

Design and Development of Clamping Fixture for Drilling of Boiler Tube Plate

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Abstract— Present invention provides special design of clamping fixture for drilling of boiler tube plate. This clamping fixture is necessary in order to self Centre the boiler tube plate. This self-centering can be done by using rack and pinion mechanism. This fixture was designed and built to hold, support and locate fire tube boiler plate to ensure that it is drilled with accuracy. The fixture set up for component is done manually. For that more cycle time required for loading and unloading the material so, there was a need to develop a system which can help in improving productivity and time. Fixtures reduce operation time and increase productivity and high quality of operation is possible.

Keywords— Boiler Tube Plate, Self Centering, Rack and Pinion, Hydraulic Clampers, Simulation in solidworks, Shaft,

INTRODUCTION

The present scenario is that for the purpose of drilling of fire tube boiler plate manual clamping method is used. This consumes more time and due to which production rate affects. Hence clamping and declamping requires high manpower. Also during drilling vibrations are induced. To remove that the conventional method of setting blocks is used. These blocks may obstruct the path of tool and require constant relocating of the blocks. Fixture design plays an important role at the setup planning phase. Proper fixture design is crucial for developing product quality in different terms of accuracy, surface finish and precision of the machined parts. In existing design the fixture set up is done manually, so the aim of this project is to replace with hydraulic fixture to save time for loading and unloading of component. Hydraulic fixture provides the manufacturer for flexibility in holding forces and to optimize design for machine operation as well as process functionality.

Steps for Fixture Design

Successful fixture designs begin with a logical and systematic plan. With a complete analysis of the fixture's functional requirements, very few design problems occur. The following is a detailed analysis of each step.

Step 1: Define Requirements

Step 2: Collect/Analyze Information

Step 3: Develop Several Options

Step 4: Choose the Best Option

Step 5: Implement the Design

Consideration Parameters

Designing of fixtures depends upon so many factors. These factors are analyzed to get design inputs for fixtures. The list of such factors are mentioned below:

1. Study of work piece and finished component size and geometry.
2. Type and capacity of the machine, its extent of automation.
3. Provision of locating devices in the machine.
4. Available clamping arrangements in the machine.
5. Available indexing devices, their accuracy.
6. Evaluation of variability in the performance results of the machine.
7. Rigidity and of the machine tool under consideration.
8. Study of ejecting devices, safety devices, etc.
9. Required level of the accuracy in the work and quality to be produced

Fixture Design

To meet all design criteria for work holder is impossible, compromise is inevitable. The most important hint of optimal design objectives is positioning, holding& supporting functions that fixtures must fulfill.

1. Position: Fixture must above all else hold the work piece, precisely in place to prevent 12 degrees of freedom, linear movement in the either direction about each axis.
2. Repeatability: Identical work piece specimens should be located by work holder in precisely the same space on repeated loading & unloading cycles. It should be impossible to hold the work piece incorrectly.
3. Adequate clamping forces: The work holder must hold the work piece immobile against the forces of gravity. Centrifugal force, inertia force, wetting force, milling & the design must calculate these machines forces against the fixture holding capacity. The device must be rigid: clamping forces must be maintained.
4. Care during loading cycles: As the work holders usually receive more punishment during the loading & unloading cycle than during the machining operation. The device must endure impact & aberration for at least the life of the job.

Literature Survey

Shailesh S. Pachbhai, Laukik P. Raut (2014) have described that in machining fixtures, minimizing work piece deformation due to clamping and cutting forces is essential to maintain the machining accuracy. This can be achieved by selecting the optimal location of fixturing elements such as locators and clamps. The fixture set up for component is done manually. For that more cycle time required for loading and unloading the material. So, there is need to develop system which can help in improving productivity and time.

T. Papastathisa, O. Bakker , S. Ratcheva, A. Popova (2012) have described that instead of using passive fixture element use active fixture element because it reduce the dynamic deformation of the work piece by 84.2%.

Chetankumar M. Patel, Dr. G. D. Acharya (2014) have discussed that Paper proves utility of hydraulics in fixture design in three different ways: (i) reduces cycle time, (ii) reduces operator fatigue and increases productivity and (iii) reduces wear and tear of fixture components.

CENTERING OF TUBE PLATE

Initially centering of the plate is done manually. Perpendicular diameters are drawn approximately and center is plotted. Now the plate is loosely clamped and tool is allowed to move from one end point of diameter towards the other and then the tool moves half of the distance backward to obtain the center. If this center matches with the manually obtained center then machining is done by tightening the clamping or else procedure is repeated unless and until exact center is obtained. During the drilling operation vibrations are induced in the plate. Hence to overcome this presently 100*100 mm blocks are placed below plate to support it.

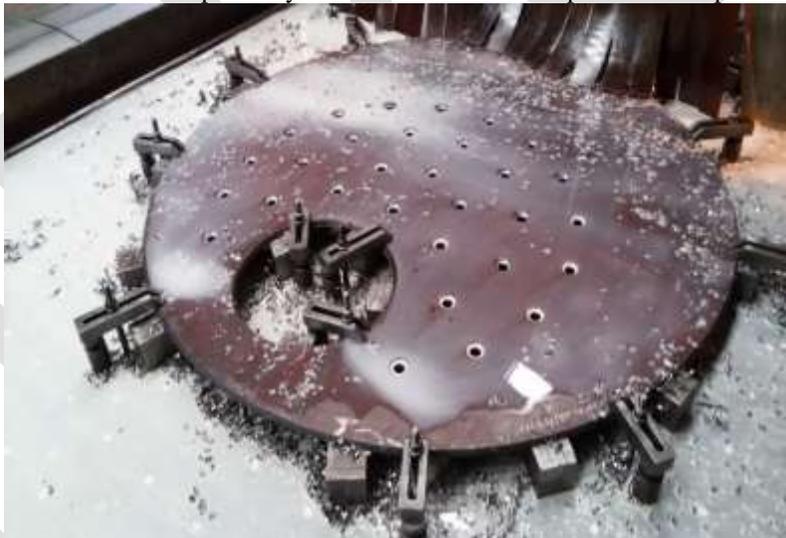


Figure 1. Actual Mounting of Plate



Figure 2. Manually adjusted Clamps

MAJOR PARTS OF THE SYSTEM

The following major parts are used in this system

1. Rack and Pinion
2. Shaft
3. Bearing
4. Coupling
5. Stand
6. Base plate
7. Clampers

DESIGN PROCEDURE

1. Design of Rack and Pinion: [7]

We have the standard rack and pinion pair available from ATALANTA RACK AND PINION Company.

Selection criteria are as follow:

Force required to pull the plate = weight of 2m diameter plate

$$W = \text{volume} \times \text{density} \times 9.81$$

$$W = \pi r^2 \times 7850 \times 9.81 = 5320 \text{ N}$$

- Step 1: Determining the Tangential Force

$$a = \frac{v}{t} \text{ [m/s}^2\text{]}$$

$$F = ((m \times g \times \mu) + (m \times a)) \text{ N}$$

- Step 2: From the given force select the standard rack and pinion pair and calculate F_{perm} .

$$F_{perm} = \frac{F_{(tab)}}{K_A \cdot S_B \cdot f_n \cdot L_{KHB}}$$

The Condition $F < F_{perm}$. Must be fulfilled.

- Step 3: Selection of load Factor K_A :

Drive	Type of load from the machines to be driven		
	Uniform	Medium Shocks	Heavy Shocks
Uniform	1	1.25	1.75
Medium Shocks	1.25	1.5	2.00
Heavy Shocks	1.5	1.75	2.25

Table 1. Shock Load Factor

Step 4: Safety Coefficient S_B :

The safety coefficient should be taken as 1.1 to 1.4
 ($S_B = 1.1$ to 1.4).

Step 5: Life-Time Factor (f_n):

Considering the peripheral speed of the pinion and lubrication.

Lubrication Peripheral Speed of Gearing m/sec	Continuous	Daily	Monthly
0.5	0.85	0.95	3 to 10
1.0	0.95	1.10	
1.5	1.00	1.20	
2.0	1.05	1.30	
3.0	1.10	1.50	
5.0	1.25	1.90	

Table 2. Life time factor

Step 6: Selection of Linear Load Distribution Factor L_{KHB} :

The linear load distribution factor considers the contact stress, while it describes unintegrated load distribution over the tool width

$L_{KHB} = 1.1$ for counter bearing, e.g. Torque Supporter.

= 1.2 for preloaded bearings on the output shaft e.g. ATLANTA HT, HP and E servo-worm gear unit, BG bevel-gear unit.

= 1.5 for unpreloaded bearings on the output shaft e.g. ATLANTA B servo-worm gear unit.

Calculations:

Mass to be Moved (m) = 550 kg

Speed (v) = 0.05 m/s

Acceleration Time (t_b) = 1 s

Acceleration Due to Gravity (g) = 9.81 m/s²

Coefficient of Friction (μ) = 0.23

Load Factor (K_a) = 1.25

Life-Time Factor (f_n) = 0.85

Safety Coefficient (S_B) = 1.4

Linear Load Distribution Factor (L_{KHB}) = 1.5

$$a = \frac{v}{t} = 0.05 \text{ m/s}^2$$

$$F_u = ((m \times g \times \mu) + (m \times a))$$

$$F_u = ((550 \times 9.81 \times 0.23) + (550 \times 0.05))$$

$$F_u = 1.268 \text{ KN}$$

Assumed feed force:

Rack C45, ind. hardened, straight tooth, and module 3.

Pinion 16MnCr5, case hardened, 40 teeth,

With $F_{tab} = 16.5 \text{ KN}$

$$F_{perm} = \frac{F_{(tab)}}{K_a \cdot S_B \cdot f_n \cdot L_{KHB}}$$

$$F_{perm} = \frac{16.5}{1.25 \times 1.4 \times 0.85 \times 1.5}$$

$$F_{perm} = 7.39 \text{ KN}$$

Condition

$$F_{perm} > F_u;$$

$$1.268 \text{ KN} > 7.39 \text{ KN} = > \text{fulfilled}$$

Result:

Rack 27 30 1001

Pinion 24 35 240 (case hardened). [4]

2. Design of Shaft

The shaft is designed using ASME code. According to this code, the permissible shear stress T_{max} for the shaft without keyways is taken as 30% of yield strength in tension or 18% of the ultimate tensile strength of the material, whichever is minimum. If keyways are present, the above are reduced by 25%. Also, the bending and torsional moments are to be multiplied by factors K_b and K_t respectively, to account for shock and fatigue.

Thus,

$$T_{max} = \frac{16Te}{\pi d^3} \sqrt{[(K_B \times M)^2 + (K_t \times T)^2]}$$

Where,

K_b = combined shock and fatigue factor applied to bending moment

K_t = combined shock and fatigue factor applied to torsional moment

Step 1: Selection of material for shaft.

The material selected for the shaft is C40 [7]

The values of the ultimate tensile strength and yield strength are as follows:

$$S_{ut} = 640 \text{ N/mm}^2$$

$$S_{yt} = 380 \text{ N/mm}^2$$

Step 2: Calculation of permissible shear stress

$$\begin{aligned} \text{Allowable stress} &= .75 \times .3 \times S_{yt} \text{ or } .75 \times .18 \times S_{ut} \\ &= 85.5 \text{ N/mm}^2 \text{ or } 86.4 \text{ N/mm}^2 \end{aligned}$$

Hence, permissible shear stress is 85.5 N/mm² Minimum value is taken.

Step 3: Calculation for maximum bending moment

Force acting on pinion is $F=1.25\text{kN}$

This force is resolved into two components as follows:

a) Tangential component acting in the direction of motion of pinion.

$$\begin{aligned} F_t &= F \cos(\alpha) \\ &= 1.25 \times \cos(20) \quad \dots 20^\circ \text{ pressure angle of pinion} \\ &= 1.17 \text{ KN} \end{aligned}$$

b) Radial component acting away from the Centre of the pinion.

$$\begin{aligned} F_r &= F_t \tan(\alpha) \\ &= 1.17 \times \tan(20) \\ &= 0.427 \text{ KN} \end{aligned}$$

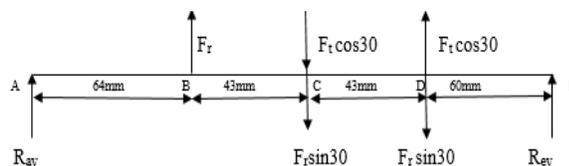


Figure 3. Vertical force diagram

$$\sum F_y = 0$$

Therefore, from vertical force diagram,

$$F_r - F_r \sin 30 - F_r \sin 30 + F_r \cos 30 - F_r \cos 30 + R_{AV} + R_{EV} = 0$$

$$0.427 - 2 \times (0.427) \times \sin 30 + R_{AV} + R_{EV} = 0$$

$$R_{AV} + R_{EV} = 0 \quad \dots (1)$$

Consider the moments about 'A'.

$$\sum M_a = 0$$

$$F_r \times 64 - (F_r \cos 30 + F_r \sin 30) \times 107 + (F_r \cos 30 - F_r \sin 30) \times 150 + R_{EV} \times 210 = 0$$

Thus,

$$R_{EV} = -0.076 \text{ kN}$$

$$R_{AV} = 0.076 \text{ kN}$$

Bending moments at different points are as follows:

$$M_{BV} = R_{AV} \times 64$$

$$= 4.864 \text{ kN-mm}$$

$$M_{CV} = R_{AV} \times 107 + F_r \times 43$$

$$= 26.514 \text{ kN-mm}$$

$$M_{DV} = R_{EV} \times 60$$

$$= -4.595 \text{ kN-mm}$$

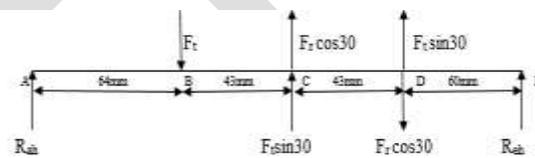


Figure 4. Horizontal force diagram

$$\sum F_x = 0$$

Therefore, from horizontal force diagram,

$$-F_t + F_r \cos 30 + F_r \sin 30 + F_r \sin 30 - F_r \cos 30 + R_{AH} + R_{EH} = 0$$

$$-1.17 - 2 \times (1.17) \times \sin 30 + R_{AH} + R_{EH} = 0$$

$$R_{AH} + R_{EH} = 0 \quad \dots (1)$$

Consider the moments about 'A'.

$$\sum M_a = 0$$

$$-F_t \times 64 + (F_r \cos 30 + F_r \sin 30) \times 107 + (F_r \sin 30 - F_r \cos 30) \times 150 + R_{EH} \times 210 = 0$$

Thus,

$$R_{EH} = -0.28 \text{ KN}$$

$$R_{AH} = 0.28 \text{ KN}$$

Bending moments at different points are as follows:

$$M_{BH} = R_{AH} \times 64$$

$$= 17.92 \text{ kN-mm}$$

$$M_{CH} = R_{AH} \times 107 - F_t \times 43$$

$$= -20.35 \text{ kN-mm}$$

$$M_{DH} = R_{EH} \times 60$$

$$= -16.8 \text{ kN-mm}$$

Resultant bending moments

$$M_B = \sqrt{[(M_{BH})^2 + (M_{BV})^2]}$$

$$= 1.856 \text{ kN-mm}$$

$$M_C = \sqrt{[(M_{CH})^2 + (M_{CV})^2]}$$

$$= 33.42 \text{ kN-mm}$$

$$M_D = \sqrt{[(M_{DH})^2 + (M_{DV})^2]}$$

$$= 17.41 \text{ kN-mm}$$

Therefore the highest total bending moment is occurring at point 'C'.

$$\text{Hence } M = 33.42 \text{ kN-mm}$$

Step 4: Calculation of torsional moment

Torque acting on the shaft is

$$T = F_t \times r$$

$$= 0.0702 \times 10^3 \text{ KN-mm}$$

Step 5: Calculation of equivalent torsional moment

For gradually loaded rotating shaft

$$K_b = 1.5 \text{ and } K_t = 1 \dots \text{ V. B. Bhandari Pg. No.334}$$

Thus the equivalent torque is

$$T_e = \sqrt{[(K_b \times M)^2 + (K_t \times T)^2]}$$

$$= 86.26 \text{ kN-mm}$$

Step 6: Verification of safety of shaft

The allowable torsional stress is given as

$$\begin{aligned}\tau_{\text{all}} &= \frac{16T_e}{\pi d^3} \\ &= 10.24 \text{ N/mm}^2 > 85.5\end{aligned}$$

Therefore design is safe.

3. Design of key

Step 1: Selection of material

C50 is selected as material for key

$$S_{\text{ut}} = 520 \text{ N/mm}^2$$

$$S_{\text{yt}} = 340 \text{ N/mm}^2$$

Step 2: Determination of dimensions of the key

For diameter of 35mm, the dimensions of keys are 10mm × 8 mm. [8]

Step 3: Permissible compressive and shear stresses

$$\begin{aligned}\sigma_c &= \frac{S_{yc}}{f_s} \\ &= 340/3 \\ &= 113.33 \text{ N/mm}^2\end{aligned}$$

According to maximum shear stress theory of failure,

$$\begin{aligned}S_{sy} &= 0.5 S_{yt} \\ &= 0.5 \times 340 \\ &= 170 \text{ N/mm}^2\end{aligned}$$

$$\begin{aligned}\tau &= \frac{S_{sy}}{f_s} \\ &= 170/3 \\ &= 56.67 \text{ N/mm}^2\end{aligned}$$

Step 4: Determination of induced compressive and shear stress

$$\begin{aligned}\sigma_c &= \frac{4 \cdot T}{d \cdot h \cdot l} \\ &= \frac{4 \cdot 70.2 \cdot 1000}{35 \cdot 8 \cdot 30} \\ &= 33.42 \text{ N/mm}^2 < 113.33 \text{ N/mm}^2\end{aligned}$$

$$\begin{aligned}\tau &= \frac{2 \cdot T}{d \cdot b \cdot l} \\ &= \frac{2 \cdot 70.2 \cdot 1000}{35 \cdot 10 \cdot 30} \\ &= 13.37 \text{ N/mm}^2 < 56.67 \text{ N/mm}^2\end{aligned}$$

Hence, the design of key is safe.

4. Design of Bearings:

Procedure for selection of bearing from manufacturing catalogue

Step 1:

Calculate i) radial (f_r) and axial forces (f_a) acting on the bearings

ii) Diameter of shaft (d)

iii) Speed of shaft (n)

Step 2:

Select the type of bearing for the given application.

Step 3:

Calculate the values of X and Y, the radial and thrust factors, from the catalogue. These values depend upon ratios, (f_a/f_r) and (f_a/C_0). The selection therefore, done by trial and error method.

To begin with, a bearing of light series, such as 60, is selected for the given diameter of the shaft and the values of C_0 is found from the catalogue.

Step 4:

Calculate the equivalent dynamic load from the equation.

$$P = X \times f_r + Y \times f_a$$

Step 5:

Make a decision about the expected bearing life and express the life L_{10} in million revolutions.

$$L_{10} = \frac{60 \times n \times L_{10h}}{10^6}$$

$$L_{10} = \frac{60 \times 10 \times 30000}{10^6}$$

$$= 18 \text{ millions}$$

Step 6:

$$C = P \times (L_{10})^{1/a}$$

$$a = 3 \text{ (ball bearing)}$$

$$C = 360.49 \times (18)^{1/3}$$

$$= 944.7525 \text{ N}$$

$$C_r = 19613.3$$

$$\text{So, } C_r > C$$

So selected bearing is safe

Step 7:

Referring the SKF manufacturing catalogue the selected bearing no is 6207[6]

Dimensions of the bearing

Inner diameter of shaft = 35mm

Outer diameter of shaft = 72mm

Thickness of bearing =17mm

5. Design of coupling:[7]

The basic procedure for finding out the dimensions of the rigid flange coupling consists of the following steps:

Shaft diameter: Calculate the shaft diameter

Dimensions of flanges: Calculate the dimensions of the flange by the following empirical equations:

$$d_h = 2d$$

$$L_h = 1.5 d$$

$$D = 3 d$$

$$t = .5 d$$

$$t_1 = .25 d$$

$$d_r = 1.5 d$$

$$D_o = (4d + 2t_1)$$

The torsional shear stress in the hub can be calculated by considering it as a hollow shaft subjected to torsional moment M_t .

The inner and outer diameters of the hub are d and d_h respectively. The torsional shear stress in the hub is given by,

$$\tau = \frac{T \times r}{J}$$

$$J = \frac{\pi}{32} (d_h^4 - d^4)$$

$$r = d_h/2$$

Shaft diameter = 35 mm

Dimensions of flange are given by following empirical equations:

$$d_h = 2d = 70\text{mm}$$

$$L_h = 1.5 d = 52.5\text{mm}$$

$$D = 3 d = 105\text{mm}$$

$$t = .5 d = 17.5 \text{ mm}$$

$$t_1 = .25 d = 8.75 \text{ mm}$$

$$d_r = 1.5 d = 52.5 \text{ mm}$$

$$D_o = (4d + 2t_1) = 157.5 \text{ mm}$$

For $d < 40\text{mm}$, $N = 3$

6. Design of hydraulic clampers [8]

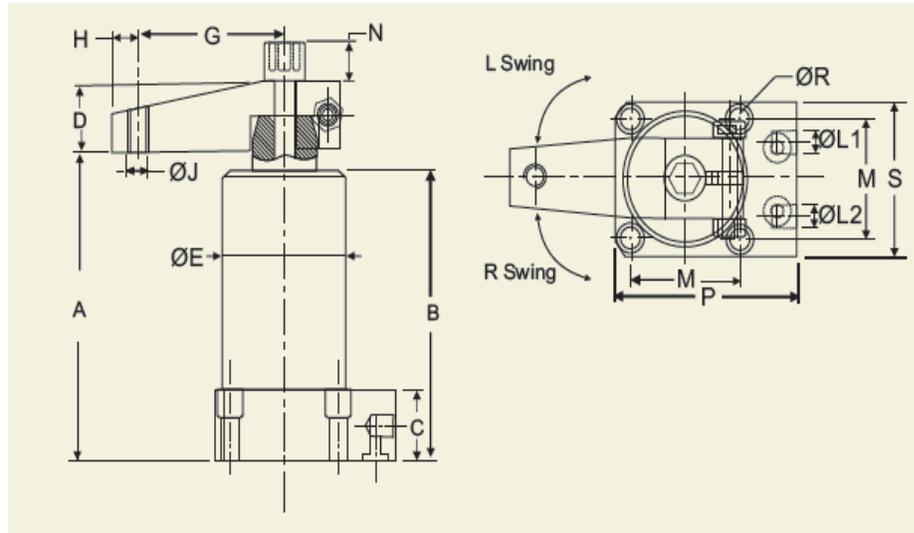


Figure 5. Design of hydraulic clampers

Model	A unclamp position	B	C	D	E	G	H	J	INLETS L1 & L2
030- 92- R/L	126	102	25	25	47.8	45	11	M10	G1/4

M	N	P	R	S	Bore dia.	Swing stroke	Clamping stroke	Clamping force(kg)
42	14.5	70.1	6.9	54	32	10	12	550

Table 3. Clamper Specifications

RESULT TABLE

Sr. No.	Component	Dimensions
1.	Rack and Pinion	Rack 27 30 1001 Pinion 24 35 240
2.	Shaft	φ35mm
3.	Bearing	6207 ID = 35mm OD = 72mm

		Thickness=17mm
4.	Coupling	dh=70mm,Lh=52.5mm D=105mm,t=17.5 mm t1 = 8.75 mm
5.	Stand	15mm

Table 4. Component Specification

ACTUAL MODEL



Figure 6. Self-Centering Mechanism without plate



Figure 7. Self-Centering Mechanism with plate

CONCLUSIONS

1. This automation reduced the human effort and hence don't need a person to adjust the plate for drilling.
2. This design also enabled vibration free operation which increased the quality of drill to the plate.
3. It increased the productivity and reduced the cycle time of 1 hour to 15 minutes.

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