SEMESTER -4

CODE	COURSE NAME	CATEGORY	L	T	P	CREDIT
MET202	**ENGINEERING THERMODYNAMICS**	**PCC**	**3**	**1**	**-**	**4**

Preamble :

Thermodynamics is the study of energy . Without energy life cannot exist. Activities from breathing to the launching of rockets involves energy transactions and are subject to thermodynamic analysis. Engineering devices like engines, turbines, refrigeration and air conditioning systems, propulsion systems etc., work on energy transformations and must be analysed using principles of thermodynamics. So, a thorough knowledge of thermodynamic concepts is essential for a mechanical engineer. This course offers an introduction to the basic concepts and laws of thermodynamics.

Prerequisite : NIL

Course Outcomes :

After completion of the course the student will be able to

CO1	Understand basic concepts and laws of thermodynamics
CO2	Conduct first law analysis of open and closed systems
CO3	Determine entropy and availability changes associated with different processes
CO4	Understand the application and limitations of different equations of state
CO5	Determine change in properties of pure substances during phase change processes
CO6	Evaluate properties of ideal gas mixtures

Mapping of course outcomes with program outcomes

	PO1	PO2	PO3	PO4	PO5	PO6	PO7	PO8	PO9	PO10	PO11	PO12
CO1	2	2										2
CO2	2	2	1	1								1
CO3	3	3	2	2								1
CO4	2	2	2	2								1
CO5	3	3	2	1								1
CO6	3	3	2	2								1

Assessment Pattern

Blooms Category	CA			ESA
	Assignment	Test - 1	Test - 2	
Remember	25	20	20	10
Understand	25	40	40	20
Apply	25	40	40	70
Analyse	25			
Evaluate				
Create				

Continuous Internal Evaluation Pattern:

Attendance : 10 marks

Continuous Assessment Test (2 numbers) : 25 marks

Assignment/Quiz/Course project : 15 marks

Mark distribution & Duration of Examination :

Total Marks	CA	ESE	ESE Duration
150	50	100	3 Hours

End semester pattern:

There will be two parts; Part A and Part B. Part A contain 10 questions with 2 questions from each module, having 3 marks for each question. Students should answer all questions. Part B contains 2 questions from each module of which student should answer any one. Each question can have maximum 2 sub-divisions and carry 14 marks.

COURSE LEVEL ASSESSMENT QUESTIONS

Course Outcome 1

1. Discuss the limitations of first law of thermodynamics.

2. Second law of thermodynamics is often called a directional law . Why?

3. Explain Joule-Kelvin effect. What is the significance of the inversion curve ?

Course Outcome 2

1. A mass of 2.4 kg of air at 150 kPa and 12°C is contained in a gas – tight, frictionless piston – cylinder device. The air is now compressed to a final pressure of 600 kPa . During this process, heat is transferred from the air such that the temperature inside the cylinder remains constant. Calculate the work input during this process.

2. Carbon dioxide enters an adiabatic nozzle steadily at 1 MPa and 500°C with a mass flow rate of 600 kg/hr and leaves at 100 kPa and 450 m/s. The inlet area of the nozzle is 40 cm^2. Determine (a) the inlet velocity and (b) the exit temperature

3. A vertical piston – cylinder device initially contains 0.25 m^3 of air at 600 kPa and 300°C. A valve connected to the cylinder is now opened and air is allowed to escape until three-quarters of the mass leave the cylinder at which point the volume is 0.05 m^3. Determine the final temperature in the cylinder and the boundary work during this process.

Course Outcome 3

1.An adiabatic vessel contains 2 kg of water at 25˚C. B paddle – wheel work transfer, the temperature of water is increased to 30˚C. If the specific heat of water is assumed to be constant at 4.186 kJ/kg.K, find the entropy change of the universe.

2. Two kilograms of water at 80°C is mixed adiabatically with 3 kg of water at 30°C in a constant pressure process at 1 atm. Find the increase in entropy of the total mass of water due to the mixing process.

3. Argon enters an insulated turbine operating under steady state at 1000˚C and 2 MPa and exhausts at 350 kPa. The mass flow rate is 0.5 kg/s and the turbine develops power at the rate of 120 kW. Determine (a)the temperature of the argon at the turbine exit, (b) the irreversibility of the turbine and (c) the second law efficiency. Neglect KE and PE effects. Take T_o = 20˚C and P_o = 1 bar

Course Outcome 4

1. What are the limitations of ideal gas equation and how does Van der Waals equation overcome these limitations ?

2. Discuss law of corresponding states and its role in the construction of compressibility chart.

3. A rigid tank contains 2 kmol of N_2 and 6 kmol of CH_4 gases at 200 K and 12 MPa. Estimate the volume of the tank, using (a) ideal gas equation of state (b) the compressibility chart and Amagat's law

Course Outcome 5

1.Steam is throttled from 3 MPa and 600˚C to 2.5 MPa. Determine the temperature of the steam at the end of the throttling process.

2. Determine the change in specific volume, specific enthalpy and quality of steam as saturated steam at 15 bar expands isentropically to 1 bar. Use steam tables

3. Estimate the enthalpy of vapourization of steam at 500 kPa, using the Clapeyron equation and compare it with the tabulated value

Course Outcome 6

1. A gaseous mixture contains , by volume, 21%nitrogen, 50% hydrogen and 29 % carbon dioxide. Calculate the molecular weight of the mixture, the characteristic gas constant of the mixture and the value of the reversible adiabatic expansion index - γ. At 10˚C, the C_p values of nitrogen, hydrogen and carbon dioxide are 1.039, 14.235 and 0.828 kJ/kg.K respectively.

2. A mixture of 2 kmol of CO_2 and 3 kmol of air is contained in a tank at 199 kPa and 20˚C. Treating air to be a mixture of 79% N_2 and 21% O_2 by volume , calculate (a) the individual mass of CO_2 , N_2 and O_2, (b) the percentage content of carbon by mass in the mixture and (c) the molar mass , characteristic gas constant and the specific volume of the mixture

3. A gas mixture in an engine cylinder has 12% CO_2, 11.5 % O_2 and 76.5% N_2 by volume. The mixture at 1000˚C expands reversibly, according to the law $PV^{1.25}$ = constant, to 7 times its initial volume. Determine the work transfer and heat transfer per unit mass of the mixture.

SYLLABUS

Module 1: Role of Thermodynamics and it's applications in Engineering and Science –Basic Concepts Macroscopic and Microscopic viewpoints, Concept of Continuum, Thermodynamic System and Control Volume, Surrounding, Boundaries, Types of Systems, Universe, Thermodynamic properties, Process, Cycle, Thermodynamic Equilibrium, Quasi – static Process, State, Point and Path function. Zeroth Law of Thermodynamics, Measurement of Temperature, reference Points, Temperature Scales.

Module 2: Energy - Work - Pdv work and other types of work transfer, free expansion work, heat and heat capacity. Joule's Experiment- First law of Thermodynamics - First law applied to Non flow Process- Enthalpy- specific heats- PMM1, First law applied to Flow Process, Mass and Energy balance in simple steady flow process. Applications of SFEE, Transient flow –Filling and Emptying Process, Limitations of the First Law.

Module 3: Second Law of Thermodynamics, Thermal Reservoir, Heat Engine, Heat pump – Kelvin-Planck and Clausius Statements, Equivalence of two statements, Reversibility, Irreversible Process, Causes of Irreversibility, PMM2, Carnot's theorem and its corollaries, Absolute Thermodynamic Temperature scale. Clausius Inequality, Entropy- Entropy changes in various thermodynamic processes, principle of increase of entropy and its applications, Entropy generation, Entropy and Disorder, Reversible adiabatic process- isentropic process, Third law of thermodynamics, Available Energy, Availability and Irreversibility- Second law efficiency.

Module 4: Pure Substances, Phase Transformations, Triple point, properties during change of phase, T-v, p-v and p-T diagram of pure substance, p-v-T surface, Saturation pressure and Temperature, T-h and T-s diagrams, h-s diagrams or Mollier Charts, Dryness Fraction, steam tables. Property calculations using steam tables. The ideal Gas Equation, Characteristic and Universal Gas constants, Deviations from ideal Gas Model: Equation of state of real substances, Vander Waals Equation of State, Virial Expansion, Compressibility factor, Law of corresponding state, Compressibility charts.

Module 5: Mixtures of ideal Gases – Mole Fraction, Mass fraction, Gravimetric and volumetric Analysis, Dalton's Law of partial pressure, Amagat's Laws of additive volumes, Gibbs-Dalton's law Equivalent Gas constant and Molecular Weight, Properties of gas mixtures: Internal Energy, Enthalpy, specific heats and Entropy, Introduction to real gas mixtures- Kay's rule. General Thermodynamic Relations – Combined First and Second law equations – Helmholtz and Gibb's functions - Maxwell's Relations, Tds Equations. The Clapeyron Equation, equations for internal energy, enthalpy and entropy, specific heats, Throttling process, Joule Thomson Coefficient, inversion curve.

Text Books

1. P. K. Nag, Engineering Thermodynamics, McGraw Hill, 2013

2. E. Rathakrishnan Fundamentals of Engineering Thermodynamics, PHI, 2005

3. Y. A. Cengel and M. A. Boles, Thermodynamics an Engineering Approach, McGraw Hill, 2011

Reference Books:

1. Moran J., Shapiro N. M., Fundamentals of Engineering Thermodynamics, Wiley, 2006

2. R. E. Sonntag and C. Borgnakke, Fundamentals of Thermodynamics, Wiley, 2009

3. Holman J. P. Thermodynamics, McGraw Hill, 2004

4. M. Achuthan, Engineering Thermodynamics, PHI, 2004

COURSE PLAN

Module	Topics	Hours Allotted
1	Role of Thermodynamics and it's applications in Engineering and Science – Basic Concepts Macroscopic and Microscopic viewpoints, Concept of Continuum, Thermodynamic System and Control Volume, Surrounding, Boundaries, Types of Systems, Universe	1L
	Thermodynamic properties, Process, Cycle, Thermodynamic Equilibrium, Quasi – static Process, State, Point and Path function.	1L
	Zeroth Law of Thermodynamics, Measurement of Temperature, reference Points, Temperature Scales.	2L + 1T
2	Energy - Work - Pdv work and other types of work transfer, free expansion work, heat and heat capacity.	2L + 1T
	Joule's Experiment- First law of Thermodynamics - First law applied to Non flow Process- Enthalpy- specific heats- PMM1	2L + 1T
	First law applied to Flow Process, Mass and Energy balance in simple steady flow process. Applications of SFEE	2L + 1T
	Transient flow –Filling and Emptying Process, Limitations of the First Law.	1L + 1T
3	Second Law of Thermodynamics, Thermal Reservoir, Heat Engine, Heat pump – Kelvin-Planck and Clausius Statements, Equivalence of two statements	2L
	Reversibility, Irreversible Process, Causes of Irreversibility, PMM2, Carnot's theorem and its corollaries, Absolute Thermodynamic Temperature scale.	2L + 1T
	Clausius Inequality, Entropy- Entropy changes in various thermodynamic processes, principle of increase of entropy and its applications, Entropy generation, Entropy and Disorder, Reversible adiabatic process- isentropic process, Third law of thermodynamics	2L + 1T
	Available Energy, Availability and Irreversibility- Second law efficiency.	2L + 1T
	Pure Substances, Phase Transformations, Triple point, properties during change of phase, T-v, p-v and p-T diagram of pure substance, p-v-T surface,	2L

4	Saturation pressure and Temperature, T-h and T-s diagrams, h-s diagrams or Mollier Charts, Dryness Fraction, steam tables. Property calculations using steam tables	2L + 1T
	The ideal Gas Equation, Characteristic and Universal Gas constants, Deviations from ideal Gas Model: Equation of state of real substances, Vander Waals Equation of State, Virial Expansion, Compressibility factor, Law of corresponding state, Compressibility charts.	2L +1T
5	Mixtures of ideal Gases – Mole Fraction, Mass fraction, Gravimetric and volumetric Analysis, Dalton's Law of partial pressure, Amagat's Laws of additive volumes, Gibbs-Dalton's law.	2L
	Equivalent Gas constant and Molecular Weight, Properties of gas mixtures: Internal Energy, Enthalpy, specific heats and Entropy	1L +1T
	Introduction to real gas mixtures- Kay's rule	1L
	General Thermodynamic Relations – Combined First and Second law equations – Helmholtz and Gibb's functions - Maxwell's Relations	2L
	Tds Equations. The Clapeyron Equation, equations for internal energy, enthalpy and entropy, specific heats, Throttling process, Joule Thomson Coefficient, inversion curve.	2L + 1T

MODEL QUESTION PAPER

APJ ABDUL KALAM TECHNOLOGICAL UNIVERSITY

FOURTH SEMESTER B.TECH DEGREE EXAMINATION

Course Code : MET202

Course Name : ENGINEERING THERMODYNAMICS

(Permitted to use Steam Tables and Mollier Chart)

Max. Marks : 100 Duration : 3 Hours

Part – A

Answer all questions.

1. Define thermodynamics. List a few of its applications

2.Differentiate between intensive and extensive properties.

3. Differentiate between heat and work.

4. Explain system approach and control volume approach as applied in the analysis of a flow process.

5. An inventor claims to have developed an engine that delivers 26 kJ of work using 82 kJ of heat while operating between temperatures 120°C and 30°C. Is his claim valid ? Give the reason for your answer.

6. Show that two reversible adiabatics cannot intersect

7.Define (i)critical point and (ii) triple point, with respect to water

8. Why do real gases deviate from ideal gas behaviour? When do they approach ideal behaviour?

9. Define Helmholtz function and Gibbs function and state their significance

10. Explain Kay's rule of real gas mixtures

(3 x 10 = 30 marks)

Part – B

Answer one full question from each module.

Module - 1

11.a] Explain macroscopic and microscopic approach to thermodynamics . (7 marks) b] With the aid of a suitable diagram, explain the working of constant volume gas thermometer. (7 marks)

OR

12.a] What is meant by thermodynamic equilibrium ? What are the essential conditions for a system to be in thermodynamic equilibrium ? (7 marks)

b] Express the temperature of 91^{o}C in (i) Farenhiet (ii) Kelvin (iii) Rankine. (7 marks)

Module – 2

13.a] A mass of 2.4 kg of air at 150 kPa and 12°C is contained in a gas – tight, frictionless piston – cylinder device. The air is now compressed to a final pressure of 600 kPa . During this process, heat is transferred from the air such that the temperature inside the cylinder remains constant. Calculate the work input during this process. (7 marks)

b] A 2 m^3 rigid tank initially contains air at 100 kPa and 22^{o}C. The tank is connected to a supply line through a valve. Air is flowing in the supply line at 600 kPa and 22^{o}C. The valve is opened, and air is allowed to enter the tank until the pressure in the tank reaches the line pressure, at which point the valve is closed. A thermometer placed in the tank indicates that the air temperature at the final state is 77^{o}C. Determine, (i) the mass of air that has entered the tank and (ii) the amount of heat transfer. (7 marks)

OR

14.a] A turbine operates under steady flow conditions, receiving steam at the following conditions : pressure 1.2 MPa, temperature 188°C, enthalpy 2785 kJ/kg, velocity 33.3 m/s and elevation 3m. The steam leaves the turbine at the following conditions : pressure 20 kPa, enthalpy 25kJ/kg, velocity 100 m/s, and elevation 0 m. Heat is lost to the surroundings at the rate of 0.29 kJ/s. If the rate of steam flow through the turbine is 0.42 kg/s, what is the power output of the turbine in kW ? (7 marks)

b] State the general energy balance equation for an unsteady flow system and from it, derive the energy balance equation for a bottle filling process, stating all assumptions. (7 marks)

Module – 3

15.a]State the Kelvin-Planck and Clausisus statements of the second law of thermodynamics and prove their equivalence. (7 marks)

b]A heat engine operating between two reservoirs at 1000 K and 300 K is used to drive a heat pump which extracts heat from the reservoir at 300 K at a rate twice that at which the engine rejects heat to it. If the efficiency of the engine is 40 % of the maximum possible and the COP of the heat pump is 50 % of the maximum possible, what is the temperature of the reservoir to which the heat pump rejects heat ? What is the rate of heat rejection from the heat pump, if the rate of heat supply to the engine is 50kW ? (7 marks)

OR

16.a] A house is to be maintained at 21°C during winter and at 26°C during summer. Heat leakage through the walls, windows and roof is about 3000 kJ/hr per degree temperature difference between the interior of the house and the environment. A reversible heat pump is proposed for realising the desired heating and cooling. What is the minimum power required to run the heat pump in the reverse, if the outside temperature during summer is 36°C? Also find the lowest environment temperature during winter for which the inside of the house can be maintained at 21°C consuming the same power. (7 marks)

b] Air enters a compressor in steady flow at 140 kPa, 17°C and 70 m/s and leaves at 350 kPa, 127°C and 110 m/s. The environment is at 100 kPa and 7°C. Calculate per kg of air (a) the actual work required (b) the minimum work required and (c) the irreversibility of the process. (7 marks)

Module – 4

17.a]Show the constant pressure transformation of unit mass of ice at atmospheric pressure and -20^{o}C to superheated steam at 220^{o}C on P-v , T-v and P-T coordinate systems and explain their salient features . (7 marks)

b] A rigid vessel of volume 0.3 m^3 contains 10 kg of oxygen at 300 K. Using (i) the perfect gas equation and (ii) the Van der Waal's equation of state, determine the pressure of oxygen in the vessel. Take the Van der Waal's constants for oxygen as a =0.1382 m^6 Pa/ mol^2 and b=0.03186 m^3/ kmol . (7 marks)

OR

18.a]Steam at 25 bar and 300^{o}C expands isentropically to 5 bar. Calculate the change in enthalpy, volume and temperature of unit mass of steam during this process using steam tables and Mollier chart and compare the values (7 marks)

b]Explain law of corresponding states and its significance to the generalized compressibility chart. (7 marks)

Module – 5

19.a] Derive the expressions for the equivalent molecular weight and characteristic gas constant for a mixture of ideal gases. (6 marks)

b] 0.5 kg of Helium and 0.5 kg of Nitrogen are mixed at 20^{o}C and at a total pressure of 100 kPa. Find (i) volume of the mixture (ii) partial volumes of the components (iii) partial pressures of the components (iv) the specific heats of the mixture and (v) the gas constant of the mixture. Take ratio of specific heats for Helium and Nitrogen to be 1.667 and 1.4 respectively. (8 marks)

OR

20.a] 2 kg of carbon dioxide at 38°C and 1.4 bar is mixed with 5 kg of nitrogen at 150°C and 1.03 bar to form a mixture at a final pressure of 70 kPa. The process occurs adiabatically in a steady flow apparatus. Calculate the final temperature of the mixture and the change in entropy during the mixing process. Take specific heat at constant pressure for CO_2 and N_2 as 0.85 kJ/kg.K and 1.04 kJ/kg respectively. (7 marks)

b]Derive the Maxwell relations. Explain their significance ? (7 marks)

MET 204	MANUFACTURING PROCESS	CATEGORY	L	T	P	Credits	Year of Introduction
		PCC	3	1	0	4	2019

Preamble:

1. To gain theoretical and practical knowledge in material casting processes and develops an understanding of the dependent and independent variables which control materials casting in a production processes.
2. Provide a detailed discussion on the welding process and the physics of welding. Introduce students to different welding processes weld testing and advanced processes to be able to appreciate the practical applications of welding.
3. The course will also provide methods of analysis allowing a mathematical/physical description of forming processes.
4. Correlate the material type with the possible fabrication processes
5. Generate solutions to problems that may arise in manufacturing engineering

Prerequisite: MET 205 Metallurgy and material science

Course Outcomes - At the end of the course students will be able to

CO 1	Illustrate the basic principles of foundry practices and special casting processes, their advantages, limitations and applications.
CO 2	Categorize welding processes according to welding principle and material.
CO 3	Understand requirements to achieve sound welded joint while welding different similar and dissimilar engineering materials.
CO 4	Student will estimate the working loads for pressing, forging, wire drawing etc. processes
CO 5	Recommend appropriate part manufacturing processes when provided a set of functional requirements and product development constraints.

Mapping of course outcomes with program outcomes (Minimum requirements)

	PO 1	PO 2	PO 3	PO 4	PO 5	PO 6	PO 7	PO 8	PO 9	PO 10	PO 11	PO 12
CO 1	3	-	-	-	-	-	-	-	-		-	-
CO 2	-	-	-	-	-	-	-	-	-	-	-	2
CO 3	-	-	3	-	-	-	-	-	-	-	-	-
CO 4	-	-	-	3	-	-	-	-	-	-	-	-
CO 5	-	4	-	-	-	-	-	-	-	-	-	-

Assessment Pattern

Bloom's taxonomy	Continuous Assessment Tests		End Semester Examination (Marks)
	Test I (Marks)	Test II (Marks)	
Remember	25	25	25
Understand	15	15	15
Apply	30	25	30
Analyse	10	10	10
Evaluate	10	15	10
Create	10	10	10

Mark distribution

Total Marks	CIE marks	ESE marks	ESE duration
150	50	100	3 Hours

Continuous Internal Evaluation (CIE) Pattern:

Attendance	10 marks
Regular class work/tutorials/assignments	15 marks
Continuous Assessment Test (Minimum 2 numbers)	25 marks

End semester pattern:- There will be two parts; Part A and Part B. Part A contain 10 questions with 2 questions from each module, having 3 marks for each question. Students should answer all questions. Part B contains 2 questions from each module of which student should answer any one. Each question can have maximum 2 sub-divisions and carry 14 marks.

COURSE LEVEL ASSESSMENT QUESTIONS

Part -A

Course Outcome 1 (CO1): - Illustrate the basic principles of foundry practices and special casting processes, their Advantages, Limitations and Applications

1. Why draft allowances are important for patterns.
2. What are the importances of permeability of molding sand?
3. How runner extension is helpful for good casting quality.
4. Internal corners are more prone to solidification shrinkages than external corners. Explain?
5. Which of the casting processes would be suitable for making small toys in large numbers? Why?

Course Outcome 2 (CO2):

Categorize welding processes according to welding principle and material

1. Why is the quality of welds produced by submerged arc welding very good?
2. What does the strength of a weld nugget in resistance spot welding depends on?
3. What is the strength of a welded joint is inferior or superior to the parent metal? Why?
4. Why some joints may have to be preheated prior to welding.

Part -B

Course Outcome 3 (CO3): Understand requirements to achieve sound welded joint while welding different similar and dissimilar engineering materials.

1. Assume that you are asked to inspect a weld for a critical application. Describe the procedure you would follow. If you find a flaw during your inspection, how would you go about determining whether or not this flaw is important for the particular application?
2. In the building of large ships, there is a need to weld large sections of steel together to form a hull, for this application, which welding process would you select? Why?

Course Outcome 4 (CO4): Student will estimate the working loads for pressing, forging, wire drawing etc. processes

1. How can you tell whether a certain part is forged or cast? Describe the features that you would investigate to arrive at a conclusion.
2. Two solid cylindrical specimens A and B, made of a perfectly plastic material, are being forged with friction and isothermally at room temperature to a reduction in height of 50%. specimen A has a height of 2 inch and cross sectional area of 1 square inch, and specimen B has a height of is 1 inch and a cross sectional area of 2 square inch will the work done be the same for the two specimens? Explain.

Course Outcome 5 (CO5): Recommend appropriate part manufacturing processes when provided a set of functional requirements and product development constraints.

1. Many missile components are made by spinning. What other methods would you use to make missile components if spinning process were not available? Describe the relative advantages and limitations of each method.
2. Suggest a suitable casting process for making an engine piston with Aluminum alloy. What type of mould can be used?
3. Suggest and explain a suitable welding method for welding railway tracks for trains.
4. Suggest a suitable manufacturing process for screw jack, postulate the fundamentals.

SYLLABUS

Module I

Casting:-Characteristics of sand - patterns- cores- -chaplets- simple problems- solidification of metals and Chvorinov's rule - Elements of gating system- risering -chills –simple problems- Special casting process- Defects in castings- Super alloy Production Methods.

Module II

Welding:-welding metallurgy-heat affected zone- grain size and hardness- stress reliving- joint quality -heat treatment of welded joints - weldability - destructive and non destructive tests of welded joints-

Thermit welding, friction welding - Resistance welding: HAZ, process and correlation of process parameters with welded joints - applications of each welding process- Arc welding:-HAZ, process and correlation of process parameters with welded joints- simple problems - applications of each welding process - Oxyacetylene welding:-chemistry, types of flame and its applications - brazing- soldering - adhesive bonding.

Module III

Rolling**:**- principles - types of rolls and rolling mills - mechanics of flat rolling-Defects-vibration and chatter - flat rolling -miscellaneous rolling process- simple problems - Bulk deformation of metals :- State of stress; yield criteria of Tresca, von Mises, comparisons; Flow rules; power and energy deformations; Heat generation and heat transfer in metal forming process.

Module IV

Forging: methods analysis, applications, die forging, defects in forging - simple problems - Metal extrusion:- metal flow, mechanics of extrusion, miscellaneous process, defects, simple problems, applications - Wire, Rod, and tube drawing:- mechanics of rod and wire drawing, simple problems, drawing defects - swaging, applications – deep drawing.

Module V

Locating and clamping methods- locating methods- locating from plane, circular, irregular surface.
Locating methods and devices- simple problems - Basic principles of clamping -Sheet metal operations- Press tool operations-Tension, Compression, tension and compression operations - applications - Fundamentals of die cutting operations - simple problems - types of die construction.

Text Books

1. Donalson cyril, LeCain, Goold, Ghose:- Tool design, McGraw Hill.
2. Serope Kalpakjian, Steven R. Schmid - Manufacturing Engineering and Technology, Pearson.

Reference

1. Joseph R. Davis, S. L. Semiatin, American Society for Metals - ASM Metals Handbook, Vol. 14 Forming and Forging ASM International (1989).
2. Peter Beeley, Foundry Technology, Butterworth-Heinemann
3. Rao P.N., Manufacturing Technology, Volume -1, Tata McGraw Hill.
4. Taylan Altan, Gracious Ngaile, Gangshu Shen - Cold and Hot Forging Fundamentals and Applications - ASM International (2004).
5. Matthew J. Donachie, Stephen J. Donachie, Super alloys A Technical Guide, Second Edition, 2002 ASM International.

MODEL QUESTION PAPER

MANUFACTURING PROCESS - MET 204

Max. Marks : 100 **Duration : 3 Hours**

Part – A

Answer all questions, each question carries 3 marks

1. Why does porosity have detrimental effects on the mechanical properties of castings? Which physical properties like thermal and electrical conductivity also are affected by porosity? explain

2. Large parts cannot be manufactured by the centrifugal casting, comment on the statement.
3. What does the strength of a weld nugget in resistance spot welding depends on?
4. Explain how the atmosphere around the work piece affect the weld obtained in electron beam welding.
5. What is the importance of roll velocity and strip velocity?
6. Explain a suitable rolling process for making threaded fasteners.
7. Explain why forged parts withstand high loads compared to cast parts.
8. Explain why the die pressure in drawing process decreases towards the exit of the die.
9. What is the basic rule for applying clamping forces?
10. What is generally used as the basic reference plane for locating?

PART -B

Answer one full question from each module.

MODULE – 1

11. What is gating ratio? What considerations affect its selection? What are the typical gating ratios for the following applications? (a) Grey iron bed castings made in cast steel, (b) Valve body castings made in cast steel, (c) Aluminum pistons for automobiles, (d) Large gun metal bushes for bearings (14 marks).

OR

12. Explain different types of casting defeats in detail with effects of each defect on quality of the casting (14 marks).

MODULE – 2

13. a. Two plates were welded together and then the strength of the joint was tested. It is found that the weld was stronger than either of the plates. Do you think that the statement is incorrect? Postulate, giving valid reasons with neat sketches (7 marks).

    b. what are the methods available for controlling the distortions in welded assembly structure? Describe their relative effects and application(7 marks).

OR

14. a. Two 1-mm thick, flat Copper sheets are being spot welded using a current of 5000A and a current flow time of t=0.18 seconds the electrodes are 5mm in diameter. Estimate the heat generated in the weld zone (7 marks).

    b. Explain why some joints may have to be preheated prior to welding? If the parts to be welded are preheated, is the likelihood that porosity will form increased or decreased? Explain(7 marks).

MODULE – 3

15. a. An annealed Copper strip 228mm wide and 25mm thick is rolled to a thickness 20mm in one pass. The roll radius is 300mm and the rolls rotate at 100rpm. Calculate the roll force and the power required in this operation (7 marks).

    b. A 100mm square billet is to be rolled into a rod of 12.5mm diameter. Draw the sequence of operations (7 marks).

OR

16. Explain the yield criteria of Tresca, von Mises and compare each other (14 marks).

MODULE – 4

17. a. Explain why crankshaft of an automobile is manufactured by forging and not by casting (7 marks).
    b. Estimate the limiting drawing ratio that you would expect from a sheet metal that, when stretched by 23 percentages in length, decreases in thickness by 10 percentages (7 marks).

OR

18. a. Assume that you are reducing the diameter of two round rods, one by simple tension and the other by indirect extrusion. Which methods would be better? Explain (7 marks).
    b. A cylindrical specimen made of annealed 4135 steel has a diameter of 6 inches and is 4inch high. It is upset by open die forging with flat dies to a height of 2inch at room temperature. Assuming that the coefficient of friction is 0.2, calculate the force required at the end of the stroke. Use average pressure formula (7 marks).

MODULE – 5

19. Estimate the force required in punching a 25mm diameter hole through a 3.2mm thick annealed Titanium Ti-6Al-4V sheet at room temperature (5 marks).
    b. Explain 3-2-1 principle of locating with neat sketches (9 marks).

OR

20. a. determine the die and punch sizes for blanking a circular disc of 20mm diameter from a C20 steel sheet whose thickness is 1.5mm (7 marks).
    b. Explain how is unevenness compensated for when locating against an irregular surface with more than three locating points? (7 marks).

Course content and lecture schedules.

Module	TOPIC	No. of hours	Course outcomes
1.1	Casting:-Characteristics of sand -pattern and allowances -type of patterns-cores-core prints-chaplets-simple problems.	2	CO1
1.2	Elements of gating system-gating system, pouring time, choke area -risering Caine's method-chills –simple problems.	2	CO1 CO5
1.3	Special casting process:-shell molding, precision investment, die casting, centrifugal casting, continues casting, squeeze casting surface roughness obtainable and application of each casting process.	2	
1.4	Defects in castings :- Shaping faults arising in pouring, Inclusions and sand defects, Gas defects, Shrinkage defects, Contraction defects, Dimensional errors, Compositional errors and segregation; significance of defects on Mechanical properties . (Kalpakjian, Beeley, Rao).	2	CO1
1.5	Superalloy Production Methods: Vacuum Induction Melting; Electroslag Remelting; Vacuum Arc Remelting (ASM).	1	
2.1	Welding:-welding metallurgy, diffusion, heat affected zone, driving force for grain growth, grain size and hardness- joint quality: porosity, slag inclusions, cracks, surface damage, residual stress lamellar tears, stress reliving, heat treatment of welded joints - weldability (Kalpakjian, Lindberg) - destructive and non destructive tests of welded joints (may be provided as class assignment - Lindberg).	2	CO2

2.2	Resistance welding: HAZ, process and correlation of process parameters with welded joints of spot, seam, projection, stud arc, percussion welding-applications of each welding process –simple problems. (Kalpakjian).	3	CO2 CO5
2.3	Arc welding:-HAZ, process and correlation of process parameters with welded joints of shielded metal arc, submerged, gas metal, flux cored, electrogas, electroslag, gas tungsten, plasma arc, electron beam, laser beam –simple problems - Thermit welding, friction welding- applications of each welding process. (Kalpakjian, Lindberg).	3	CO2
2.4	Oxyacetylene welding:-chemistry, types of flame and its applications - brazing- soldering - adhesive bonding.	1	
3.1	Rolling**:**- principles - types of rolls and rolling mills - mechanics of flat rolling, roll pressure distribution, neutral point, front and back tension, torque and power, roll forces in hot rolling, friction, deflection and flattening, spreading -– simple problems.	3	CO4 CO5
3.2	rolling defects-vibration and chatter - flat rolling -miscellaneous rolling process: shape, roll forging, ring, thread and gear, rotary tube piercing, tube rolling - applications – simple problems. (Kalpakjian).	2	CO4
3.3	Plastic deformation of metals - stress-strain relationships- State of stress - yield criteria of Tresca, von Mises, and comparisons - applications.	2	
3.4	Flow rules -power and energy deformations - Heat generation and heat transfer in metal forming process -temperature in forging. (ASM- Taylan Altan).	1	CO4
4.1	Forging: material characterization; grain flow and strength - Forging**:**-classification - open die forging, forces and work of deformation - Forging methods analysis:- slab method only, solid cylindrical, rectangular work piece in plane strain, forging under sticking condition - simple problems -applications.	3	CO4
	Deformation zone geometry – die forging: - impression, close, coining, skew rolling etc. –simple problems– defects in forging. (Kalpakjian).	1	
4.2	Metal extrusion: - metal flow - mechanics of extrusion:-deformation and friction, actual forces, die angle, forces in hot extrusion - miscellaneous process- defects -—simple problems- applications. (Kalpakjian, Lindberg).	2	
4.3	Wire, Rod, and tube drawing: - mechanics of rod and wire dramwing: deformation, friction, die pressure and angle, temperature, reduction per pass, drawing flat strip and tubes- –simple problems- drawing defects-swaging-applications. (Kalpakjian, Lindberg, Rao).	2	CO4
4.4	Deep drawing- deep drawbility, simple problems - different drawing practices	1	
5.1	Locating and clamping methods: - basic principle of location; locating methods; degrees of freedom; locating from plane, circular, irregular surface –simple problems.	2	CO4
	Locating methods and devices: - pin and button locators, rest pads and plates, nest or cavity location.	1	

5.2	Basic principles of clamping:-strap, cam, screw, latch, wedge, hydraulic and pneumatic clamping –simple problems. (Donaldson, Wilson F.W.).	2	CO4
5.3	Sheet metal operations: Press tool operations: shearing action, shearing operations: blanking, piercing, simple problems, trimming, shaving, nibbing, notching – simple problems - applications.	2	CO4 CO5
5.4	Tension operations: stretch forming - Compression operations: - coining, sizing, ironing, hobbing - tension and compression operations: drawing, spinning, bending, forming, embossing – simple problems- applications. (Donaldson, Wilson F.W., Rao P.N).	2	CO4
	Fundamentals of die cutting operations - inverted, progressive and compound die - simple problems. (Donaldson)	1	

CODE	COURSE NAME	CATEGORY	L	T	P	CREDIT
MET206	FLUID MACHINERY	PCC	3	1	-	4

Preamble :

This course provides an understanding of reciprocating and rotary fluid machinery. The course consists of hydraulic pumps, turbines, air compressors and gas turbines

Prerequisite : NIL

Course Outcomes :

After completion of the course the student will be able to

CO1	Explain the characteristics of centrifugal and reciprocating pumps
CO2	Calculate forces and work done by a jet on fixed or moving plate and curved plates
CO3	Explain the working of turbines and Select a turbine for specific application.
CO4	Analyse the working of air compressors and Select the suitable one based on application.
CO5	Analyse gas turbines and Identify the improvements in basic gas turbine cycles.
CO6	Explain the characteristics of centrifugal and reciprocating pumps

Mapping of course outcomes with program outcomes

	PO1	PO2	PO3	PO4	PO5	PO6	PO7	PO8	PO9	PO10	PO11	PO12
CO1	3	3	2									
CO2	3	3	2									
CO3	3	3	2									
CO4	3	3	2									
CO5	3	3	2									

Assessment Pattern

Blooms Category	CA			ESA
	Assignment	Test - 1	Test - 2	
Remember	25	20	20	10
Understand	25	40	40	20
Apply	25	40	40	70
Analyse	25			
Evaluate				
Create				

Continuous Internal Evaluation Pattern:

Attendance : 10 marks

Continuous Assessment Test (2 numbers) : 25 marks

Assignment/Quiz/Course project : 15 marks

Mark distribution & Duration of Examination :

Total Marks	CA	ESE	ESE Duration
150	50	100	3 Hours

End semester pattern:

There will be two parts; Part A and Part B. Part A contain 10 questions with 2 questions from each module, having 3 marks for each question. Students should answer all questions. Part B contains 2 questions from each module of which student should answer any one. Each question can have maximum 2 sub-divisions and carry 14 marks.

Course Outcome 1

1. A centrifugal pump discharges 0.15 m^3/s of water against a head of 12.5 m, the speed of the impeller being 600 r.p.m. The outer and inner diameters of impeller are 500 mm and 250 mm respectively and the vanes are bent back at 35° to the tangent at exit. If the area of flow remains 0.07 m^2 from inlet to outlet, calculate :
   (a) Manometric efficiency of pump,
   (b) Vane angle at inlet, and
   (c) Loss of head at inlet to impeller when discharge is reduced by 40% without changing the speed.
2. (a) What is slip in a reciprocating pump. What is the reason for negative slip in a reciprocating pump.
   (b) A single acting reciprocating pump having a bore of 150 mm and a stroke of 300 mm length, discharges 250 l of water per minute at 50 rpm. Neglecting losses, find theoretical discharge and slip of the pump.
   (c) With a neat sketch explain the working of a gear pump.
3. Explain the following terms as they are applied to a centrifugal pump:
   (a) Static suction lift,
   (b) static suction head,
   (c) static discharge head and
   (d) total static head.

Course Outcome 2

1. Prove that the force exerted by a jet of water on a fixed semi-circular plate in the direction of the jet when the jet strikes at the centre of the semi-circular plate is two times the force exerted by the jet on an fixed vertical plate.
2. Show that the angle of swing of a vertical hinged plate is given by

$$\sin\theta = \frac{\rho a V^2}{W}$$

   where V = Velocity of the jet striking the plate, a = Area of the jet, and W = Weight of the plate.
3. A jet of water moving at 60 m/s is deflected by a vane moving at 25 m/s in a direction at 30° to the direction of the jet. The water jet leaves the blade normally to the motion of the vanes. Draw the inlet and outlet velocity triangles and find the vane angles for no shock at entry or exit. Take the relative velocity at outlet to be 0.85 of the relative velocity at inlet.

Course Outcome 3

1. Explain the purpose of providing
   (a) scroll casing
   (b) stay vanes
   (c) guide vanes, for a reaction turbine.

2. A Pelton wheel turbine has a mean bucket speed of 12 m/s with a jet of water flowing at a rate of 900 l/s under a head of 40 m. The bucket deflects the jet at an angle of 165°. Calculate the power given by the water to the runner and the hydraulic efficiency of the turbine. Draw the velocity triangle. Assume the coefficient of velocity to be 0.96.

3. (a) What are the unit quantities used to analyze the performance of hydraulic turbines. Explain its importance.
   (b) What is specific speed of a turbine.

Course Outcome 4

1. With a neat sketch explain the working of centrifugal compressors.

2. An ideal single stage single acting reciprocating compressor logs a displacement volume of 14 litres and a clearance volume of 5%. It intakes air at 1 bar and delivers the same at 7 bar. The compression is polytropic with an index of 1.3 and re-expansion is isentropic with an index of 1.4. Determine the indicated work of a cycle.

3. What is surging in axial flow compressor? What are its effects? Describe briefly.

Course Outcome 5

1. A gas turbine unit operates at a mass flow of 30 kg/s. Air enters the compressor at a pressure of 1 bar and temperature 15 $°C$ and is discharged from the compressor at a pressure of 10.5 bar. Combustion occurs at constant pressure and results in a temperature rise of 420 K. If the flow leaves the turbine at a pressure of 1.2 bar, determine the net power output from the unit and also the thermal efficiency. Take $C_p = 1.005kJ/kgK$ and $\gamma = 1.4$.

2. Derive the expression for maximum specific work output of a gas turbine considering machine efficiencies.

3. Write a short note on different type of compression chambers used in a gas turbine engine.

SYLLABUS

Module 1: Impact of jets: Introduction to hydrodynamic thrust of jet on a fixed and moving surface (flat and curve),– Series of vanes - work done and efficiency. Hydraulic Turbines : Impulse and Reaction Turbines – Degree of reaction – Pelton Wheel – Constructional features - Velocity triangles – Euler's equation – Speed ratio, jet ratio and work done, losses and efficiencies, design of Pelton wheel – Inward and outward flow reaction turbines- Francis Turbine – Constructional features – Velocity triangles, work done and efficiencies. Axial flow turbine (Kaplan) Constructional features – Velocity triangles- work done and efficiencies

Module 2: Characteristic curves of turbines – theory of draft tubes – surge tanks – Cavitation in turbines – Governing of turbines – Specific speed of turbine , Type Number– Characteristic curves, scale Laws – Unit speed – Unit discharge and unit power. Rotary motion of liquids – free, forced and spiral vortex flows Rotodynamic pumps- centrifugal pump impeller types,-velocity triangles- manometric head- work, efficiency and losses, H-Q characteristic, typical flow system characteristics, operating point of a pump. Cavitation in centrifugal pumps- NPSH required and available- Type number-Pumps in series and parallel operations. Performance characteristics- Specific speed-Shape numbers – Impeller shapes based on shape numbers.

Module 3: Positive displacement pumps- reciprocating pump – Single acting and double acting- slip, negative slip and work required and efficiency- indicator diagram- acceleration head - effect of acceleration and friction on indicator diagram – speed calculation- Air vessels and their purposes, saving in work done to air vessels multi cylinder pumps. Multistage pumps-selection of pumps- pumping devices-hydraulic ram, Accumulator, Intensifier, Jet pumps, gear pumps, vane pump and lobe pump.

Module 4: Compressors: classification of compressors, reciprocating compressor-single stage compressor, equation for work with and without clearance volume, efficiencies, multistage compressor, intercooler, free air delivered (FAD).
Centrifugal compressor-working, velocity diagram, work done, power required, width of blades of impeller and diffuser, isentropic efficiency, slip factor and pressure coefficient, surging and chocking. Axial flow compressors:- working, velocity diagram, degree of reaction, performance. Roots blower, vane compressor, screw compressor.

Module 5 Gas turbines: classification, Thermodynamic analysis of gas turbine cycles-open, closed and semi closed cycle; ideal working cycle- Brayton cycle-P-v and T-s diagram, thermal efficiency. Effect of compressor and turbine efficiencies. Optimum pressure ratio for maximum specific work output with and without considering machine efficiencies. Comparison of gas turbine and IC engines, Analysis of open cycle gas turbine, Improvements of the basic gas turbine cycles-regeneration, intercooling and reheating-cycle efficiency and work output-Condition for minimum compressor work and maximum turbine work. Combustion chambers for gas turbines. pressure loss in combustion process and stability loop.

Text books

Subramanya, K., Hydraulic Machines, Tata McGraw Hill, 1st edition, 2017

Rathore, M., Thermal Engineering, Tata McGraw Hill, 1st edition, 2010

Reference Books

Ganesan, V., Gas Turbines, Tata McGraw Hill, 3rd edition, 2017.

Sawhney G.S., Thermal and Hydraulic Machines, Prentice Hall India Learning Private Limited; 2nd edition , 2011

COURSE PLAN

Module	Topics	Hours Allotted
I	Impact of jets: Introduction to hydrodynamic thrust of jet on a fixed and moving surface (flat and curve),– Series of vanes - work done and efficiency Hydraulic Turbines : Impulse and Reaction Turbines – Degree of reaction – Pelton Wheel – Constructional features - Velocity triangles – Euler's equation – Speed ratio, jet ratio and work done, losses and efficiencies, design of Pelton wheel – Inward and outward flow reaction turbines- Francis Turbine – Constructional features – Velocity triangles, work done and efficiencies. Axial flow turbine (Kaplan) Constructional features – Velocity triangles- work done and efficiencies	6-3-0
II	Characteristic curves of turbines – theory of draft tubes – surge tanks – Cavitation in turbines – Governing of turbines – Specific speed of turbine , Type Number– Characteristic curves, scale Laws – Unit speed – Unit discharge and unit power. Rotary motion of liquids – free, forced and spiral vortex flows Rotodynamic pumps- centrifugal pump impeller types,-velocity triangles- manometric head- work, efficiency and losses, H-Q characteristic, typical flow system characteristics, operating point of a pump. Cavitation in centrifugal pumps- NPSH required and available- Type number-Pumps in series and parallel operations. Performance characteristics- Specific speed-Shape numbers – Impeller shapes based on shape numbers.	7-2-0
III	Positive displacement pumps- reciprocating pump – Single acting and double acting- slip, negative slip and work required and efficiency- indicator diagram- acceleration head - effect of acceleration and friction on indicator diagram – speed calculation- Air vessels and their purposes, saving in work done to air vessels multi cylinder pumps. Multistage pumps-selection of	7-2-0

	pumps-pumping devices-hydraulic ram, Accumulator, Intensifier, Jet pumps, gear pumps, vane pump and lobe pump.	
IV	Compressors: classification of compressors, reciprocating compressor-single stage compressor, equation for work with and without clearance volume, efficiencies, multistage compressor, intercooler, free air delivered (FAD) Centrifugal compressor-working, velocity diagram, work done, power required, width of blades of impeller and diffuser, isentropic efficiency, slip factor and pressure coefficient, surging and chocking. Axial flow compressors:- working, velocity diagram, degree of reaction, performance. Roots blower, vane compressor, screw compressor.	7-2-0
V	Gas turbines: classification, Thermodynamic analysis of gas turbine cycles-open, closed and semi closed cycle; ideal working cycle- Brayton cycle-P-v and T-s diagram, thermal efficiency. Effect of compressor and turbine efficiencies. Optimum pressure ratio for maximum specific work output with and without considering machine efficiencies. Comparison of gas turbine and IC engines, Analysis of open cycle gas turbine, Improvements of the basic gas turbine cycles-regeneration, intercooling and reheating-cycle efficiency and work output-Condition for minimum compressor work and maximum turbine work. Combustion chambers for gas turbines. pressure loss in combustion process and stability loop.	7-2-0

MODEL QUESTION PAPER

APJ ABDUL KALAM TECHNOLOGICAL UNIVERSITY

IV SEMESTER B.TECH DEGREE EXAMINATION

MET206: FLUID MACHINERY

Mechanical Engineering

Maximum: 100 Marks Duration: 3 hours

PART A

Answer all questions, each question carries 3 marks

1. What is degree of reaction? What will be the degree of reaction for a Pelton wheel.
2. Explain speed ratio and jet ratio.
3. What is governing of a turbine? Why is it important?
4. Explain the term specific speed of a pump. How is it different from specific speed of a turbine.
5. Define slip, percentage slip and negative slip of a reciprocating pump.
6. What is the purpose of air vessels in multi-cylinder reciprocating pump.
7. What are the classifications of compressors? Explain briefly.
8. Write a short note on axial flow compressors. Why is it preferred in aerospace applications.
9. Explain briefly the process of regeneration in a gas turbine engine.
10. Draw the p-v diagram and T-s diagram of Brayton cycle.

(10×3=30 Marks)

PART B

Answer one full question from each module

MODULE-I

11. (a) A 50 mm diameter jet having a velocity of 25 m/s, strikes a flat plate, the normal of which is inclined at 30° to the axis of the jet. Calculate the normal force exerted on the plate

i. when the plate is stationary,

ii. when the plate is moving with a velocity of 10 m/s in the direction of the jet.

Find also the work done and the efficiency of the jet when the plate is moving. (7 Marks)

(b) A Pelton wheel has a mean bucket speed of 10 m/s with a jet of water flowing at the rate of 700 $litres/s$ under a head of 30 m. The buckets deflect the jet through an angle of 160°. Calculate the power given by the water to the runner and the hydraulic efficiency of the turbine. Assume coefficient of velocity as 0.98. (7 Marks)

12. (a) A reaction turbine works at 450 rpm under a head of 120 m. Its diameter at inlet is 120 cm and the flow area is 0.4 m^2. The angles made by absolute and relative velocities at inlet are 20° and 60° respectively with the tangential velocity. Determine:

   i. The volume flow rate,
   ii. The power developed, and
   iii. Hydraulic efficiency.

   Assume whirl at outlet to be zero. (7 Marks)

   (b) A Kaplan turbine runner is to be designed to develop 7357.5 kW shaft power. The net available head is 10 m. Assume that the speed ratio is 1.8 and flow ratio is 0.6. If the overall efficiency is 70% and diameter of the boss is 0.4 times the diameter of the runner, find the diameter of the runner, its speed and specific speed. (7 Marks)

MODULE-II

13. (a) A Pelton wheel is revolving at a speed of 190 rpm and develops 5150.25 kW when working under a head of 220 m with an overall efficiency of 80%. Determine unit speed, unit discharge and unit power. The speed ratio for the turbine is given as 0.47. Find the speed, discharge and power when this turbine is working under a head of 140 m. (7 Marks)

   (b) What do you understand by the characteristic curves of a turbine? Describe the important types of characteristic curves. (7 Marks)

14. (a) Why are centrifugal pumps used sometimes in series and sometimes in parallel? Draw the following characteristic curves for a centrifugal pump:
   Head, power and efficiency versus discharge with constant speed. (7 Marks)

   (b) State the effects of cavitation on the performance of water turbines and also state how to prevent cavitation in water turbines. (7 Marks)

MODULE-III

15. (a) Draw an indicator diagram, considering the effect of acceleration and friction in suction and delivery pipes. Find an expression for the work done per second in case of single-acting reciprocating pump. (7 Marks)

   (b) Differentiate :

   i. Between a single-acting and double-acting reciprocating pump,
   ii. Between a single cylinder and a double cylinder reciprocating pump. (7 Marks)

16. (a) A single-acting reciprocating pump running at 30 r.p.m, delivers 0.012 m^3/s of water. The diameter of the piston is 25 cm and stroke length is 50 cm. Determine :

   i. The theoretical discharge of the pump,
   ii. Coefficient of discharge, and
   iii. Slip and percentage slip of the pump. (8 Marks)

   (b) Write a short note on gear pumps. Why gear pump is known as positive displacement pump. (6 Marks)

MODULE-IV

17. (a) With a neat sketch explain the working of an axial flow compressor. (7 Marks)

    (b) Derive the expression for the work done in a reciprocating compressor with and without clearance volume. (7 Marks)

18. (a) A single stage double acting air compressor is required to deliver 14 m^3 of air per minute measured at 1.013 bar and 15 $°C$. The delivery pressure is 7 bar and the speed 300 rpm. Take clearance volume as 5% of the swept volume with compression and expansion index n=1.3. Calculate

    i. Swept volume of the cylinder,
    ii. Delivery temperature,
    iii. Indicated power.

    (10 Marks)

    (b) Draw the velocity diagram of an axial flow compressor. (4 Marks)

MODULE-V

19. (a) The air enters the compressor of an open cycle constant pressure gas turbine at a pressure of 1 bar and temperature 20 $°C$. The pressure of air after compression is 4 bar. The isentropic efficiencies of compressor and turbine are 80% and 85% respectively. The air fuel ratio is 90:1. If flow rate of air is 3.0 kg/s, find

    i. Power developed
    ii. Thermal efficiency of cycle

    (7 Marks)

    (b) A gas turbine has a pressure ratio of 6:1 and a maximum cycle temperature of 600 $°C$. The isentropic efficiencies of compressor and turbine are 0.82 and 0.85 respectively. Calculate the power output in kW of an electric generator geared to turbine when the air enters the compressor at 15 $°C$ at the rate of 15 kg/s. Assume the working fluid to be air with $C_p = 1.005$ and $\gamma = 1.4$. (7 Marks)

20. (a) What are the improvements made to the basic gas turbine cycle. Explain with temperature entropy diagram. (8 Marks)

    (b) Differentiate between open, closed and semi closed gas turbine cycles. (6 Marks)

CODE MEL202	COURSE NAME FM & HM LAB	CATEGORY	L	T	P	CREDIT
		PCC	0	0	3	2

Preamble:

This lab is mainly focussed to develop a platform where the students can enhance their engineering knowledge in the fluid mechanics domain by applying their theoretical knowledge acquired.

Prerequisite: MET203 Mechanics of Fluids

Course Outcomes:

After the completion of the course the student will be able to

CO 1	Determine the coefficient of discharge of flow measuring devices (notches, orifice meter and Venturi meter)
CO 2	Calibrate flow measuring devices (notches, orifice meter and Venturi meter)
CO 3	Evaluate the losses in pipes
CO 4	Determine the metacentric height and stability of floating bodies
CO 5	Determine the efficiency and plot the characteristic curves of different types of pumps and turbines

Mapping of course outcomes with program outcomes

	PO 1	PO 2	PO 3	PO 4	PO 5	PO 6	PO 7	PO 8	PO 9	PO 10	PO 11	PO 12
CO 1	2	1						2	3	2		2
CO 2	2	1						2	3	2		2
CO 3	2	1						2	3	2		2
CO 4	2	1						2	3	2		2
CO 5	2	1						2	3	2		2

Assessment Pattern

Mark distribution

Total Marks	CIE	ESE	ESE Duration
150	75	75	2.5 hours

Continuous Internal Evaluation Pattern:

Attendance	:	15 marks
Continuous Assessment	:	30 marks
Internal Test (Immediately before the second series test)	:	30 marks

End Semester Examination Pattern: The following guidelines should be followed regarding award of marks

(a) Preliminary work	: 15 Marks
(b) Implementing the work/Conducting the experiment	: 10 Marks
(c) Performance, result and inference (usage of equipments and trouble shooting)	: 25 Marks
(d) Viva voce	: 20 marks
(e) Record	: 5 Marks

General instructions:

Practical examination to be conducted immediately after the second series test covering entire syllabus given below. Evaluation is a serious process that is to be conducted under the equal responsibility of both the internal and external examiners. The number of candidates evaluated per day should not exceed 20. Students shall be allowed for the University examination only on submitting the duly certified record. The external examiner shall endorse the record.

A minimum of 10 experiments are to be performed.

SYLLABUS

LIST OF EXPERIMENTS

1. Determination of coefficient of discharge and calibration of Notches.

2. Determination of coefficient of discharge and calibration of Orifice meter.

3. Determination of coefficient of discharge and calibration of Venturi meter.

4. Determination of hydraulic coefficients of orifices.

5. Determination of Chezy's constant and Darcy's coefficient on pipe friction apparatus.

6. Determine the minor losses in pipe.

7. Experiments on hydraulic ram.

8. Reynolds experiment.

9. Bernoulli's experiment.

10. Determination of metacentric height and radius of gyration of floating bodies.

11. Performance test on positive displacement pumps.

12. Performance test on centrifugal pumps, determination of operating point and efficiency.

13. Performance test on gear pump.

14. Performance test on Impulse turbines.

15. Performance test on reaction turbines (Francis and Kaplan Turbines).

16. Speed variation test on Impulse turbine.

17. Determination of best guide vane opening for Reaction turbine.

18. Impact of jet.

Reference Books

1. Yunus A. Cenegel, John M. Cimbala; Fluid Mechanics- Fundamentals and Applications (in SI Units); McGraw Hill, 2010.

2. Bansal R.K, Fluid Mechanics and Hydraulic Machines (SI Units); Laxmi Publications, 2011.

3. Modi P.N and Seth S.M, “Hydraulics and Fluid Mechanics Including Hydraulic Machines” Standard Book House, New Delhi, 20th Edition, 2015

4. Graebel. W. P, "Engineering Fluid Mechanics", Taylor & Francis, Indian Reprint, 2011

5. Robert W. Fox, Alan T. McDonald, Philip J. Pritchard, “Fluid Mechanics and Machinery”, John Wiley and sons, 2015.

6. J. Frabzini, 'Fluid Mechanics with Engineering Applications', McGraw Hill, 1997.

<table>
<tr><td rowspan="2">MEL 204</td><td rowspan="2">MACHINE TOOLS LAB- I</td><td>CATEGORY</td><td>L</td><td>T</td><td>P</td><td>Credits</td><td>Year of Introduction</td></tr>
<tr><td>PCC</td><td>0</td><td>0</td><td>3</td><td>2</td><td>2019</td></tr>
</table>

Preamble:

1. To understand the parts of various machine tools and impart hands on experience on lathe, drilling, shaping, milling, slotting, grinding, tool and cutter grinding machines.
2. To develop knowledge and importance of metal cutting parameters such as feed, velocity and depth of cut etc on cutting force and surface roughness obtainable.
3. To develop fundamental knowledge on tool materials, cutting fluids and tool wear Mechanisms.
4. To apply knowledge of basic mathematics to calculate the machining parameters for different machining processes.
5. To study process parameters and practice on arc and gas welding technologies.
6. To gain knowledge on the structure, properties, heat treatment, testing and applications of ferrous and non ferrous metals.

Prerequisite: MET 204 - Manufacturing Process

Course Outcomes - At the end of the course students will be able to

CO 1	The students can operate different machine tools with understanding of work holders and operating principles to produce different part features to the desired quality.
CO 2	Apply cutting mechanics to metal machining based on cutting force and power consumption.
CO 3	Select appropriate machining processes and process parameters for different metals.
CO 4	Fabricate and assemble various metal components by welding and students will be able to visually examine their work and that of others for discontinuities and defects.
CO 5	Infer the changes in properties of steel on annealing, normalizing, hardening and tempering.

Mapping of course outcomes with program outcomes (Minimum requirements)

	PO 1	PO 2	PO 3	PO 4	PO 5	PO 6	PO 7	PO 8	PO 9	PO 10	PO 11	PO 12
CO 1	-	-	3	-	-	-	-	-	-	-	-	-
CO 2	-	3	-	-	-	-	-	-	-	-	-	-
CO 3	-	-	-	2	-	-	-	-	-	-	-	-
CO 4	2	-	-	-	-	-	-	-	-	-	-	-
CO 5	-	-	-	-	2	-	-	-	-	-	-	-

Assessment Pattern

Bloom's taxonomy	Continuous Assessment Tests	
	Test 1 (Marks)	Test 2 (Marks)
Remember	20	20
Understand	10	10
Apply	30	30
Analyse	20	20
Evaluate	10	10
Create	10	10

Mark distribution

Total Marks	CIE marks	ESE marks	ESE duration
150	75	75	2.5 Hours

Continuous Internal Evaluation (CIE) Pattern:

Attendance	15 marks
Regular class work/ /Laboratory Record and Class Performance	30 marks
Continuous Assessment Test/s	30 marks
The student's assessment, continuous evaluation, record bonafides, awarding of sessional marks, oral examination etc. should be carried out only by the assistant professor or above. Any two **e**xperiments mentioned in part - B, and any eight experiments in part A and total of minimum of ten experiments are to be performed.	

End semester examination pattern

The Practical Examination will comprise of three hours. Oral examination should be conducted and distribution of marks will be decided by the examiners.

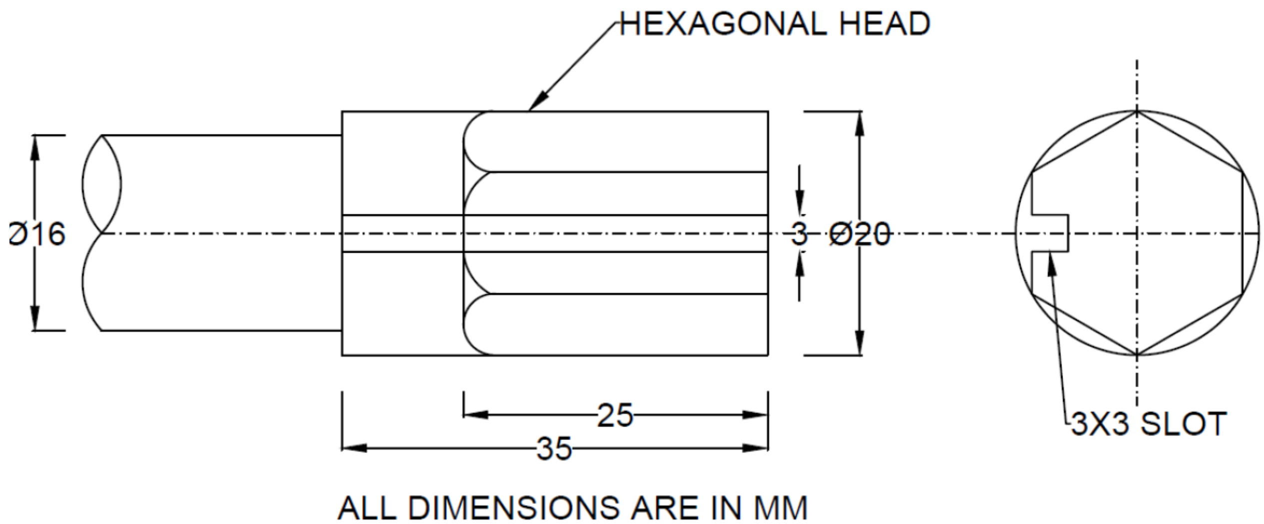
Conduct of University Practical Examinations

The Principals of the concerned Engineering Colleges with the help of the Chairmen/Chairperson will conduct the practical examination with the approval from the University and bonafide work / laboratory record, hall ticket, identity card issued by college are mandatory for appearing practical University examinations. To conduct practical examination, an external examiner and an internal examiner should be appointed by the University.

END SEMESTER EXAMINATION
MODEL QUESTION PAPER

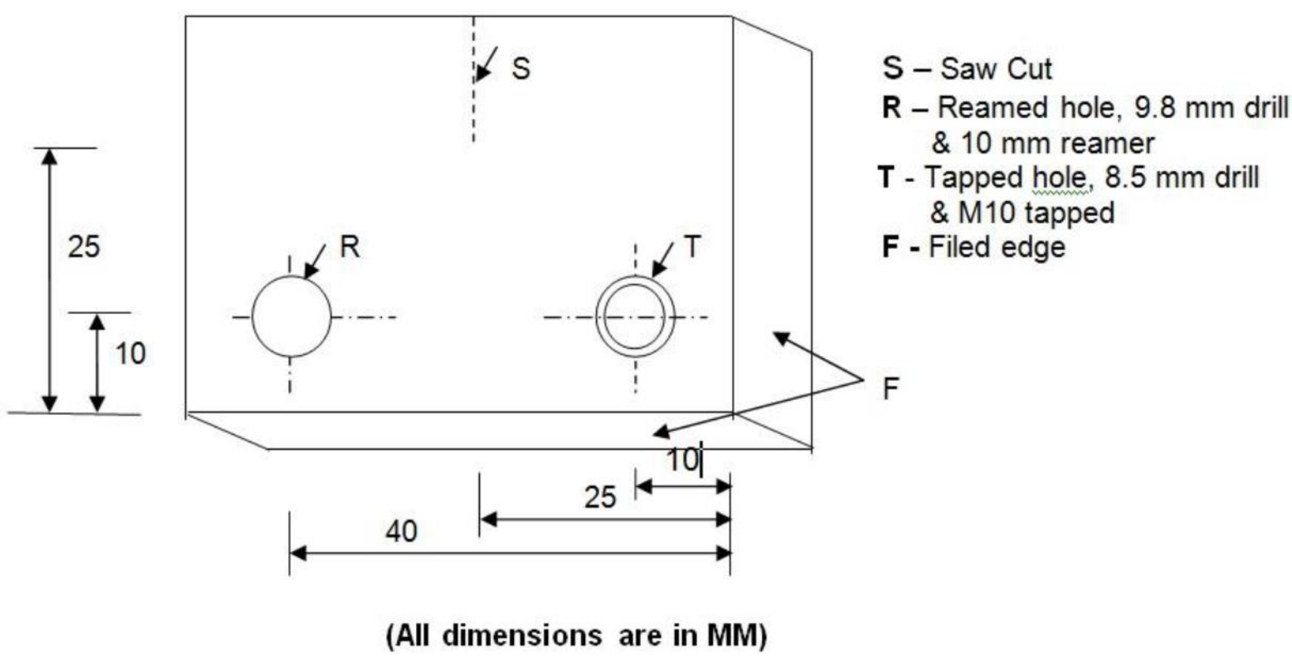
Maximum Marks : 75 **Duration: 2.5 hours**

1. To machine the hexagonal head and the slot shown in the sketch on the specimen and measure the tool wear using toolmaker's microscope.



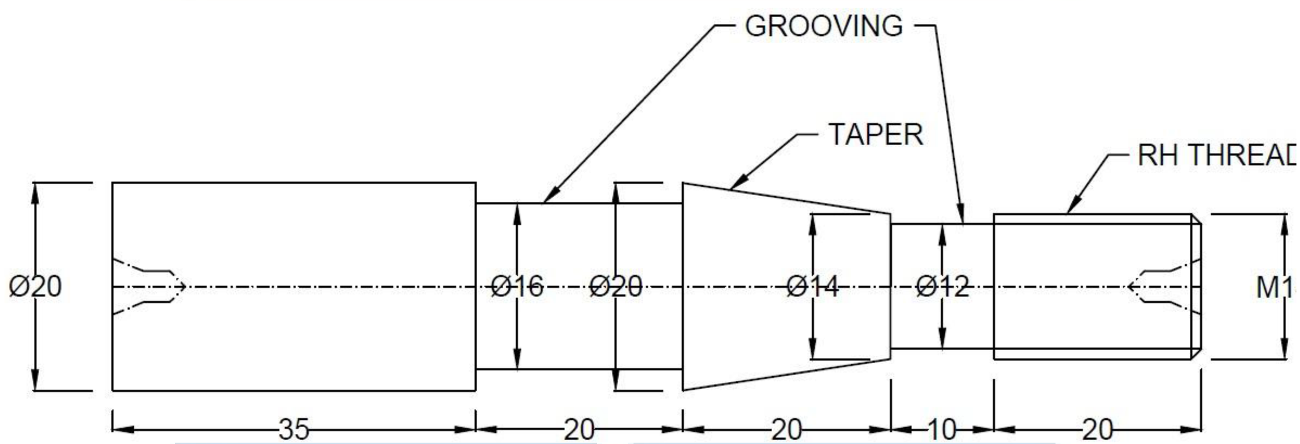
OR

2. To drill, file, as shown in the sketch, ream and tap holes on the mild steel plate and measure the tool wear using toolmaker's microscope.



OR

3. To make the part shown in the sketch from a mild steel rod on a Lathe and measure the tool flank wear using toolmaker's microscope.



OR

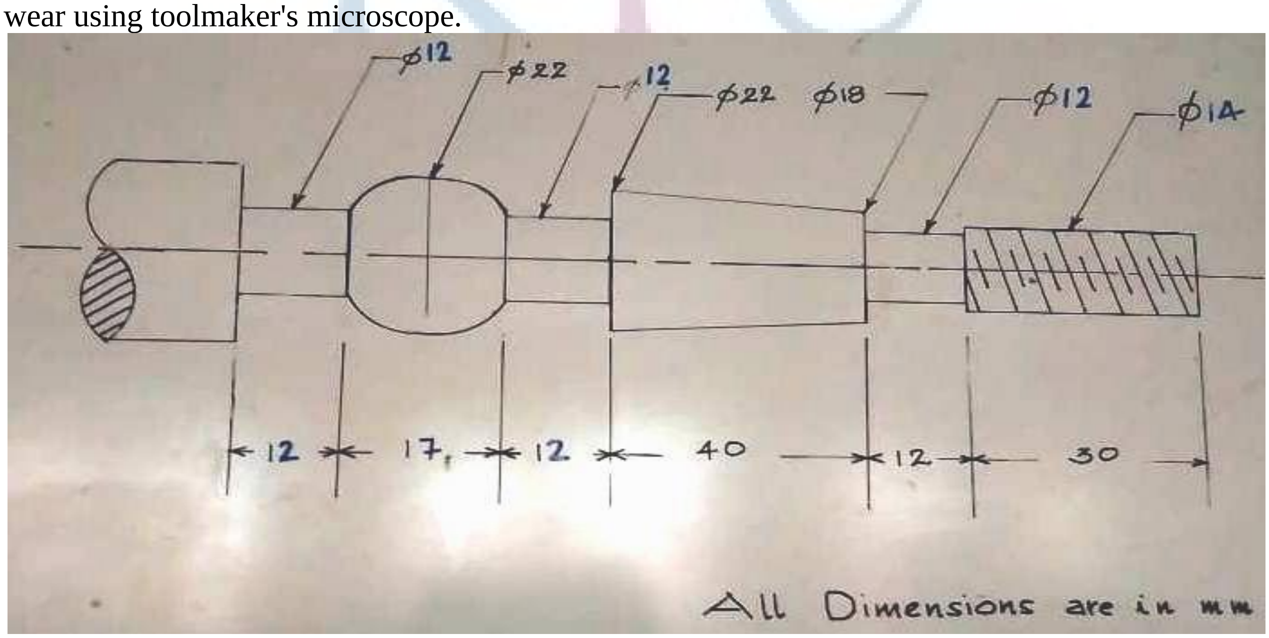
4. Prepare a metallurgical sample and determine the grain size using a optical microscope.

OR

5. To prepare a butt joint with mild steel strip using suitable welding technique and infer on the welded joint.

OR

6. To make the part shown in the sketch from a mild steel rod on a Lathe and measure the tool flank wear using toolmaker's microscope.



SYLLABUS

PART - A

Safety precautions in machine shop - Exercises on machine tools: turning, knurling, drilling, boring, reaming, trepanning, milling, hobbing, planning, shaping, slotting, broaching, grinding, lapping, honing etc. - Welding practice.

PART - B

Metallurgy, heat treatment and testing.

Text Books:

1. Acherkan N. S. "Machine Tool", Vol. I, II, III and IV, MIR Publications.
2. HMT, Production Technology, Tata McGraw Hill.
3. W. A. J. Chapman, Workshop Technology Part I, ELBS & Edward Arnold Publishers.

Course content and drawing schedules.

	List of Experiments **A minimum of ten experiments are to be carried out**	**Course outcomes**	**No. of hours**
Experiments	**PART -A** **(minimum eight experiments)**		
1	**Centre Lathe** Study of lathe tools: - tool materials - selection of tool for different operations - tool nomenclature and attributes of each tool angles on cutting processes – effect of nose radius, side cutting edge angle, end cutting edge angle and feed on surface roughness obtainable – tool grinding. • Study the different methods used to observe the work-piece is precisely fixed on lathe. • Study the optimum aspect ratio of work-piece to avoid vibration and wobbling during turning. • Machine tool alignment test on lathe. • Re-sharpening of turning tool to specific geometry	CO 1	3
2,3,4,5,6	**Exercises on centre lathe**:- Facing, plain turning, step turning and parting – groove cutting, knurling and chamfering - form turning and taper turning – eccentric turning, multi-start thread, square thread and internal thread etc.	CO 1 CO 2	3
	Exercises on lathe: - Measurement of cutting forces in turning process and correlate the surface roughness obtainable by varying feed, speed, feed, nose radius, side and end cutting edge angles.		6

7	Measurement of cutting temperature and tool life in turning and machine tool alignment test on lathe machine.	CO 2	3
86	**Exercises on Drilling machine** • **Exercises on drilling machine**: - drilling, boring, reaming, taping and counter sinking etc. • **Exercises on drilling machine: -** Measurement of cutting forces in drilling process and correlate with process parameters.	CO 1 CO 2	3
9	**Exercises on Shaping machine** • Exercises on shaping machine: - flat surfaces, grooves and key ways. **Exercises on Slotting machine** • Exercises on slotting machine: - flat surfaces, grooves and key ways.	CO 2	3
10	**Planing and Broaching machine** Study and demonstration of broaching and hobbing machine. • Exercises on planing machine	CO 1	3
11	**Exercises on Grinding machine** • Exercise on surface grinding, cylindrical grinding and tool grinding etc. • Measurement of cutting forces and roughness in grinding process and correlate with process parameters. • Study and demonstration of lapping and honing machines.	CO 1	3
12	**Exercises on Welding machine** • Exercises on arc and gas welding: - butt welding and lap welding of M.S. sheets.	CO 4	3
	PART - B - Metallurgy **(minimum two experiments)**	CO 5	6
13	• **Specimen preparation**, etching & microscopic study of Steel, Cast iron and Brass and grain size measurement.		
14	• **Heat treatment study**:–Effect on mechanical properties and microstructure of ferrous and non ferrous metals. • Studies of various quenching mediums, Carryout heat treatments on steel based on ASM handbook vol.4 and observe the hardness obtained.	CO 5	6

SEMESTER -4

MINOR

CODE	COURSE NAME	CATEGORY	L	T	P	CREDIT
MET282	THEORY OF MACHINES	VAC	3	1	0	4

Preamble:

Goal of this course is to expose the students to the fundamentals of kinematics of mechanisms, design of cams, theory and analysis of gears, gear trains, clutches, brakes. The students will also be exposed to velocity and acceleration analysis of different mechanisms. It provides the knowledge on balancing of rotating and reciprocating masses, Gyroscopes, Energy fluctuation in Machines.

Prerequisite: Nil

Course Outcomes: After the completion of the course the student will be able to

CO 1	Interpret basic principles of mechanisms and machines and Analyse a given mechanism based on velocity and acceleration. List the basic selection requirements of different types of mechanical clutches.
CO 2	Describe the theories of gears and gear trains. List the basic selection requirements of different types of mechanical brakes.
CO 3	Develop the profile of CAMs as per the requirements and to understand cam profile.
CO 4	Explain the dynamic balancing of revolving and reciprocating masses. Describe the fundamentals of gyroscope and its application.
CO 5	Analyse the performance of governors and flywheels.

Mapping of course outcomes with program outcomes

	PO 1	PO 2	PO 3	PO 4	PO 5	PO 6	PO 7	PO 8	PO 9	PO 10	PO 11	PO 12
CO 1	3	3	2	2		3						2
CO 2	3	3	2	2		3						2
CO 3	3	3	2	2		3						2
CO 4	3	3	3	2		1						1
CO 5	3	3	3	3		1						3

Assessment Pattern

Bloom's Category	**Continuous Assessment Tests**		**End Semester Examination**
	1	**2**	
Remember			
Understand	30	40	80
Apply		10	10
Analyse	20		10
Evaluate			
Create			

Mark distribution

Total Marks	CIE	ESE	ESE Duration
150	50	100	3 hours

Continuous Internal Evaluation Pattern:

Attendance : 10 marks
Continuous Assessment Test (2 numbers) : 25 marks
Assignment/Quiz/Course project : 15 marks

End Semester Examination Pattern: There will be two parts; Part A and Part B. Part A contain 10 questions with 2 questions from each module, having 3 marks for each question. Students should answer all questions. Part B contains 2 questions from each module of which student should answer any one. Each question can have maximum 2 sub-divisions and carry 14 marks.

COURSE LEVEL ASSESSMENT QUESTIONS

Course Outcome 1 (CO1): *Interpret basic principles of mechanisms and machines. Analyse a given mechanism based on velocity and acceleration. List the basic selection requirements of different types of mechanical clutches.*

1. Explain the inversions of a four bar mechanism.
2. Explain with neat sketches, the working of single plate clutch.
3. The crank of a slider crank mechanism rotates clockwise at a constant speed of 300 r.p.m. The crank is 150 mm and the connecting rod is 600 mm long. Determine: 1. Linear velocity and acceleration of the midpoint of the connecting rod, and 2. angular velocity and angular acceleration of the connecting rod, at a crank angle of 45° from inner dead centre position

Course Outcome 2 (CO2) *Describe the theories of gears and gear trains. List the basic selection requirements of different types of mechanical brakes.*

1. State and prove the law of gearing
2. In an epicyclic gear train, an arm carries two gears A and B having 36 and 45 teeth respectively. If the arm rotates at 150 rpm in the anticlockwise direction about the centre of the gear A which is fixed, determine the speed of gear B. If the gear A instead of being fixed makes 300 rpm in the clockwise direction, what will be the speed of gear B?
3. Discuss the various types of the brakes.

Course Outcome 3 (CO3): *Develop the profile of CAMs as per the requirements and and to understand cam profile.*

1. Explain the different classifications of cam and followers.
2. Draw the displacement, velocity and acceleration diagrams when the follower moves in SHM.
3. A cam with 30 mm as minimum diameter is rotating clockwise at a uniform speed of 1200 r.p.m. and has to give the following motion to a roller follower 10 mm in diameter:
   a) Follower to complete outward stroke of 25 mm during 120° of cam rotation with equal uniform acceleration and retardation;
   b) (b) Follower to dwell for 60° of cam rotation;
   c) (c) Follower to return to its initial position during 90° of cam rotation with equal uniform acceleration and retardation;
   d) (d) Follower to dwell for the remaining 90° of cam rotation.

   Draw the cam profile if the axis of the roller follower passes through the axis of the cam.

Course Outcome 4 (CO4): *Explain the static and dynamic balancing of revolving and reciprocating masses. Describe the fundamentals of gyroscope and its application*

1. Four masses m1, m2, m3 and m4 are 200 kg, 300 kg, 240 kg and 260 kg respectively. The corresponding radii of rotation are 0.2 m, 0.15 m, 0.25 m and 0.3 m respectively and the angles between successive masses are 45°, 75° and 135°. Find the position and magnitude of the balance mass required, if its radius of rotation is 0.2 m.

2. Explain with neat sketches, the terms Swaying Couple and Hammer Blow.

3. A ship propelled by a turbine rotor which has a mass of 5000 kg and a speed of 2100 r.p.m. The rotor has a radius of gyration of 0.5 m and rotates in a clockwise direction when viewed from the stern. Find the gyroscopic effects in the following conditions:

   a. The ship sails at a speed of 30 km/h and steers to the left in a curve having 60 m radius.

   b. The ship pitches 6 degree above and 6 degree below the horizontal position. The bow is descending with its maximum velocity. The motion due to pitching is simple harmonic and the periodic time is 20 seconds.

   c. The ship rolls and at a certain instant it has an angular velocity of 0.03 rad/s clockwise when viewed from stern.

   Determine also the maximum angular acceleration during pitching. Explain how the direction of motion due to gyroscopic effect is determined in each case.

Course Outcome 5 (CO5): *Analyse the performance of governors and flywheels.*

1. The turning moment diagram for a petrol engine is drawn to the following scales : Turning moment, 1 mm = 5 N-m ; crank angle, 1 mm = 1°. The turning moment diagram repeats itself at every half revolution of the engine and the areas above and below the mean turning moment line taken in order are 295, 685, 40, 340, 960, 270 mm^2. The rotating parts are equivalent to a mass of 36 kg at a radius of gyration of 150 mm. Determine the coefficient of fluctuation of speed when the engine runs at 1800 r.p.m

2. Explain the different types of governors.

3. The arms of a Porter governor are each 250 mm long and pivoted on the governor axis. The mass of each ball is 5 kg and the mass of the central sleeve is 30 kg. The radius of rotation of the balls is 150 mm when the sleeve begins to rise and reaches a value of 200 mm for maximum speed. Determine the speed range of the governor. If the friction at the sleeve is equivalent of 20 N of load at the sleeve, determine how the speed range is modified.

SYLLABUS

Module 1: Kinematics - Links, mechanism, Degrees of freedom, Grashoff's law. Four-bar chain, Slider crank chain- Inversions and practical applications. Velocity and acceleration diagrams of simple mechanisms. Coriolis acceleration (Theory only). Friction clutch - Pressure and wear theories, pivot and collar friction, Single and multiple disc clutches.

Module 2: Gear – Classification of gears- Gear terminology- Law of gearing, Gear trains - Simple, compound gear trains and epicyclic gear trains. Brakes - Block and band brakes, self-energizing and self-locking in braking.

Module 3: Cams- Types of cams, cam profiles for knife edged and roller followers with and without offsets for SHM, constant acceleration-deceleration, and constant velocity

Module 4: Static and dynamic balancing of rotating mass- Single and several masses in different planes. Balancing of reciprocating mass. Gyroscope –Gyroscopic torque, gyroscopic stabilization of ships and aeroplanes.

Module 5: Governors - Types of governors- simple watt governor - Porter governor- Theory of Proell governor - Isochronism, hunting, sensitivity and stability. Flywheel - Turning moment diagrams, fluctuation of energy

Text Books

1. Ballaney P.L. Theory of Machines, Khanna Publishers,1994

2. S. S. Rattan, Theory of Machines, Tata McGraw Hill, 2009

3. V. P. Singh, Theory of Machines, Dhanpat Rai,2013

Reference Books

1. C. E. Wilson, P. Sadler, Kinematics and Dynamics of Machinery, Pearson Education,2005
2. D. H. Myskza, Machines and Mechanisms Applied Kinematic Analysis, Pearson Education,2013
3. G. Erdman, G. N. Sandor, Mechanism Design: Analysis and synthesis Vol I & II, Prentice Hall of India,1984.
4. Ghosh, A. K. Malik, Theory of Mechanisms and Machines, Affiliated East West Press,1988
5. J. E. Shigley, J. J. Uicker, Theory of Machines and Mechanisms, McGraw Hill,2010
6. Holowenko, Dynamics of Machinery, John Wiley, 1995

COURSE PLAN

No	Topic	No. of Lectures
1	**Module 1 (CO1)**	
1.1	Introduction to link, constrained motions, mechanism, machine	1
1.2	Degrees of freedom, Problem, Grashof's law	1
1.3	Inversion – Four Bar chain – Single Slider Chain – Practical Applications	2
1.4	Velocity Analysis – I Centre Methos – Relative Velocity Method	2
1.5	Acceleration Analysis - Four Bar Mechanism – Single Slider Chain	2
1.6	Corriolis Component of Acceleration –Quick Return Mechanisms	2
1.7	Clutches – Theories - Classifications	1
2	**Module 2 (CO2)**	
2.1	Gear – Classifications – Terminology – Law of Gearing – Velocity of Sliding – Interference - Problems	3
2.2	Gear Train –Classifications - Problems on Epi cyclic gear trains	3
2.3	Brake – Theory – Classifications	2
3	**Module 3 (CO3)**	
3.1	Cam – Introduction - Classifications	1
3.2	Velocity and Acceleration Diagrams – Uniform Velocity – Uniform Acceleration and Deceleration – SHM – Calculations	2
3.3	Construction of Cam Profile	4
4	**Module 4 (CO4)**	
4.1	Static and dynamic balancing of rotating masses –Single and several masses in different planes	2
4.2	Balancing of reciprocating masses	3
4.3	Gyroscope – Introduction – Stabilization of Ships	2
4.4	Stabilization of Air Planes	2
5	**Module 5 (CO5)**	
5.1	Governors – Introduction –Classifications	2
5.2	Analytical Problems	2
5.3	Hunting – Sensitivity – Isochronism -Stability	2
5.4	Flywheels – Turning Moment Diagrams –Fluctuation of Energy	2
5.5	Analytical Problems	2

MODEL QUESTION PAPER

APJ ABDUL KALAM TECHNOLOGICAL UNIVERSITY

FIFTH SEMESTER B.TECH DEGREE EXAMINATION

Course Code : MET282

Course Name : THEORY OF MACHINES

Max. Marks : 100 Duration : 3 Hours

PART – A

(*ANSWER ALL QUESTIONS, EACH QUESTION CARRIES 3 MARKS*)

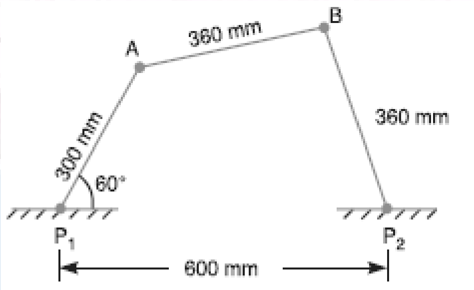
1. Write down the Kutzbach criterion of movability of plane mechanisms. Derive the Grubler's equation from it.
2. Explain the types of constrained motions with neat sketches.
3. With a neat sketch prove the common normal at the point of contact between a pair of teeth must always pass through the pitch point.
4. Explain the terms : (i) Module, (ii) Pressure angle, and (iii) Addendum.
5. Explain the different classifications of followers.
6. Define the following terms as applied to cam with a neat sketch :-(a) Base circle, (b) Pitch circle, (c) Pressure angle
7. Why reciprocating masses is cannot be completely balanced by revolving mass?
8. Derive the formula for the magnitude of gyroscopic couple.
9. Write down the differences between a gyroscope and a flywheel.
10. Explain the term hunting and isochronism.

PART – B

(*ANSWER ONE FULL QUESTION FROM EACH MODULE*)

MODULE – 1

11. The dimensions and configuration of the four bar mechanism, shown in Figure, are as follows : P_1A = 300 mm; P_2B = 360 mm; AB = 360 mm, and P_1P_2 = 600 mm. The angle AP_1P_2 = 60°. The crank P_1A has an angular velocity of 10 rad/s and an angular acceleration of 30 rad/s2, both clockwise. Determine the angular velocities and angular accelerations of P_2B, and AB and the velocity and acceleration of the joint B. (14 marks)



OR

12. a) With neat sketches explain the inversions of a four bar mechanism. (7 marks)

b) Derive the equation for the corrioli's component of acceleration. (7 marks)

MODULE – 2

13. An internal wheel B with 80 teeth is keyed to a shaft F. A fixed internal wheel C with 82 teeth is concentric with B. A compound wheel D-E gears with the two internal wheels; D has 28 teeth and gears with C while E gears with B. The compound wheels revolve freely on a pin which projects from a disc keyed to a shaft A co-axial with F. If the wheels have the same pitch and the shaft A makes 800 r.p.m., what is the speed of the shaft F ? Sketch the arrangement.

(14 marks)

OR

14. a) What do you mean by a self-energizing brake and self-locking brake. (4 Marks)

b) A simple band brake operates on a drum of diameter 600 mm that is running at a speed of 200 rpm. The coefficient of friction is 0.3. The brake band has an angle of contact of 270^{0}. One end of it is fastened to a fixed pin and the other end to the brake arm 125 mm and is placed perpendicular to the line bisecting the angle of contact.

i. What is the effort necessary at the end of brake arm to stop the wheel if 30 kW power is absorbed? What is the direction of rotation of drum for minimum pull?

ii. What is the width of steel band required for this brake if the maximum tensile stress is not to exceed 50 N/mm^2 and the thickness of band is 2.5 mm.

(10 marks)

MODULE – 3

15. A cam rotating clockwise at a uniform speed of 1000 r.p.m. is required to give a roller follower the motion defined below : 1. Follower to move outwards through 50 mm during 120° of cam rotation, 2. Follower to dwell for next 60° of cam rotation, 3. Follower to return to its starting position during next 90° of cam rotation, 4. Follower to dwell for the rest of the cam rotation. The minimum radius of the cam is 50 mm and the diameter of roller is 10 mm. The line of stroke of the follower is off-set by 20 mm from the axis of the cam shaft. If the displacement of the follower takes place with uniform and equal acceleration and retardation on both the outward and return strokes, draw profile of the cam. (14 marks)

OR

16. From the following data, draw the profile of a cam in which the follower moves with simple harmonic motion during ascent while it moves with uniformly accelerated motion during descent : Least radius of cam = 50 mm ; Angle of ascent = 48° ; Angle of dwell between ascent and descent = 42° ; Angle of descent = 60° ; Lift of follower = 40 mm ; Diameter of roller = 30 mm ; Distance between the line of action of follower and the axis of cam = 20 mm. If the cam rotates at 360 r.p.m. anticlockwise, find the maximum velocity and acceleration of the follower during descent. (14 marks)

MODULE – 4

17. a) A shaft carries four masses A, B, C and D of magnitude 200 kg, 300 kg, 400 kg and 200 kg respectively and revolving at radii 80 mm, 70 mm, 60 mm and 80 mm in planes measured from A at 300 mm, 400 mm and 700 mm. The angles between the cranks measured anticlockwise are A to B 45°, B to C 70° and C to D 120°. The balancing masses are to be placed in planes X and Y. The distance between the planes A and X is 100 mm, between X and Y is 400 mm and between Y and D is 200 mm. If the balancing masses revolve at a radius of 100 mm, find their magnitudes and angular positions. (10 marks)

    b) Explain the term swaying couple and hammer blow (4 marks)

OR

18. A ship propelled by a turbine rotor which has a mass of 5000 kg and a speed of 2100 r.p.m. The rotor has a radius of gyration of 0.5 m and rotates in a clockwise direction when viewed from the stern. Find the gyroscopic effects in the following conditions: 1. The ship sails at a speed of 30 km/h and steers to the left in a curve having 60 m radius. 2. The ship pitches 6 degree above and 6 degree below the horizontal position. The bow is descending with its maximum velocity. The motion due to pitching is simple harmonic and the periodic time is 20 seconds. 3. The ship rolls and at a certain instant it has an angular velocity of 0.03 rad/s clockwise when viewed from stern. Determine also the maximum angular acceleration during pitching. Explain how the direction of motion due to gyroscopic effect is determined in each case.

(14 marks)

MODULE – 5

19. a) A Porter governor has all four arms 250 mm long. The upper arms are attached on the axis of rotation and the lower arms are attached to the sleeve at a distance of 30 mm from the axis. The mass of each ball is 5 kg and the sleeve has a mass of 50 kg. The extreme radii of rotation are 150 mm and 200 mm. Determine the range of speed of the governor. (10 marks)

    b) What is stability of a governor? How does it differ from sensitiveness? (4marks)

OR

20. A three cylinder single acting engine has its cranks set equally at 120° and it runs at 600 r.p.m. The torque-crank angle diagram for each cycle is a triangle for the power stroke with a maximum torque of 90 N-m at 60° from dead centre of corresponding crank. The torque on the return stroke is sensibly zero. Determine : 1. power developed. 2. coefficient of fluctuation of speed, if the mass of the flywheel is 12 kg and has a radius of gyration of 80 mm, 3. coefficient of fluctuation of energy, and 4. maximum angular acceleration of the flywheel. (14 marks)

CODE MET284	COURSE NAME THERMODYNAMICS	CATEGORY	L	T	P	CREDIT
		VAC	3	1	-	4

Preamble:

Thermodynamics is the study of energy. Without energy life cannot exist. Activities from breathing to the launching of rockets involves energy transactions and are subject to thermodynamic analysis. Engineering devices like engines, turbines, refrigeration and air conditioning systems, propulsion systems etc., work on energy transformations and must be analysed using principles of thermodynamics. So, a thorough knowledge of thermodynamic concepts is essential for a mechanical engineer. This course offers an introduction to the basic concepts and laws of thermodynamics.

Prerequisite: NIL

Course Outcomes:

After completion of the course the student will be able to

CO1	Understand basic concepts and laws of thermodynamics
CO2	Conduct first law analysis of open and closed systems
CO3	Determine entropy changes associated with different processes
CO4	Understand the application and limitations of the ideal gas equation of state
CO5	Determine change in properties of pure substances during phase change processes
CO6	Evaluate properties of ideal gas mixtures

Mapping of course outcomes with program outcomes

	PO1	PO2	PO3	PO4	PO5	PO6	PO7	PO8	PO9	PO10	PO11	PO12
CO1	2	2										2
CO2	2	2	1	1								1
CO3	3	3	2	2								1
CO4	2	2	2	2								1
CO5	3	3	2	1								1
CO6	3	3	2	2								1

Assessment Pattern

Blooms Category	CA			ESA
	Assignment	Test - 1	Test - 2	
Remember	25	20	20	10
Understand	25	40	40	20
Apply	25	40	40	70
Analyse	25			
Evaluate				
Create				

Continuous Internal Evaluation Pattern:

Attendance : 10 marks

Continuous Assessment Test (2 numbers) : 25 marks

Assignment/Quiz/Course project : 15 marks

Mark distribution & Duration of Examination :

Total Marks	CA	ESE	ESE Duration
150	50	100	3 Hours

End semester pattern:

There will be two parts; Part A and Part B. Part A contain 10 questions with 2 questions from each module, having 3 marks for each question. Students should answer all questions. Part B contains 2 questions from each module of which student should answer any one. Each question can have maximum 2 sub-divisions and carry 14 marks.

COURSE LEVEL ASSESSMENT QUESTIONS

Course Outcome 1

1. Discuss the limitations of first law of thermodynamics.

2. Second law of thermodynamics is often called a directional law . Why?

3. Explain Joule-Kelvin effect. What is the significance of the inversion curve ?

Course Outcome 2

1. A mass of 2.4 kg of air at 150 kPa and 12°C is contained in a gas – tight, frictionless piston – cylinder device. The air is now compressed to a final pressure of 600 kPa . During this process, heat is transferred from the air such that the temperature inside the cylinder remains constant. Calculate the work input during this process.

2. Carbon dioxide enters an adiabatic nozzle steadily at 1 MPa and 500°C with a mass flow rate of 600 kg/hr and leaves at 100 kPa and 450 m/s. The inlet area of the nozzle is 40 cm^2. Determine (a) the inlet velocity and (b) the exit temperature

3. Water is being heated in a closed pan on top of a range while being stirred by a paddle – wheel. During the process, 30 kJ of heat is transferred to the water and 5 kJ of heat is lost to the surrounding air. The paddle – wheel work amounts to 500 N-m. Determine the final energy of the system, if its initial energy is 10 kJ.

Course Outcome 3

1.An adiabatic vessel contains 2 kg of water at 25˚C. B paddle – wheel work transfer, the temperature of water is increased to 30˚C. If the specific heat of water is assumed to be constant at 4.186 kJ/kg.K, find the entropy change of the universe.

2. Two kilograms of water at 80°C is mixed adiabatically with 3 kg of water at 30°C in a constant pressure process at 1 atm. Find the increase in entropy of the total mass of water due to the mixing process.

3. An iron block of unknown mass at 85^{o}C is dropped into an insulated tank that contains 0.1 m3 of water at 20^{o}C. At the same time a paddle-wheel driven by a 200 W motor is activated to stir the water. Thermal equilibrium is established after 20 minutes when the final temperature is 24^{o}C. Determine the mass of the iron block and the entropy generated during this process.

Course Outcome 4

1. Discuss the limitations of ideal gas equation.

2. Discuss law of corresponding states and its role in the construction of compressibility chart.

3. A rigid tank contains 2 kmol of N_2 and 6 kmol of CH_4 gases at 200 K and 12 MPa. Estimate the volume of the tank, using (a) ideal gas equation of state (b) the compressibility chart and Amagat's law

Course Outcome 5

1.Steam is throttled from 3 MPa and 600˚C to 2.5 MPa. Determine the temperature of the steam at the end of the throttling process.

2. Determine the change in specific volume, specific enthalpy and quality of steam as saturated steam at 15 bar expands isentropically to 1 bar. Use steam tables

3. Estimate the enthalpy of vapourization of steam at 500 kPa, using the Clapeyron equation and compare it with the tabulated value

Course Outcome 6

1. A gaseous mixture contains , by volume, 21%nitrogen, 50% hydrogen and 29 % carbon dioxide. Calculate the molecular weight of the mixture, the characteristic gas constant of the mixture and the value of the reversible adiabatic expansion index - γ. At 10˚C, the C_p values of nitrogen, hydrogen and carbon dioxide are 1.039, 14.235 and 0.828 kJ/kg.K respectively.

2. A mixture of 2 kmol of CO_2 and 3 kmol of air is contained in a tank at 199 kPa and 20˚C. Treating air to be a mixture of 79% N_2 and 21% O_2 by volume , calculate (a) the individual mass of CO_2 , N_2 and O_2, (b) the percentage content of carbon by mass in the mixture and (c) the molar mass , characteristic gas constant and the specific volume of the mixture

3. A gas mixture in an engine cylinder has 12% CO_2, 11.5 % O_2 and 76.5% N_2 by volume. The mixture at 1000˚C expands reversibly, according to the law $PV^{1.25}$ = constant, to 7 times its initial volume. Determine the work transfer and heat transfer per unit mass of the mixture.

SYLLABUS

Module 1: Role of Thermodynamics and it's applications in Engineering and Science –Basic Concepts Macroscopic and Microscopic viewpoints, Concept of Continuum, Thermodynamic System and Control Volume, Surrounding, Boundaries, Types of Systems, Universe, Thermodynamic properties, Process, Cycle, Thermodynamic Equilibrium, Quasi – static Process, State, Point and Path function. Zeroth Law of Thermodynamics, Measurement of Temperature, reference Points, Temperature Scales.

Module 2: Energy - Work - Pdv work and other types of work transfer, free expansion work, heat and heat capacity. Joule's Experiment- First law of Thermodynamics - First law applied to Non flow Process- Enthalpy- specific heats- PMM1, First law applied to Flow Process, Mass and Energy balance in simple steady flow process. Applications of SFEE, Limitations of the First Law.

Module 3: Second Law of Thermodynamics, Thermal Reservoir, Heat Engine, Heat pump – Kelvin-Planck and Clausius Statements, Equivalence of two statements, Reversibility, Irreversible Process, Causes of Irreversibility, PMM2, Carnot's theorem and its corollaries, Absolute Thermodynamic Temperature scale. Clausius Inequality, Entropy- Entropy changes in various thermodynamic processes, principle of increase of entropy and its applications, Entropy generation, Entropy and Disorder, Reversible adiabatic process- isentropic process, Third law of thermodynamics.

Module 4: Pure Substances, Phase Transformations, Triple point, properties during change of phase, T-v, p-v and p-T diagram of pure substance, p-v-T surface, Saturation pressure and Temperature, T-h and T-s diagrams, h-s diagrams or Mollier Charts, Dryness Fraction, steam tables. Property calculations using steam tables. The ideal Gas Equation, Characteristic and Universal Gas constants, Limitations of ideal Gas Model: Equation of state of real substances, Compressibility factor, Law of corresponding state, Compressibility charts.

Module 5: Mixtures of ideal Gases – Mole Fraction, Mass fraction, Gravimetric and volumetric Analysis, Dalton's Law of partial pressure, Amagat's Laws of additive volumes, Gibbs-Dalton's law Equivalent Gas constant and Molecular Weight, Properties of gas mixtures: Internal Energy, Enthalpy, specific heats and Entropy. General Thermodynamic Relations – Combined First and Second law equations – Helmholtz and Gibb's functions - Maxwell's Relations, Tds Equations. The Clapeyron Equation, equations for internal energy, enthalpy and entropy, specific heats, Throttling process, Joule Thomson Coefficient, inversion curve.

Text Books

1. P. K. Nag, Engineering Thermodynamics, McGraw Hill, 2013

2. E. Rathakrishnan Fundamentals of Engineering Thermodynamics, PHI, 2005

3. Y. A. Cengel and M. A. Boles, Thermodynamics an Engineering Approach, McGraw Hill, 2011

Reference Books:

1. Moran J., Shapiro N. M., Fundamentals of Engineering Thermodynamics, Wiley, 2006

2. R. E. Sonntag and C. Borgnakke, Fundamentals of Thermodynamics, Wiley, 2009

3. Holman J. P. Thermodynamics, McGraw Hill, 2004

4. M. Achuthan, Engineering Thermodynamics, PHI, 2004

COURSE PLAN

Module	Topics	Hours Allotted
1	Role of Thermodynamics and it's applications in Engineering and Science – Basic Concepts Macroscopic and Microscopic viewpoints, Concept of Continuum, Thermodynamic System and Control Volume, Surrounding, Boundaries, Types of Systems, Universe	2L
	Thermodynamic properties, Process, Cycle, Thermodynamic Equilibrium, Quasi – static Process, State, Point and Path function.	2L
	Zeroth Law of Thermodynamics, Measurement of Temperature, reference Points, Temperature Scales.	2L + 1T
2	Energy - Work - Pdv work and other types of work transfer, free expansion work, heat and heat capacity.	2L + 1T
	Joule's Experiment- First law of Thermodynamics - First law applied to Non flow Process- Enthalpy- specific heats- PMM1	2L + 1T
	First law applied to Flow Process, Mass and Energy balance in simple steady flow process. Applications of SFEE, Limitations of first law	2L + 1T
3	Second Law of Thermodynamics, Thermal Reservoir, Heat Engine, Heat pump – Kelvin-Planck and Clausius Statements, Equivalence of two statements	3L
	Reversibility, Irreversible Process, Causes of Irreversibility, PMM2, Carnot's theorem and its corollaries, Absolute Thermodynamic Temperature scale.	2L + 1T
	Clausius Inequality, Entropy- Entropy changes in various thermodynamic processes, principle of increase of entropy and its applications, Entropy generation, Entropy and Disorder, Reversible adiabatic process- isentropic process, Third law of thermodynamics	2L + 2T
4	Pure Substances, Phase Transformations, Triple point, properties during change of phase, T-v, p-v and p-T diagram of pure substance, p-v-T surface,	3L
	Saturation pressure and Temperature, T-h and T-s diagrams, h-s diagrams or Mollier Charts, Dryness Fraction, steam tables. Property calculations using steam tables	2L + 1T

	The ideal Gas Equation, Characteristic and Universal Gas constants, Limitations of ideal Gas Model: Equation of state of real substances, Compressibility factor, Law of corresponding state, Compressibility charts.	2L +1T
5	Mixtures of ideal Gases – Mole Fraction, Mass fraction, Gravimetric and volumetric Analysis, Dalton's Law of partial pressure, Amagat's Laws of additive volumes, Gibbs-Dalton's law.	2L
	Equivalent Gas constant and Molecular Weight, Properties of gas mixtures: Internal Energy, Enthalpy, specific heats and Entropy	2L +1T
	General Thermodynamic Relations – Combined First and Second law equations – Helmholtz and Gibb's functions - Maxwell's Relations	2L
	Tds Equations. The Clapeyron Equation, equations for internal energy, enthalpy and entropy, specific heats, Throttling process, Joule Thomson Coefficient, inversion curve.	2L + 1T

MODEL QUESTION PAPER

APJ ABDUL KALAM TECHNOLOGICAL UNIVERSITY

THIRD SEMESTER B.TECH DEGREE EXAMINATION

Course Code : MET284

Course Name : THERMODYNAMICS

(Permitted to use Steam Tables and Mollier Chart)

Max. Marks : 100 Duration : 3 Hours

Part – A

Answer all questions.

1. Define thermodynamics. List a few of its applications

2.Differentiate between intensive and extensive properties.

3. Differentiate between heat and work.

4. Explain system approach and control volume approach as applied in the analysis of a flow process.

5. An inventor claims to have developed an engine that delivers 26 kJ of work using 82 kJ of heat while operating between temperatures 120°C and 30°C. Is his claim valid ? Give the reason for your answer.

6. Show that two reversible adiabatics cannot intersect

7.Define (i)critical point and (ii) triple point, with respect to water

8. Why do real gases deviate from ideal gas behaviour? When do they approach ideal behaviour?

9. Define Helmholtz function and Gibbs function and state their significance

10. State Dalton's law and Amagat's laws for ideal gas mixtures.

(3 x 10 = 30 marks)

Part – B

Answer any two full questions from each module.

Module - 1

11.a] Explain macroscopic and microscopic approach to thermodynamics . (7 marks)

b] With the aid of a suitable diagram, explain the working of constant volume gas thermometer. (7 marks)

OR

12.a] What is meant by thermodynamic equilibrium ? What are the essential conditions for a system to be in thermodynamic equilibrium ? (7 marks) b] Express the temperature of 91^{0}C in (i) Farenhiet (ii) Kelvin (iii) Rankine. (7 marks)

Module – 2

13.a] A mass of 2.4 kg of air at 150 kPa and 12°C is contained in a gas – tight, frictionless piston – cylinder device. The air is now compressed to a final pressure of 600 kPa . During this process, heat is transferred from the air such that the temperature inside the cylinder remains constant. Calculate the work input during this process. (7 marks)

a] Air enters a 28 cm diameter pipe steadily at 200 kPa and 20°C with a velocity of 5m/s. Air is heated as it flows, and leaves the pipe at 180 kPa and 40°C. Determine (i) the volume flow rate of air at the inlet (ii) the mass flow rate of air and (iii) the velocity and volume flow rate at the exit. (7 marks)

OR

14.a] A turbine operates under steady flow conditions, receiving steam at the following conditions : pressure 1.2 MPa, temperature 188°C, enthalpy 2785 kJ/kg, velocity 33.3 m/s and elevation 3m. The steam leaves the turbine at the following conditions : pressure 20 kPa, enthalpy 25kJ/kg, velocity 100 m/s, and elevation 0 m. Heat is lost to the surroundings at the rate of 0.29 kJ/s. If the rate of steam flow through the turbine is 0.42 kg/s, what is the power output of the turbine in kW ? (7 marks)

b] Derive the steady flow energy equation, stating all assumptions. (7 marks)

Module – 3

15.a]State the Kelvin-Planck and Clausius statements of the second law of thermodynamics and prove their equivalence. (7 marks)

b]A heat engine operating between two reservoirs at 1000 K and 300 K is used to drive a heat pump which extracts heat from the reservoir at 300 K at a rate twice that at which the engine rejects heat to it. If the efficiency of the engine is 40 % of the maximum possible and the COP of the heat pump is 50 % of the maximum possible, what is the temperature of the reservoir to which the heat pump rejects heat ? What is the rate of heat rejection from the heat pump, if the rate of heat supply to the engine is 50kW ? (7 marks)

OR

16.a] A house is to be maintained at 21°C during winter and at 26°C during summer. Heat leakage through the walls, windows and roof is about 3000 kJ/hr per degree temperature difference between the interior of the house and the environment. A reversible heat pump is proposed for realising the desired heating and cooling. What is the minimum power required to run the heat pump in the reverse, if the outside temperature during summer is 36°C? Also find the lowest environment temperature during winter for which the inside of the house can be maintained at 21°C consuming the same power. (8 marks)

b] Give the Nernst statement of the third law and explain its significance. (6 marks)

Module – 4

17.a]Show the constant pressure transformation of unit mass of ice at atmospheric pressure and -20^{o}C to superheated steam at 220^{o}C on P-v , T-v and P-T coordinate systems and explain their salient features . (8 marks)

b] Nitrogen enclosed in a piston cylinder arrangement is at a pressure of 2 bar and temperature 75°C. Calculate the specific volume of Nitrogen using ideal gas equation. What would be the specific volume of this Nitrogen , if its compressibility factor at the prevailing condition is 0.9.
. (6 marks)

OR

18.a]Steam at 25 bar and 300^{o}C expands isentropically to 5 bar. Calculate the change in enthalpy, volume and temperature of unit mass of steam during this process using steam tables and Mollier chart and compare the values (8 marks)

b]Explain law of corresponding states and its significance to the generalized compressibility chart. (6 marks)

Module – 5

19.a] Derive the expressions for the equivalent molecular weight and characteristic gas constant for a mixture of ideal gases. (6 marks)

b] 0.5 kg of Helium and 0.5 kg of Nitrogen are mixed at 20^{o}C and at a total pressure of 100 kPa. Find (i) volume of the mixture (ii) partial volumes of the components (iii) partial pressures of the components (iv) the specific heats of the mixture and (v) the gas constant of the mixture. Take ratio of specific heats for Helium and Nitrogen to be 1.667 and 1.4 respectively. (8 marks)

OR

20.a] 2 kg of carbon dioxide at 38°C and 1.4 bar is mixed with 5 kg of nitrogen at 150°C and 1.03 bar to form a mixture at a final pressure of 70 kPa. The process occurs adiabatically in a steady flow apparatus. Calculate the final temperature of the mixture and the change in entropy during the mixing process. Take specific heat at constant pressure for CO_2 and N_2 as 0.85 kJ/kgK and 1.04 kJ/kg respectively. (7 marks)

b]Derive the Maxwell relations. Explain their significance? (7 marks)

MET 286	MANUFACTURING TECHNOLOGY (MINOR)	CATEGORY	L	T	P	Credits	Year of Introduction
		VAC	3	1	0	4	2019

Preamble:

1. To understand basic manufacturing processes of casting and welding
2. Provide a detailed discussion on the welding process and the physics of welding.
3. To understand mechanisms of material removal in LBM and EBM process
4. To introduce the different forming process of forging, extrusion and drawing.
5. To introduce the different fabrication of microelectronic devices

Prerequisite: MET 255 - Material Science & Technology (Minor)

Course Outcomes - At the end of the course students will be able to

CO 1	Illustrate the basic principles of foundry practices and special casting processes, their advantages, limitations and applications.
CO 2	Categorize welding processes according to welding principle and material.
CO 3	Understand the advantages of LBM and EBM over fusion welding process.
CO 4	An ability to understand the principles of the basic microelectronic processing technology.
CO 5	Learn about key aspects of the microelectronics industry, from device design, to processing, to photolithography, to manufacturing and packaging. Students will come out knowing the core processes of ion implantation, diffusion, oxidation, deposition, etching, including the fundamental physical mechanisms, and the necessary understanding for using these processes in a manufacturing environment.

Mapping of course outcomes with program outcomes (Minimum requirements)

	PO 1	PO 2	PO 3	PO 4	PO 5	PO 6	PO 7	PO 8	PO 9	PO 10	PO 11	PO 12
CO 1	3	-	-	-	-	-	-	-	-		-	-
CO 2	-	-	-	-	-	-	-	-	-	-	-	2
CO 3	-	-	3	-	-	-	-	-	-	-	-	-
CO 4	-	-	-	3	-	-	-	-	-	-	-	-
CO 5	-	4	-	-	-	-	-	-	-	-	-	-

ASSESSMENT PATTERN

Bloom's taxonomy	Continuous Assessment Tests		End Semester Examination (Marks)
	Test I (Marks)	Test II (Marks)	
Remember	25	25	25
Understand	15	15	15
Apply	30	25	30
Analyze	10	10	10
Evaluate	10	15	10
Create	10	10	10

Mark distribution

Total Marks	CIE marks	ESE marks	ESE duration
150	50	100	3 Hours

Continuous Internal Evaluation (CIE) Pattern:

Attendance	10 marks
Regular class work/tutorials/assignments	15 marks
Continuous Assessment Test (2 numbers)	25 marks

End semester pattern:- There will be two parts; Part A and Part B. Part A contain 10 questions with 2 questions from each module, having 3 marks for each question. Students should answer all questions. Part B contains 2 questions from each module of which student should answer any one. Each question can have maximum 2 sub-divisions and carry 14 marks.

Course Level Assessment Questions

Course Outcome 1 (CO1): - Illustrate the basic principles of foundry practices and special casting processes, their advantages, limitations and applications.

1. Explain Why casting is an important manufacturing processes
2. Name the important factors in selecting sand for molds.
3. Why does die casting produce the smallest cast parts?
4. What is the difference between sand-mold and shell mold casting?

Course Outcome 2 (CO2): Categorize welding processes according to welding principle and material.

1. Describe the functions and characteristics of electrodes. What functions do coatings have? How are electrodes classified?
2. Describe the role of filler metals in welding.
3. Explain the significance of the stiffness of the components being welded on both weld quality and part shape.

Course Outcome 3 (CO3): Understand the advantages of LBM and EBM over fusion welding process.

1. What is the power of LBM and EBM used for welding?
2. Why LBM and EBM are better quality than fusion welding?
3. What is the HAZ of LBM as compared to fusion welding process.

Course Outcome 4 (CO4): An ability to understand the principles of the basic microelectronic processing technology.

1. Why is silicon the semiconductor most used in IC technology?
2. Define selectivity and isotropy and their importance in relation to etching.
3. Explain the differences between wet and dry oxidation.
4. How is epitaxy different from other techniques used for deposition? Explain.

Course Outcome 5 (CO5): Learn about key aspects of the microelectronics industry, from device design, to processing, to photolithography, to manufacturing and packaging. Students will come out knowing the core processes of ion implantation, diffusion, oxidation, deposition, etching, including the fundamental physical mechanisms, and the necessary understanding for using these processes in a manufacturing environment.

1. Describe bulk and surface micromachining.
2. Lithography produces projected shapes, so true three dimensional shapes are more difficult to produce. What lithography processes are best able to produce three-dimensional shapes, such as lenses? Explain.
3. Explain how you would produce a spur gear if its thickness was one-tenth of its diameter and its diameter was (a) 10 um, (b) 100 um, (c) 1 mm, (d) 10 mm, and (e) 100 mm.

SYLLABUS

Module I

Metal casting:-sand casting:- shell molding, evaporative pattern casting, investment casting, permanent mold casting, vacuum casting, slush casting, pressure casting, die casting, centrifugal casting, squeeze casting, semi solid metal forming, casting for single crystal, casting defects.

Module II

Powder metallurgy:-powder production methods; powder characteristics; blending, mixing; compaction of metal powders; sintering fundamentals and mechanisms; infiltration and impregnation - Welding: arc welding: non consumable electrodes; heat affected zone; quality; case study and weld ability of metals.

Module III

Consumable electrodes; electron and laser beam welding; heat affected zone; power density; weld quality; case study; applications - Brazing:- filler metals, fluxes, joint strength; brazing methods, applications -Soldering:- solders and fluxes - soldering methods - solder ability, case study, typical joint designs, applications.

Module IV

Metal forging: quality, defects -Metal extrusion: process, defects, applications - Metal drawing process, drawing practice, defects, applications - Fabrication of microelectronic devices - crystal growing and wafer preparation - Film deposition - oxidation - Photo lithography

Module V

Different lithography methods - Etching, wet etching, dry etching- diffusion and Ion implantation- metallization and testing - wire bonding and packing - yield and reliability - fabrication of micro electro mechanical devices.

Text Books

1. Serope Kalpakjian, Steven R. Schmid - Manufacturing Engineering and Technology, seventh edition, Pearson.

Reference

1. https://nptel.ac.in/courses/103106075/
2. Principles of Metal Casting – Hine and Rosenthal
3. Materials and Processes in Manufacturing - Paul Degarma E and Ronald A. Kosher
4. Manufacturing Technology Foundry, Forming and Welding – P. N. Rao

MODEL QUESTION PAPER

MANUFACTURING PROCESS - MET 286 Max. Marks : 100 **Duration : 3 Hours**

Part – A

Answer all questions.

Answer all questions, each question carries 3 marks

1. What are composite molds? Why are they used?
2. What are the advantages of pressure casting over other processes?
3. Describe what occurs to metal powders during sintering.
4. Explain the basic principles of arc-welding processes.
5. Are fluxes necessary in brazing? If so, why?
6. Soldering is generally applied to thinner components. Explain Why.
7. Why is control of the volume of the blank important in closed-die forging?
8. Define selectivity and isotropy and their importance in relation to etching.
9. Describe the difference between isotropic etching and anisotropic etching.
10. What is the difference between chemically reactive ion etching and dry-plasma etching?

PART -B

Answer one full question from each module.

MODULE -1

11. Explain why squeeze casting produces parts with better mechanical properties, dimensional accuracy, and surface finish than do expendable-mold processes (14 marks).

OR

12. Explain different types of casting defeats in detail (14 marks).

MODULE -2

13. a.Explain the difference between impregnation and infiltration. Give some applications of each (7 marks).
    b.Describe the relative advantages and limitations of cold and hot isostatic pressing (7 marks).

OR

14. Explain the factors that contribute to the differences in properties across a welded joint (14 marks).

MODULE -3

15. a.What are the principles of (a) wave soldering and (b) reflow soldering? (7 marks).
    b.It is common practice to tin-plate electrical terminals to facilitate soldering. Why is it tin that is used? (7 marks).

OR

16. Examine various household products and describe how their components are joined and assembled. Explain why those particular processes were used and not others (14 marks).

MODULE -4

17. a.Describe the factors involved in precision forging (7 marks).
    b.Explain why cold extrusion is an important manufacturing process (7 marks).

OR

18. a.A common problem in ion implantation is channeling, in which the high-velocity ions travel deep into the material via channels along the crystallographic planes before finally being stopped. How could this effect be avoided? Explain (7 marks).
    b.Describe your understanding of the important features of clean rooms and how they are maintained (7 marks).

MODULE -5

19. a.List the advantages and disadvantages of surface micromachining compared with bulk micromachining (7 marks).
    b.What is the difference between chemically reactive ion etching and dry-plasma etching? (7 marks).

OR

20. a. What is the main limitation to successful application of MEMS? (7 marks).
    b. What is the purpose of a spacer layer in surface micromachining? (7 marks).

Course content and lecture schedules.

Module	TOPIC	No. of hours	Course outcomes
1.1	Metal casting:-sand casting:- sand, types of sand mold, pattern, cores, casting operations.	2	CO1
1.2	Shell molding, plaster and ceramic mold casting; evaporative pattern casting, investment casting,	3	CO1 CO5
1.3	Permanent mold casting, vacuum casting, slush casting, pressure casting, die casting,	2	

1.4	Centrifugal casting, squeeze casting, semi solid metal forming - applications of each process.	2	CO1
1.5	Casting for single crystal, applications of each process, casting defects.	1	
2.1	Powder metallurgy:-powder production methods, atomization, reduction, electrolytic deposition, carbonyls, comminution.	2	CO2
2.2	Powder characteristics:- particle size, shape and distribution	1	CO2 CO5
2.3	Blending, mixing and compaction of metal powders, isostatic pressing	2	CO2
2.4	Sintering: fundamentals and mechanisms - infiltration and impregnation.	1	
2.5	Welding: arc welding non consumable electrodes, heat transfer in arc welding, gas tungsten arc, plasma arc and atomic hydrogen welding; heat affected zone, weld ability, weld quality, applications of each processes.	3	CO4 CO5
3.1	Consumable electrodes:-shielded metal, submerged, gas metal arc welding, heat affected zone, weld ability, weld quality, applications of each processes.	3	CO4
3.3	Electron and laser beam welding, heat affected area, power density, weld quality, heat affected zone, case study, applications of each processes.	1	
3.4	Brazing:- filler metals, fluxes, joint strength; brazing methods, torch, furnace, induction, resistance, dip brazing, applications of each processes.	2	CO4
3.5	Soldering:-types of solders and fluxes - different soldering methods - solder ability, case study, typical joint designs, applications of each processes.	2	CO4
4.1	Metal forging:-open die, impression die, closed die, precision die, quality, defects.	3	CO4
4.2	Metal extrusion:-process, hot, cold, impact and hydrostatic extrusion; defects, applications - Metal drawing process- drawing practice- defects, applications of each processes.	3	
4.3	Fabrication of microelectronic devices:-clean rooms-semiconductors and silicon- crystal growing and wafer preparation	2	CO4
4.4	Film deposition - oxidation - Photo lithography	1	
5.1	electron beam lithography, X-ray, Ion beam, photo resistant lithography, scattering with angular limitations projection electron beam lithography.	1	CO4
5.2	Etching:- wet etching:- isotropic etchants, anisotropic etching - dry etching:-sputter, reactive plasma, physical chemical and cryogenic dry etching.	2	CO4
5.3	Diffusion and Ion implantation- metallization and testing- Wire bonding and packing-yield and reliability - printed circuit boards	3	CO4 CO5
5.4	Fabrication of micro electro-mechanical devices:-micromachining of MEMS devices: bulk and surface micro machining, single crystal silicon reactive etching and metallization, silicon micromachining by single step plasma etching, etching combined with diffusion bonding with suitable example and applications.	3	CO4

SEMESTER -4
HONOURS

CODE MET292	COURSE NAME CONTINUUM MECHANICS	CATEGORY	L	T	P	CREDIT
		VAC	3	1	0	4

Preamble:

At the end of the course the students will have a comprehensive, systematic and integrated knowledge of the principles of continuum mechanics. They be conversant with physical laws and analytical tools such as tensor calculus required to formulate and solve continuum problems. Also they have an in-depth understanding of the common principles which underlie the disciplines of solid mechanics and fluid mechanics – hitherto considered mostly separate. The course equip the students to pursue further specialized areas of study such as aeroelasticity, nonlinear mechanics, biomechanics etc. which are essentially based on continuum mechanics.

Prerequisite:

MECHANICS OF SOLIDS

Course Outcomes:

After the completion of the course the student will be able to

CO 1	**Make use of the concepts of tensor formalism for practical applications**
CO 2	**Apply deformation and strain concepts for practical situations**
CO 3	**Identify stresses acting on components subjected to complex loads**
CO 4	**Make use of fundamental laws for problem formulations and mathematical modeling**
CO 5	**Develop constitutive relations and solve 2 D elasticity problems**

Mapping of course outcomes with program outcomes

	PO 1	PO 2	PO 3	PO 4	PO 5	PO 6	PO 7	PO 8	PO 9	PO10	PO 11	PO 12
CO 1	3				2				2			3
CO 2	3	3	3		2	1			2			3
CO 3	3	3	3		2	1			2			3
CO 4	3								2			3
CO 5	3	3	3		2	1			2			3

Assessment Pattern

Bloom's Category	Continuous Assessment Tests		End Semester Examination
	1	2	
Remember	10	10	10
Understand	20	20	20
Apply	20	20	70
Analyse			
Evaluate			
Create			

Mark distribution

Total Marks	CIE	ESE	ESE Duration
150	50	100	3 hours

Continuous Internal Evaluation Pattern:

Attendance : 10 marks
Continuous Assessment Test (2 numbers) : 25 marks
Assignment/Quiz/Course project : 15 marks

End Semester Examination Pattern:

There will be two parts; Part A and Part B. Part A contain 10 questions with 2 questions from each module, having 3 marks for each question. Students should answer all questions. Part B contains 2 questions from each module of which student should answer any one. Each question can have maximum 2 sub-divisions and carry 14 marks.

COURSE LEVEL ASSESSMENT QUESTIONS

Course Outcome 1

1. With the help of mathematical derivations obtain the relation between circulation of a vector field per unit area around a point in a plane and curl of the vector.
2. Prove the vector identity $u \times (v \times w) = (u.w)v - (u.v)w$
3. Show that a) $\delta_{3p}v_p = v_3$ b) $\delta_{3i}A_{ji} = A_{j3}$

Course Outcome 2

1. Discuss the physical interpretations of components of Linearized strain tensor.
2. Given the displacement components $u_1 = kx_2{}^2, u_2 = 0,\ u_3 = 0,\ k = 10^{-4}$, obtain infinitesimal strain tensor E
3. Given $x_1 = X_1 + 2X_2,\ x_2 = X_2, x_3 = X_3,$ obtain the right Cauchy Green deformation tensor, right stretch tensor and rotation tensor.

Course Outcome 3

1. Given a continuum, where the stress state is known at one point and is represented by the Cauchy stress tensor components $[\sigma_{ij}] = \begin{bmatrix} 1 & 1 & 0 \\ 1 & 1 & 0 \\ 0 & 0 & 2 \end{bmatrix}$Pa, find the principal stresses and principal directions.
2. The stress state at one point is represented by the Cauchy stress components $[\sigma_{ij}] = \begin{bmatrix} \sigma & a\sigma & \boldsymbol{b}\sigma \\ a\sigma & \sigma & c\sigma \\ b\sigma & c\sigma & \sigma \end{bmatrix}$, where a, b, c constants are and σ is the value of the stress. Determine the constants such that the traction vector on the octahedral plane is zero.
3. Find the maximum principal stress, maximum shear stress and their orientations for the state of stress given $[\sigma_{ij}] = \begin{bmatrix} 6 & 9 & 0 \\ 9 & -6 & 0 \\ 0 & 0 & 3 \end{bmatrix} MPa$

Course Outcome 4

1. Explain Reynold's Transport Theorem
2. Prove the symmetry of stress using principle of conservation of angular momentum.
3. Obtain the Eulerian form of continuity equation

Course Outcome 5

1. From linear elastic constitutive relation for isotropic materials, deduce the strain stress relation $\varepsilon_{ij} = \frac{1+\nu}{E}\ \sigma_{ij} - \frac{\nu}{E}\sigma_{kk}\delta_{ij}$
2. Formulate the stress compatibility equation for plain strain problems in the absence of body force.
3. Derive the stress compatibility equation for a plain stress problem with body force. State the condition under which it becomes the biharmonic equation.

MODEL QUESTION PAPER

APJ ABDUL KALAM TECHNOLOGICAL UNIVERSITY

IV SEMESTER B.TECH DEGREE EXAMINATION

Course Code : MET292

Course Name : CONTINUUM MECHANICS

PART A

Each question carries three marks

1. Differentiate between vector space and inner product space.
2. Prove div (**A** x **B**) = curl **A**.**B** – curl **B**.**A**, using indicial notation.
3. Differentiate between Lagrangian and Eulerian description of fluid motion.
4. The Lagrangian coordinate of a material particle is $(x(t), y(t), z(t))$. Obtain the mathematical expression for the component of acceleration along the direction of motion of the material particle.
5. Derive an equation for octahedral shear stress in terms of the stress invariants.
6. The Cauchy stress tensor at a point P is given $\sigma ij = \begin{bmatrix} 5 & 6 & 7 \\ 6 & 8 & 9 \\ 7 & 9 & 2 \end{bmatrix}$ GPa. Obtain the deviatoric and volumetric parts of the tensor.
7. Deduce the equilibrium equations from linear momentum principle.
8. Express the local and global form of Reynold's Transport Theorem.
9. Write down the stress strain relations of a linear elastic isotropic material.
10. Write down the radial and tangential components of stress in terms of Airy's stress function.

PART B

Answer one full question from each module.

MODULE 1

11 a) Evaluate using indicial notation (8)

i. $\mathbf{u} \times (\mathbf{v} \times \mathbf{w})$

ii. $(\mathbf{uv}) : (\mathbf{ws})$

b) Expand using summation convention (6)

iii. $\rho \dot{v}_i = \rho b_i + \sigma_{ij,j}$

iv. $e'_i = Q_{mi} e_m$

OR

12 a) Prove that $[A \quad B \quad C][D \quad E \quad F] = \begin{bmatrix} A.D & A.E & A.F \\ B.D & B.E & B.F \\ C.D & C.E & C.F \end{bmatrix}$, from there show that

$$e_{ijk}e_{rst} = \begin{bmatrix} \delta_{ir} & \delta_{is} & \delta_{it} \\ \delta_{jr} & \delta_{js} & \delta_{jt} \\ \delta_{kr} & \delta_{ks} & \delta_{kt} \end{bmatrix} \quad (9)$$

b) Establish the identity $e_{ijk}e_{mnk} = \delta_{im}\delta_{jn} - \delta_{in}\delta_{jm}$ (5)

MODULE 2

13 a) Given the motion of a body $x_i = X_i + 0.2tX_2\delta_{1i}$, for a temperature field given by $\theta = 2x_1 + (x^2)^2$, find the material description of temperature and the rate of change of temperature of a particle at time t=0 , which was at the place (0,1,0). (8)

b) Derive compatibility equation (6)

OR

14 a) Given that $[F] = \begin{bmatrix} \sqrt{3} & 1 & 0 \\ 0 & 2 & 0 \\ 0 & 0 & 1 \end{bmatrix}$, determine the left and right stretch tensors. (14)

b) Explain infinitesimal deformation theory.

c) Obtain an expression for Linearized strain.

MODULE 3

15 a) The stress matrix in MPa when refereed to axes $Px_1x_2x_3$ is (14)

$$[\sigma_{ij}] = \begin{bmatrix} 3 & 10 & 0 \\ -10 & 0 & 30 \\ 0 & 30 & -27 \end{bmatrix}$$

Determine

i. the principal stresses
ii. principal planes
iii. maximum shear stress
iv. Octahedral normal and shear stress

OR

16 a) The principal stresses of stress at a point are σ_1, σ_2 and σ_3 with $\sigma_1 > \sigma_2 > \sigma_3$. Now derive equations of the direction cosines of a plane passing through this point, which is subjected to normal and shear stress σ_n and τ_n respectively. (6)

b) For the stress state given

$$[\sigma_{ij}] = \begin{bmatrix} 12 & 9 & 0 \\ 9 & -12 & 0 \\ 0 & 0 & 6 \end{bmatrix} MPa$$

where the Cartesian coordinate variables X_i are in meters and the unit of stress are MPa. Determine the principal stresses and principal directions of stress at the point $X = e_1 + 2e_2 + 3e_3$. (8)

MODULE 4

17 a) Derive the differential form of conservation of energy. (4)

b) What is localization theorem? Write down its relevance in the derivation of differential equations. (6)

c) Derive the Cauchy's equation of motion using the conservation of linear momentum principle (4)

OR

18 a) Prove the symmetry of stress $\sigma_{ij} = \sigma_{ji}$ using principle of conservation of angular momentum. (8)

b) Obtain the Eulerian form of continuity equation. (6)

MODULE 5

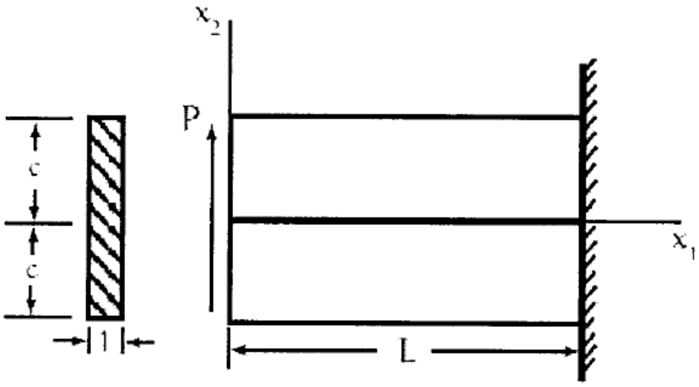
19 a)Show that for an isotropic elastic medium (6)

a. $\lambda = \frac{E\nu}{(1+\nu)(1-2\nu)}$ b) $\mu = \frac{E}{2(1+\nu)}$

b. Determine the radial stress and tangential stress developed in a thick cylinder of internal radius '*a*' and external radius '*b*' subjected internal pressure P_i and external pressure P_o using stress function method. (8)

OR

20 Consider a special stress function having the form $\phi = B_2 x_1 x_2 + D_4 x_1 x_3$. Show that this stress function ma)'- be adapted to solve for the stresses in an end-loaded cantilever beam as shown in the sketch. Assume the body forces are zero for this problem. (14)



SYLLABUS

Module 1

Mathematical preliminaries - Index notation, Einstein's summation convention- Kronecker delta and Levi-Civita symbols, Cartesian basis- Concept of tensor- Tensor as a linear transformation - Vector as a first order tensor- Coordinate transformation of vectors and tensors.

Principal values, trace and invariants-Gradient, divergence and curl of vector and tensor fields- Vector identities-Gauss' divergence and Stokes' theorems.

Module 2

Concept of continua- Reference and current configuration- Deformation gradient tensor- Lagrangian and Eulerian description of motion.

Polar decomposition theorem- Right and left Cauchy Green tensors- Infinitesimal deformation theory- Linearized strain- Principal strains- Saint Venant's compatibility equations

Module 3

Traction- Cauchy stress tensor- Stress component along orthonormal basis vector- Components of Cauchy stress tensor on any plane.

Principal planes- Principal stress components- Normal and shear stresses- Stress transformation- Equilibrium equations

Module 4

Balance Laws - Reynold's transportation theorem- Localization theorem- Lagrangian and Eulerian forms of equation for mass balance.

Balance of linear momentum equation- Balance of angular momentum- Symmetry of stress tensor- Balance of energy

Module 5

Constitutive relations - Generalized Hooke's law for isotropic materials in indicial and matrix forms- Relation connecting Lame's constants with Young's modulus, Poisson's ratio and Bulk modulus.

2D formulation of field equations; Airy's stress function- Biharmonic equation-Uni axial tension and pure bending of a beam; End loaded cantilever- Polar coordinates- Axisymmetric formulation- Lame's thick cylinder problem- Quarter circle cantilevered beam with radial load.

Text Books

1. G. Thomas Mase, George E. Mase.. Ronald E. Smelser. Continuum mechanics for engineers 3rd ed CRC Press
2. . Lawrence E. Malvern. Introduction to the Mechanics of a Continuous Medium – Prentice Hall

Reference Books

1. J.H. Heinbockel, Introduction to Tensor Calculus and Continuum Mechanics – Open Source
2. W. Michael Lai, David Ribin, Erhard Kaempl, Introduction to Continuum Mechanics 4th Ed., Butterworth- Heinemann
3. J. N. Reddy, An Introduction to Continuum Mechanics with applications - Cambridge University Press
4. Y. C. Fung, A First Course in Continuum Mechanics for Physical and Biological Engineers and scientists - Prentice Hall
5. Han-Chin W, Continuum mechanics and plasticity - CRC Press
6. Sudhakar Nair, Introduction to Continuum Mechanics – Cambridge University press
7. Morton E. Gurtin, An introduction to continuum mechanics, Academic Press
8. S.P. Timoshenko, J.N. Goodier, Theory of Elasticity, 3rd Edition, McGraw Hill Publishing

COURSE CONTENTS AND LECTURE SCHEDULE

Sl. No.	Topic	Number of lecture hours
1	Index notation, Einstein's summation convention- Kronecker delta and Levi-Civita symbols	2
2	Cartesian basis- Concept of tensor- Tensor as a linear transformation - Vector as a first order tensor	1
3	Coordinate transformation of vectors and tensors.	2
4	Principal values, trace and invariants	2
5	Gradient, divergence and curl of vector and tensor fields	2
6	Vector identities-Gauss' divergence and Stokes' theorems.	1
7	Concept of continua- Reference and current configuration, Lagrangian and Eulerian description of motion	2
8	Deformation gradient tensor, Right and left Cauchy Green tensors	2

9	Infinitesimal deformation theory- Linearized strain	2
10	Principal strains	1
11	Polar decomposition theorem	1
12	Saint Venant's compatibility equations	1
13	Traction- Cauchy stress tensor- Stress component along orthonormal basis vector	2
14	Components of Cauchy stress tensor on any plane., Normal and shear stresses	2
15	Principal planes- Principal stress components	2
16	Stress transformation	2
17	Reynold's transportation theorem- Localization theorem, Introduction on Balance Laws	1
18	Lagrangian and Eulerian forms of equation for mass balance.	1
19	Balance of linear momentum, equilibrium equations	1
20	Balance of angular momentum, Symmetry of stress tensor	1
21	Balance of energy	1
22	Constitutive relations - Generalized Hooke's law for isotropic materials in indicial and matrix forms	1
23	Relation connecting Lame's constants with Young's modulus, Poisson's ratio and Bulk modulus.	1
24	2D formulation of field equations; Airy's stress function; Biharmonic equation	4
25	Uni axial tension and pure bending of a beam; End loaded cantilever	1
26	Polar coordinates; Axisymmetric formulation	2
27	Lame's thick cylinder problem	2
28	Quarter circle cantilevered beam with radial load.	2

CODE	COURSE NAME	CATEGORY	L	T	P	CREDIT
MET294	ADVANCED MECHANICS OF FLUIDS	VAC	3	1	0	4

Preamble:

This course is a survey of principal concepts and methods of fluid dynamics. Topics include conservation equations, exact solutions of Navier-Stokes Equations, potential flow solutions, Boundary layers; introduction to turbulence and turbulence modelling

Prerequisite:

MET 203- Mechanics of Fluids

Course Outcomes: After the completion of the course the student will be able to

CO 1	Apply conservation equations of fluid mechanics
CO 2	Use potential flow theory in fluid problems
CO 3	Utilize approximate solutions of the Navier-Stokes equations
CO 4	Compute effect on boundary layers.
CO 5	Explain turbulence and turbulence modelling

Mapping of course outcomes with program outcomes

	PO 1	PO 2	PO 3	PO 4	PO 5	PO 6	PO 7	PO 8	PO 9	PO 10	PO 11	PO 12
CO 1	3											
CO 2	3	2	1									
CO 3	3	2	1	1								
CO 4	3	2	1									
CO 5	3	1										

Assessment Pattern

Blooms Category	CA			ESA
	Assignment	Test - 1	Test - 2	
Remember	25	20	20	10
Understand	25	40	40	20
Apply	25	40	40	70
Analyse	25			
Evaluate				
Create				

Continuous Internal Evaluation Pattern:

Attendance : 10 marks

Continuous Assessment Test (2 numbers) : 25 marks

Assignment/Quiz/Course project : 15 marks

Mark distribution & Duration of Examination :

Total Marks	CA	ESE	ESE Duration
150	50	100	3 Hours

End semester pattern:

There will be two parts; Part A and Part B. Part A contain 10 questions with 2 questions from each module, having 3 marks for each question. Students should answer all questions. Part B contains 2 questions from each module of which student should answer any one. Each question can have maximum 2 sub-divisions and carry 14 marks.

COURSE LEVEL ASSESSMENT QUESTIONS

Course Outcome 1

1. What is the significance of RTT in the study of transport phenomena.
2. Explain the relationship between the stress tensor and the rate of deformation.
3. Derive the expression for the Navier-Stokes equation and explain the different terms involved.

Course Outcome 2

1. Derive the expression for stream function and potential function of a doublet using the potential flow theory.
2. Derive the expression for lift for flow past a cylinder with circulation.
3. What is the significance of conformal mapping?

Course Outcome 3

1. Derive the expression for the pressure gradient for Couette flow.
2. Explain the working of a Viscometer based on the flow through a rotating annulus.
3. What is Stokes' first problem?

Course Outcome 4

1. Explain the development of boundary layer along a thin flat plate held parallel to a uniform flow. Point out the salient features.
2. Discuss on the effect of pressure gradient on boundary layer separation.
3. Find the thickness of the boundary layer at the trailing edge of a smooth plate of length 5 m and width 1.2 m when the plate is moving at 5 m/s in stationary air. Take the kinematic viscosity of air as 0.11 stokes.

Course Outcome 5

1. What are the semi-empirical theories associated with turbulent flow?
2. Explain the two equation models used in turbulent flow.
3. Distinguish between DNS and LES.

Syllabus

Module 1: Concept of viscosity, stress tensor, relation between stress and rate of deformation, Stokes hypothesis, Reynolds Transport Theorem, Mass, Momentum and Energy conservation, Derivation of Navier-Stokes equations.

Module 2: Potential flow: Uniform flow, source flow, sink flow, free vortex flow and super imposed flow-source and sink pair, doublet, plane source in a uniform flow(flow past a half body), source and sink pair in a uniform flow(flow past a Rankine oval body), doublet in a uniform flow(flow past a circular cylinder). Pressure distribution on the surface of the cylinder. Flow past a cylinder with circulation, Kutta-Juokowsky's law. Complex flow potential, complex flow potentials for source, sink, vortex and doublet. Potential flow between two parallel plates, potential flow in a sector. Introduction to conformal transformation, conformal mapping.

Module 3: Exact Solutions of Navier Stokes Equations. Parallel flow through straight channel and couette flow. Couette flow for negative, zero and positive pressure gradients, flow in a rotating annulus, Viscometer based on rotating annulus. Flow at a wall suddenly set to motion (Stokes first problem)

Module 4: Boundary layer equations; Boundary layer on a flat plate, Prandtl boundary layer equations, Blasius solution for flow over a flat plate, Von- Karman momentum integral equations, Pohlhausen approximation solution of boundary layer for non-zero pressure gradient flow, favorable and adverse pressure gradients, flow separation and vortex shedding. Boundary layer control.

Module 5: Introduction Statistical approach to turbulent flows, Length and time scales and Kolomogrov's energy cascading theory Reynolds averaged Navier Stokes equations, Turbulence modeling. Concept of eddy viscosity and Prandtl's mixing length hypothesis Zero, one and two equation turbulence models and Reynold's stress models. Concepts of LES and DNS.

Text Books

(1) White, F. M. *Viscous Fluid Flow*, McGraw Hill Education; 3 edition, 2017
(2) Schlichting, H. Boundary layer theory. McGraw Hill Education; 7 edition, 2014

COURSE PLAN

Module	Topics	Hours Allotted
I	Concept of viscosity, stress tensor, relation between stress and rate of deformation, Stokes hypothesis, Reynolds Transport Theorem, Mass, Momentum and Energy conservation, Derivation of Navier-Stokes equations.	6-2-0
II	Potential flow: Uniform flow, source flow, sink flow, free vortex flow and super imposed flow-source and sink pair, doublet, plane source in a uniform flow(flow past a half body), source and sink pair in a uniform flow(flow past a Rankine oval body), doublet in a uniform flow(flow past a circular cylinder). Pressure distribution on the surface of the cylinder. Flow past a cylinder with circulation, Kutta-Juokowsky's law. Complex flow potential, complex flow potentials for source, sink, vortex and doublet. Potential flow between two parallel plates, potential flow in a sector. Introduction to conformal transformation, conformal mapping.	7-2-0
III	Exact Solutions of Navier Stokes Equations. Parallel flow through straight channel and couette flow. Couette flow for negative, zero and positive pressure gradients, flow in a rotating annulus, Viscometer based on rotating annulus. Flow at a wall suddenly set to motion (Stokes first problem)	6-2-0
IV	Boundary layer equations; Boundary layer on a flat plate, Prandtl boundary layer equations, Blasius solution for flow over a flat plate, Von- Karman momentum integral equations, Pohlhausen approximation solution of boundary layer for non-zero pressure gradient flow, favorable and adverse pressure gradients, flow separation and vortex shedding. Boundary layer control.	8-3-0
V	Introduction Statistical approach to turbulent flows, Length and time scales and Kolomogrov's energy cascading theory Reynolds averaged Navier Stokes equations, Turbulence modeling. Concept of eddy viscosity and Prandtl's mixing length hypothesis Zero, one and two equation turbulence models and Reynold's stress models. Concepts of LES and DNS.	7-2-0

MODEL QUESTION PAPER

APJ ABDUL KALAM TECHNOLOGICAL UNIVERSITY

IV SEMESTER B.TECH DEGREE EXAMINATION

MET294 ADVANCED MECHANICS OF FLUIDS

Mechanical Engineering

Maximum: 100 Marks Duration: 3 hours

PART A

Answer all questions, each question carries 3 marks

1. What is Stokes hypothesis?
2. What is the importance of RTT in the study of transport phenomena?
3. What are the different elementary flows used in potential flow theory?
4. Draw the stream-lines and potential lines for a doublet in a uniform flow and mark the different regions.
5. With a neat sketch explain the Stokes first problem.
6. Draw the velocity profile in Couette flow for negative, zero and positive pressure gradients.
7. With a neat sketch explain the different regions of boundary layer flow over a flat plat
8. What are the different methods employed in controlling the boundary layer separation?
9. Explain Prandtl's Mixing length theory.
10. What is the importance of Turbulence Modeling in fluid dynamics?

(10×3=30 Marks)

PART B

Answer one full question from each module

MODULE-I

11. (a) Derive Reynolds Transport Theorem. (7 Marks)

    (b) Derive the expression for the law of conservation of mass from RTT. (7 Marks)

12. (a) Derive Navier-Stokes equations in Cartesian coordinate system. (10 Marks)

    (b) Write the expanded form of Navier-Stokes equations in Cartesian coordinate system. (4 Marks)

MODULE-II

13. (a) Explain uniform flow with source and sink. Obtain an expression for stream and velocity potential function and show their approximate distribution. (7 Marks)

    (b) A uniform flow with a velocity of 2m/s is flowing over a source placed at the origin. The stagnation point occurs at $(-0.398, 0)$. Determine: (i) Strength of the source, (ii) Maximum width of Rankine half-body and (iii) Other principal dimensions of the Rankine half-body. (7 Marks)

14. (a) A uniform flow with a velocity of 3m/s is flowing over a plane source of strength 30m^2/s. The uniform flow and source flow are in the same plane. A point P is situated in the flow field. The distance of the point P from the source is 0.5m and it is at an angle of 30° to the uniform flow. Determine: (i) stream function at point P (ii) resultant velocity of flow at P and (iii) location of stagnation point from the source.hfill (10 Marks)

    (b) Describe the following terms: i)Complex flow potential ii) Conformal mapping(4 Marks)

MODULE-III

15. (a) An oil of viscosity 18 poise flows between two horizontal fixed parallel plates which are kept 150mm apart. The maximum velocity of flow is 1.5m/s. Find:

    i. The pressure gradient
    ii. The shear stress at the two horizontal parallel plates
    iii. The discharge per unit width for laminar flow of oil.

    (7 Marks)

    (b) Explain the significance of Navier-Stokes equation in viscous fluid flow. Derive the expression for flow in a rotating annulus from the Navier-Stokes Equation. (7 Marks)

16. (a) Derive the expression for pressure gradient in the parallel flow through a straight channel. (7 Marks)

    (b) Explain the working of a Viscometer based on the flow through a rotating annulus. (7 Marks)

MODULE-IV

17. (a) Explain the essential features of Blasius method of solving laminar boundary layer equations for a flat plate. Derive an expression for boundary layer thickness from this solution. (7 Marks)

(b) For the velocity profile for laminar boundary layer flows given as

$$\frac{u}{U} = 2(y/\delta) - (y/\delta)^2$$

find an expression for boundary layer thickness (δ), shear stress (τ_0) and co-efficient of drag (C_D) in terms of Reynold number. (7 Marks)

18. (a) For the velocity profile in laminar boundary layer as,

$$\frac{u}{U} = \frac{3}{2}\left(\frac{y}{\delta}\right) - \frac{1}{2}\left(\frac{y}{\delta}\right)^3$$

find the thickness of the boundary layer and the shear stress 1.5 m from the leading edge of a plate. The plate is 2m long and 1.4m wide and is placed in water which is moving with a velocity of 200mm per second. Find the total drag force on the plate if μ for water = .01 poise. (7 Marks)

(b) Derive Von Karman momentum integral equation for boundary layer flows.(7 Marks)

MODULE-V

19. (a) Explain and differentiate DNS and LES. (7 Marks)

(b) What is the difference between zero equation, one equation and two equation models in turbulent flow? (7 Marks)

20. (a) Explain in detail any one of the two equation models. (7 Marks)

(b) Explain Kolmogrovs energy cascade theory. (7 Marks)

MET 296	MATERIALS IN MANUFACTURING (HONORS)	CATEGORY	L	T	P	Credits	Year of Introduction
		VAC	3	1	0	4	2019

Preamble: Understanding of the correlation between the chemical bonds and crystal structure of metallic materials to their mechanical properties.

Recognize the importance of deformation of metals at high temperature.

Enrich knowledge of various behavior and property changes inside the material structure in raised temperature and methods to strengthening the material.

Provide in-depth proficiency in material science and engineering fields for elevated temperature applications.

Prerequisite: MET 202 - Metallurgy and Material Science

Course Outcomes - At the end of the course students will be able to

CO 1	Understand the chemical bonds, crystal structures and their relationship with the properties.
CO 2	Correlate structure and properties relationship for high temperature applications.
CO 3	Understand the attributes and purity obtainable through triple vacuum induction melting process.
CO 4	To have knowledge in improving material strength against high temperature environment and predict life time.
CO 5	Understand the properties of super alloys and its strengthening processes.

Mapping of course outcomes with program outcomes (Minimum requirements)

	PO 1	PO 2	PO 3	PO 4	PO 5	PO 6	PO 7	PO 8	PO 9	PO 10	PO 11	PO 12
CO 1	-	3	-	-	-	-	-	-	-		-	-
CO 2	-	-	3	-	-	-	-	-	-	-	-	-
CO 3	-	-	-	3	-	-	-	-	-	-	-	-
CO 4	3	-	-	-	-	-	-	-	-	-	-	-
CO 5	-	-	-	-	-	-	-	-	-	-	-	3

ASSESSMENT PATTERN

Bloom's taxonomy	Continuous Assessment Tests		End Semester Examination (Marks)
	Test 1 (Marks)	Test 11 (Marks)	
Remember	25	25	25
Understand	15	15	15
Apply	30	25	30
Analyze	10	10	10
Evaluate	10	15	10
Create	10	10	10

Mark distribution

Total Marks	CIE marks	ESE marks	ESE duration
150	50	100	3 Hours

Continuous Internal Evaluation (CIE) Pattern:

Attendance	10 marks
Regular class work/tutorials/assignments	15 marks
Continuous Assessment Test (2 numbers)	25 marks

End semester pattern:- There will be two parts; Part A and Part B. Part A contain 10 questions with 2 questions from each module, having 3 marks for each question. Students should answer all questions. Part B contains 2 questions from each module of which student should answer any one. Each question can have maximum 2 sub-divisions and carry 14 marks.

Course Level Assessment Questions

Part -A

Course Outcome 1 (CO1): Understand the chemical bonds, crystal structures and their relationship with the properties.

1. Why electrons of higher principal quantum number form weaker bonds.
2. Postulate why ionic and covalent bonded material exhibit bad conductors of heat and electricity?
3. What are the roles of surface imperfections on crack initiation.
4. Which mechanism of strengthening is the Hall- Petch equation related to?

Course Outcome 2 (CO2): Correlate structure and properties relationship for high temperature applications.

1. Nickel has an atomic weight of 58.71, a number which arises from the relative proportions of isotopes of weights 58, 60, 61, 62 and 64. Why is there little contribution from the isotopes of weight 59 and 63?
2. Comparison of the rates of interdiffusion of the transition group metals (the solutes) with nickel (the solvent) indicates that (i) the interdiffusion rate increases with increasing misfit strain between solvent and solute and (ii) the activation energy for interdiffusion decreases with increasing misfit strain. Why might these observations be contrary to expectation? How might this apparent anomaly be rationalised?

Course Outcome 3 (CO3): Understand the attributes and purity level obtainable through triple vacuum induction melting process.

1. What is the need of vacuum for obtaining purifying metals?
2. What are conditions for freckle formation and how can be eliminated?
3. Explain the need of electrode quality in ESR and VAR process?
4. Which are the factors governs the quality of vacuum arc remelting process.

Course Outcome 4 (CO4): To have knowledge in improving material strength against high temperature environment and predict life time.

1. Explain why it might not be sensible, even for single-crystal superalloys, to eliminate completely the grain-boundary strengtheners such as carbon and boron from the melt chemistry.
2. The rate of oxide formation in Al_2O_3 forming single-crystal superalloys is greatly increased with additions of Ti to the alloy chemistry. Explain why this effect occurs.
3. Non-conductive material will you recommend to use at high temperature explain?
4. Both titanium and steel melt at temperatures in excess of 1500 C. Steel can be used at temperatures as high as 1000C but titanium cannot. Why is this?

Course Outcome 5 (CO5): Understand the properties of super alloys and its strengthening processes.

1. The following defects can occur during the casting of single-crystal components:(i) high-angle grain boundaries, (ii) freckles and (iii) spurious grains. What is meant by these terms? Give a brief explanation of the origin of each effect.
2. Suggest a high electrical conductive material which can use at 1100C.
3. Give two reasons why the use of titanium alloys is increasing at the expense of aluminum in both civil and military aircraft.

SYLLABUS

MODULE - 1

Atomic structure- chemical bonds-crystallography-miller indices - slip - dislocation - crystallization-frank-reed source - Structural parameters in high-temperature deformed metals - dislocation structure - distances between dislocations in sub-boundaries - sub-boundaries as dislocation sources and obstacles -dislocations inside sub-grains - vacancy loops and helicoids - structural peculiarities of high - temperature deformation.

MODULE - II

Characteristics of high-temperature materials - The super alloys as high-temperature materials- The requirement: the gas turbine engine- Larson–Miller approach for the ranking of creep performance- development of the super alloys- Nickel as a high-temperature material: justification- super alloy production methods:- vacuum induction melting (VIM), vacuum arc remelting (VAR), VIM, electroslag remelting (ESR),VIM, ESR, VAR- Freckles, three rings, white spot- cleanliness.

MODULE - III

Superalloys:- metallurgy, characteristics - wrought, cast superalloys, properties -crystal structures, phases in superalloys, Iron-Nickel-base superalloys, Nickel-base superalloys, Cobalt-base superalloys, - elements causing brittle phase formation, detrimental tramp elements, elements producing oxidation and hot corrosion resistance- microstructure, gamma prime, gamma double prime, Carbide and Boride phases, strengthening mechanisms- Heat treatment.

MODULE - IV

Single-crystal super alloys for blade applications:- solidification, heat transfer, defects - mechanical behavior, performance in creep, fatigue -Titanium: binary phase diagram - production of ingot - forgings - shear bands - pickling - Ti alloys - machining and welding of Titanium - Heat Treatment - properties of titanium aluminides - Niobium: production of niobium - niobium in steel making – niobium alloys characteristics and applications- Niobium products for the superalloy industry.

MODULE - V

Molybdenum: Ferromolybdenum - production of molybdenum – properties - effect of molybdenum alloying– applications - TZM, TZC- Maraging steel:- reaction in austenite - austenite to martensite transformation- reaction in martensite - time of maraging - precipitate size - fracture toughness - welding and ageing attributes - superior features - applications - cobalt free maraging steel - intermetallics:- phase diagrams- Hume-Rothery phases- structures of $MgCu_2$, $MgZn_2$, $MgNi_2$.

Text Books

1. Callister William. D., Material Science and Engineering, John Wiley, 2014
2. Matthew J. Donachie, Stephen J. Donachie, Super alloys A Technical Guide, Second Edition, 2002 ASM International.

Reference

1. Barrett, C. S. and Massalski, T. B. Structure of metals, Third edition. New York, N.Y., McGraw-Hill Book Company, 1966.
2. Decker, Raymond Frank, Source book on maraging steels: A comprehensive collection of outstanding articles from the periodical and reference literature, Published by American Society for Metals (1979).
3. Gerd Lutjering James C.Williams, Titanium, springer.
4. Roger C. Reed, The Super alloys Fundamentals and Applications, Cambridge university press.
5. Valim Levitin - High temperature strain of metals and alloys - physical fundamentals, Wiley-VCH (2006).
6. https://www.phase-trans.msm.cam.ac.uk/teaching.html

MODEL QUESTION PAPER

MATERIALS IN MANUFACTURING - (HONORS) - MET -296

Max. Marks : 100 **Duration : 3 Hours**

Part – A

Answer all questions.

Answer all questions, each question carries 3 marks

1. NASA's Parker solar probe will be the first-ever mission to "Touch" the Sun. The spacecraft, about the size of a small car, will travel directly into the Sun's atmosphere about 4 million miles from the earth surface. Postulate the coolant used in the parker solar probe with chemical bonds.
2. Explain the structural parameters in time and creep curve for Nickel.
3. Explain the characteristics required for high-temperature materials
4. Explain the ways and means to improve super alloy cleanliness
5. What are the elements causing brittle phase formation in super alloys.
6. Explain the process and need of stress relieving used for super alloys
7. The preferred growth direction of a single-crystal superalloy is (100) Why?
8. Where is hundred percentage pure Titanium is used?
9. What are the special attributes of marging steel welded joint after ageing process?
10. How the structure of intermetallics are determined ?

PART -B

Answer one full question from each module.

MODULE -1

11. a. Explain the basic mechanism involved for metal deformation (7 marks).

b. Explain process involved in high temperature strain of metals and alloys (7 marks).

OR

12. What are the roles played by the fan, compressor, combustor and turbine arrangements in a typical gas turbine engine? How do these affect (i) the pressure and (ii) the average temperature of the gas stream? Explain why your findings justify the use of nickel based superalloys in the combustor and turbine sections, but not in the compressor regions (14 marks).

MODULE -2

13. Explain the justification for the development of super alloys as high temperature alloys (14 marks).

OR

14. Explain the conditions of freckles, three rings and white spots formation and its implications (14 marks).

MODULE -3

15.Explain with neat sketches of different strengthening mechanisms of super alloys with its microstructure (14 marks).

OR

16.Explain different types of heat treatments employed for super alloys (14 marks).

MODULE -4

17. The materials used for high-pressure turbine blade aerofoils are often referred to as single-crystal superalloys. Explain why the use of the term ‘single-crystal’ is disingenuous (14 marks).

OR

18. Explain the process of closed die forging for Titanium alloy manufacturing (14 marks).

MODULE -5

19a. Explain the different reaction in austenite in maraging steel (7 marks).

19b. Explain the Maraging steel hardness produced with aging time versus aging time and different temperatures with neat sketches (7 marks).

OR

20a. Explain the synergetic effect of cobalt and molybdenum in maraging steel with graphs and sketch (7 marks).

20b. Explain structures of $MgCu_2$, $MgZn_2$, $MgNi_2$ with neat sketches (7 marks).

Course content and lecture schedules.

Module	TOPIC	No. of hours	Course outcomes
1.1	Earlier and present development of atomic structure- Primary bonds: Secondary bonds - crystallography-miller indices- slip- crystallization - frank reed source	1	CO1
1.2	Structural parameters in high-temperature deformed metals: structural parameters.	2	CO1
1.3	Dislocation structure - distances between dislocations in sub-boundaries - sub-boundaries as dislocation sources and obstacles.	3	CO1
1.4	Dislocations inside sub-grains - vacancy loops and helicoids - structural peculiarities of high-temperature deformation (levitin).	3	
2.1	Characteristics of high-temperature materials - The superalloys as high-temperature materials.	3	CO1 CO2
2.2	The requirement: the gas turbine engine- Larson–Miller approach for the ranking of creep performance		
2.3	Development of the super alloys- Nickel as a high-temperature material: justification. (Reed).	2	CO2
2.4	Super alloy production methods:- melt routes for super alloys, characteristics, process parameters, application of each process Vacuum induction melting (VIM), Vacuum arc remelting (VAR), VIM, electroslag remelting (ESR),VIM, ESR, VAR.	3	CO2 CO3
2.5	Freckles, conditions of freckles, three rings, white spot- Super alloy cleanliness: ways and means to improve super alloy cleanliness, advantages of improved cleanliness, homogenization oxide cleanliness. (ASM).	2	CO3
3.1	Superalloys:- metallurgy of superalloys, superalloy characteristics - applications - service temperatures for superalloys.	1	CO2

3.2	Wrought superalloys, cast superalloys, properties of superalloys, mechanical properties and the application of superalloys, selecting superalloys.	1	CO2
3.3	Crystal structures, phases in superalloys, Iron-Nickel-base superalloys, Nickel-base superalloys, Cobalt-base superalloys, alloy elements and microstructural effects in superalloys, elements causing brittle phase formation, detrimental tramp elements, elements producing oxidation and hot corrosion resistance.	3	CO2
3.4	Microstructure, gamma prime, gamma double prime, Carbide and Boride phases, strengthening mechanisms: precipitate, gamma prime, gamma double prime, Carbides, M7C3 Carbides, Borides and other beneficial minor elements.	3	CO5
3.5	Heat treatment types:- stress relieving, annealing, quenching, precipitation, (ASM).	1	CO2
4.1	Single-crystal super alloys for blade applications:- directional solidification, heat transfer, formation of defects during directional solidification - mechanical behavior of the single-crystal super alloys, performance in creep, performance in fatigue (Reed).	3	CO4
4.2	Titanium: Ti-based binary phase diagram - production of ingot, Vacuum Arc Remelting - effect of forging temperature and forging pressure - closed die forgings - shear bands - pickling of titanium - Ti alloys - scrap recycling -problems in machining Titanium - welding of titanium - Heat Treatment of Ti - properties of titanium aluminides - applications.	4	CO2 CO5
4.3	Niobium: Production of niobium - niobium alloys - niobium in steel making – niobium alloys characteristics and applications- Niobium products for the superalloy industry.	2	CO2
5.1	Molybdenum: Ferromolybdenum - production of molybdenum – properties - effect of molybdenum alloying on hot strength, corrosion resistance, and toughness – applications - TZM, TZC.	2	CO2
5.2	Maraging steel:- Maraging steel chronology - reaction in austenite - austenite to martensite transformation- reaction in martensite - time of maraging - precipitate size - fracture toughness - welding and ageing attributes - superior features - applications - cobalt free maraging steel and comparisons.	4	CO2 CO4
5.3	Intermetallics:- Electronegativity, characteristics, property prediction - phase diagrams:- Magnesium - Lead, Copper – Zinc, Nickel -Titanium phase diagram - - The Hume-Rothery phases, electron phases /compounds, laves phases - Strukturbericht C15, C14, C36, etc - structures of $MgCu_2$, $MgZn_2$, $MgNi_2$.	3	CO2 CO4