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Design and Development in Scientific Aspects of Ensuring Quality of Parts Fashioned by Impact Cutting Maneuver in Pneumatic sys-tems

[1] Dr. P. Madhan Kumar, [2] M.Sathish Kumar, [3] P.Krishnan, [4] G.Arun Kumar, [5] P.Raj Kumar

[1]Assistant professor, [2]Final Year, [3] Final Year, [4] Final Year, [5] Final Year,

[1]Department of Mechanical Engineering,

[1]Mangayarkarasi College of Engineering, Madurai, India

Abstract: Metal in the structure of sheets is paramount in the manufacturing industry. Its functions are countless. But metallic in the structure of sheets can't be immediately used, operations like cutting, punching, blanking, bending, trimming, etc. are wished to be carried out on the metallic sheets in order to thoroughly make use of them. For these operations, most large-scale manufacturing industries use hydraulically operated machines. But on account that hydraulic machines are no longer cost- effective, most small and medium scale industries use hand-operated machines for carrying out sheet steel operation. The trouble with hand-operated machines is that are gradual and can't be automated. This is the place the idea of pneumatics will show itself advantageous. It is a guide technique so that sheet metals are to be wasted someday due to the fact of errors befell such as incorrect dimensions etc., and additionally even a easy reducing might also take lengthy time. Hydrau- lic machines are additionally accessible for sheet metallic cutting. But this technique is used for solely heavy metallic slicing and its value is very high. We are the use of a pneumatic device for sheet metallic slicing in an convenient way. It is operated by means of a pneumatic hand lever of two-way manage valve. Control valve is operated through a compressor. Hydraulic machines are additionally used for sheet metallic cutting. But these machines are used for heavy metallic slicing and its price is very high. Hence, we are the use of a pneumatic device for sheet metallic reducing in a handy manner. The principal gain of pneumatic sheet metallic slicing desktop is to enhance product quality, repetition of work and growing manufacturing rate.

Index Terms **- Hydraulic, Pneumatic, FRL unit, Double Acting Cylinder. DCV, Pressure Relief Valve etc.**

I. INTRODUCTION

The sheet slicing computer is the coronary heart of sheet steel industries. In some industries, hand sheet cutter is used which is operated manually. In these machines, we are the use of pneumatic cylinder for sheet steel cutting. These machines must be effortless to function and hold also. Hence, we are introducing a pneumatic sheet metallic reducing computer which will limit manufacturing value and limit industrial works troubles which is the largest headache for human. The primary goal of our mission is to function job keeping operation efficiently with much fewer human efforts with the aid of the usage of a computer with the pneumatic power. This will additionally decrease the time required for steel cutting. By the usage of these machines, we can enlarge the manufacturing price and mechanically the enterprise will be in profit. Automation performs an necessary position in mass production. Automation can be done thru pneumatic form. The principal gain of pneumatic machine is economically affordable and convenient to handle. Generally suitable for purposes involving much less pressure than hydraulic applications, and generally much less high priced than electric powered applications, most pneumatic units are designed to use smooth dry air as an strength source. The actuator then converts that compressed air into mechanical motion. The kind of movement produced relies upon on the plan of the actuator.

Pneumatics is employed in a range of settings. In dentistry applications, pneumatic drills are lighter, quicker and less difficult than an electric powered drill of the identical strength rating, due to the fact the high mover, the compressor, is separate from the drill and pumped air is successful of rotating the drill bit at extraordinarily excessive rpm.

Pneumatic switch structures are employed in many industries to go powders and pellets. Sheet metallic is truly steel fashioned into skinny and flat pieces. It is one of the essential varieties used in steel working and can be reduced and bent into a range of exclusive shapes. Countless daily objects are developed of the material. Thicknesses can range significantly, even though extraordinarily skinny thicknesses are regarded foil or leaf, and portions thicker than 6 mm (0.25 in) are viewed plate. Sheet metallic is handy in flat portions or as a coiled strip.

The coils are fashioned by using jogging a non-stop sheet of steel via a roll slitter. The thickness of the sheet metallic is referred to as its gauge. Commonly used metal sheet metallic tiers from 30 gauge to about eight gauge. The large the gauge number, the thinner the metal. Gauge is measured in ferrous (iron based) metals whilst nonferrous metals such as aluminum or copper are specified differently; i.e., Copper is measured in thickness with the aid of Ounce. There are many extraordinary metals that can be made into sheet metal, such as aluminum, brass, copper, steel, tin, nickel and titanium. For ornamental uses, vital sheet metals encompass silver, gold and platinum (platinum sheet metallic is additionally utilized as a catalyst.) Sheet steel additionally has purposes in auto bodies, plane wings, clinical tables, roofs for constructions (Architectural) and many different things. Sheet metallic of iron and different substances with excessive magnetic permeability, additionally recognized as laminated metal cores, has purposes in transformers and electric powered machines. Historically, an essential use of sheet metallic used to be in plate Armor worn through cavalry, and sheet steel continues to have many ornamentals uses, inclusive of in horse tack. Sheet metallic employees are additionally recognized as "Tin Bashers",("Tin Knockers") which is derived from the hammering of panel seams when putting in tin roofs.

II. LITERATURE REVIEW

In shearing or slicing operation as or blade descends upon the metal, the stress exerted by means of the blade first brought on the plastic deformation of the metal, because the clearance between to blade is very small. The plastic deformation takes area in localize place and the metallic adjoining to the reducing edges of the blade edges end up incredibly stress, with publications the facture to begin on each facet of the sheet as the deformation progresses and sheet is shear. Pneumatic gadget is the development of the header which is carried out in the upward and downward route the use of the pneumatic double appearing piston and cylinder unit association alongside with the foot operated path manipulate valve. In this kind of desktop excessive strain air is used as the working fluid for the switch of electricity and the motion. Hydraulic device the reducing and elevating of the header which is carried over the use of the hydraulic piston and cylinder arranged. To actuate the piston and cylinder, the oil is allowed to enter the cylinder for the front or again aspect of the piston. But the oil is comparatively value layer and it is leakage can also reason so many problems.

The working of spring-operated computer is comparable to the rack and pinion operated desktop however differs from it in construction. Here the reducing and the elevating of the heating take care of are carried out manually and it requires too plenty stress for its operation and additionally there is opportunity of having injury to the work piece if now not treated cautiously Madhukumar V. et. al. [1] developed a pneumatic desktop that would operate slicing as properly as bending operation to minimize the price of operations carried out on sheet metal. Further adjustments in their graph can additionally enlarge the reducing force.T. Z. Quazi et. al. [2] studied the impact of punch-die clearance in blanking process. Investigation showed that by means of lowering clearance the required blanking pressure increased. They determined that 10% is the ideal clearance is required for minimizing blanking force. Viraj N. Suryawanshi et. al. [3] fabricated a pneumatic punching computing device to decrease punching price on steel sheet. K. K. Alaneme et. al. [4] investigated the motives in the back of the failure of mold dies in a punching machine. They located out that die failure passed off because of unsuitable warmness remedy consequently decreasing the sturdiness and fatigue resistance of die material. Neeraj Pandita et. al. [5] developed a pneumatic sheet steel slicing desktop which is higher in contrast to guide pushed sheet cutters. The effectivity of the cutter can be extended through similarly enhancement in reducing blade. Sudeep Kelaginamane et. al. [6] designed a PLC managed pneumatic punching machine. The computing device decreased the manufacturing time and elevated productiveness from 60 devices per hour to 420 devices per hour. A. K. Gupta et. al. [7] studied the affect of pa- rameters like blanking force, clearance, blanking diagram on sheet deformation. They located that the tolerance in the dimension of the punch gap can be minimized via growing the compressor pressure. They discovered that variant in the dimension was once extra in case of a galvanized iron sheet as in contrast to the aluminium sheet.

T. Jon Babu et. al. [8] located out that via altering the stress of compressed air variable slicing forces may want to be bought and by using including extra add-ons this gear can reduce a greater vary of sheet thickness Arun S. et. al. [9] devel- oped a technique for controlling the operations of punching laptop the use of Programmable Logic Controllers. Reduced manufac- turing lead time and make bigger employee security the use of this system. A. S. Aditya Polapragada et. al. [10] developed a pneumatic and punching machine. The mission helped decrease manufacturing value for small scale industries. R. M. Lathe et. al. [11] transformed a manually managed press into an automated computer the use of which they saved most running time. Using this most output expand and human intervention decreased. Pradeshi Ram et. al. [12] Transformed a manually operat- ed traditional sheet bending desktop to an computerized laptop and eradicated the trouble of sign overlapping by way of the usage of stepper module. Indrajeet Chaudhary et. al. [13] employed a stepper module, a aspect of superior pneumatics for automation of traditional sheet steel bending computer operations consequently changing a manually operated bending computing device to an automated machine. Khagendra Barman et. al. [14] Developed a pneumatic sheet metallic slicing desktop which runs through capability of pre-compressed air. It is an environment friendly way of increasing manufacturing for small scale industries.

Suleyman Yaldiz et. al. [15] developed a pneumatic accelerator for high-speed punching which can be effortlessly employed in traditional presses hence putting off the use of excessive electricity price forming (HERF) machines to save energy. The accelerator when employed on mechanical presses converts low pace operation of hammer to high-speed operation. F. W. Travis et. al. [16] experimented on the high-speed perforation of moderate metal plates for have an impact on velocities up to 300 m/s analysed the bulge top at perforation. They c o n c l u d e d with the end result that bulge peak improved with the enlarge of plate thickness but due to the improvement of thermo-plastic instability it dropped sub- sequently.

Karan Dutt et. al. [17] studied a variety of kinds of pneumatic machines and factors alongside with their benefits and disadvantages. He concluded that pneumatic machines can supply energy at a cheaper, safer and greater dependable way than electric powered motors and actuators. A. K. Murthy et. al. [18] designed and fabricated robotically operated paper shearing laptop with the capability to reduce 25mm thick and 300mm broad paper. The computing device may want to produce a variable pressure the use of screw press which made it beneficial to function different operations like bending, punching and embossing. Martin Feistle et. al. [19] developed techniques to measure the formation of aspect cracks on shearing blades. It has been determined that the forming electricity of excessive electricity steels is curtailed due to facet fractures and can be increased with the aid of various method parameters like die clearance, geometry and reducing line. Utkarsh Sharma et. al. [20] designed and fabricated an automated pneumatic gap punching desktop powered with the aid of photo voltaic energy. The laptop has been designed on Solid Works software. Since the desktop makes use of photo voltaic electricity as a supply of electricity it will eliminate/reduce the utilization of electrical energy in jogging the machines in small scale industries.

III. DESIGN AND CONSTRUCTION

Double-acting cylinder (DAC) makes use of the pressure of air to go in each extraction and retraction strokes. It has two ports to enable air in, one for outstroke and one for in stroke. Stroke size for this layout is no longer limited; however, the piston rod is extra prone to buckling and bending. Additional calculations need to be carried out as well. Pneumatic cylinder consist piston, piston rod and a physique or tube as shown Fig.1.

Fig.1 Double-acting cylinder

Compressed air enters at one stop of the tube imparting Force on the piston which is then displaced in order to stability the pressure exerted on the piston. cylinders are on hand in a range of sizes and. shapes and has various stroke. A standard cylinder sizes vary from a small 2.5 mm air cylinder which may be used for selecting up a small transistor or different component. Air leaving a compressor is hot, dirty, and wet—which can harm and shorten the existence of down- stream equipment, such as valves and cylinders. Before air can be used it desires to be filtered, regulated and lubricated.

Selecting the appropriate dimension of filter for any utility must be achieved with the aid of identifying the most allowable stress drop, which can be induced by way of the filter. An airline filter cleans compressed air. It traces the air and traps strong particles (dust, dirt, rust) and separates drinks (water, oil) entrained in the compressed air. Filters are established in the air line upstream of regulators, lubricators, directional manipulate valves, and air pushed units such as cylinders and air motors Airline filters take away contaminants from pneumatic systems, stopping harm to gear and lowering manufacturing losses due to contaminant associated downtime. Downtime in an industrial plant is expensive; frequently it is the end result of a contaminated and poorly maintained compressed air system. The strain drop can be decided by using referring to go with the flow curves furnished via the manufacturer. Directional manipulate valves are one of the most crucial components in hydraulic equipment as properly as pneumatic equipment as proven fig two permit fluid go with the flow into distinct paths from one or extra sources. Usually consist of a spool interior a cylinder which is robotically or electrically controlled. The motion of the spool restricts or lets in the flow; thus, it controls the fluid flow. A 5/2 directional manipulate valve would have 5 ports and two spool positions.

Fig .2 Directional Control Valve

The Sheet cutter are hand-operated shearing tools. It consists of a pair of metallic blades pivoted so that the sharpened edges slide towards every different when the handles (bows) contrary to the pivot are closed. High-carbon, excessive chromium metal is used in manufacturing of sheet cutter It types the sturdy helps to stand the laptop vertically. It holds the weight of the vertical put up and helps the path manage valve. It is made of slight steel. It is made of rectangular base with the vertical put up and the horizontal channel.

An air compressor is a gadget that converts energy (Using an electric powered motor, diesel or gas engine, etc.) in- to practicable electricity saved in pressurized air (i.e., compressed air). By one of various methods, an air compressor forces extra and extra air into a storage tank, growing the pressure. When tank stress reaches its top restriction the air compressor shuts off. The compressed air, then, is held in the tank till referred to as into use. The power contained in the compressed air can be used for a range of applications, utilizing the kinetic power of the air as it is launched and the tank depressurizes. When tank strain reaches its decrease limit, the air compressor turns on once depressurizes from the tank.

IV. DESIGN FORCE CALCULATION

Force required to cut the Sheet = L*t*T max for sheet of 0.5 mm thickness, force required = 25*0.5*30= 375 N This is the force required to cut the sheet metal, however the initial force required to cut the sheet is more and it is 140-150% than we calculated. Therefore, max force required to cut the sheet = 525 to 562.5 N. Now we have chosen 12-volt DC Air Compressor that develops a pressure of 10.34 bar (150psi). Design of Cylinder Since the max force required to cut the sheet = 562.5 N And pressure applied by 12-volt compressor =10.34 bar Therefore, Force applied by the cylinder, F = (Pi/4) *d2*P 562.5=(Pi/4) *d2*(10.34/10) d=26.3 mm for safety, we have taken the cylinder of diameter 30 mm.

3.1 Design Specification

The various components and its specifications as mention table.1 all below fabricated compound commonly made by mild steels such as Base plate, shearing Blade, connecting Link etc.…

Table.1 Fabricated Components Specifications

NAME OF THE PARTS	QUANTITY	HEIGHT	LENGTH	WIDTH	WEIGHT
Base Frame	1	300mm	90mm	300mm	5kg
Shearing Blade	2	60mm	300mm	15mm	3.5kg
Base Plate	1	65mm	65mm	6mm	2kg
Fork End	1	5mm	75mm	20mm	5 kg
Angle Section	1	45mm	300m	45mm	0.5kg
Connecting Link	1	5mm	25mm	5mm	0.3mm
Support Links-	2	90mm	30mm	25mm	5kg
Blade Link	1	90mm	20mm	5mm	2kg

3.2 Working Principle

The pneumatic laptop consists of a desk with aid palms to preserve the sheet, stops or publications to invulnerable the sheet, higher and decrease straight - side blades, a gauging system to exactly role the sheet. The desk additionally consists of the two-way directional valve. The two-way directional valve is linked to the compressor. The compressor has a piston for a movable member. The piston is linked to a crankshaft, which is in flip related to a top mover (electric motor, inner combustion engine).

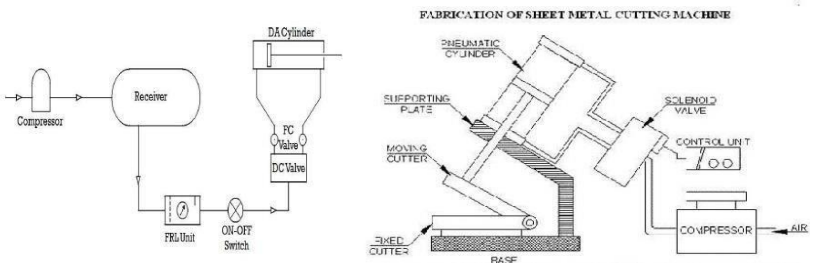

Fig.3 General Layout

At inlet and outlet ports, valves permit air to enter and exit the chamber. When the compressor is switched ON, the compressed air is waft to inlet of the pneumatic cylinder. The sheet is positioned between the higher and the decrease blade. The decrease blade stays stationary whilst the higher blade is pressured downward. The top blade is barely offset from the decrease blade, about 5–10% of the sheet thickness. Also, the higher blade is normally angled so that the reduce progresses from one stop to the other, as a result decreasing the required force. After the cloth is cut, alter the pneumatic hand lever to the mid role (i.e., ordinary position) and then the compressor is switched OFF.

The following fig.3 indicates popular diagram for the machine. Through FRL unit air can be controlled. From the manifold a separate furnish for the desktop is taken out and given to at first the air-compressor is started out and allowed the receiver tank air stress to attain up to eight bars. The provide air is then handed to the manifold ONOFF switch; so as to function the laptop at will except interrupting the walking of compressor. Then the pipe includes compressed air first to machine's Direction Control Valve. At function 'A' suggests the non-actuated circuit diagrams. At this role the piston is constant and locked. All ports are in closed condition. At function 'B', the DC valve is at left hand role as proven in figure. The cap give up port & strain port get related to every different and the rod give up port receives related to the exhaust port. The compressed air comes in the cap cease of the cylinder and pushes the pistons outwards. The air already existing in the rod stop aspect is pushed out of the cylinder. When the piston moves outwards, the pressure is transmitted thru the connecting hyperlink and the higher blade strikes downwards. Before the actuating DC valve, the sheet is inserted in between the top & decrease blades. As higher blade strikes downwards, the stress is generated in the sheet steel and goes past last shear stress of sheet metal. And thus, the shearing motion takes place. Now the DC valve is operated to come at role 'C', as shown in fig.4.

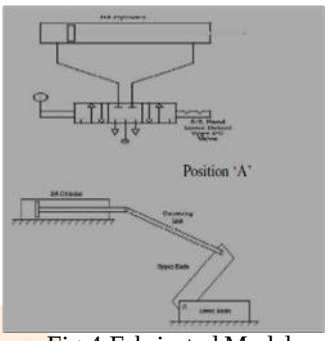

Fig.4 Fabricated Model

The rod gives up port & stress port get related to every different and the cap stop port receives linked to the exhaust port. The compressed air comes in the rod cease of the cylinder and pushes the pistons inwards. The air already existing in the cap give up facet is pushed out of the cylinder. sheet steel is both once more inserted for similarly slicing in case of giant pieces; the small reduce portions are eliminated and the subsequent sheet is inserted to cut.

3.3 Shearing

As referred to above, quite a few slicing strategies exist that make use of shearing pressure to reduce sheet metal. However, the time period "shearing" with the aid of itself refers to a particular reducing method that produces straight line cuts to separate a piece of sheet metal. Most commonly, shearing is used to reduce a sheet parallel to an current part which is held square, however angled cuts can be made as well. For this reason, shearing is specially used to reduce sheet inventory into smaller sizes in instruction for different processes. Shearing has the following capabilities. Sheet thickness: 0.005 – 0.25 inches Tolerance: 0.1 inches The shearing is carried out on a shear machine, frequently referred to as a squaring shear or strength shear, that can be operated manually or by using hydraulic, pneumatic, or electric powered power. A regular shear laptop consists of a desk with assist palms to preserve the sheet, stops or publications to impervious the sheet, higher and decrease straight - aspect blades, a gauging gadget to exactly role the sheet. The sheet is positioned between the top and the decrease blade, which are then compelled collectively in opposition to the sheet, slicing the material. In most devices, the decrease blades stay stationary whilst the top blade is compelled downward. The higher blade is barely offset from the decrease blade, about 5 – 10% of the sheet thickness. Also, the top blade is normally angled so that the reduce progresses from one cease to the other, as a result lowering the required force. The knife part and are handy in special materials, such as low alloy metal and excessive carbon steel.

3.4 Pneumatic Transmission of Energy:

The motive for the use of pneumatics, or any different kind of power transmission on a machine, is to function work. The accomplishment of work requires the software of kinetic electricity to a resisting object ensuing in the object transferring via a distance. In a pneumatic system, strength is saved in a workable kingdom underneath the shape of compressed air. Working power (kinetic electricity and pressure) outcomes in a pneumatic device when the compressed air is allowed to expand. For example, a tank is charged to one hundred PSIA with compressed air. When the valve at the tank retailers opened, the air interior the tank expands till the strain inner the tank equals to atmospheric pressure. Air growth takes the shape of airflow. To operate any relevant quantity of work then, a gadget is wanted which can grant an air tank with a ample quantity of air at a favored pressure. This system is fantastic displacement compressor.

V. CONCLUSION

The pneumatic Shearing machine is very low-cost as in contrast to hydraulic shearing machine. The range of the reducing thickness can be extended by way of arranging a high-pressure compressor and putting in greater hardened blades. This laptop is fantastic to small sheet steel slicing industries as can't find the money for the high-priced hydraulic shearing machine.

VI.FUTURE SCOPE

Since historical age man usually time to obtain greater and extra luxurious. Man is continually trending to enhance extra and extra modified approach with the growing the ascetic seem to be and monetary consideration, subsequently there is usually lot of scope however being the diploma engineers and having the capability to assume and design however due to some time constraints, and additionally due to lack of font, right here only have idea and put in the file the following future modification.

- It can be made hydraulically power operated by installing the gear oil pump at the place of air compressor and pneumatic air arrangement
- It can be made as rack and pinion operated or spring an leaver operated, by replacing pneumatic circuit by rack and pinion arrangement by the square threaded screw and nut arrangement
- The place where there is scarcity of the electricity the electric motor operate compressor is replace by an IC engine install compressor
- In this machine, compress air is use to move the cutting tool for carrying our cutting operation. After the completion of the cycle the air moves out through the outward of control valve, this air is release to the atmosphere. In future the mechanism can be develop to use this air again for the working of cylinder

Thus, in future there are many modifications, which we can make to survive the huge global work of computation.

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