
CONTENTS

Preface xiii

About the Author xvii

Standard Units and Symbols Used in This Book xviii

1 INTRODUCTION 1

- 1.1 What Is Manufacturing? 3
- 1.2 Materials in Manufacturing 9
- 1.3 Manufacturing Processes 12
- 1.4 Production Systems 20
- 1.5 Images of Manufacturing 24

Part I Material Properties, Product Attributes, and Related Phenomena

2 THE NATURE OF MATERIALS 27

- 2.1 Atomic Structure and the Elements 28
- 2.2 Bonding Between Atoms and Molecules 30
- 2.3 Crystalline Structures 32
- 2.4 Noncrystalline (Amorphous) Structures 38
- 2.5 Engineering Materials 40

3 MECHANICAL PROPERTIES OF MATERIALS 43

- 3.1 Stress–Strain Relationships 44
- 3.2 Hardness 57
- 3.3 Effect of Temperature on Properties 61
- 3.4 Fluid Properties 62
- 3.5 Viscoelastic Behavior of Polymers 65

4 PHYSICAL PROPERTIES OF MATERIALS 73

- 4.1 Volumetric and Melting Properties 74

- 4.2 Thermal Properties 77
- 4.3 Mass Diffusion 79
- 4.4 Electronic Properties 80
- 4.5 Electrochemical Processes 83

5 DIMENSIONS, TOLERANCE, AND SURFACES 86

- 5.1 Dimensions, Tolerances, and Related Attributes 87
- 5.2 Surfaces 88
- 5.3 Effect of Manufacturing Processes 94

6 FRICTION, WEAR, AND LUBRICATION 99

- 6.1 Friction 99
- 6.2 Wear 102
- 6.3 Lubrication 104

Part II Engineering Materials

7 METALS 109

- 7.1 Alloys and Phase Diagrams 110
- 7.2 Ferrous Metals 114
- 7.3 Nonferrous Metals 131
- 7.4 Superalloys 143
- 7.5 Guide to the Processing of Metals 145

8 HEAT TREATMENT OF METALS 149

- 8.1 Annealing 150
- 8.2 Martensite Formation in Steel 150
- 8.3 Precipitation Hardening 154
- 8.4 Surface Hardening 156
- 8.5 Heat Treatment Methods and Facilities 157

9 CERAMICS 162

- 9.1 Structure and Properties of Ceramics 164
- 9.2 Traditional Ceramics 166
- 9.3 New Ceramics 169
- 9.4 Glass 172
- 9.5 Some Important Elements Related to Ceramics 177
- 9.6 Guide to Processing Ceramics 180

10 POLYMERS 183

- 10.1 Fundamentals of Polymer Technology 186
- 10.2 Thermoplastic Polymers 196
- 10.3 Thermosetting Polymers 204

- 10.4 Elastomers 208
- 10.5 Guide to the Processing of Polymers 217

11 COMPOSITE MATERIALS 220

- 11.1 Technology and Classification of Composite Materials 221
- 11.2 Metal Matrix Composites 230
- 11.3 Ceramic Matrix Composites 233
- 11.4 Polymer Matrix Composites 234
- 11.5 Guide to Processing Composite Materials 237

Part III Casting, Molding, and Related Processes

12 FUNDAMENTALS OF METAL CASTING 240

- 12.1 Overview of Casting Technology 242
- 12.2 Heating and Pouring 244
- 12.3 Solidification and Cooling 248

13 METAL CASTING PROCESSES 260

- 13.1 Sand Casting 261
- 13.2 Other Expendable Mold Casting Processes 266
- 13.3 Permanent Mold Casting Processes 272
- 13.4 Foundry Practice 281
- 13.5 Casting Quality 285
- 13.6 Metals for Casting 287
- 13.7 Product Design Considerations 289

14 GLASSWORKING 295

- 14.1 Raw Materials Preparation and Melting 296
- 14.2 Shaping Processes in Glassworking 296
- 14.3 Heat Treatment and Finishing 303
- 14.4 Product Design Considerations 305

15 SHAPING PROCESSES FOR PLASTICS 308

- 15.1 Properties of Polymer Melts 310
- 15.2 Extrusion 313
- 15.3 Production of Sheet and Film 323
- 15.4 Fiber and Filament Production (Spinning) 326
- 15.5 Coating Processes 327
- 15.6 Injection Molding 328
- 15.7 Compression and Transfer Molding 339
- 15.8 Blow Molding and Rotational Molding 341
- 15.9 Thermoforming 346

- 15.10 Casting 350
- 15.11 Polymer Foam Processing and Forming 351
- 15.12 Product Design Considerations 353

16 RUBBER PROCESSING TECHNOLOGY 360

- 16.1 Rubber Processing and Shaping 361
- 16.2 Manufacture of Tires and Other Rubber Products 366
- 16.3 Product Design Considerations 371

17 SHAPING PROCESSES FOR POLYMER MATRIX COMPOSITES 373

- 17.1 Starting Materials for PMCs 374
- 17.2 Open Mold Processes 378
- 17.3 Closed Mold Processes 383
- 17.4 Filament Winding 386
- 17.5 Pultrusion Processes 388
- 17.6 Other PMC Shaping Processes 390

Part IV Particulate Processing for Metals and Ceramics

18 POWDER METALLURGY 393

- 18.1 Characterization of Engineering Powders 396
- 18.2 Production of Metallic Powders 399
- 18.3 Conventional Pressing and Sintering 402
- 18.4 Alternative Pressing and Sintering Techniques 408
- 18.5 Materials and Products for PM 411
- 18.6 Design Considerations in Powder Metallurgy 412

19 PROCESSING OF CERAMICS AND CERMETS 419

- 19.1 Processing of Traditional Ceramics 420
- 19.2 Processing of New Ceramics 427
- 19.3 Processing of Cermets 430
- 19.4 Product Design Considerations 432

Part V Metal Forming and Sheet Metalworking

20 FUNDAMENTALS OF METAL FORMING 435

- 20.1 Overview of Metal Forming 436
- 20.2 Material Behavior in Metal Forming 438
- 20.3 Temperature in Metal Forming 439
- 20.4 Effect of Strain Rate 441
- 20.5 Friction and Lubrication 444

21 BULK DEFORMATION PROCESSES IN METALWORKING 447

- 21.1 Rolling 448
- 21.2 Forging 458
- 21.3 Extrusion 475
- 21.4 Wire and Bar Drawing 487

22 SHEET METALWORKING 500

- 22.1 Cutting Operations 501
- 22.2 Bending Operations 508
- 22.3 Drawing 513
- 22.4 Other Sheet-metal Forming Operations 520
- 22.5 Dies and Presses for Sheet-metal Processes 523
- 22.6 Sheet-metal Operations Not Performed on Presses 530
- 22.7 Bending of Tube Stock 536

Part VI Material Removal Processes

23 THEORY OF METAL MACHINING 543

- 23.1 Overview of Machining Technology 544
- 23.2 Theory of Chip Formation in Metal Machining 548
- 23.3 Force Relationships and the Merchant Equation 552
- 23.4 Power and Energy Relationships in Machining 558
- 23.5 Cutting Temperature 562

24 CUTTING TOOL TECHNOLOGY 568

- 24.1 Tool Life 569
- 24.2 Tool Materials 575
- 24.3 Tool Geometry 584
- 24.4 Cutting Fluids 588

25 MACHINING OPERATIONS AND MACHINE TOOLS 595

- 25.1 Turning and Related Operations 596
- 25.2 Drilling and Related Operations 605
- 25.3 Milling 611
- 25.4 Machining Centers and Turning Centers 619
- 25.5 Other Machining Operations 622
- 25.6 Shape, Tolerance, and Surface Finish 629
- 25.7 Machinability 637
- 25.8 Selection of Cutting Conditions 639
- 25.9 Product Design Considerations in Machining 645

26 GRINDING AND OTHER ABRASIVE PROCESSES 655

- 26.1 Grinding 657
- 26.2 Related Abrasive Process 674

27 NONTRADITIONAL MACHINING AND THERMAL CUTTING PROCESSES 681

- 27.1 Mechanical Energy Processes 682
- 27.2 Electrochemical Machining Processes 686
- 27.3 Thermal Energy Processes 690
- 27.4 Chemical Machining 700
- 27.5 Application Considerations 706

Part VII Joining and Assembly Processes

28 FUNDAMENTALS OF WELDING 712

- 28.1 Overview of Welding Technology 713
- 28.2 The Weld Joint 717
- 28.3 Physics of Welding 720
- 28.4 Features of a Fusion Welded Joint 724

29 WELDING PROCESSES 728

- 29.1 Arc Welding 729
- 29.2 Resistance Welding 739
- 29.3 Oxyfuel Gas Welding 747
- 29.4 Other Fusion Welding Processes 750
- 29.5 Solid-state Welding 753
- 29.6 Weld Quality 758
- 29.7 Weldability 763
- 29.8 Design Considerations in Welding 764

30 BRAZING, SOLDERING, AND ADHESIVE BONDING 770

- 30.1 Brazing 771
- 30.2 Soldering 777
- 30.3 Adhesive Bonding 781

31 MECHANICAL ASSEMBLY 789

- 31.1 Threaded Fasteners 790
- 31.2 Rivets and Eyelets 796
- 31.3 Assembly Methods Based on Interference Fits 798
- 31.4 Other Mechanical Fastening Methods 801
- 31.5 Molding Inserts and Integral Fasteners 802
- 31.6 Design for Assembly 803

Part VIII Surface Processing Operations**32** CLEANING AND SURFACE TREATMENTS 811

- 32.1 Chemical Cleaning 812
- 32.2 Mechanical Cleaning and Surface Preparation 815
- 32.3 Diffusion and Ion Implantation 817

33 COATING AND DEPOSITION PROCESSES 821

- 33.1 Plating and Related Processes 822
- 33.2 Conversion Coatings 826
- 33.3 Physical Vapor Deposition 828
- 33.4 Chemical Vapor Deposition 831
- 33.5 Organic Coatings 834
- 33.6 Porcelain Enameling and Other Ceramic Coatings 838
- 33.7 Thermal and Mechanical Coating Processes 839

Part IX Electronics Manufacturing Technologies**34** PROCESSING OF INTEGRATED CIRCUITS 844

- 34.1 Overview of IC Processing 846
- 34.2 Silicon Processing 850
- 34.3 Lithography 854
- 34.4 Layer Processes Used in IC Fabrication 858
- 34.5 Integrating the Fabrication Steps 865
- 34.6 IC Packaging 867
- 34.7 Yields in IC Processing 872

35 ELECTRONICS ASSEMBLY AND PACKAGING 878

- 35.1 Electronics Packaging 879
- 35.2 Printed Circuit Boards 881
- 35.3 Printed Circuit Board Assembly 890
- 35.4 Surface Mount Technology 894
- 35.5 Electrical Connector Technology 899

Part X Automation and Production Systems**36** PRODUCTION LINES 907

- 36.1 Fundamentals of Production Lines 908
- 36.2 Manual Assembly Lines 911
- 36.3 Automated Production Lines 915

37 PROGRAMMABLE AUTOMATION 924

- 37.1 Numerical Control 925

- 37.2 Industrial Robotics 938
- 37.3 Programmable Logic Controllers 944

38 GROUP TECHNOLOGY AND FLEXIBLE MANUFACTURING SYSTEMS 951

- 38.1 Group Technology 951
- 38.2 Flexible Manufacturing Systems 957

Part XI Support Functions in Manufacturing

39 MANUFACTURING ENGINEERING 966

- 39.1 Process Planning 967
- 39.2 Problem Solving and Continuous Improvement 975
- 39.3 Design for Manufacturability 976
- 39.4 Rapid Prototyping 981

40 PRODUCTION PLANNING AND CONTROL 985

- 40.1 Aggregate Planning and the Master Production Schedule 987
- 40.2 Inventory Control 988
- 40.3 Material and Capacity Requirements Planning 992
- 40.4 Just-in-time Production 997
- 40.5 Shop Floor Control 999

41 MEASUREMENT AND INSPECTION 1006

- 41.1 Metrology 1007
- 41.2 Inspection Principles 1010
- 41.3 Conventional Measuring Instruments and Gages 1013
- 41.4 Surface Measurements 1020
- 41.5 Advanced Measurements and Inspection Technologies 1024

42 QUALITY CONTROL 1033

- 42.1 What Is Quality? 1034
- 42.2 Process Capability 1035
- 42.3 Statistical Tolerancing 1036
- 42.4 Taguchi Methods 1039
- 42.5 Statistical Process Control 1043

INDEX 1053