



Ultrasonic machining is a non-traditional machining process. USM is grouped under the mechanical group NTM processes. In ultrasonic machining, a tool of desired shape vibrates at an ultrasonic frequency (19 ~ 25 kHz) with an amplitude of around 15 – 50 μm over the workpiece. Generally, the tool is pressed downward with a feed force, F . Between the tool and workpiece, the machining zone is flooded with hard abrasive particles generally, in the form of a water based slurry. As the tool vibrates over the workpiece, the abrasive particles act as the indenters and indent both the work material and the tool. The abrasive particles, as they indent, the work material, would remove the same, particularly if the work material is brittle, due to crack initiation, propagation and brittle fracture of the material. Hence, USM is mainly used for machining brittle materials (which are poor conductors of electricity and thus cannot be processed by Electrochemical and Electro discharge machining (ECM and EDM)).

FEED MECHANISMS: -

1. Counter weight feed mechanisms
2. Spring loaded feed mechanisms
3. Pneumatic and hydraulic feed mechanisms
4. Electric solenoid control
5. Motor type etc.

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