

German University In Cairo

SalahEl-Din Ebeed

48– Mechatronics

1 Lecture 4

Question 1 *What are Mechanical properties of a material reflect ?*

It reflects its response or deformation due to a certain load or force.

Question 2 *What factor to be considered in measuring mechanical properties ?*

Factors to be considered include the nature of the applied load and its duration, as well as the environmental conditions. It is possible for the load to be tensile, compressive, or shear, and its magnitude may be constant with time, or it may fluctuate continuously. Application time may be only a fraction of a second, or it may extend over a period of many years. Service temperature and humidity may also be important factors.

Question 3 *The most common mechanical test ?*

The tension test, where a specimen is put under pure axially oriented stress (axial tension). The machine simply keeps increasing the load while measuring the load vs elongation.

Question 4 *How to normalize the tension test regardless of the dimensions of the specimen and load ?*

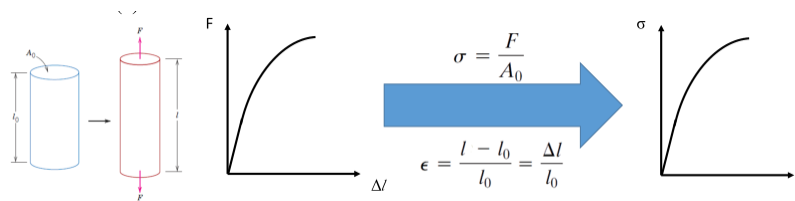
We divide the load by the **initial area** to get the stress

$$\sigma = \frac{L}{A_0}.$$

and we divide the elongation by the **initial length** to have the strain.

$$\epsilon = \frac{\Delta L}{L}.$$

So instead of the force-elongation curve we get what is called the stress-strain curve.



Question 5 *What do we get from the stress-strain curve ?*

We know the mechanical properties of the material such as: Modulus of Elasticity, Ductility, Resilience, Toughness, UTS, Yield Stress, Allowable stress. (stress or strength)

Question 6 *Describe the elastic behaviour ?*

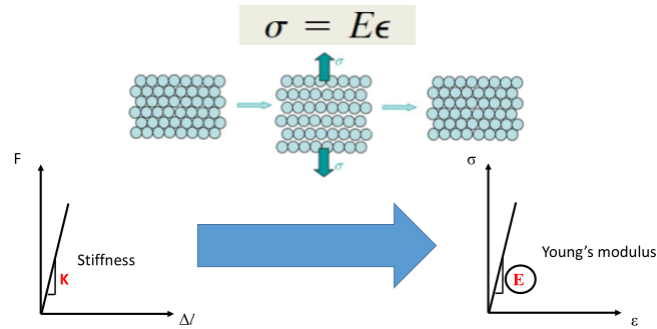
The elastic region or range, is when the tension is at relatively low levels where no bonds are broken, so the material returns to its original shape when The load is removed. Note that the elastic deformation persists only to strains of about 0.005 or (0.5%).

Question 7 *Where can we find the Yield Stress(Strength) of a material ?*

At the end of the elastic(linear) region.

Question 8 *What is young's modulus ? And how do we get it ?*

Young's modulus or the modulus of elasticity (E) is a measure of the material's stiffness. The greater the stiffer the material. We calculate it using the stress-strain graph's elastic region as it is the slope of the linear region.

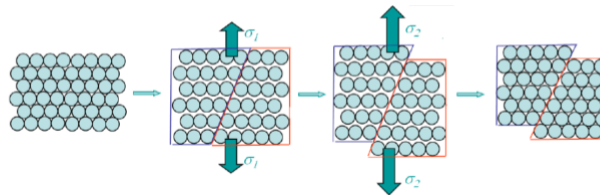


Question 9 What are the most stiff elements/materials ?

Ceramics. They have the highest E.

Question 10 What is the plastic behaviour of a material ?

After the 0.005 strain (yield strain) we get to the plastic region, where if the material is deformed in this region it won't get back to its original state or shape. Non-recoverable. In this region there is a slip that happens in the atoms planes.

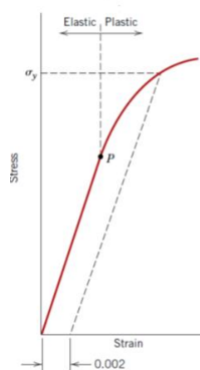


Question 11 When does the plastic deformation occur?

Exactly after the yield stress. σ_y . At a point P which is called the proportionality limit.

Question 12 How to find the point P or the yield stress σ_y ?

We go 0.002 (0.2%) offset, 0.002 of the total deformation (x-axis) and then make a straight line parallel to the elastic region's line. The point we hit is called the P.



Question 13 What is the UTS?

The ultimate tensile strength, is the stress at the maximum point on the engineering stress-strain curve. After which Necking happens and then the stress decreases as the force decreases and the original area is constant.

Question 14 What to choose when designing a material to be your safety guideline ?

We choose the yield strength instead of the ETs and of course divide it by the safety factor in order to get the allowable stress.

$$\sigma_{all} = \frac{\sigma_y}{FS}.$$

Question 15 What is Ductility and Brittles ?

it is a measure of the degree of plastic deformation that has been sustained at fracture . The material that experiences significant plastic deformation until fracture is said to be **ductile** . (long plastic deformation region). While the material that exhibits only less than 5% or no plastic deformation is said to be **brittle**.

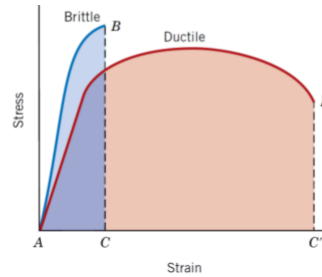
Question 16 How to calculate Ductility ?

Well, it is a percent. Percent elongation or percent reduction in area.

$$\%EL = \left(\frac{l_f - l_0}{l_0} \right) \times 100$$

$$\%RA = \left(\frac{A_0 - A_f}{A_0} \right) \times 100$$

Where the subscript 0 refers to the initial value while the subscript f refers to the final value at fracture



Question 17 What is Resilience ?

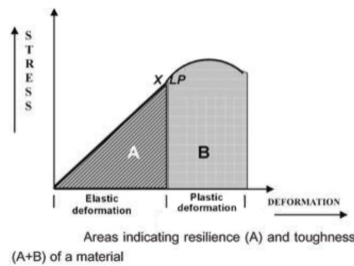
it is the capacity of the material to absorb energy while being deformed elastically. And upon unloading this energy is released. It represents the energy per unit volume (Makes sense).

Question 18 How to measure Resilience ?

Using the modulus of resilience U_r

$$U_r = \frac{1}{2} \sigma_y \epsilon_y = \frac{1}{2} \sigma_y \left(\frac{\sigma_y}{E} \right) = \frac{\sigma_y^2}{2E} J/m^3.$$

It is like Spring Energy. The area under the Elastic region Curve

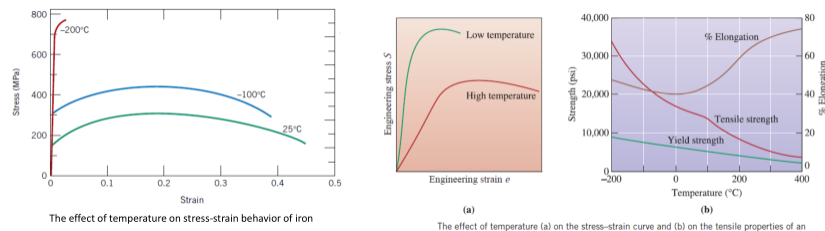


Question 19 What is toughness ?

is the ability of the material to absorb energy and plastically deform before fracturing. Like resilience.

Question 20 What is the effect of temperature on mechanical properties ?

We notice from the following graphs that decreasing the temperature decreases the ductility and hence decreases the toughness, but increases the strength of the material.



Question 21 What is the True stress-strain curve ?

Instead of the engineering stress-strain curve we have what is called the true stress-strain curve, in which the stress is computed by dividing the current force with the instant's cross sectional area not the original area.

$$\sigma = \frac{F}{A_i}$$

Question 22 Compare the engineering VS the true stress-strain curve ?

in the engineering one, after the M point (at which UTS exists), the metal becomes weaker. But this is not true, in fact it is increasing in strength. The cross section is decreasing so the stress becomes higher.

Question 23 But why does the curve go lower in the engineering one?

It is part of the experiment, we choose a certain strain rate to pull the specimen with, So the force needed to pull the specimen decreases with time as the area becomes smaller significantly when necking occurs. The machine decreases the force in order to have the same strain rate.

Question 24 How to calculate the true stress in the curve ?

$$\sigma_T = \frac{F}{A_i}.$$

Question 25 How to calculate the true strain ?

$$\text{Elongation} = \epsilon_T = \sum d\epsilon = \sum \frac{dl}{l} = \int_{l_0}^l \frac{dl}{l} = \ln(l) - \ln(l_0) = \ln\left(\frac{l}{l_0}\right).$$

Question 26 The relationship between the true and engineering stress-strain curves ?

We can assume that the volume of the specimen is the same (constant) as it deforms (**but this is before the necking**) so:

$$A_0 l_0 = A l.$$

and Hence:

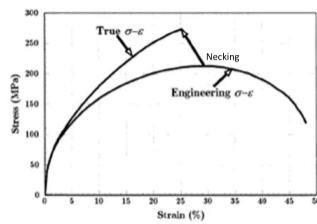
$$\sigma_T = \frac{F}{A} = \frac{F l}{A_0 l_0} = \frac{\sigma l}{l_0}.$$

$$l = l_0 + \Delta l.$$

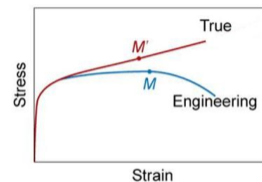
$$\sigma_T = \sigma \left(1 + \frac{\Delta l}{l_0}\right) = \sigma(1 + \epsilon).$$

and Again

$$\epsilon_T = \ln(1 + \epsilon).$$



True stress-strain computed till necking



True stress-strain computed till necking and continued via measurements of instantaneous area and length till fracture

Question 27 Define true strain

The instantaneous elongation per unit length of the specimen.

Question 28 Compare true and engineering stresses and strains.

The true stress is higher than the Engg. stress, while the true strain is smaller than the Engg. Strain.

Question 29 The relationship between true stress and strain?

$$\sigma_T = K \epsilon_T^n.$$

This is called the flow stress, K and n are constants and they vary from one metal or alloy to the other. N is called the strain hardening exponent, it is less than 1.

Question 30 What is the region of the **flow stress** ?

it begins after (not from) the yielding point (0.002 or if given) to the necking point (UTS).

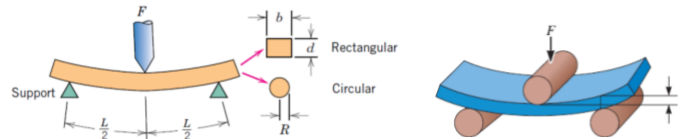
2 Lecture 5

Question 31 What other tests can we use to find mechanical properties ?

Three point bend test - impact test - hardness test

Question 32 Why normal tensile test cannot easily be done on brittle materials ?

1. it is difficult to prepare and test specimens having the required geometry.
2. it is difficult to grip brittle materials without fracturing them.
3. ceramics fail after only about 0.1% strain, which necessitates that tensile specimens be perfectly aligned to avoid the presence of bending stresses



Question 33 what is the flexural strength ?

flexural strength or bend strength or modulus of rupture, is the stress at fracture using the three point bend test. It is an important parameter for brittle materials.

For a rectangular cross section, the flexural strength (σ_{fs}) is given by

$$\sigma_{fs} = \frac{3F_f L}{2bd^2}$$

Where F_f is the force at which the sample fractures
For a circular cross section, the flexural strength (σ_{fs}) is given by

$$\sigma_{fs} = \frac{F_f L}{\pi R^3}$$

Question 34 What does fracture strength depend on ?

it depends on the specimen size ? Increasing the volume will increase the probability of existence of a crack and thus decrease the flexural strength.

Question 35 Flexural strength for brittle materials Vs fracture strength from tensile test.

The fracture strength using the 3point bend test is much greater than it is measured using tensile test.

Question 36 But why ?

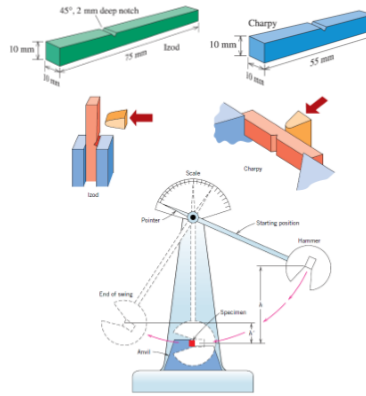
This phenomenon may be explained by differences in specimen volume that are exposed to tensile stresses: The entirety of a tensile specimen is under tensile stress, whereas only some volume fraction of a flexural specimen is subjected to tensile stresses—those regions in the vicinity of the specimen surface opposite to the point of load application .

Question 37 how different the results of 3point test

The flexural strength has units of stress. The results of the bend test are similar to the stress-strain curves; however, the stress is plotted versus deflection rather than versus strain since we actually care more about strength rather than ductility.

Question 38 What happens in the impact test ?

a material is subjected to a sudden intense blow from a weighted pendulum hammer released from a cocked position at a fixed height, strain rate is extremely rapid ($10^3 s^{-1}$). It measures the amount of absorbed energy till fracture. It is similar to toughness but in high strain rates compared to those with the tensile test.

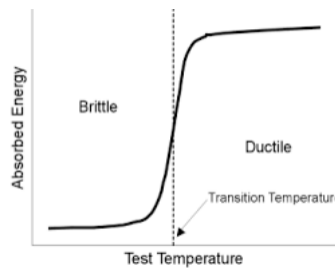


the specimen is positioned at the base as shown. Upon release, a knife edge mounted on the pendulum strikes and fractures the specimen at the notch, which acts as a point of stress concentration for this high-velocity impact blow. The pendulum continues its swing, rising to a maximum height h , which is lower than h_0 . The energy absorption, computed from the difference between h_0 and h , is a measure of the impact energy.

$$E = mg\Delta h = mg(h_0 - h).$$

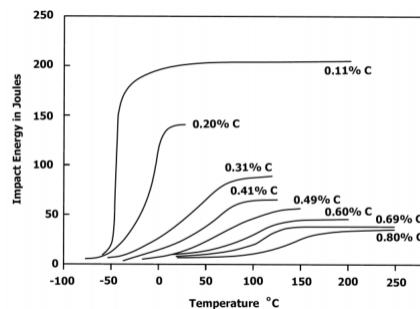
Question 39 What else does impact test measure ?

besides the absorbed energy, it also determines whether a material experiences a **ductile-to-brittle transition** with decreasing temperature or not. If so, what is the range of temperatures over which it occurs ?



Question 40 Ductile vs Brittle material in energy absorption ?

Ductile materials absorb higher energy until fracture compared to brittle materials. Below is a graph that shows the change in impact energy absorbed by carbon steels depending on the carbon content.

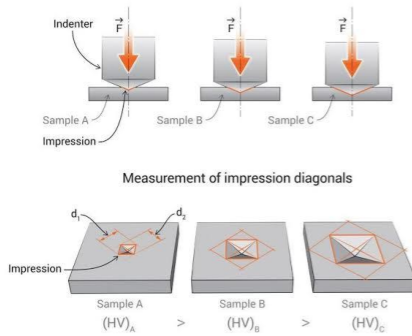


Question 41 What is Hardness ?

Hardness is the resistance of the material to localized plastic deformation (like a small dent, or a scratch depending on context).

Question 42 Describe the Hardness test ?

In a modern hardness test, a small indenter is forced into the surface of a material to be tested under controlled conditions of load and rate of application. The depth or size of the resulting indentation is measured and related to a hardness number; the softer the material, the larger and deeper the indentation, and the lower the hardness index number. Most common hardness tests are the Rockwell, Vicker and Brinell tests. Hardness numbers are used primarily as a qualitative basis for comparison of materials.



Test	Indenter	Shape of Indentation	Load	Formula for Hardness Number*
Brinell	10-mm sphere of steel or tungsten carbide	Side View: Sphere of diameter D indented to depth d. Top View: Circle of diameter d.	P	$HB = \frac{2P}{\pi D(D - \sqrt{D^2 - d^2})}$
Vickers microhardness	Diamond pyramid	Side View: Pyramid with 136° angle. Top View: Square of diagonal d1, d2.	P	$HV = 1.854P/d_1^2$
Knoop microhardness	Diamond pyramid	Side View: Pyramid with 172° angle. Top View: Rhombus of diagonals l, b.	P	$HK = 14.2P/l^2$
Rockwell and superficial Rockwell	Diamond cone: 1/8, 1/16, 1/32 in. diameter steel spheres	Side View: Cone with 120° angle. Top View: Circle of diameter d.	60 kg } Rockwell 100 kg } 150 kg } 15 kg } Superficial Rockwell 30 kg } 45 kg }	

*For the hardness formulae given, P (the applied load) is in kg, and D, d, d1, d2, and l are all in millimeters.

Question 43 Hardness and tensile stress/strength ?

The harder the material the stronger it is. and there is a relation between them.

$$TS(\text{MPa}) = 3.45 \times HB$$

$$TS(\text{psi}) = 500 \times HB$$

Question 44 What are the advantages of Hardness test over other tests ?

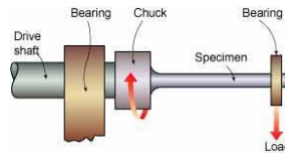
1. They are simple and inexpensive—typically, no special specimen need be prepared, and the testing apparatus
2. is relatively inexpensive. The test is non-destructive—the specimen is neither fractured nor excessively deformed; a small indentation is the only deformation.
3. Other mechanical properties often may be estimated from hardness data, such as tensile strength

Question 45 What is fatigue ?

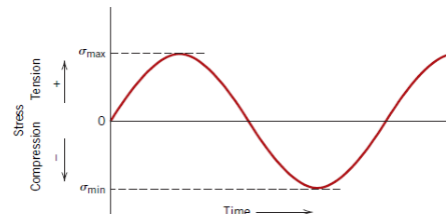
Fatigue is a form of failure that occurs in structures subjected to dynamic and fluctuating stresses (e.g., bridges, aircraft, machine components). Under these circumstances, it is possible for failure to occur at a stress level considerably lower than the tensile or yield strength for a static load. The term fatigue is used because this type of failure normally occurs after a lengthy period of repeated stress or strain cycling. The applied stress (positive and negative) may be axial (tension–compression), flexural (bending), or torsional (twisting) in nature. This is the first **time-dependent** behavior discussed.

Question 46 The fatigue test.

The most common type of test conducted in a laboratory setting employs a rotating– bending beam: alternating tension and compression stresses of equal magnitude are imposed on the specimen as it is simultaneously bent and rotated. In this case, $R = -1$.



Data are plotted as stress versus the logarithm of the number N of cycles to failure for each of the specimens. The S parameter is normally taken as either maximum stress (σ_{max}) or stress amplitude (σ_a) forming what is called the S–N curve.



$$\sigma_m = \frac{\sigma_{max} + \sigma_{min}}{2}$$

The range of stress is defined as:

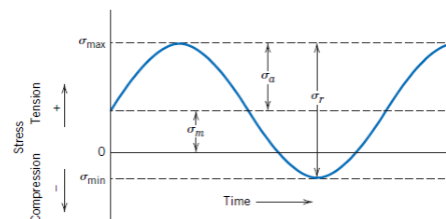
$$\sigma_r = \sigma_{max} - \sigma_{min}$$

The stress amplitude is defined as:

$$\sigma_a = \frac{\sigma_r}{2} = \frac{\sigma_{max} - \sigma_{min}}{2}$$

Finally, the stress ratio R is defined as

$$R = \frac{\sigma_{min}}{\sigma_{max}}$$



Question 47 *Relation between number of cycles before fatigue and stress ?*

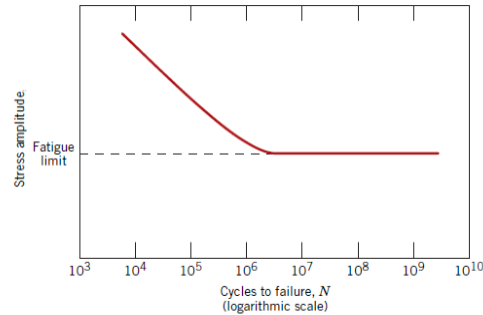
Two distinct types of S-N behavior are observed for several materials. The higher the magnitude of the stress, the smaller the number of cycles the material is capable of sustaining before failure.

Question 48 *What is the fatigue limit/endurance limit ?*

It is the limiting stress, below which fatigue will not occur. For many steels, fatigue limits range from 35 to 60% of the tensile strength .

Question 49 *S-N curve for some ferrous(iron-based) and titanium alloys ?*

becomes horizontal at higher N values .



Question 50 *What is creep property ?*

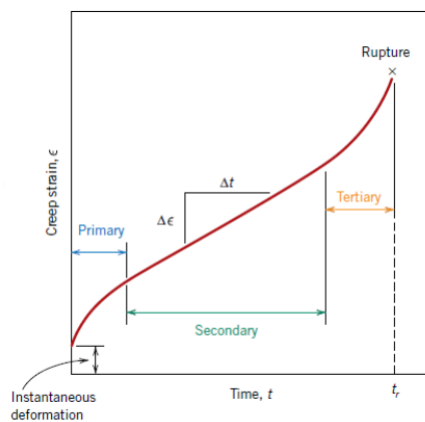
it is yet another time dependent failure/property of materials. It is the time-dependent and permanent deformation of materials when subjected to a constant load or stress less than the yield strength. For metals, it becomes important for temperatures greater than about $0.4T_m$ (melting temp). **Lead (Pb) creeps at room temperature .**

Question 51 *What is the creep test ?*

A typical creep test consists of subjecting a specimen to a constant tensile load or stress while maintaining the temperature constant; deformation or strain is measured and plotted as a function of elapsed time.

Question 52 *What is steady-state creep rate ?*

it is the slope of the secondary portion of the creep curve.



Question 53 *Relation between creep rate and stress/temp.*

With either increasing stress or temperature, creep rate increases or rupture lifetime decreases. Time to rupture, or the rupture lifetime t_r is an important parameter. For its determination, creep tests must be conducted to the point of failure; these are termed **creep rupture tests** .

Question 54 *How to improve creep properties ?*

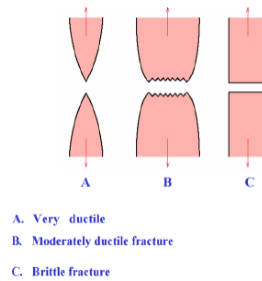
GB sliding is one of the mechanisms responsible for creep, so to overcome GB we do:

- Conventional casting
- Columnar grain
- Single Crystal

3 Lecture 6

Question 55 When does the brittle/ductile behaviour exist ?

Once the elastic limit is exceeded, the bonds between the atoms break and the material behaves either in a ductile or brittle manner



Question 56 Explain plastic deformation:

In ductile materials, the component continues to deform as the force is applied until fracture, this deformation is irreversible.

Question 57 Do brittle materials show plastic deformation ?

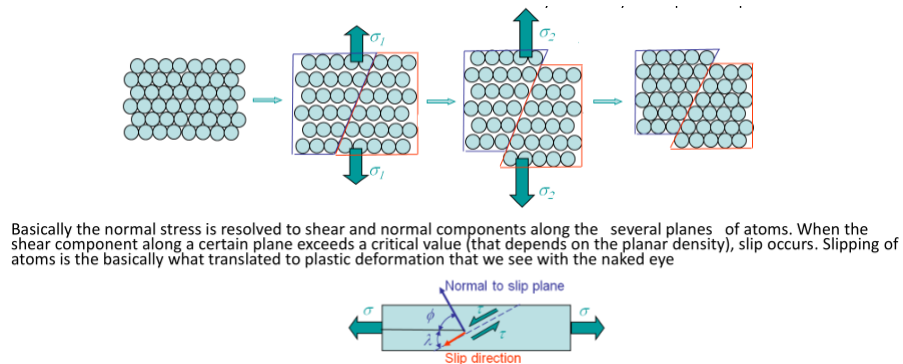
Yes, they do, yet this is not significant it is only a small amount. As the applied tensile stress breaks the bonds between the atoms and divides the component into two pieces by **cleavage**. Brittle materials fail in **tension**

Question 58 What is ductility ?

It is basically the motion of dislocations that causes plastic deformation before fracture.

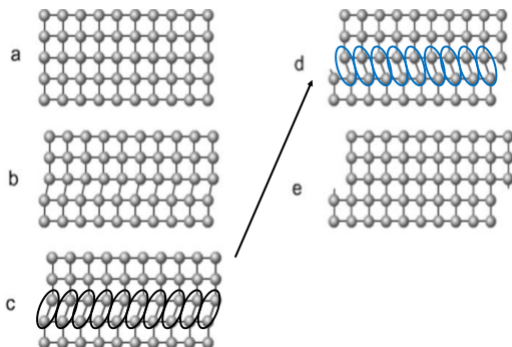
Question 59 What is the cause of plastic deformation ?

It's basically caused by the slip of one plane of atoms relative to another in **SHEAR**.



Question 60 Explain slip in perfect crystals ?

It involves breaking and forming of bonds between the atoms while the planes move along one another. This slipping requires so much energy.



This happens in perfect crystals that have no dislocations. (Hypothetical situation)

Question 61 Define Real-life slip ?

in also involves forming and breaking bonds but it is one at a time. That's why we call it dislocation slip/glide. It makes plastic deformation easier to occur, as the energy needed to break one bond at a time is lower than that needed to break a whole plane of bonds, look at the following figure.

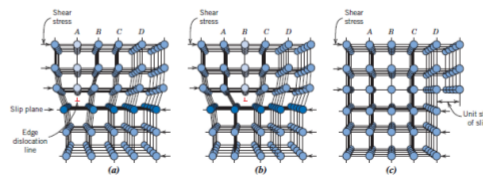


Question 62 What are the carriers of plasticity ?

Dislocations are the carriers of plasticity, because in real life there are no perfect crystals.

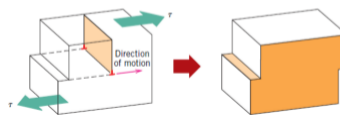
Question 63 What happens to the number of dislocations during plastic deformation ?

The number of dislocation increase dramatically !



Question 64 Define the Slip system ?

It's a system that consists of slip plane and a slip direction. The process by which plastic deformation happens itself is called slip.



Question 65 What are slip planes and directions ?

Slip planes are planes which have the highest planar density, and slip direction are those which have the highest linear density.

Question 66 Slip occurs first on which type of planes and directions ?

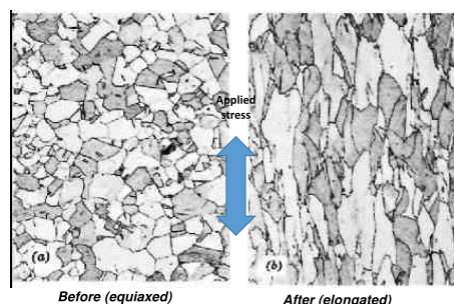
a smooth plane is the one in which atoms are dense and close together, and thus has higher planar density. So smooth planes are easier to slip.

Question 67 For an FCC material what is the plane that has the highest planar density, or what is the slip plane ?

it is (111). and the directions along the sides of this plane are the slip directions.

Question 68 Ductility in polycrystalline materials ?

Before deformation, the grains are **equiaxed** or have approximately the same dimensions in all direction. After deformation, grains are elongated in a direction parallel to the load/applied stress direction. (Only that direction). Polycrystalline materials are much stronger than their equivalent single crystalline and thus require higher stresses to initiate slip and yielding.



Question 69 What is the relation between ductility and bond types in materials ?

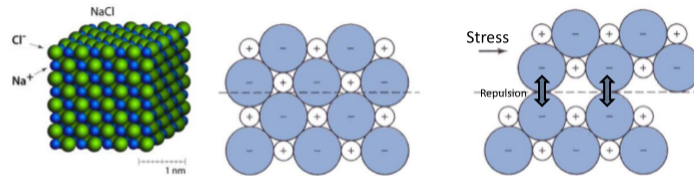
We know that covalent bonds < Ionic < Metallic in Strength. And thus covalent metals such as Silicon and diamond are less ductile than ionic ones such as ceramics .

Question 70 Relation between ductility and strength of a material ?

The more ductile the material the weaker. And the less ductile the stronger. Inverse relationship.

Question 71 Why ceramics such as (NaCl) are brittle ?

because their lattice is consisted of charged ions. Once slip starts and bonds are broken, ions of the same charge come in contact and they don not form any bonds due to repulsion. This leads to brittle fracture since once slip starts to occur, ions repel and fracture happens



Question 72 How to Strengthen one material ?

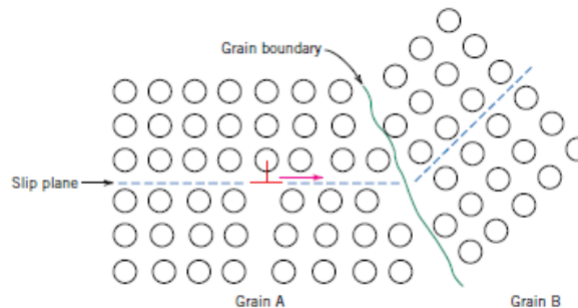
Strength (yield and tensile) are related to the ease with which plastic deformation can occur. So reducing the movement of dislocations, will increase the strength and thus decrease the ductility. **Restricting or hindering dislocation motion renders a material harder and stronger.**

Question 73 What are the strengthening mechanisms ?

- Grain size reduction
- Solid solution strengthening
- Strain hardening

Question 74 What happens in grain size reduction technique ?

We know that grain boundaries are a barrier to the dislocation movement, so in order to decrease dislocation and thus ductility and thus increase strength we increase the grain boundaries by reducing the grain size.



Small angle grain boundaries are not very effective in blocking dislocations. High-angle grain boundaries block slip and increase strength of they material .

Question 75 How to increase the area of grain boundaries to better impede motion ?

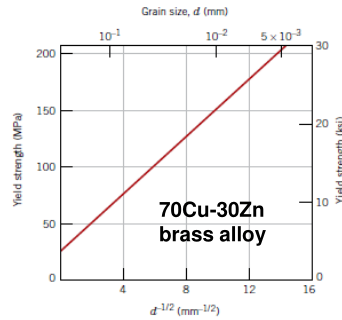
The finer the grains the larger the area of grain boundaries .

Question 76 What is the Hall-Petch equation ?

it is the relation that relates yield strength and grain size d.

$$\sigma_y = \sigma_0 + k_y(d)^{-0.5}.$$

where σ_0 and k are constants for a particular material, d is the average grain diameter.

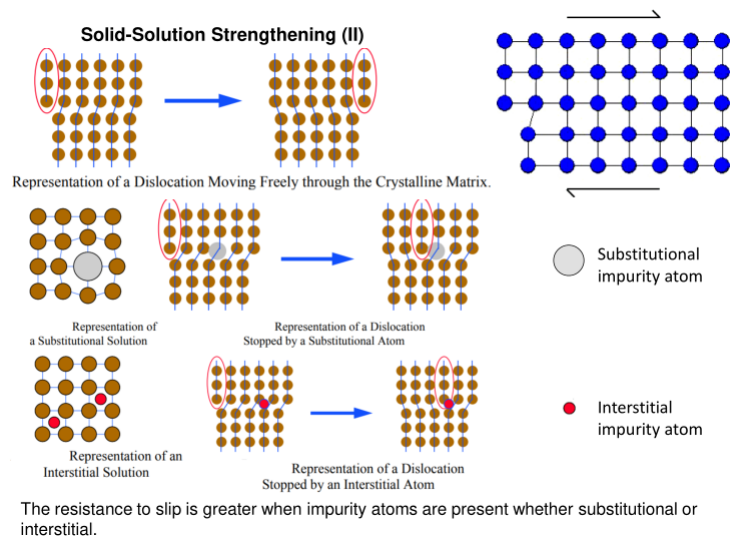


Question 77 What are solid solutions ?

means a combination of two solid or in other words an alloy :). Alloys are usually stronger than pure metals of the solvent.

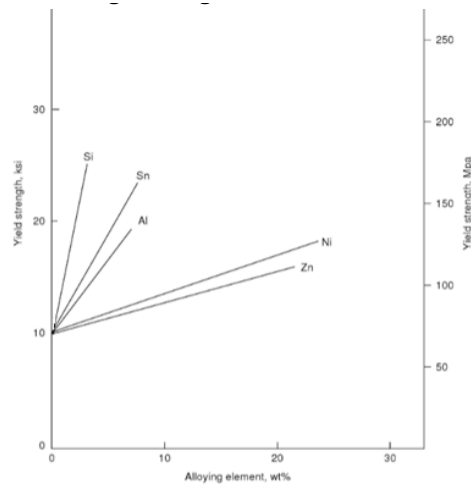
Question 78 What happens in Solid-solution strengthening ?

We use interstitial or substitutional impurities/defects to cause lattice distortion and as a result it hinders the dislocation movement.



Question 79 What makes the solid-solution technique make higher strength ?

The more the difference between impurity and base material atom sizes (radii), the higher the strengthening. And the higher concentration of the impurity atoms the higher the strength. Look at the following copper materials treated with different impurities.



Effects of several alloying elements on the yield strength of copper.

Atomic radii of some elements in pm

			Al	Si
			125	110
Ni	Cu	Zn	Ga	Ge
135	135	135	130	125
Pd	Ag	Cd	In	Sn
140	160	155	155	145

The greatest strength happened with Silicon as the difference in radii is so large.

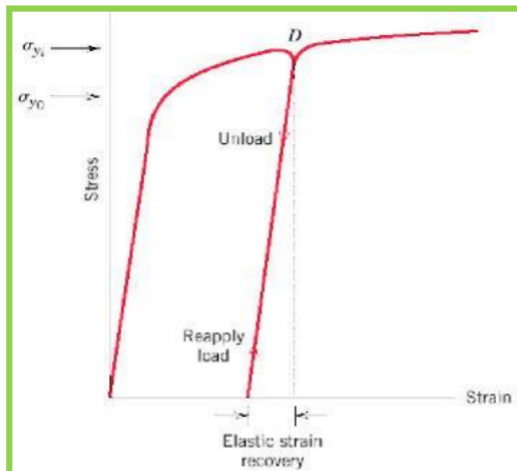
Question 80 What happens in the Strain Hardening/Work Hardening/Cold Working?

Ductile materials become more stronger when they are deformed plastically at temperatures below the melting point. We do this strain hardening in order to increase the dislocation density with applied stress. In this technique we do mechanical forces (like forging) in low temperatures below melting point. The average distance between dislocations decrease and dislocations start blocking the motion of each other.

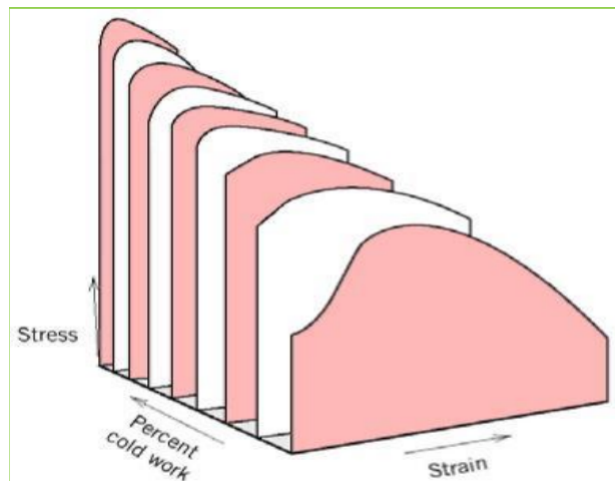
Question 81 Calculate the percent cold work (%CW).

$$\%CW = \left(\frac{A_0 - A_d}{A_0} \right) * 100.$$

%CW is just another measure of the degree of plastic deformation, in addition to strain.



New yield strength σ_{y_1} is higher than the initial yield strength, σ_{y_0} . The reason for this effect - strain hardening.



Yield strength and hardness are increasing as a result of strain hardening but ductility is decreasing (material becomes more brittle but strong).

Question 82 What if we needed to do some Strain hardening to a material that is strain hardened ?

We need first a heat treatment in 3 processes.

- Recovery
- Recrystallization
- Grain Growth (may or may not be a step)

This is a resonation to the state before the hard working.

Question 83 *What does heating do to a material in general ?*

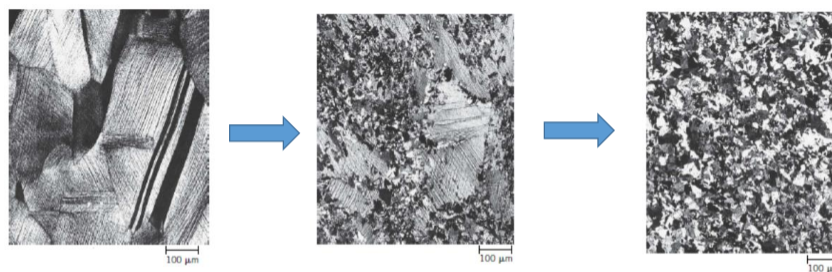
Heating in general allows materials to relief internal stresses/strains and annihilate (destroy) defects. Defects in general are distortions leading to stresses and strains. If atoms are given enough energy (through heating), they tend to move (diffuse) in a away that annihilates defects and associated stresses to a certain extent.

Question 84 *Discuss recovery :*

Heating \rightarrow increased diffusion \rightarrow enhanced dislocation motion \rightarrow decrease in dislocation density by annihilation and rearrangement \rightarrow relieve of the internal strain

Question 85 *Discuss Recrystallization:*

After recover some grains may be still strained. Those strained grained of cold-worked metal can be replaced, upon heating, by other strain-free (equiaxed) grains with low density of dislocations. Recrystallization is the nucleation and growth of new grains until they consume the while material. It depends on temperatures and time.



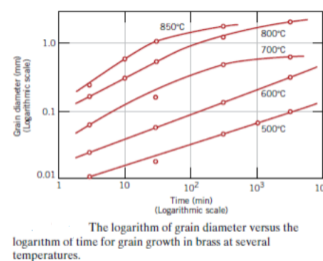
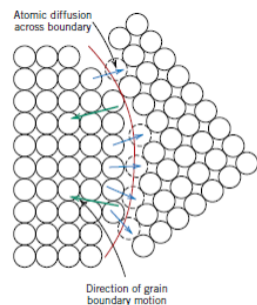
During recrystallization, grain-boundary motion occurs as the new grain form and then grow.

Question 86 *What is the Recrystallization temperature ?*

temperature at which the process is complete in one hour. It is typically 1/3 to 1/2 of the melting temperature (can be as high as 0.7 T_m in some alloys).

Question 87 *Discuss grain growth :*

If deformed polycrystalline material is maintained at annealing temperature following complete recrystallization, then further grain growth occurs.



Question 88 *What is the driving force in grain growth ?*

Driving force is reduction of grain boundary area. Big grains grow at the expense of the small ones.

Question 89 *Do grain growth happens only after recrystallization or deformation ?*

No, Grain growth during annealing occurs in all polycrystalline materials (i.e. they do not have to be deformed or recrystallized first).

Question 90 *What causes boundary motion ?*

Boundary motion occurs by diffusion of atoms across the grain boundary.

