

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

Chapter 4: Abrasive Processes

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

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	229
T. Vopát, M. Haršáni, M. Kuruc, V. Šimna, R. Zaujec, J. Peterka and L. Čaplovic	
Types of Tool Wear of AlTiN Coated Cutting Insert after Machining of Weld Overlay	237
D. Kottfer, I. Maňková, M. Vrabel', M. Kianicová, F. Rehák and M. Franková	
Optimization of Nickel Alloy Turning Considering the Tool in Different Wear Phases	243
W. Zebala	
A Method for the Determination of Theoretical Roughness in Face Milling Considering the Run-Out of the Inserts	251
C. Felho and J. Kundrák	
Stress Analysis of the Rotating Circular Saw Blade	259
O. Bilek and M. Kovařík	
Comparative Analysis between Conventional and Dry Turning	267
P.N. Botsaris, C. Kyritsi and D. Iliadis	

Chapter 6: Analysis of Surfaces and Machining Accuracy

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

Chapter 7: Modeling and Simulation

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

Chapter 8: Manufacturing Systems

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

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

Chapter 9: Engineering Management in Manufacturing Systems

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