



Article

## Experimental Study of Electrolytic Processing of Discharge-Assisted Jet Masks

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Abstract: There has been some research on jet electrolytic processing at home and abroad, and the phenomenon of discharge during the process has been reported, but there has been little research on the mode of jet electrolytic with the aid of discharge. A jet mask electrolytic processing experiment was set up to prepare a blue oil mask on the surface of the workpiece using photolithography; two processing modes were achieved using different tool electrodes, the workpiece was processed by two types of motion, the processing micro-pits were observed morphologically using an optical microscope, and the test data were analyzed by plotting graphs. Experiments show that a blue oil mask with a thickness of 50 µm covers the workpiece to strengthen the fixity, and that jet electrolytic discharge machining can effectively improve the depth-to-width ratio by increasing the contribution to depth by 30%-38% and the contribution to width by 2%-18%, compared to jet electrolytic machining. The former has less island effect than the latter, with a flatter bottom and better-machined shape.

Keywords: jet electrolytic machining; in-line dressing of electrical discharges; workpiece morphology analysis

#### 1. Introduction

Jet electrolytic machining (Jet-ECM) is a special form of electrochemical machining (ECM) that uses an electrolytic jet as a tool. It offers advantages over other electrochemical machining processes such as good domain fixation, high machining speeds, and machining position flexibility [1,2]. The use of a displacement stage to drive the nozzle cathode to follow a pre-defined path enables rapid and precise fabrication of complex structures on the workpiece surface [3–5]. Hinduja and Pattavanitch [6] electrochemically machined a simple square pocket and a pocket with a humanoid protrusion, using tools with round and square electrodes. Hackert-Oschätzchen et al. [7] used a continuous electrolytic free jet to obtain a high degree of positioning in the removal area and electrochemically processed cavities with a depth of about 180 μm and a width of about 190 μm. Kawanaka and Kunieda [8] investigated the effect of current conditions and nozzle movement speed on the surface roughness of stainless steel, and achieved a mirror-like surface with Rz surface values of less than 0.2 μm. It was shown that the surface roughness of the cavities decreased as the nozzle translation speed increased, and that for constant speeds the surface roughness of the cavities decreased and increased again after reaching a minimum value [8–10].

Electrochemical discharge machining (ECDM) is considered to be a hybrid machining method. Material removal is based on two phenomena: electrochemical dissolution of the material and corrosion due to hot inter-electrode discharge [11,12]. Kim et al. [13] proposed an ECDM drilling method for glass workpieces, where a working fluid containing potassium hydroxide facilitated the process. Kobayashi [14] described a solution for obtaining shaped cavities by ECDM and electro-corrosion, using an electrolyte based on sodium



Citations: Chen, C.; Wu, S.; Zhang, T.; Wang, Y.; Shao, X.; Mo, E. Experimental Study of Electrolytic Processing of Deschange-Assisted Jet. Masko. Contings 2023, 13, 1280. https://doi.org/10.3000/ continued.3071280

Academic Editor: Tadeusci Hirosimolox

Reviewd: 7 June 2023 Revised: 17 July 2023 Accepted: 20 July 2023 Published: 21 July 2023



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# **Study Of Relaxation In Electrolytic Solu**

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Properties of Gases, Liquids, and Solutions Warren P. Mason,2013-10-22 Physical Acoustics Principles and Methods Volume II Part A Properties of Gases Liquids and Solutions ponders on high frequency sound waves in gases liquids and solids that have been proven as effective tools in examining the molecular domain wall and other types of motions The selection first offers information on the transmission of sound waves in gases at very low pressures and the phenomenological theory of the relaxation phenomena in gases Topics include free molecule propagation phenomenological thermodynamics of irreversible processes and simultaneous multiple relaxation processes The book then takes a look at relaxation processes in gases as well as excitation relaxation molecular theory of relaxation times and relaxation of a dissociation equilibrium The manuscript surveys thermal structural and shear relaxation in liquids Discussions focus on the basic theory for a single chemical reaction structural viscosity and cooperative effects on mechanical and dielectric processes The book also underscores the propagation of ultrasonic waves in electrolytic solutions including ultrasonic velocity and relaxation processes in electrolytic solutions The selection is highly recommended for readers interested in physical acoustics

Physical Chemistry of Electrolyte Solutions Josef Barthel, H. Krienke, Werner Kunz, W. Kunz, 1998-04 The aim and purpose of this book is a survey of our actual basic knowledge of electrolyte solutions It is meant for chemical engineers looking for an introduction to this field of increasing interest for various technologies and for scientists wishing to have access to the broad field of modern electrolyte chemistry Transport, Relaxation, and Kinetic Processes in Electrolyte Solutions Pierre Turg, Josef M.G. Barthel, Marius Chemla, 2012-12-06 The presence of freely moving charges gives peculiar properties to electrolyte solutions such as electric conductance charge transfer and junction potentials in electrochemical systems These charges play a dominant role in transport processes by contrast with classical equilibrium thermodynamics which considers the electrically neutral electrolyte compounds The present status of transport theory does not permit a first prin ciples analys1s of all transport phenomena with a detailed model of the relevant interactions Host of the models are still unsufficient for real systems of reasonable complexity The Liouville equation may be adapted with some Brownian approximations to problems of interact ing solute particles in a continuum solvent however keeping the Liouville level beyond the limiting laws is an unsolvable task Some progress was made at the Pokker Planck level however despite a promising start this theory in its actual form is still unsatis factory for complex systems involving many ions and chemical reac tions A better approach is provided by the so called Smoluchowski level in which average velocities are used but there the hydrodyna mic interactions produce some difficulties. The chemist or chemical engineer or anyone working with complex electrolyte solutions in applied research wants a general representation of the transport phenomena which does not reduce the natural complexity of the multicomponent systems Reduction of the natural complexity generally is connected with substantial changes of the systems Aqueous Solutions of Simple Electrolytes Felix Franks, 2012-12-06 The chapters making up this

volume had originally been planned to form part of a single volume covering solid hydrates and aqueous solutions of simple molecules and ions However during the preparation of the manu scripts it became apparent that such a volume would turn out to be very unwieldy and I reluctantly decided to recommend the publication of sepa rate volumes The most sensible way of dividing the subject matter seemed to lie in the separation of simple ionic solutions. The emphasis in the present volume is placed on ion solvent effects since a number of excellent texts cover the more general aspects of electrolyte solutions based on the classical theories of Debye Huckel On sager and Fuoss It is interesting to speculate as to when a theory becomes classical Perhaps this occurs when it has become well known well liked and much adapted The above mentioned theories of ionic equilibria and transport certainly fulfill these criteria There comes a time when the refinements and modifications can no longer be related to physical significance and can no longer hide the fact that certain fundamental assumptions made in the development of the theory are untenable especially in the light of information obtained from the application of sophisticated molecular and thermodynamic techniques A Review of the Literature Published Between June 2000 and May 2001 A. E. Aliev, 2002 For those wanting to become rapidly acquainted with specific areas of NMR this title provides unrivalled scope of coverage Magnetic Resonance and Related Phenomena E. Kundla, E. Lippmaa, T. Nuclear Magnetic Resonance G A Webb, 2007-10-31 As a spectroscopic method Nuclear Saluvere, 2014-01-13 Magnetic Resonance NMR has seen spectacular growth over the past two decades both as a technique and in its applications Today the applications of NMR span a wide range of scientific disciplines from physics to biology to medicine Each volume of Nuclear Magnetic Resonance comprises a combination of annual and biennial reports which together provide comprehensive of the literature on this topic This Specialist Periodical Report reflects the growing volume of published work involving NMR techniques and applications in particular NMR of natural macromolecules which is covered in two reports NMR of Proteins and Acids and NMR of Carbohydrates Lipids and Membranes For those wanting to become rapidly acquainted with specific areas of NMR this title provides unrivalled scope of coverage Seasoned practitioners of NMR will find this an in valuable source of current methods and applications Specialist Periodical Reports provide systematic and detailed review coverage in major areas of chemical research Compiled by teams of leading authorities in the relevant subject areas the series creates a unique service for the active research chemist with regular in depth accounts of progress in particular fields of chemistry Subject coverage within different volumes of a given title is similar and publication is on an annual or biennial basis

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the Chemical Society have been publishing reports charting developments in chemistry which originally took the form of Annual Reports However by 1967 the whole spectrum of chemistry could no longer be contained within one volume and the series Specialist Periodical Reports was born The Annual Reports themselves still existed but were divided into two and subsequently three volumes covering Inorganic Organic and Physical Chemistry For more general coverage of the highlights in chemistry they remain a must Since that time the SPR series has altered according to the fluctuating degree of activity in various fields of chemistry Some titles have remained unchanged while others have altered their emphasis along with their titles some have been combined under a new name whereas others have had to be discontinued Advances in Physical Chemistry, Water Resources Research Catalog ,1966

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