

Table of Contents

Preface, Committees

Chapter 1: Precision Machining

Effect of Cutting Feed and Chip Size Ratio on Cutting Force J. Kundrák, T. Makkai and I. Deszpoth	3
Integration of Process Mechanics and Materials Mechanics for Precision Machining S.Y. Liang and Z.P. Pan	9
Evaluation of Relationship between Cutting Parameters and Torque in Hole Making of Titanium Alloy I. Maňková, M. Vrabel', D. Kottfer, M. Franková and M. Paľo	17
Machining Efficiency Increase when Nickel Based Alloy Machining A. Matras and W. Zębala	22
Selection Criteria of Optimal Characteristic Material and Technologies for Precision Processing of Basic Working Surface of Human Hip-Joint Implant R. Turmanidze and G. Popkhadze	28
Experimental Investigation of Cutting Conditions from the View of Force Load at High Speed Milling J. Řehoř, J. Fulemová, A. Vagaská, M. Gombár and K. Monkova	36
Specific Cutting Force in Turning of Sintered Nickel Alloy G. Struzikiewicz and K. Rumian	44
A Method for Determination of the Minimal Thickness of the Cutting Layer during Precision Machining Performed with the Indexable Cutting Tools J. Krajewska-Śpiewak and J. Gawlik	50
Temperature Distribution in the Machining Zone during the Turning of a Shaft Made of the AMS5643 Steel Ł. Ślusarczyk	58

Chapter 2: Micro- and Nano-Materials and Machining

The Effect of Machining Toolpath on Surface Roughness and Dimensional Accuracy for High-Speed Micro Milling A. Dadgari, D.H. Huo and D. Swailes	69
Influence Analysis of Micro-Milling Vibrational Phenomena on Workpiece Topomorphy E. Stergianni, D. Sagris, C. Tsiafis, K. David and I. Tsiafis	77
Experimental Study on Micro-Machinability of Hardened Tool Steel in Profile Micro-Milling B. Sredanovic and G. Globocki Lakic	85
In-Plane Longitudinal Cutting in Single-Crystal Silicon Wafer Surface Micromachining R.A.S. Delos-Reyes	93
The Influence of the Machining Parameters on the Quality of the Holes Made by μEDM in Electrically Conductive Alumina-Oxide B.Z. Farkas, L. Csorba, T. Szalay, V.V. Kuzin and S.Y. Fedorov	101
On Time Step in the Molecular Dynamics (MD) Simulation of Nanomachining A.O. Oluwajobi and X. Chen	108
Molecular Dynamics Simulation of Nano-Grinding with Multiple Abrasive Grains N.E. Karkalos and A.P. Markopoulos	115
Thermal Conductivity Enhancement by Adding Nanoparticles to Ionic Liquids A.A. Minea, M.G. Moldoveanu and O. Dodun	121

Chapter 3: Non-Conventional Machining

Prediction of Crater Size in Drilling and Texturing by Pulsed Laser Ablation E. Stathatos, G.C. Vosniakos and D. Pantelis	129
Experimental Investigation of Effect of the Laser-Assisted Finish Turning of Ti-6Al-4V Alloy on Machinability Indicators W.F. Habrat	135
Laser Beam Milling of Alumina Ceramics - The Impact on Material Removal Efficiency and Machined Surface Morphology P. Šugár, M. Frnčík, J. Šugárová and M. Sahul	143
Analysis of Surface Texture of High Aspect Ratio Blind Micro Holes on Titanium Alloy (Ti-6Al-4V) in Micro Electrical Discharge Drilling S. Barman, A.B. Puri and Nagahanumaiah	151
Making Twist-Free Surfaces by Magnetic Assisted Ball Burnishing Z.F. Kovács, Z.J. Viharos and J. Kodácsy	159
Development of a Polishing Jig for Machining Centres T. Mitropoulos, P. Avrampos and G.C. Vosniakos	167
Influence of Ultrasound on Delamination during Machining of GFRP Composite Material M. Kuruc, V. Šimna, M. Necpal, T. Vopát and J. Peterka	173

Chapter 4: Abrasive Processes

Application of New Abrasives and their Quality Parameters F. Holešovský, M. Bartos, M. Dian and J. Řehoř	181
Effect of Honing Parameters on Generated Surface Quality of Cylinder Liner within Automotive Engine Production M. Vrabel', I. Maňková and N.M. Durakbasa	189
An Intelligent Grinding Wheel Wear Monitoring System Based on Acoustic Emission N. Ding, C.L. Zhao, X.C. Luo and J. Shi	195
Computational Methods for the Assessment of Nanofluids in Abrasive Processes N.E. Karkalos and A.P. Markopoulos	201
The Effect of Changes in Feed Rate on Surface Integrity during Nickel Coating Grinding M. Marek and M. Novák	207
The Influence of Cutting Conditions on Surface Roughness during Steel 100Cr6 Grinding M. Novák and N. Naprstkova	215
An Intelligent Prediction of Surface Roughness on Precision Grinding N. Ding, C.L. Zhao, X.C. Luo, Q.H. Li and Y.C. Shi	221

Chapter 5: Cutting Tools

Effect of Substrate Bias and Coating Thickness on the Properties of nc-AlCrN/a-Si_xN_y Hard Coating and Determination of Cutting Parameters T. Vopát, M. Haršáni, M. Kuruc, V. Šimna, R. Zaujec, J. Peterka and E. Čaplovič	229
Types of Tool Wear of AlTiN Coated Cutting Insert after Machining of Weld Overlay D. Kottfer, I. Maňková, M. Vrabel', M. Kianicová, F. Rehák and M. Franková	237
Optimization of Nickel Alloy Turning Considering the Tool in Different Wear Phases W. Zębala	243
A Method for the Determination of Theoretical Roughness in Face Milling Considering the Run-Out of the Inserts C. Felho and J. Kunderák	251
Stress Analysis of the Rotating Circular Saw Blade O. Bilek and M. Kovařík	259
Comparative Analysis between Conventional and Dry Turning P.N. Botsaris, C. Kyritsi and D. Iliadis	267

Chapter 6: Analysis of Surfaces and Machining Accuracy

Application of Neuro-Fuzzy Systems for Modeling Surface Roughness Parameters for Difficult-to-Cut-Steel	
P. Kovač, B. Savković, D. Rodić, M. Gostimirović, M. Sekulić and D. Ješić	277
Effects of Technological Parameters on Surface Characteristics in Face Milling	
G. Varga and J. Kundrák	285
The Analysis of the Machining Influence of the Surface Layer on Durability	
M. Lattner and F. Holešovský	293
Comparison of Theoretical and Real Surface Roughness in Case of Ball-End Milling	
B. Mikó, B. Tóth and B. Varga	299
Brush-Deburring Evaluation of Austenitic Stainless Steel	
J. Kodácsy and J. Liska	305
Design and Machining of the Femoral Component of Total Knee Implant	
A.P. Markopoulos, N.E. Karkalos, N.I. Galanis and D.E. Manolakos	313
Study on Spindle Vibration and Surface Finish in Turning of Al 7075	
A. Şahinoğlu, Ş. Karabulut and A. Güllü	321

Chapter 7: Modeling and Simulation

A New Strategy in Face Milling - Inverse Cutting Technology	
B. Karpuschewski, J. Kundrák, T. Emmer and D. Borysenko	331
A Study of Explicit Numerical Simulations in Orthogonal Metal Cutting	
E. Kaselouris, T. Papadoulis, E. Variantza, A. Baroutsos and V. Dimitriou	339
FEA-Based Comparative Investigation on High Speed Machining of Aluminum Alloys AA6061-T6 and AA7075-T651	
W. Jomaa, V. Songmene, P. Bocher and A. Gakwaya	347
Finite Element Analysis of Tool Stresses, Temperature and Prediction of Cutting Forces in Turning Process	
M. Necpal, P. Pokorný and M. Kuruc	354
Numerical Investigation of Mechanical Induced Stress during Precision End Milling Hardened Tool Steel	
A. Reimer, S. Fitzpatrick, X.C. Luo and J. Zhao	362
Deformation and FEM Analysis of the Chip Root in Face Milling Process	
P. Pokorný, R. Zaujec, V. Šimna and T. Vopát	370
Development of ANFIS Model for Flow Forming of Solution Annealed H30 Aluminium Tubes	
B. Podder, P. Banerjee, K.R. Kumar and N.B. Hui	378
A Heuristic Approach to Design Discrete Fractional Order Integrators without Using s-to-z Transform	
S. Mahata, S.K. Saha, R. Kar, D. Mandal and N. Banerjee	386
Discrete Non-Integer Order Differentiator Models Using Moth-Flame Optimization Algorithm	
S. Mahata, S.K. Saha, R. Kar and D. Mandal	394
Computer Aided Concept Building	
Á. Takács	402
Analysis of Helical Torsion Spring for Epicyclic Traction Drive	
G. Nemeth	408
Choosing Profile Shift Coefficients for Spur Gears	
Z. Tomori, J. Szente and G. Vadászné Bognár	416

Chapter 8: Manufacturing Systems

Recent Developments in Desktop-Sized Machine Tools	
J.C. Aurich, C. Müller, M. Bohley, P. Arrabiyeh and B. Kirsch	425
Advanced Metrology and Intelligent Quality Automation for Industry 4.0-Based Precision Manufacturing Systems	
N.M. Durakbasa, J. Bauer and G. Poszvek	432

Internet of Things and Industrial Applications for Precision Machining P.G. Benardos and G.C. Vosniakos	440
On Systematic CAD/CAM Modeling of Blow Molds for Plastic Bottles A.A. Krimpenis and J.G. Tsakanikas	448
Sensor Networks for Smart Manufacturing Processes J. Konyha and T. Bányai	456
A Generic Multi-Axis Post-Processor Engine for Optimal CNC Data Creation and Intelligent Surface Machining N.A. Fountas, C.I. Stergiou, N.M. Vaxevanidis and R. Benhadj-Djilali	463
An Ontology Based Semantic Machine Tool Selection for Multi Scale Wire EDM Processes B.L. Sadigh, S.N.B. Oliaei and S. Dadvandipour	470

Chapter 9: Engineering Management in Manufacturing Systems

New Challenges for Quality Assurance of Manufacturing Processes in Industry 4.0 B. Illés, P. Tamás, P. Dobos and R. Skapinyecz	481
Indirect Impacts of Drastic Scrap Rate Reduction on Costs of Production Process in Precision Machining V. Molnar	487
Cost Reduction of Manufacturing and Assembly - Case Study F. Sarka	495
Optimization of In-Plant Production Supply with Black Hole Algorithm P. Veres, T. Bányai and B. Illés	503
Supply Chain Design of Manufacturing Processes with Blending Technologies Á. Bányainé Tóth, B. Illés and F. Schenk	509
Examining the Integration Possibilities for Lean Tools and Simulation Modeling P. Tamás and B. Illés	516