Study on High Pressure Solidification Process of A356 Aluminum EPC Casting

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ABSTRACT

In this study, high pressure of 10 atm solidification mode and T6 heat treatment were conducted on the evaporative pattern casting (EPC) process of A356 aluminum alloy. The effect of casting process parameters such as pouring temperature, coating thickness and high pressure duration time on tensile strength, yield strength, elongation rate, Rockwell hardness, density, porosity and microstructure of the A356 aluminum alloy castings were also evaluated. The purposes of this study are to understand the improvement of high-pressure solidification mode on the mechanical properties and quality of A356 aluminum EPC casting. The results of this research provide the industry-university cooperation manufacturers with the better high pressure casting mode process for the production of A356 aluminum alloy castings. The result found that the difference exist between tensile strength, yield strength, elongation, Rockwell hardness, and toughness of the A356 aluminum alloy standard tensile test bars and ladder-type castings under the high pressure solidification conditions with different process parameters. For the standard tensile test bar castings of 720 ℃ pouring temperature, their strength, hardness and ductility are superior to those of 700 ℃, 740 ℃ and 760 ℃ pouring temperature. The standard tensile test bar castings and ladder type castings of pattern coated with 0.3mm coating thickness show better strength, hardness and ductility and toughness then the castings of pattern coated with 0.6mm coating thickness. The A356 aluminum alloy standard tensile test bar castings with 6 minutes duration under 10 atm high pressure solidification possess better strength and ductility than those with 3 minutes or 10 minutes duration under 10 atm high pressure. Through T6 heat treatment, the strength, hardness, ductility and toughness of A356 aluminum alloy standard tensile test bars and ladder type castings under 10 atm high pressure solidification are superior to the as-cast castings. For 10atm high pressure continued to 6min, 720 ℃ pouring temperature and 0.6mm thickness of coating A356 aluminum alloy standard tensile test bars, cast and T6 heat treatment hole rate, the rate of 0.39% of the cast holes in the T6 heat-treated 0.36% not very different, due to the T6 heat-treated test bars is not measured before the porosity of the test bars, therefore the porosity of the difference, the mechanical nature of difference. Casting for the EPC to take 10 atm high pressure solidification mode of the A356 aluminum alloy casting, high pressure for 6 minutes, 720 ℃pouring temperature and 0.3mm thickness of coating aluminum castings internal porosity of the little, the aluminum grain size distribution is better , but also no accumulation of eutectic segregation phenomenon.

Keywords: evaporative pattern casting、A356 aluminum alloy、high pressure solidification、mechanical property

Table of Contents

封面內頁 簽名頁 中文摘要.........................iii ABSTRACT.......................iv 誌謝............................vii 目錄............................viii 圖目錄...........................xi 表目錄...........................xxii 符號表...........................xxiii 第一章 前言......................1 第二章 文獻探討...................3 2.1 A356鋁合金..................3 2.2 消失模型鑄造法................3 2.3 模型製作.....................6 2.3.1 聚苯乙烯發泡步驟.............6 2.3.2 模型密度...................8 2.4 模型塗層.....................8 2.4.1 塗層性能...................8 2.4.2 塗層材料...................9 2.4.3 塗層透氣性.................9 2.4.4 塗層塗覆方法...............10 2.5 振砂造模....................11 2.6 澆鑄.......................12 2.7 A356鋁合金析出硬化熱處理......13 2.7.1 固溶處理..................13 2.7.2 淬火處理..................14 2.7.3 人工時效處理................14 2.8 高壓凝固....................15 第三章 實驗方法及步驟.............26 3.1 實驗模型與製作...............26 3.2 塗層.......................27 3.3 振砂造模....................28 3.4 鋁合金熔煉處理與澆注..........28 3.4.1 鋁合金熔煉.................28 3.4.2 除氣處理...................28 3.5 高壓凝固鑄造.................29 3.6 人工時效熱處理...............30 3.7 鑄件孔洞率與量測..............31 3.7.1 鑄件孔洞率量測..............31 3.7.2 鑄件機械性質量測............31 3.8 金相顯微組織觀察..............33 第四章 結果與討論.................47 4.1 10大氣壓對鑄件機械性質之影響...47 4.2 澆注溫度對機械性質之影響........48 4.3 塗層厚度對機械性質之影響........48 4.4 高壓持續時間對鑄件機械性質之影響..49 4.5製程參數對鑄件機械性質之影響.......50 4.6製程參數對鑄件硬度之影響..........50 4.7製程參數對鑄件孔洞率之影響.........52 4.8 OM金相顯微組織觀察.............53 4.9 SEM+EDS金相顯微組織觀察........55 第五章 結論........................100 參考文獻...........................102

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