

TECHNICAL UNIVERSITY OF MOMBASA

Faculty of Engineering and Technology

DEPARTMENT OF MECHANICAL AND AUTOMOTIVE ENGINEERING

UNIVERSITY EXAMINATIONS FOR DEGREE IN BACHELOR OF SCIENCE IN
MECHANICAL ENGINEERING

(BSME) Y4-S1

EMG 2402: MATERIALS FORMING PROCESSES I

END OF SEMESTER EXAMINATIONS

SERIES: MAY 2016

TIME: 2 HOURS

INSTRUCTIONS:

- ❖ You should have; Answer booklet,; Drawing instruments and Scientific calculator
- ❖ This paper consists of FIVE questions
- ❖ Attempt any THREE questions.

This paper consists of THREE printed pages

QUESTION 1

a) (i) State TWO conditions that determine how well a material may be deep drawn.

(ii) Contrast hot working process with cold working process (4½ marks)

(b) A 40mm square aperture is to be produced on a steel strip of 3mm thick. The shear stress of the material is 450N/mm² and penetration occurs at one quarter of the thickness. If the maximum punch force is to be reduced by one third, and assuming single shear on the punch, calculate:

(i) Amount of shear required (mm)

(ii) Angle of shear (5½ marks)

(c) A cup of final diameter 75mm and height 200mm is to be deep drawn on a press tool. The blank is 1mm thick and the tensile stress is 420 N/mm². The reductions of 50%, 40% , 30% etc . Determine:

(i) Blank size

(ii) Number of drawing operations required and the height after each draw

(iii) Maximum drawing force (10 marks)

QUESTION 2

- a) Describe:
- i) Upsetting
 - ii) Impact extrusion (7 marks)
- b) A copper billet 135mm diameter and 265mm long is extruded at 820° C at a speed of 225mm/s. Using square dies and assuming poor lubrication, estimate the force required in this operation if the final diameter is 60mm. (Take $C=131\text{MPa}$, $m=0.06$) (6 marks)
- c) A 500mm wide 6061-T6 aluminium strip is rolled from a thickness of 21mm to 17mm. If the roll radius is 305mm and roll r.p.m is 115, estimate the total horsepower required for the operation. (Take $K=410\text{MPa}$, $n=0.05$) (7 marks)

QUESTION3

Describe:

- i. Transfer moulding
- ii. Rotational moulding
- iii. Laminated sheet, and
- iv. Injection moulding (20 marks)

QUESTION4

- a) Describe THREE types of ceramics. (3 marks)
- b) Describe the methods of forming ceramics. (6 marks)
- c) A solid cylindrical ceramic part is to be made whose final length is to be $l_f=20\text{mm}$. It has been established that for this material, linear shrinkage during drying and firing are 5% and 9% respectively based on the dried dimension L_d . Calculate:
- (i) Initial length L_o of the part.
 - (ii) The dried porosity P_d if the porosity of the fired part P_f is 6%. (6 marks)
- d) A steel workpiece has a given face with a desired length of 600mm . It is to be cast from a pattern of white iron. This pattern is itself derived from an original wooden pattern. Given that the shrinkage allowance for steel is 15mm/m, and the machining allowance for steel is 16mm/m; and that for white iron the shrinkage allowance is 11mm/m and machining allowance for white iron is 16mm/m, determine:
- i) Dimension of white iron pattern
 - ii) Dimension of wooden pattern (5 marks)

QUESTION5

Describe:

- a) Investment casting
- b) Hot chamber die casting
- c) Centrifugal casting
- d) Slush casting (20 marks)