and high temperature (Manshor et al., 2016). Despite their good properties, Tan et al. (2018) mentioned some problems are detected while machining with ceramic tools, such as chipping and fracture due to low toughness. Alumina-based cutting tools are also vulnerable to thermal cracking as stated in Varma et al. (2016). Due to that, researchers are performing studies to improve the properties of the tools by adding secondary material. One of the additives that show good potential is zirconia,  $\text{ZrO}_2$  which is added to  $\text{Al}_2\text{O}_3$  to form zirconia toughened alumina, ZTA (Manshor et al., 2016).

ZTA can be a great material for the cutting tool and can be expanded more for further improvement. Varma et al. (2016) mentioned that ZTA is known to be low in cost and ease the fabricating process. Due to their advantageous mechanical properties,

Manshor et al. (2016) stated that it is commonly recognized as a tool material with high hardness, high-temperature strength, and able to sustain the shape of cutting edge at higher temperatures. However, in order to enhance ZTA's properties such as fracture toughness and hardness, the additives are introduced into the ceramic compositions (Ali et al., 2018). Researchers have made many efforts in their studies to develop the mechanical properties of the ZTA cutting tool (Rejab et al., 2016).

One of the additives used in this research is Titania,  $\text{TiO}_2$ . Manshor et al. (2015) mentioned that the sintering temperature of alumina can be reduced with the addition of  $\text{TiO}_2$ . Despite that, it also improved the mechanical properties of the sample. For instance, in the study by Dhar et al. (2015), the density value increased as Vickers hardness increased due to the addition of  $\text{TiO}_2$  as an additive. However, further addition of  $\text{TiO}_2$  resulted in a minor increment of the values mentioned. This data is supported by Manshor et al. (2015), where the value of the density is directly related to the Vickers hardness. Moreover, Manshor et al. (2016) stated that the properties of the sample are excellent for providing resistance to abrasive wear and high-temperature erosion with corresponding to high thermal shock resistance by using  $\text{TiO}_2$  as an additive. It is also known for its low thermal conductivity and high toughness. Although the hardness decreases with the further addition of  $\text{TiO}_2$  due to the reduction in density, adhesion strength and wears resistance improved.

Furthermore, chromia,  $\text{Cr}_2\text{O}_3$  is also used as an additive as it has attracted attention due to its great ability to replace coated carbide or carbide itself (Singh et al., 2016). Due to the addition of  $\text{Cr}_2\text{O}_3$ , grain growth can be observed in the optimum state. Moreover, the density, fracture toughness, and Vickers hardness value of the sample also increased. The interaction between the crack and the matrix grains improved by the creation of large plate-like grains. The strength increased due to grain deflection caused

by the inter-granular fracture mode where the cracks dispersed along the grain's borders. (Manshor et al., 2016).

Due to that, this research will be focusing on the newly developed cutting tool, ZTA added with  $\text{TiO}_2$  and  $\text{Cr}_2\text{O}_3$ . Despite the fact the mentioned cutting tool has been improved, its performance and potential have yet to be fully realized, as the cutting tool's wear has not been thoroughly investigated, particularly in high-speed machining. Thus, this research aimed to further investigate the potential of the ZTA- $\text{TiO}_2$ - $\text{Cr}_2\text{O}_3$  ceramic cutting tool developed from the previous work by Manshor et al. (2016).

## **1.2 PROBLEM STATEMENT**

The great potential of ZTA as a cutting tool makes the researchers keep developing and making improvements to it. Therefore, some additives have been added for this purpose (Ali et al., 2015; Dhar et al., 2015; Manshor et al., 2016; Al Mahmood et al., 2017). As a prove, Manshor et al. (2016) in their work shows that by the addition of  $\text{TiO}_2$  as an additive to the ZTA composition, the wear resistance and adhesion strength improved. Moreover, the study also showed that the effect of the  $\text{Cr}_2\text{O}_3$  additive is bringing some improvements to the composition, such as the increase of fracture toughness. The addition of  $\text{TiO}_2$  and  $\text{Cr}_2\text{O}_3$  to the ZTA composition increased the hardness and fracture toughness.

In conjunction to determine the performance of the ceramic cutting tool, the machining process must be carried out. The tool wears, such as flank wear, crater wear, and chipping can be analyzed throughout the process (Ali et al., 2015; Lima et al., 2017; Tan et al., 2018). Additionally, the surface roughness of the machined surface (Das et

al., 2015; Mir & Wani, 2018) and machining parameters (Singh et al., 2016; Ali et al., 2018) also has been the factors that affect the performance of the tool.

Although the good properties of ZTA-TiO<sub>2</sub>-Cr<sub>2</sub>O<sub>3</sub> have been achieved, the performance of the ZTA-TiO<sub>2</sub>-Cr<sub>2</sub>O<sub>3</sub> cutting tool is unknown and needs further study. A detailed study on the wear of this cutting tool is needed to prove the performance of the tool. As the solutions, tool wear of the ZTA-TiO<sub>2</sub>-Cr<sub>2</sub>O<sub>3</sub> cutting tool and the surface roughness on the workpiece surface will be studied in this research.

### **1.3 RESEARCH OBJECTIVES**

The objectives of this research are:

1. To analyze the flank wear, crater wear, and chipping of ZTA-TiO<sub>2</sub>-Cr<sub>2</sub>O<sub>3</sub> ceramic cutting tool and surface roughness of the machined surface, stainless steel 316L at different parameters.
2. To develop an empirical model for predicting the tool wear of the ZTA-TiO<sub>2</sub>-Cr<sub>2</sub>O<sub>3</sub> ceramic cutting tool.
3. To compare the wears of the ZTA-TiO<sub>2</sub>-Cr<sub>2</sub>O<sub>3</sub> ceramic cutting tool to the Sandvik commercial ceramic cutting tool.

### **1.4 SCOPE OF THE STUDY**

This project analyzes the new ceramic cutting tool, ZTA-TiO<sub>2</sub>-Cr<sub>2</sub>O<sub>3</sub> by turning stainless steel 316L. There are three types of wear that were analyzed from the tool, such as flank wear, crater wear, and chipping. The surface roughness of the machined surface, stainless steel 316L was determined by the value of roughness average, Ra.

The empirical model of the ZTA-TiO<sub>2</sub>-Cr<sub>2</sub>O<sub>3</sub> ceramic cutting tool was developed for predicting the tool wear of the tool by using the RSM model in Design Expert 11 software. The optimum cutting parameter can be chosen by getting the minimum value of the tool wear and the surface roughness of the machined surface, stainless steel 316L. This model was developed for the parameter of spindle speed range from 908 rpm to 1543 rpm, feed rate 0.08 mm/rev to 0.22 mm/rev, and depth of cut 0.2 mm.

The tool wears of the ZTA-TiO<sub>2</sub>-Cr<sub>2</sub>O<sub>3</sub> ceramic cutting tool and Sandvik commercial ceramic cutting tool were compared as a benchmark to improve the performance of the new cutting tool.

## **1.5 SIGNIFICANCE OF THE STUDY**

Good potential on the ZTA-TiO<sub>2</sub>-Cr<sub>2</sub>O<sub>3</sub> ceramic cutting tool can be seen for commercialization due to the improved properties. The performance of the cutting tool has been investigated and compared with Sandvik commercial ceramic cutting tool. The optimum parameters were obtained based on the minimum tool wears and the surface roughness of the machined surface, stainless steel 316L. Therefore, this study could contribute to other researcher's studies by developing the ceramic cutting tool in the steel cutting industry.