

Grindability and Machinability of Cast Ti-Nb-Fe Alloys for Dental Applications

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ABSTRACT

In this study, the microstructure, mechanical properties, grindability and machinability of as-cast Ti-5Nb-xFe alloys with Fe content ranging from 1 to 5 wt.% prepared using a dental cast machine were investigated and compared with commercially pure titanium (c.p. Ti) and Ti-6Al-4V, which was used as a control. Experimental results indicated that the diffraction peaks of all the Ti-5Nb alloys have β phase peaks. With 1,2,3 wt% Fe, metastable β phase starts to be retained. With Fe contents higher than 4 wt%, the equi-axed β phase is almost entirely retained. In addition, α phase was found in the Ti-5Nb-4Fe and Ti-5Nb-5Fe alloys. The largest quantity of α phase and highest microhardness were found in Ti-5Nb-4Fe alloy. The grinding rate of the Ti-5Nb-xFe alloys showed a similar tendency with the microhardness. The grindability was evaluated by the volume of metal removed per minute (grinding rate) and the volume ratio of metal removed compared to the wheel material lost, calculated from the diameter loss (grinding ratio). The grindability of each metal was found to be largely dependent on the grinding conditions. The addition of Fe to Ti alloys did contribute to improving the grindability of c.p. Ti. The Ti-5Nb-xFe alloys with a higher Fe concentration could be ground more readily. The grinding rate of the Ti-5Nb-4Fe alloy at 1000 m/min was about 1.9 times higher than that of c.p. Ti.

Machinability was evaluated by the cutting forces, which traveled by the end mill to go from one edge of the specimen for permitted calculation of the average cutting forces for different metals. The experimental results indicated that the current cutting conditions, Ti-5Nb-xFe alloys and cp Ti than when the increase of Fe content when it's trend of cutting forces has increased dramatically to the Ti-5Nb-4Fe was reduced. The Ti-5Nb-xFe alloys with a higher Fe concentration could be cut more readily. Ti-5Nb-4Fe alloy at 110 m/min cutting speed, feed rate 30 mm/min, the cutting force is 5.09N. In addition, after adding cutting fluid will Ti-5Nb-xFe alloy cutting forces down 1~4N. The Ti-5Nb-4Fe alloy at 110 m/min cutting speed of the groove surface of the specimen, showing no adhesion of metal chips, and has the lowest surface roughness value (Ra).

Keywords : dental alloy、 Ti-Nb alloys、 microstructure、 mechanical properties、 grindability、 machinability

Table of Contents

封面內頁 簽名頁 中文摘要.....	iii	英文摘要.....	iii
要.....	v	誌謝.....	vii
vii 目錄.....	viii	圖目.....	xii
錄.....	xii	表目.....	xvi
錄.....	xvi	第一章 緒論.....	1
論.....	1	1.1 生醫材料的簡介.....	1
材料必須符合的性質.....	2	1.1.1 生醫材料的分類.....	1
金之特性.....	6	1.1.2 生醫材料之分類.....	3
質與發展.....	7	1.2 生醫材料之分類.....	4
質.....	11	2 第二章 理論及文獻回顧.....	7
發展.....	15	2.1 純鈦的性質與發展.....	7
理.....	18	2.2 鈦合金相之分類.....	8
物理、化學對切削之影響.....	19	2.3 鈮元素介紹與性質.....	13
性.....	20	2.4 鐵元素介紹與性質.....	13
液.....	22	2.5 生醫用鈦合金近年來的發展.....	15
義.....	25	2.6 切削加工的探討.....	17
性.....	38	2.6.1 切削原理.....	18
驗方法.....	31	2.6.2 材料的切削性.....	18
備.....	33	2.6.3 材料之機械性質與物理、化學對切削之影響.....	19
(Nb).....	33	2.7 鈦的切削.....	21
造.....	34	2.7.1 材料之機械性質與物理、化學對切削之影響.....	19
析.....	38	2.7.2 鈦的切削.....	21
		2.8 切屑型態.....	21
		2.9 切削液.....	22
		2.10 加工表面粗糙度.....	23
		2.11 研削性定義.....	25
		2.12 砂輪磨耗性.....	27
		2.13 研削性.....	38
		2.14 實驗目的.....	30
		第三章 材料及實驗方法.....	31
		3.1 實驗流程.....	31
		3.2 試料的準備.....	33
		3.2.1 純鈦 (Ti).....	33
		3.2.2 鈮 (Nb).....	33
		3.2.3 鐵 (Fe).....	33
		3.3 熔煉及鑄造.....	34
		3.4 SEM/EDS成分分析.....	35
		3.5 相分析.....	38
		3.5.1 XRD繞射分析.....	38
		3.6 機械性質分析.....	38

析	39 3.6.1 微硬度測試	39 3.7 研削性測試(grinding test)
法	40 3.7.1 試片準備	40 3.7.2 研削性測試系統設計並建立
法	41 3.7.3 實驗參數選擇	43 3.7.4 研削性評估方法
法	43 3.7.5 試片測試方式	45 3.7.6 金屬切屑(metal chip)收集
法	46 3.7.7 掃描式電子顯微鏡觀察	47 3.7.8 光學顯微鏡觀察
法	47 3.8切削性測試(machinability test)	48 3.8.1 試片準備
法	48 3.8.2 切削性測試系統設計並建立	48 3.8.3 實驗參數選擇
法	50 3.8.4 切削性評估方法	51 3.8.5 試片測試方式
法	51 3.8.6 金屬切屑(metal chip)收集	53 3.8.7 掃描式電子顯微鏡觀察
法	53 3.8.9 測試表面粗糙度	54 第四章 結果與討論
法	55 4.1 相分析	55 4.1.1 SEM/EDS成分分析
法	59 4.1.2 XRD繞射分析	66 4.2 機械性質分析
法	58 4.2.1 微硬度測試	58 4.3 研削性測試
法	60 4.3.1 金屬及合金的密度計算	60 4.3.2 研削量及研削比
法	61 4.3.3 SEM切屑觀察	67 4.3.4 切屑粒徑大小
法	73 4.3.5 光學顯微鏡觀察研削後試片表面形態	74 4.4 切削性測試
法	80 4.4.1 切削力測試	80 4.4.2 切削表面粗糙值
法	82 4.4.3 試片表面觀察	84 4.4.4 切屑觀察
法	95 第六章 結論	106 參考文獻
法	109 圖目錄	圖2.1 鈦添加不同元素之穩定相圖[30]
法	10 圖2.2 Ti-Nb二元合金之平衡相圖[32]	13 圖2.3 Ti-Fe二元合金之平衡相圖[32]
法	15 圖2.4 平面銑削之示意圖	18 圖2.5 粗糙度與切削速率之間關係
法	24 圖2.6 平面銑削之工件表面示意圖	25 圖2.7 研削及切削法之示意圖
法	26 圖2.8 研削典型的磨耗曲線[42]	27 圖2.11 各種金屬之被削性指數[47]
法	31 圖3.1 實驗流程圖	32 圖3.2 真空電弧殼式熔融機的外觀[62]
法	35 圖3.3 真空電弧殼式熔融機之熔煉室構造圖[61]	36 圖3.4 研削試驗及切削試驗試片之石墨模式意圖
法	40 圖3.6 研削試驗機之示意圖：(a) 測試系統(左視圖)；(b) 上視圖；(c) 前視圖；(d) 測試區域放大圖[61]	42 圖3.7 阿基米德原理示意圖[61]
法	46 圖3.9 合金試片之研削轉速分佈圖[62]	46 圖3.10 金屬切屑收集法示意圖[62]
法	47 圖3.11 CNC切削試驗機外觀示意圖	49 圖3.12 金屬及合金試片之切削測試
法	52 圖3.13 合金試片之切削分佈圖	52 圖3.14 金屬切屑收集法示意圖
法	54 圖4.1 Ti-5Nb-xFe合金以高掃描速度(4 deg/min)之XRD繞射圖	56 圖4.2 Ti-5Nb-xFe合金以低掃描速度(0.5 deg/min)之XRD繞射圖
法	57 圖4.3 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金的微硬度值	58 圖4.4 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金的金屬研削量
法	65 圖4.5 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金的金屬/砂輪研削比	66 圖4.6 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金以500 m/min速率研削之金屬切屑觀察(倍率：×300)
法	69 圖4.7 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金以750 m/min速率研削之金屬切屑觀察(倍率：×300)	70 圖4.8 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金以1000 m/min速率研削之金屬切屑觀察(倍率：×300)
法	71 圖4.9 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金以1200 m/min速率研削之金屬切屑觀察(倍率：×300)	72 圖4.10 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金之切屑粒徑大小
法	73 圖4.11 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金以500 m/min速率研削之試片表面觀察	76 圖4.12 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金以750 m/min速率研削之試片表面觀察
法	77 圖4.13 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金以1000 m/min速率研削之試片表面觀察	78 圖4.14 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金以1200 m/min速率研削之試片表面觀察
法	79 圖4.15 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金乾切削之切削力	81 圖4.16 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金濕切削之切削力
法	85 圖4.17 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金乾切削之表面粗糙值	84 圖4.18 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金濕切削之表面粗糙值
法	84 圖4.19 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金乾切削以55 m/min 30 mm/min(A)條件之試片表面觀察	87 圖4.20 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金乾切削以55 m/min 60 mm/min(B)條件之試片表面觀察
法	88 圖4.21 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金乾切削以110 m/min 30 mm/min(C)條件之試片表面觀察	89 圖4.22 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金乾切削以110 m/min 60 mm/min(D)條件之試片表面觀察
法	90 圖4.23 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金濕切削以55 m/min 30	

mm/min(A)條件之試片表面觀察.....	92	圖4.24 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金濕切削以55 m/min 60
mm/min(B)條件之試片表面觀察.....	93	圖4.25 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金濕切削以110 m/min 30
mm/min(C)條件之試片表面觀察.....	94	圖4.26 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金濕切削以110 m/min 60
mm/min(D)條件之試片表面觀察.....	95	圖4.27 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金乾切削以55 m/min 30
mm/min(A)條件之切屑觀察.....	97	圖4.28 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金乾切削以55 m/min 60
mm/min(B)條件之切屑觀察.....	98	圖4.29 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金乾切削以110 m/min 30
mm/min(C)條件之切屑觀察.....	99	圖4.30 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金乾切削以110 m/min 60
mm/min(D)條件之切屑觀察.....	100	圖4.31 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金濕切削以55 m/min 30
mm/min(A)條件之切屑觀察.....	102	圖4.32 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金濕切削以55 m/min 60
mm/min(A)條件之切屑觀察.....	103	圖4.33 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金濕切削以110 m/min 30
mm/min(C)條件之切屑觀察.....	104	圖4.34 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金濕切削以110 m/min 30
mm/min(C)條件之切屑觀察.....	105	表目錄 表1.1 目前生醫陶瓷的使用[15]..... 4
表2.1 純鈦的物理性質[23,24].....	8	表2.2 鈮的物理性質.....
.....	12	表2.3 鐵的物理性質.....
.....	14	表2.4 砂輪周速
與研削加工[41].....	27	表3.1 本實驗之切削測試條件.....
.....	51	表4.1
Ti-5Nb-xFe合金之SEM/EDS成分分析表.....	55	表4.2 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金之平均微硬度表.....
60	表4.3 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金的密度.....	61
表4.4 c.p. Ti、Ti-5Nb-xFe及Ti-6Al-4V合金研削測試於不	62	
同速率下之火花及聲音.....		

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