

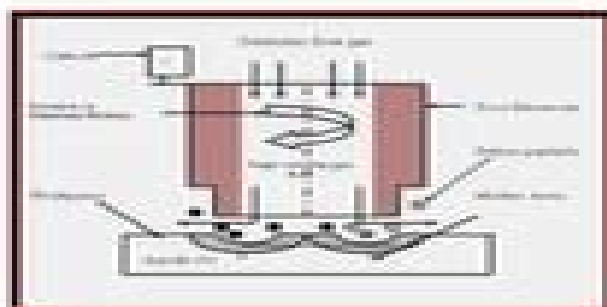


Fig. 4-Principle of Dry EDM

4.1 Research Progress in Dry EDM

Table-4

Researcher, contribution, Year, refer
Kamada et al. [1991]: oxygen gas introduced in discharge gap based dielectric in water increased removal rate.
Kamada et al. [1997]: Electrical discharge machining can be achieved in gas.
Yoshida et al. [1999]: tool electrode is almost negligible for any pulse duration in dry EDM.
Kamada et al. [2001]: narrower gap, no corrosion of work piece and high finish cutting in dry EDM.
Zhang et al. [2000]: EDM with ultrasonic aid (U-EDM) can be achieved in gas medium.
Wang et al. [2000]: dry EDM removes environmental pollution due to liquid dielectric. Better straightness with dry EDM.
Kamada et al. [2003]: oxidation of work piece due to the usage of oxygen electrode wear is almost negligible increase MRR.
Correia et al. [2000]: a thermoplastic composite electrode used in dry EDM using air as dielectric medium.
Z. B. Yu et al. [2003]: dry EDM is suitable for 3D milling of difficult to cut materials such as oxidized carbide.
Kamada et al. [2004]: improvement of dry EDM by controlling the discharge gap using a piezoelectric

actuator.

Wang T. et al. [2004]: the explosive force and electrostatic force acting on wire electrode decrease in dry WEEDM.

Zhang et al. [2004]: ultrasonic vibration improves MRR in gas by increasing the effective discharge.

Li L.Q. [2004]: discharge passage extends rapidly in the gas medium of dry EDM.

Zhang et al. [2005]: a theoretical model of surface roughness in ultrasonic vibration assisted EDM (U-EDM) in gas.

Zhang et al. [2006]: Optimum combination of depth of cut, gas pressure & pulse duration 25µm it is lead to maximum material removal rate & minimum tool wear.

Shen K. Y. et al. [2010]: Dry Electrical discharge machining (Dry EDM), using gas as dielectric, has been developed to solve problems against environment. It has both advantages of high material removal rate (MRR) and low relative electrode wear ratio (REWR).

Masahiro Fujiki [2011]: Achieve high material removal rate in tool path planning for the semi-dry electrical discharge machining (EDM) milling process using tubular electrode with a lead angle.

Wang T. et al. [2013]: More advantages of dry finishing of WEEDM such as better straightness, lower SR and shorter gap length.

Roth R. et al. [2013]: Heat energy from the oxidation has only a little effect on the material removal rate and that the main difference between oxygen and less oxidizing gases is to find in different stability and time efficiency of the process.

4.2 Conclusion

Dry EDM is eco friendly machining. Pollution is reduced by use of gas instead of oil based dielectric. Harmful & toxic fumes are not generated during machining. Material removal rate, Electrode wear ratio also get enhanced by dry EDM. This technique should be supported and more investigation should be made since it helps to save the environment.

V. POWDER MIXED WIRE EDM

Powder mixed electric discharge machining (PM-EDM) is one of the new innovations for the enhancement of capabilities of electric discharge machining process. In this process, a suitable material in fine powder is properly mixed into

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