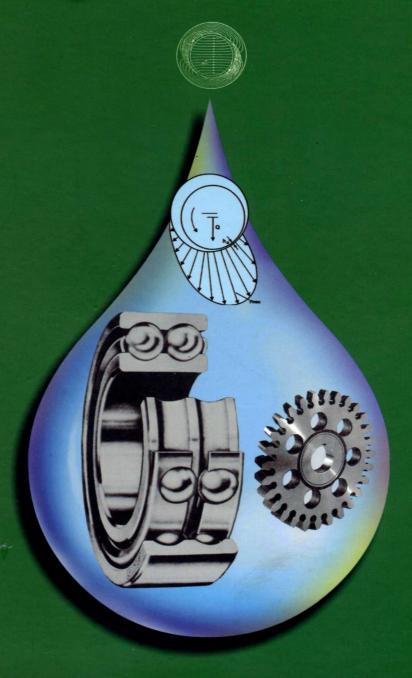
TRIBOLOGY IN 2000 AND BEYOND

Proceedings of the Second International Conference on Industrial Tribology

December 1-4, 1999

Hyderabad, India





Editor: H. Prashad

Tribology in 2000 and Beyond

Tribology in 2000 and Beyond

Editor

H. Prashad

BHEL, Corporate R&D Division

Vikasnagar, Hyderabad - 500 093, India



Printed at KALA JYOTHI PROCESS LTD. Hyderabad, India.

SECOND INTERNATIONAL CONFERENCE ON INDUSTRIAL TRIBOLOGY

DECEMBER 1-4, 1999 HYDERABAD, INDIA



Organized by



BHARAT HEAVY ELECTRICALS LIMITED CORPORATE R&D DIVISION

Under the Aegis of



TRIBOLOGY SOCIETY OF INDIA



Dedicated to



The Almighty, whose blessings, continued inspiration and silent guidance has nurtured us to follow the path of untiring research for the ultimate progress......

November, 1999

Dr. Har Prashad

ICIT-99

Steering Committee of ICIT-99

Shri M.K.Mittal

Director (E,R&D)

B.H.E.L.

(Chairman, Steering Committee)

Dr.A.K.Bhatnagar

Director(R&D)

Indian Oil Corporation Ltd

Shri H.L.Zutshi

Chairman and Managing Director

Hindustan Petroleum Corporation Ltd

Dr.J.Bhatia

Managing Director

Fuchs Lubricants (India) Ltd.

Prof.D.V.Singh

Vice Chairman (President TSI)

All India Council for Technical Education

Prof.(Dr.) T.C.Rao

Director

Regional Research Laboratory(CSIR)

Dr.G.Sundara Rajan

Director

International Advanced

Research Centre (ARCI)

Shri Sudhir Singhal

Director

Indian Institute of Petroleum

Dr.S.K.Bhattacharyya

Director

SAIL

R&D Centre for Iron and

Steel (RDCIS)

Shri R.S.Guha

Director (Petroleum)

IBP Co. Limited

Prof.G.N.Mathur

Director

D.M.S.R.D.E.

Shri K.K.Dhingra

Executive Director

Petroleum Conservation

Research Association

Shri S.Mani

Director/MP

Research Designs and

Standards Organisation (RDSO)

Ch.Surendar

Executive Director

(Operations)

Nuclear Power Corporation

Dr.Shrikant Bhave

Head

Thermal Engg

Larsen & Toubro Ltd

Shri S.A.Bohra

Chief Engineer(MS)

Nuclear Power Corporation

Sri C.V.Chandrasekharan

Managing Director

Balmer Lawrie and Co Ltd

Shri G.S.Ravi

Director

Standard Oil Additives

Shri N.R.Bhoopatkar

Chief Executive

Apar Industries Ltd

Dr.A.Prabhakara Rao

General Manager Incharge

B.H.E.L., Corporate R & D Division

Editorial Board

ICIT '99 - TECHNICAL COMMITTEE

Chairman: Dr. Har Prashad, BHEL, Corporate R & D, Hyderabad

Lubrication Basics:

Prof. D. V. Singh

All India Council for Technical Education Indira Gandhi Sports Complex I.P.Estate, New Delhi-110002

Lubricants

Dr. J. Bhatia

Fuchs Lubricants (India) Ltd. Karmayog Building Parsi Panchayat Road Andheri (E), Mumbai-400069

Lubricants:

Mr. Sudhir Singhal
Indian Institute of Petroleum
P.O.Mohkampur
Dehradun-248005

Surface Engineering:

Dr. A. Sethuramiah ITMMEC, IIT Hauz Khas New Delhi-110016

Tribology of Materials:

Dr. A. K. Jha Regional Research Laboratory Near Habibganj Naka Bhopal-462026

Condition Monitoring:

Dr. B. S. Prabhu

Professor Mechanical Engg IIT, Chennai

Tribotesting and Analytical Techniques.

Mr. A. K. Mehta
IOC, R&D Centre
Sector 13,
Faridabad-121007

Dynamic Fluid Sealing, Seals and

Rotodynamic Coefficients

Prof. M. K. Ghosh

Banaras Hindu University Institute of Technology Department of Mech Engg Varanasi-221005

Tribology in Power Sector and Allied

Industries.

Dr. Har Prashad BHEL, Corp R&D Vikasnagar Hyderabad-500093

Special Topics in Tribology:

Prof.M.C.DwivediIIT,Dept of Chemical Engg
Mumbai-400076

NATIONAL PLANNING AND ORGANIZING COMMITTEE

Dr.P.Jagannathan

Chairman, Organizing Committee BHEL, R&D, Hyderabad

Prof.D.V.Singh

President, TSI

A.I.C.T.E., New Delhi

Mr.Sudhir Singhal

Immediate Past President

TSI, I.I.P., Dehradun

Dr.J.Bhatia

Vice President, TSI

Fuchs Lubricants (India) Ltd.

Mumbai

Mr.A.K.Mehta

Secretary, TSI

I.O.C., R&D, Faridabad

Mr.V. Narayan Sharma

Treasurer, TSI

Balmer Lawrie & Co

Calcutta

Dr.M.R.Tyagi

Jt.Secretary, TSI

I.I.P., Dehradun

Dr.A.K.Bhatnagar

Director

I.O.C., R&D Centre

Faridabad

Prof.B.S.Prabhu

Professor, I.I.T., Chennai

Mr.C.Misra

TISCO, Jamshedpur

Mr.K.Balasubramanian

Fidelity Industries Ltd

Chennai

Dr.Har Prashad

Jt.Secretary, TSI

Convener & Organizing

Secretary, BHEL,

Corp R&D, Hyderabad

ORGANIZING COMMITTEE

BHEL, Corporate R&D Division, Hyderabad

Dr.P.Jagannathan

Chairman

Shri S.K.Goyal

Dr.S.K.Roy

Dr.K.K.Chaturvedi

Shri K. Venugopal

Shri H.Krishnan

Dr.(Mrs.) P.Kamalam

Shri P.K.Kakkar

Shri N.S.Rao

Shri M.Mukundan

Dr.C.K.Rao

Shri A. Vishwanathan

Shri E.D. Vinod Kumar

Sri Vijay Mohan

Shri C.B.M.Prakash

Dr.U.M.Choudhari

Shri B.K.Dhingra

Shri A. Yadagiri

Shri P.Nagaraju

Shri S.Sudhakar

Shri P.B. Janwadkar

Shri P.Rajasekhar

Dr.Har Prashad

Convener

FOREWORD

Over the years, Tribology has played a major role in ensuring safe and efficient operation of variety of industrial machinery. It has gained increasing importance in many respects including energy conservation by optimum design of machinery following correct tribological practices. Industry has realized that Tribology is a techno-economical tool for maintainability and reliability. Tribology Society of India has made a significant contribution in creating awareness of Tribology by way of organizing conferences, seminars and publications of News Letters and TSI Journal.

The Second International Conference on Industrial Tribology with a theme of Tribology in 2000 and Beyond offers a platform to focus the achievements of Tribology by 2000 and the future advancement of this discipline in the 21st Century. The Conference will mainly deal with the use of synthetic, environment friendly, multigrade lubricants, friction modifiers, increased wear resistant surface treatment, use of magnetic bearings and optimum energy saving bearing design to enhance the performance of the equipments. The papers included in this proceeding will certainly be of interest to the delegates drawn from wide cross-section of industries like steel, petroleum, engineering, power generation as well as from academic institutions and research laboratories from India and abroad.

I hope that the Conference will be able to identify the likely knowledge gaps and evolve a plan to fill up the gaps for the benefit of Tribologists of our country and abroad.

I wish the Conference all success.

Dr. A. Prabhakara Rao General Manager Incharge BHEL, Corporate R&D Division Hyderabad

FROM THE ORGANISING SECRETARY

Effective utilization of energy is technically not effective without the technological advancement in Tribology. Researchers and practicing engineers both have to interact very closely to fill up the know-how and know-why gaps prevailing between theory and practice in this area. Also, the Government has to take measures to draw attention of people for adopting the correct tribological practices in this regard.

The theme of the conference - **Tribology in 2000 and Beyond -** was chosen considering present know-how gaps and status of Tribology in this century and the orientation to be adopted in the next century. It would be a matter of great satisfaction if appropriate thoughts and directions for perspective development can emerge out of the deliberations of the conference.

Tribology in 2000 and Beyond is divided into ten broad areas besides keynote / plenary session. Each area has been dealt by individual session organizer of International repute for selection, review of the papers and conduct of the session. Besides this special session on "Energy Efficient Bearings and Tribology in 2000 and Beyond" by presentations of papers selected exclusively in the frontier areas is also organized. One day four parallel Technical courses relevant to industries are also planned before the conference. Furthermore, panel discussion is planned on "Automotive Pollution - Role of Lubricants" apart from the "Tribology in 2000 and Beyond".

ICIT-99, under the aegis of Tribology Society of India is the second conference after 1984, being organized by BHEL, Corporate R&D division at Hyderabad. On behalf of organizers, I thank the Executive Committee of TSI for granting us this privilege and opportunity.

ICIT-99 is the result of inspired team effort. Apart from my colleagues from BHEL, Corporate R&D Division and the Executive Committee of TSI, I am grateful to the Tribologists and practicing professionals of our country and abroad, who have contributed towards this venture. I am thankful to all the delegates, authors and keynote speakers, who have participated/contributed to this conference. I am thankful to the Chairman and Managing Director of BHEL, Director (Engg, R&D), General Manager Incharge R&D, Steering Committee members for their encouragement and valuable guidance, as also the sponsors, co-sponsors and supporters who have extended their whole-hearted assistance in organizing the conference.

Dr.Har Prashad

Sr. Dy. General Manager

B.H.E.L., Corporate R&D Division

Hyderabad, India

CONTENTS

Organizers	V
Dedicated to	VII
Steering Committee	VIII
Editorial Board: ICIT'99 - Technical Committee	IX.
National Planning and Organizing Committee	X
Organizing Committee, BHEL, Corporate R&D Division, Hyderabad	X
Foreword	XI
From the Organizing Secretary	XII
KEYNOTE / PLENARY	
Tribology in the Twenty First Century Bo Jacobson	AMYT
Synthetic Lubricants Scenario in 21st Century S.P.Srivastava	7
3. Aluminium Machining - A New Challenge D.Hoerner	18
4. Energy Efficient Journal Bearings Through Lubrication Jack Schofield	19
 Complexity of Future Development of Lubricants and Lubrication Systems - Machine Tool Lubrication. Theo Mang 	26
6. Tribology Under Electrical Environment Har Prashad	34
7. Gear Lubricants as Design Elements - a Tool for Gear Designers Wilfried J.Bartz and Klaus Michaelis	41
8. Bearings in 2000 and Beyond B.C.Majumdar	52
9. Tribology Practices in Steel Industry C.Misra	59

LU	BRICATION BASICS	
10.	Transient Response of Capillary Compensated Hybrid Journal Bearing System During Starting and Stopping Operation Vijay Kumar, Satish C.Sharma and S.C.Jain	75
11.	Engine Journal Bearing: Design and Case Study Analyses H.Hirani, K.Athre and S.Biswas	83
12.	Some Experiments on Magnetically Suspended Test Rotor V.Kamala, P.Muthu, U.K.Choudhary and A.Rajamani	93
13.	Effect of Load Direction on the Hydrostatic/Hybrid Performance of a Multirecess Orifice Compensated Flexible Journal Bearing Satish C.Sharma, S.C.Jain and B.V.N.Surendra Kumar	101
14.	Transient Orbit Analysis for Acceleration and Deceleration of Rotors using Finite Element Method - R.K.Purohit and O.P.Singhal	109
DY.	NAMIC FLUID SEALINGS, SEALS AND ROTODYNAMIC EFFICIENTS	Since the same of
15.	Effect of Fluid Inertia on Stability of Oil Journal Bearings considering Time History of Film Shape S.K.Kakoty and B.C.Majumdar	117
16.	Unbalance Vibration Control of Flexible Rotors Employing Radial and Angular Damping of Active Magnetic Bearings S.Jana, R.Bhattacharyya and B.Samanta	124
17.	Life Prediction Model of Treated Surfaces under Rolling Contact Accounting for Tractional Effect	131

154

D.Dinakar and M.M.Mayuram

M.K.Ghosh and M.R.Satish

Finite Element Method

Hydrodynamic Journal Bearing T.V.V.L.N.Rao, S.Biswas and K.Athre

D.Rame Gowda, P.Chandrasekhar and B.S.Prabhu

18. Rotodynamic Coefficients and Stability of Multilobe Hybrid bearings

20. A Methodology to Evalute Non-linear Dynamic Coefficients in a

19. Estimation of Leakage and Dynamic Characteristics of Labrinth Seal, using

LUBRICANTS: INDUSTRIAL AND SOLID LUBRICANTS, GREASES, ADDITIVES, SPECIALITY LUBRICANTS INCLUDING LUBRICANTS AT EXTREME TEMPERATURES AND CONDITIONS

21.	Mo-S Complexes as Multifunctional Lubricant Additives V.K. Verma, R. Singh, A. Bhattacharya, A.K. Tripathi, P.K. Singh and Vandana Srivastava	162
22.	Synthetic Aluminium Complex Grease: A Tribological Evaluation Using a Four-ball Test Tarunendr Singh and M.F.Sait	168
23.	Effects of Average Molecular Weight and Concentration of Styrene-isoprene Co-polymer on Tribological Characteristics Mahendra Pal	173
24.	Degradation Kinetics of Hydrogenerated Poly (Styrene-co-Isoprene) N.M.Desai and N.C.Joshi	179
25.	Effect of Emulsifier Chemistry on Wear Behaviour of Invert Emulsion Fire Resistant Hydraulic Fluid A.K.Jain, B.S.Nagarkoti, D.V.Prasad, M.P.Bangwal, A.B.Shah and M.F.Sait	185
	BRICANTS: AUTOMOTIVE, METAL WORKING AND	
PO	WER TRANSMISSION	
26.	Effect of Water Soluble Metal working coolants on Surface State of High Hardness Steel at Finishing Treatment Mishchuk O.A., Protsishin V.T. and Rizhov Yu.E.	190
27.	Metal working Fluid: An Environmental View Mahendra Pal	196
28.	A Laboratory Technique for Evaluation of API GL-5 Level Auto Gear Oils R.P.S. Bisht and V.K.Jain	200
SU	RFACE ENGINEERING : COATING AND RHEALOGY RFACE FILMS, WEAR MECHANISM, MODELLING, EROS D WEAR OF MACHINE COMPONENTS	
29.	HVOF Deposited WC-12% Co Coating on Ti-alloy for Improved Erosion Resistance Manish Roy, B.E.Narkhede and S.N.Paul	205
30.	Abrasive Wear of Al Alloy-Al ₂ O ₃ Particle Composite: A Study on the Combined Effect of Load and Size of Abrasive D.P.Mondal, S.Das, Sunita Gupta, A.K.Jha and B.K.Prasad	216

. Response of Plasma Sprayed Alumina - Titania System to Three - Body Abrasion S.L.Ajit Prasad, M.M.Mayuram and R.Krishnamurthy	224
Effect of Experimental Factors on the Slurry Erosive Wear Behaviour of a Few Hardfacing Alloys with Varying Chromium Content R.Dasgupta, A.K.Jha, B.K.Prasad, O.P.Modi, S.Das and A.H.Yegneswaran	232
. Erosive-Corrosive Wear Characteristics of a Zinc-Based Alloy and Composite under the Conditions of Varying Slurry Composition and Distance B.K.Prasad, O.P.Modi, S.Das, R.Dasgupta and D.P.Mondal	241
. Fractal Characterization of Running-in Behaviour of an IC Engine Piston Rings and Cylinder Liner Surface Combination K.C.Joseph and N.Raman	247
Aluminium Matrix Composites: A Potential Material for Automobile and Engineering Applications S.Das, D.P.Mondal, O.P.Modi, and A.H. Yegneswaran	258
Mechanism of Material Removal during Erosion-Corrosion of an Al-SiC Particle Composite	265
Improvement in Lubrication during Cold Rolling of Electrical Steel Madhu Ranjan, P.Pathak, A.K.Marik, P.P.Sen Gupta, R.C.Thakur and G.M.D.Murty	273
IBOLOGY OF MATERIALS	
Antifrictional Coatings with Organomineral Fillers for Heavy-Duty Friction Joints I.I.Zlotnikov, V.A.Smurugov and S.V.Piskunov	280
Erosive Wear Studies of Unidirectionally Carbon Fibre Reinforced Epoxy Composites U.S.Tewari and A.P.Harsha	283
Comparative Study of Wear on the Rollers during Flow Forming of Different Materials C.S.Krishna Prasada Rao, M.Komaraiah and G.Chandra Mohan Reddy	291
Factorial Designing of High Stress Abrasive Wear Response of Steels R.Dasgupta and A.Roy	299
Wear Characteristics of H.S.S.Cutting Tool during Turning Operation of Cast Aluminium Alloy-Sic/Gr Composites M.S. Bhagyashekar, C.S. Ramesh, A. Ramachandra, and K.Chandrashekara	306
A New Three Stage Mechanism for Low Stress Abrasion in Glass Fibre Polyester Composites Navin Chand and Somit Neogi	312
	S.L.Ajit Prasad, M.M.Mayuram and R.Krishnamurthy Effect of Experimental Factors on the Slurry Erosive Wear Behaviour of a Few Hardfacing Alloys with Varying Chromium Content R.Dasgupta, A.K.Jha, B.K.Prasad, O.P.Modi, S.Das and A.H.Yegneswaran Erosive-Corrosive Wear Characteristics of a Zinc-Based Alloy and Composite under the Conditions of Varying Slurry Composition and Distance B.K.Prasad, O.P.Modi, S.Das, R.Dasgupta and D.P.Mondal Fractal Characterization of Running-in Behaviour of an IC Engine Piston Rings and Cylinder Liner Surface Combination K.C.Joseph and N.Raman Aluminium Matrix Composites: A Potential Material for Automobile and Engineering Applications S.Das, D.P.Mondal, O.P.Modi, and A.H. Yegneswaran Mechanism of Material Removal during Erosion-Corrosion of an Al-SiC Particle Composite S.Das, D.P.Mondal, R.Dasgupta and B.K.Prasad Improvement in Lubrication during Cold Rolling of Electrical Steel Madhu Ranjan, P.Pathak, A.K.Marik, P.P.Sen Gupta, R.C.Thakur and G.M.D.Murty IBOLOGY OF MATERIALS Antifrictional Coatings with Organomineral Fillers for Heavy-Duty Friction Joints I.I.Zlotnikov, V.A.Smurugov and S.V.Piskunov Erosive Wear Studies of Unidirectionally Carbon Fibre Reinforced Epoxy Composites U.S.Tewari and A.P.Harsha Comparative Study of Wear on the Rollers during Flow Forming of Different Materials C.S.Krishna Prasada Rao, M.Komaraiah and G.Chandra Mohan Reddy Factorial Designing of High Stress Abrasive Wear Response of Steels R.Dasgupta and A.Roy Wear Characteristics of H.S.S.Cutting Tool during Turning Operation of Cast Aluminium Alloy-Sic/Gr Composites M.S. Bhagyashekar, C.S. Ramesh, A. Ramachandra, and K.Chandrashekara A New Three Stage Mechanism for Low Stress Abrasion in Glass Fibre Polyester Composites

44.	Investigations into Tribological Aspects during Forming of Sintered Preforms S.Kumar, Rajiv Ranjan and S.C.Prasad	324
45.	A Study on Sliding Wear Behaviour of Phosphor-Bronze Alloy Composite Materials S.C.Sharma and B.M.Satish, B.M.Girish, Rathnakar Kamat and R.Venkatesan	332
46.	Role of Adhesion on Normal Impact of Rough Surfaces P.Sahoo, M.V.R.Kishore, S.K.Roy Chowdhury	338
47.	Effect of Addition of Flyash in PP/PC Blend on Abrasive Wear Navin Chand and Anuradha Pandey	346
TR	BOTESTING AND ANALYTICAL TECHNIQUES	
48.	Tribo Testing and its Role in Establishing the Service Life of Lubricants M.C.Jain, S.P.Srivastava and A.K.Bhatnagar	352
49.	Artificial Digital Images in Tribotesting V.V.Konchits, L.V.Markova and N.K.Myshkin	361
50.	Burnished Films of Molybdenum and Graphite A.K.Kohli	367
51.	Studies on Rolling Contact Fatigue Lives of EN31 Steel Balls V.R.K.Sastry, B.M.Shukla and R.P.S.Bisht	376
52.	Performance Evaluation of Hydraulic Oil Filters using Multipass Test M.I.Sakri	380
TR	BOLOGY IN POWER SECTOR AND ALLIED INDUSTR	RIES
53.	Recent Trend in "Predictive Maintenance" and Significance of Transient Data Analysis and its Applications in Turbine Generator. Chandra Gupta Porwal	386
54.	Application of Machine Dynamics and Vibration Analysis in Problem Diagnostics of High Capacity Turbo Generator M.G.Poduval	393
55.	Role of Lubricants in Diagnostic Studies of Power Plant Equipment- Some Case Studies Zafar Mehdi, D.K.Singh and J.K.Quddusi	400
56.	Measurement of Load on Pads of Large Thrust Bearings with Pad Support Pivots as Load Cells U.M.Chaudhari, M.Mohan Prabhu, B. Rama Rao, A.D.Baone and S.K.Goyal	404
57.	Some Operational and Trouble Shooting Experiences with Thrust and Guide Bearings of Hydrogenerators. Sukul Lomash and A.M.Gupta	410

CONDITION MONITORING: VIBRATION DIAGNOSTICS, FAILURE ANALYSIS AND PREDICTIVE MAINTENANCE

58.	Designing Large Motor Bearings for a Reliable Operating Life of 40 years in CANDU Reactors Ashok N. Kumar	418
59.	Condition Monitoring of Extrusion Operation using Load Cells Interfaced with Computer G.Chandra Mohan Reddy, M.Komaraiah, V.Kamala, A.K.Dhar and N.V. Srinivasulu	426
60.	Cutting Tool Wear Monitoring A.Ramachandra, K.Chandrashekara, P. Prasad and Srinivasa Pai P.	431
61.	Failure Analysis of Bearing, Gear and Hydraulic Systems of Heavy Earth Moving Machines (HEMM) - Case Studies at Opencast Coal Mines of C.C.L. Kamal Mukherjee	438
62.	Engine Oil Ageing in HEMM (Mining Equipment) - A Case Study P.S.Mukherjee, A.N.Sinha and A.De	449
63.	Improvement in Blast Furnace Availability through Condition Monitoring of Bell Less Top System in Bhilai Steel Plant P.K.Bandyopadhyay, A.K.Misra, A.Ghosh Hazra, P.C.Basak, T.D.Chatterjee, S.Jha, A.Mohammad, K.U.Rao and N.Ahmad	454
64.	Vibration Diagnostics of Rotating Machinery Through Expert System M.Sarath Kumar and B.S.Prabhu	461
65.	Expert System and Condition Monitoring of Machinery A.Ramachandra, K.Chandrashekara, Kala Shirish, R. and N.J.Krishna Prasad	471
66.	Condition Monitoring of Rolling Element Bearing, vis-à-vis Its Life Prediction R.Sen, S.Islam and S.C.Nidhi	476
67.	Factors Influencing the Performance of Fluid Film Bearings of Vertical Machines N.Santhanam	483
68.	Ferrographic Wear Particle Analysis Prateek Mehta	491
69.	Fluids for Machine Condition Monitoring A.K.Misra, P.K.Bandyopadhyay, A.Ghosh Hazra, P.C.Basak, T.D.Chatterjee, S.Jha, A.Mohammad	499
	and A.M.Patel	

SPECIAL TUPICS IN TRIBULUGI	
70. Tribology in Wire Drawing S.Srivastava, N.R.Bhoopatkar	505
71. Computer Aided Analysis and Monitoring of Sheet Metal Forming Operations with Force Transients G.Chandra Mohan Reddy, V.Kamala, M.Komaraiah and C.S. Krishna Prasad Rao	513
SYMPOSIUM: ENERGY EFFICIENT BEARINGS AND TRIBOLOGY IN 2000 AND BEYOND	
72. A Low Cost On-Site Oil Analysis Strategy M.K. Williamson	519
73. Role of Water Lubricated Bearings in CANDU Reactors Ashok N Kumar	527
74. Leaded Aluminium Alloys as Plain Bearing Materials of Twenty First Century J.P.Pathak	535
75. Tribology in 2000 and Beyond for Heavy Earth Moving Machines (HEMM) Kamal Mukherjee	539
76. Vibration Data Collectors meet Mobile Computers - Mobile Collectors Prateek Mehta	545
AUTHOR INDEX	551