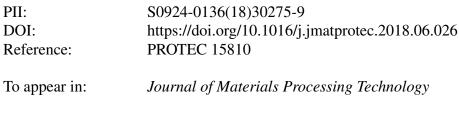
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Self-adjusting EDM/ECM high speed drilling of film cooling holes

Chaojiang Li^{a,b,1}, Bowei Zhang^{b,1}, Yong Li^{a,*}, Hao Tong^a, Songlin Ding^{c,*}, Zhiqiang Wang^a, Lei Zhao^a

a) Department of Mechanical Engineering; State Key Laboratory of Tribology, Tsinghua University, Beijing 100084, China;

b) School of Materials science and Engineering, Nanyang Technological University, 50
 Nanyang Avenue, 639798, Singapore

c) School of Engineering, RMIT University, Mill Park 3082, Victoria, Australia.

*Corresponding author: songlin.ding@rmit.edu.au (SL. Ding) and liyong@tsinghua.edu.cn (Y.

Li), <u>Tel:+86-10-62772212</u>, Fax:+86-10-62796339

¹These authors contributed equally to the paper.

Abstract: In order to reduce the thickness of recast layer and improve the surface quality of film cooling holes, a novel high speed self-adjusting electrical discharge machining (EDM)/ electrochemical machining (ECM) approach was developed by applying two independent flushing systems that were able to switch automatically in the machining process. The new flushing systems used different work-liquids and online dynamically changing discharge parameters. With the change in gap distance and the depth of the hole drilled, the dominant machining (ECDM) and ECM. The formation mechanism of the recast layer on nickel alloy was investigated by comparing the surface characters of the bulk material and those of the recast layer using transmission electron microscope (TEM) and energy dispersive X-ray spectroscopy (EDS). The results from comparison experiments, in which different discharge parameters and sustaining time were applied, show that this new flushing systems would ensure much better flushing continuity of the working fluid and improve the discharge gap status. In addition, low voltage and current would benefit the ECM process and the removal of recast layer.

Keywords: EDM; ECM; Film cooling holes; Recast layer.

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