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## **RO8501 CNC MACHINE AND METROLOGY**

### **DETAILED SYLLABUS**

#### **UNIT I INTRODUCTION TO CNC MACHINE TOOLS**

Evolution of CNC Technology, principles, features, advantages, applications, CNC and DNC concept, classification of CNC Machines – turning centre, machining centre, grinding machine, EDM, types of control systems, CNC controllers, characteristics, interpolators– Computer Aided Inspection, CNC Machine building, structural details, configuration and design, guide ways – Friction, Anti friction and other types of guide ways

#### **UNIT II DRIVES AND WORK HOLDING DEVICES**

Spindle drives – DC shunt motor, 3 phase AC induction motor, feed drives –stepper motor, servo principle, DC and AC servomotors, Axis measuring system – synchro, synchro-resolver, gratings, moiré fringe gratings, encoders, inductosyn, laser interferometer, work holding devices for rotating and fixed work parts, economics of CNC, maintenance of CNC machines

#### **UNIT III CNC PROGRAMMING**

Coordinate system, structure of a part program, G & M Codes, tool length compensation, cutter radius and tool nose radius compensation, do loops, subroutines, canned cycles, mirror image, parametric programming, machining cycles, programming for machining centre and turning centre for well known controllers such as Fanuc, Heidenhain, Sinumerik etc., generation of CNC codes from CAM packages.

#### **UNIT IV LINEAR AND ANGULAR MEASUREMENTS**

Linear Measuring Instruments – Evolution – Types – Classification – Limit gauges – gauge design – terminology – procedure – concepts of interchange ability and selective assembly – Angular measuring instruments – Types – Bevel protractor clinometers angle gauges, spirit levels sine bar – Angle alignment telescope – Autocollimator – Applications.

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## **UNIT V ADVANCES IN METROLOGY**

Basic concept of lasers Advantages of lasers – laser Interferometers – types – DC and AC Lasers interferometer – Applications – Straightness – Alignment. Basic concept of CMM – Types of CMM – Constructional features – Probes – Accessories – Software – Applications – Basic concepts of Machine Vision System – Element – Applications

### **OBJECTIVES:**

Understand evolution and principle of CNC machine tools

Write simple programs for CNC turning and machining centres

Generate CNC programs for popular CNC controllers

Describe about linear and angular measurements in metrology

Study about the advancement in metrology

### **TEXT BOOKS:**

1. “Mechatronics”, HMT, Tata McGraw-Hill Publishing Company Limited, New Delhi, 2005.
2. Warren S.Seamers, “Computer Numeric Control”, Fourth Edition, Thomson Delmar, 2002.
3. Jain R.K. “Engineering Metrology”, Khanna Publishers, 2005.
4. Gupta. I.C., “Engineering Metrology”, Dhanpatrai Publications, 2005.

### **REFERENCES:**

1. Charles Reginald Shotbolt, “Metrology for Engineers”, 5th edition, Cengage Learning EMEA,1990.
2. Backwith, Marangoni, Lienhard, “Mechanical Measurements”, Pearson Education , 2006.
- 3.Peter Smid, “CNC Programming Hand book”, Industrial Press Inc., 2000
4. Berry Leathan – Jones, “Introduction to Computer Numerical Control”, Pitman, London, 1987.
5. Radhakrishnan P “Computer Numerical Control Machines”, New Central Book Agency, 2002.