



# SERTIFIKAT



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**Rudi Kurniawan Arief**

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## Daftar Isi

Perancangan dan Mekanika Terapan		
PMT-01	Influence of Bevel Knives Type against Levels of Sharpness and Bluntness on the Cutting Process of Knives <i>Norman Iskandar, Ijran Mayura, Agung Putranto, Mochamad Dzulfan dan Munadi</i>	1
PMT-02	Influence of Current and Electrode Type on Shielded Metal Arc Welding <i>Priyo Tri Iswanto dan Mudjijana</i>	7
PMT-03	Parametric Study on Combination Tool of Forming Limit Diagram: Case Study on Non-Cylinder Air Vent <i>Riona Ihsan Media, Riky Adhianto dan Endjang Patriatna</i>	14
PMT-04	Failure Analysis of Hydraulics Cylinder on 800 Ton Plastic Injection Moulding Machine <i>Edi Sutoyo, Setya Permana Sutisna dan Budi Hartono</i>	21
PMT-05	Optimization of Foam Filled Double Cylinder Tube under Bending Load <i>Ilyas Renreng, Fauzan Djameluddin dan Thomas Tjandinegara</i>	26
PMT-06	Gear fault detection using Wavelet Transformation Method/Morlet Wavelet <i>R. Lullus Lambang G Hidayat dan Budi Santoso</i>	32
PMT-07	Insertion Loss Inspection of Airflow Noise by Tuned-Side Branch Resonator Application at Limited Room <i>I Made Miasa, Sucipto dan Ardi Wiranata</i>	39
PMT-08	Active Suspension Simulation on Three-Wheel Reverse Trike Vehicle Using Proporsional-Integral-Derivative Controller <i>Wibowo, R. Lullus Lambang G Hidayat, Gilang Pratama Putra dan Eko Surojo</i>	44
PMT-09	Diagnosis Prognosis of Machine Based on Vibration Signal Regim <i>Achmad Widodo, Toni Prahasto, Smoyo Haryanto dan Djoeli Satrijo</i>	50
PMT-10	Optimization of Power Energy Harvesters Based on Genetic Algorithm Using Transverse Galloping <i>Smoyo Haryanto, Achmad Widodo, Djoeli Satrijo dan Toni Prahasto</i>	55
PMT-11	Development of Plate Cutting CNC with Laser Cutter and Stepper Motor Driver <i>Budhi Martana, Yuhani Djaya dan M. Arifudin Lukmana</i>	62
PMT-12	Design and Fabrication of Three Wheeled Electric Drive <i>Indrawanto, Dewanta Priatama dan Ernest Rudolf Hutapea</i>	67
PMT-13	Aluminum Alloy Construction on Rubber Fender to Increase Energy Absorption Capability <i>Witono Hardi dan Tri Suyono</i>	72

PMT-14	Numerical Analysis on the Effect of Regional Long Slip Against the Lubrication Performance on the Hydrophobic Journal Bearing <i>Mohammad Tauviqirrahman, Bayu Kurniawan dan Jamari</i>	77
PMT-15	Vibration Spectrum Analysis to Identify the Signal Disturbance of the Differensial Gear Transmission System <i>Noor Eddy dan Arrijal Surya Kamal</i>	82
PMT-16	Design Arrangement of Ply Angle Combination in Carbon Fiber of Composite Material for Bicycle Fork <i>Alief Wikarta dan Filipi Cahya Adi Nugraha</i>	86
PMT-17	Shell Thickness Reduction Effect on Working Stress of Cement Kiln with Mechanic and Thermal Load <i>Meifal Rusli, Angga Hertoh Hendra, Dorce Yunirsyam dan Mulyadi Bur</i>	91
PMT-18	The Overview of Impact Energy Absorber Module on Plastic Deformation Mechanisms <i>Yuwono Budi Pratiknyo dan Rachman Setiawan</i>	95
PMT-19	Synthesis and Analysis of Planar 3-RRR Parallel Mechanism <i>Syamsul Huda, Melzi Armal dan Mulyadi Bur</i>	101
PMT-20	The Effect of Filler Size Variation on The Mechanical Strength and Failure of Epoxy Adhesive Layer <i>Khairul Anam dan Anindito Purnowidodo</i>	108
PMT-21	Analisa Kekakuan Peredam Histerisis Baja Berbentuk U Akibat Pembebanan Berulang <i>Eka Satria, Lovely Son dan Hanif Muzhaffar Rafi</i>	113
PMT-22	Pengaruh Profil dan Dimensi Penampang Kolom terhadap Harga Frekuensi Pribadi dan Bentuk Modus Getar Struktur Bangunan Dua Lantai <i>Lovely Son, Mulyadi Bur dan Meifal Rusli</i>	118
PMT-23	Development of Patient Bed Made of Aluminum using Finite Element Method <i>Fitroh Anugrah Yudha dan Suyitno</i>	122
PMT-24	Analisa Tegangan pada Chassis Mobil Pedesaan Menggunakan Metode Elemen Hingga <i>Ojo Kurdi, Rifky Ismail, Amal Budi S dan Yudis</i>	125
PMT-25	Numerical and Experimental Analysis of Cantilever Beam with Various Shaft Orientation <i>Jhon Malta, Ahmad Bukhari dan Mulyadi Bur</i>	129
PMT-26	Design of 2 Axis Flexible Fixture Control System Based on Microcontroller <i>Havif Alvyhan Ikhwanudin, Sampurno dan Suhardjono</i>	133
PMT-27	Analisa Pengaruh Mesin Potong Rumput pada Badan Manusia Ditinjau dari Aspek Ergonomi Desain <i>Iskandar Hasanuddin, Syahriza dan Sanneri Yulistia</i>	138
PMT-28	Comparative Study on Performance of Mecanum Wheels under Various Rollers and Loads <i>Chaerul Qalbi. AM, Alfian Djafar dan Sulistijono</i>	142

PMT-29	Kinematic and Dynamic Analysis of Lower Limb Exoskeleton Robot <i>Munadi, M. I. Zulkarnain, M. Ariyanto, Norman Iskandar dan J.D. Setiawan</i>	147
PMT-30	LS-DYNA Application for Calculation of Energy Absorption Capacity on Bus Rollover Accident <i>Abdul Hakim Masyhur, Ahmad Fauzan Suryono, Sandro Mihradi, Indra Nurhadi dan Satrio Wicaksono</i>	154
PMT-31	Finite Element Method Application for Stress Distribution Analysis on Hip Stem Prosthesis Model for Walking and Climbing Stair <i>Syifaul Huzni, M. Ari Azhari, M. Rizki dan Syarizal Fonna</i>	160
PMT-32	Analisa Sumber Kesalahan Sumbu Spindel pada Mesin Bubut CNC dengan Metoda Uji Pemotongan <i>Albertus Rianto, Veky M. Fikry dan Nasril Bakri</i>	164
PMT-33	Perbandingan Karakteristik Hasil Uji Split-Hopkinson Pressure Bar antara Geometri Silinder dan Kubus <i>Muhammad Agus Kariem, Dini Adilah Prabowo dan Iffah Faizah</i>	168
PMT-34	Design of Calibration Framework for Motionable and Portable Optical-Based Motion Recorder <i>Ferryanto, Mega Pradipta, Indria Herman, Sandro Mihradi, Tatacipta Dirgantarra dan Andi Isra Mahyuddin</i>	173
PMT-35	Influence of Backpack Design on Human's Upper Motion <i>Ferryanto, Taufik Akbar, Sandro Mihradi, Tatacipta Dirgantara dan Andi Isra Mahyuddin</i>	179
PMT-36	Strategi Mengemudi Mobil Listrik pada Kontes Mobil Hemat Energi (KMHE) <i>Muhammad Tadjuddin, Udink Aulia, Teuku Firsya dan Reza Alfurqan</i>	185
PMT-37	Analisis Crashworthiness Struktur Kereta Penumpang Indonesia <i>Rachman Setiawan dan Michael Pamintori</i>	191
PMT-38	Analysis of Natural Frequency Changes in Palm Trees Caused by Geometric and Morphologic Aspects <i>Radon Dhelika, Anantama Karis dan Wahyu Nirbito</i>	196
PMT-39	Design, Fabricated, and Trial on a Fatigue Test Machine <i>Syamsul Hadi, Anggit Murdani dan Fatkhur Rokhman</i>	201
PMT-40	Pengaruh Konstanta Kinematik terhadap Workingspace Alat Bantu Bedah Berbasis Mekanisme Paralel <i>Syafri dan Teguh Iman</i>	208
PMT-41	Optimasi Ketebalan Serat Cotton untuk Silinder Liner Baja dan Aluminium pada Copv Menggunakan Pendekatan Elemen Hingga <i>Dedi Lazuardi, Rifqi Muhammad Al Ghifari dan Agus Sentana</i>	214

## Teknik Produksi Mesin

TPM-01	Aplikasi Box Behnken Design untuk Optimasi Parameter Proses Pemesinan Bubut Magnesium AZ31 <i>Arinal Hamni, Opi Sumardi, Gusri Akhyar Ibrahim dan Achmad Yahya</i>	1
TPM-02	Analisa Keausan Pahat Putar pada Pembubutan Magnesium Az31 Menggunakan Udara Dingin Bertekanan <i>Gusri Akhyar Ibrahim, Dhika Arifan, Arinal Hamni, Suryadiwansa Harun dan Yanuar Burhanuddin</i>	6
TPM-03	Studi Pengaruh Parameter Proses Drilling pada Tulang terhadap Temperatur dan Kualitas Lubang yang Dihasilkan <i>Rusnaldy, Toni Prahasto, Lis Prasetyo, Mudjianto dan Wahyu Isti Nugroho</i>	11
TPM-04	Optimalisasi Perancangan Runner dan Gate Cetakan Injeksi Plastik dengan Metode Simulasi <i>Agung Kaswadi dan Muhammad Insan Tauhid</i>	15
TPM-05	Evaluasi Desain Probe pada Proses Pengelasan Gesek Aluminium 6061 <i>Djarot B. Darmadi, Widia Setiawan, Eko Siswanto dan Anindito Purnowidodo</i>	21
TPM-06	Simulation of Injection Process Parameters to Optimize PET Preform Quality Using Design of Experiment Method <i>Cahyo Budiyanoro</i>	25
TPM-07	Effect of Gap and Voltage on MRR and Overcut of SS316 Electrochemical Machining Using Unisolated Brass Electrode <i>Aris Widyo Nugroho, Ilham Dwi Cahyo, Sudarisman dan Muhamad Budi Nur Rahman</i>	32
TPM-08	Stamping Force Reduction with Inclined Punch <i>Rudi Kurniawan Arief</i>	36
TPM-09	Pengaruh Teknik Isolasi terhadap Kekuatan Tarik dan Lengkung Material Komposit pada Pembuatan Fuselage Pesawat Tanpa Awak <i>Gesang Nugroho dan Ogi Budiana</i>	40
TPM-10	Estimasi Waktu Produksi dan Perencanaan Proses Pemesinan pada Pembuatan 3 Axis Flexible Fixture Berbasis Microcontroler <i>Alfan Fauzi, Sampurno dan Bobby Oedy Pramudyo Supangat</i>	45
TPM-11	Kajian Rancangan Purwarupa Mesin CNC Milling CTU3x terhadap Kapasitas Mampu Proses Material dan Penggunaan Alat <i>Asep Indra Komara, Iman Apriana Effendi dan Muhamad Aditya Royandi</i>	51
TPM-12	Development of Component Control System for Rubber Drying Machine Using Programmable Logic Controller <i>Hendra, A.S Yulianto, A. Indriani, Hernadewita dan Hermiyetti</i>	60
TPM-13	Development of CNC 4-Axis by Modifying Milling Machine EMCO TU 3-Axis <i>Teuku Firsa, Muhammad Tadjuddin dan Hendra Ahmad Farmansyah</i>	66
TPM-14	Perancangan Sistem Deteksi Kolam Las Menggunakan Machine Vision pada Pengelasan Tungsten Inert Gas Baja SS304 <i>Ario Sunar Baskoro dan Vandy Ilham</i>	72



## Konversi Energi

KE-01	Simulation of Particle Flows of Circulating Fluidized Bed <i>Urip Agus Salim, Muslim Mahardika dan Aristo Taufiq</i>	1
KE-02	Pengaruh Sudut Swept dan Sudut Incidence pada Sayap Pesawat Tanpa Awak dengan Simulasi Komputasi Dinamika Fluida <i>Muhammad Agung Bramantya, Gesang Nugroho, dan Reynaldi Dimas K</i>	9
KE-03	Valve Diameter Optimization of Hydram Pump Waste <i>Made Suarda, Ainul Ghurri, Made Sucipta danl Gusti Bagus Wijaya Kusuma</i>	14
KE-04	Influence of Guide Vane Number and Angle on Cross Flow Turbine Performance of Cooling Tower <i>Budi Santoso, Dominicus Danardono D.P. Tjahjana dan Purwadi Joko Widodo</i>	19
KE-05	Suction Active Control Application on Vehicle Models with Variation of Front Geometry <i>Rustan Tarakka, Nasaruddin Salam dan Jalaluddin Haddada</i>	25
KE-06	Pengaruh Jumlah TEC terhadap Unjuk Kerja Mesin Pendingin Termoelektrik <i>Mega Nur Sasongko, Abdi Sultan Habibi dan Fikrul Akbar Alamsyah</i>	29
KE-07	Experimental Study on Effect of Electrolyte Phase Variations with Titanium Dioxide Nanoparticles on Dye Sensitized Solar Cell Power Using ITO Glass Substrate <i>Eqwar Saputra, Amalia Isna Rahmawati, Ni'mah Mufidah, Golda Defannisa Astrid, Evi Rohmatul Aini dan Tri Widayatno</i>	34
KE-08	Karakteristik Larutan Nanofluid CaCO <sub>3</sub> melalui Pipa Bulat <i>Yanuar dan Sealtial Mau</i>	39
KE-09	Investigation on Valve Snifter Design of Hydram Pump <i>Made Sucipta, Made Suarda dan I Wayan Bogik Wiastra</i>	44
KE-10	Performance Comparison of 9-Lt Diesel Engine with Three Types of Fuel: Biosolar, Pertadex and B30 <i>Ade Kurniawan, Ma'ruf dan Ihwan Haryono</i>	49
KE-11	Thermal Simulation of Continuous Torefaction Reactor Tubular Type for Solid Fuel Production of Municipal Waste <i>Amrul, Muhammad Fariz dan Indra M. Gandidi</i>	53
KE-12	Cross Winds Effect Analysis on Aerodynamic Characteristic of Jakarta-Bandung Rapid Train using CFD <i>Tony Suryo Utomo, Syaiful dan Zanuar Sunu Pratama</i>	57
KE-13	Effect of Blade Shapes on Savonius Wind Turbine Performance <i>Ridwan, Iwan Setyawan dan Setiyono</i>	62
KE-14	Effect of Temperature and Volume Fraction on Viscosity and Density of Nano Fluid TiO <sub>2</sub> /Termo XT32 Oil <i>Herry Irawansyah dan Samsul Kamal</i>	67
KE-15	Effect of Attack Angle Configuration on Performance of Three-Angle Horizontal Wind Turbine Prototype <i>Illa Rizianiza dan Rachmat Miftakhul Huda</i>	70

KE-16	Effect of Drop Frequency on Effectiveness of Multiple Droplets Cooling in Natural Convection Regime <i>Dannys Arif Kusuma, Indro Pranoto, Aria Riswanda, Deendarlianto dan Fauzun</i>	74
KE-17	Effect of Early Pressure on Induction Distance Detonation Hydrogen-Oxygen Mixture with Schcelkin Spiral <i>Willie Prasadha, Jayan Sentanuhady, Davin Demas Sanchorehan dan Taufiq Hidayat</i>	79
KE-18	Effect of Air Flow Velocity on Solar Water Heater Efficiency of Flat Plate Type with Fin and Baffle <i>Sophian Rumboko Aditama, Arrad Ghani Safitra dan Lohdy Diana</i>	85
KE-19	Effect of Air-Fuel Ratio to Non-premixed Burning Characteristics in Boiler Furnace Using CFD <i>Heri Santoso, Teguh Hady Ariwibowo dan Arrad Ghani Safitra</i>	92
KE-20	Analysis of Multiple Droplets Collision Phenomenon in Surface Temperature of Boiling Films on Weber Medium <i>Teguh Wibowo, Samsul Kamal, Indarto Indarto dan Deendarlianto</i>	99
KE-21	Heat Value Analysis of Briquette Hybrid as Alternative Fuel <i>Hendri Nurdin, Hasanuddin dan Irzal</i>	103
KE-22	Karakteristik Biodiesel dari Minyak Goreng Bekas sebagai Campuran Bahan Bakar pada Mesin Diesel <i>Adjar Pratoto, Asyhari Prima Nanda dan Fadjar Goembira</i>	107
KE-23	Multifunctional Optimization of Evaporator Design Discrete Finned-Tube Plate Using Minimizing Entropy Generation Method <i>Matheus M. Dwinanto, Suhanan dan Prajitno</i>	113
KE-24	Perancangan dan Simulasi Numerik Perpindahan Panas pada Reaktor Pirolisis tipe Fixed Bed Skala Laboratorium <i>Thoharudin, Muhammad Nadjib dan Tito Hadji Agung Santosa</i>	120
KE-25	Effect of Tip Speed Ratio on Power Generated Prototype of Horizontal Axis Wind Turbine with Three Blades <i>Rachmat Miftakhul Huda, Illa Rizianiza dan Sulistijono</i>	126
KE-26	Experimental Study on Effect of Blade Number and Attack Angle on Power and Rotation of Crossflow Water Turbine <i>Rijal Surya Rahmany, Alfian Djafar dan Sulistijono</i>	130
KE-27	Design and Simulation of Three-Way Nozzle on Cross Flow Water Turbine for Various Heads <i>Ika Kurniawati, Isnain Aliman dan Priyono Sutikno</i>	135
KE-28	Design and Simulation of Control Flow Vane Nozzle at Cross Flow Turbine <i>Isnain Aliman, Josi Ayu Wulandari Pratama Putri, and Priyono Sutikno</i>	142
KE-29	Solar Distillation for Turning Brackish Water into Freshwater Using Heat Collector <i>Mulyanef, Arfan Fikri dan Edi Septe S</i>	149

KE-30	Design of Plantwide Control for Steam Power Plant Control System <i>Achmad Qomarul Mujahidin, Hendrik Elvian Gayuh Prasetya dan Erik Tridianto</i>	153
KE-31	Karakteristik Gasifikasi Menggunakan Bubbling Fluidised Bed <i>Tri Agung Rohmat dan Yullian Endi</i>	158
KE-32	Pengaruh Putaran Scraper, Flowrate dan Salinitas terhadap Pembentukan Bubur Es pada Sea Water Ice Slurry Generator. <i>Intan Permata Sari, Agus Sunjarianto Pamitran dan Idrus Alhamid</i>	163
KE-33	Perbandingan Nilai Hambatan Kapal antara Hasil Simulasi dengan Eksperimen pada Kapal Pelat Datar Semi-Trimaran <i>Muhammad Arif Budiyanto, Hadi Tresno Wibowo dan Muhammad Fattah</i>	168
KE-34	Karakteristik Geometris Partikel Es pada Ice Slurry Generator Menggunakan Scraper Simetris Berlapis Teflon <i>Fajri Ashfi Rayhan, Abdul Rafii Lazuardian Ramadhan, Agus Pamitran dan Mufti Petala Patria</i>	172
KE-35	Development of Archimedes Turbine Research: Review Article <i>Budiarso, Warjito, Dendy Adanta dan M.H. Gumelar Syafei</i>	177
KE-36	Studi Fuel Economy Penggunaan Bahan Bakar Biosolar dan Solar #51 pada Kendaraan Penumpang <i>Siti Yubaidah, Hari Setiapraja dan Budi Rochmanto</i>	182
KE-37	40,000 Km Road Test of Vehicle Fueled by 20% Biodiesel <i>Ihwan Haryono dan Mokhtar</i>	187

## Pendidikan Teknik Mesin

PTM-01	Development of Interactive Teaching Materials Based on Multimedia for Engineering Materials <i>Adella Hotnyda Siregar, Yuhani Jaya dan Sugeng Prayitno</i>	1
PTM-02	Teaching Materials Development of The Geometric Specification and Verification for Mechanical Components <i>Indra Djodikusumo, Sri Hardjoko Wirjomartono, M. Abdulkadir, Agus Dwi Iskandar dan Agung Wibowo</i>	6
PTM-03	Recognition of Hemi-Savonius Windmill as Energi Conversion System Model on Windmill Techno Park at Coastal Area <i>Hasanuddin, Hendri Nurdin, Waskito dan Refdinal</i>	16

Material		
MT-01	Effect of Fluid Cooling on The Mechanical Properties and Microstructure of SS 304 <i>Tumpal Ojahan R, Yusup Hendronursito dan Arif Hidayat</i>	1
MT-02	Effect of Graphite Oxide Additive on Tensile Strength and Burn length of Glass/Epoxi Composite <i>Adi Purwoko Chriswadyanto dan Hermawan Judawisastra</i>	6
MT-03	Effect of T6 Heat Treatment on Mechanical Properties of Coal Ash-Aluminum Composite as Brake Disk Holder Component <i>Maula Nafi dan Ichlas Wahid</i>	12
MT-04	Experimental Observation on The Changes of Microstructure Grain of AlCoal Ash Composite under T6 Heat Treatment <i>Ichlas Wahid dan Maula Nafi</i>	15
MT-05	Effect of Angle Orientation on Mechanical Strength of Arenga Pinnata Composite <i>Achmad Kusairi Samlawi dan Fatah Hidayatullah</i>	19
MT-06	Comparison of Pore Size on Solid Oxide Fuel Cell Electrodes by Wet Spraying Process and Compaction <i>Solihin Sulistyono</i>	23
MT-07	Hydrogen Induced Cracking Testing in 3.5% Wt NaCl Environment Using Cantilever Bending <i>Mudjijana, Mochammad Noer Ilman dan Priyo Tri Iswanto</i>	27
MT-08	Failure Analysis on Shaft of Circulating Water Pump at Power Plant <i>Gunawan Dwi Haryadi, Suluh Pertiwanda dan Rifky Ismail</i>	32
MT-09	Development of Implant Material from Powder Metallurgy <i>Ahmad Kafrawi Nasution, Aan Mardiansyah dan Lega Putri Utami</i>	38
MT-10	Hardness and Wear of Nickel-Tungsten Layers on Medium Carbon Steel under Rolling-Sliding Contact Test <i>I Made Widiyarta, I Made Parwata, I Putu Lokantara dan D. Ranto</i>	42
MT-11	Bending Strength Analysis on Composite Reinforced with Discontinuous Dewang Leaf (Corypha Utan Lam) <i>Jefri Samuel Bale, Dominggus G.H. Adoe dan Meki I. Sing</i>	46
MT-12	Effect of Chisel Speed on Friction Stir Welding of Non-Similar Metals <i>Sulardjaka dan Rizqi Saiful Umam</i>	51
MT-13	Effect of Recycled and New Mixtures of Acrylonitril Butadiene Styrene on Product Mechanical Properties <i>Rohmat Setiawan dan Muhammad Nur Andi Widodo</i>	56
MT-14	Analysis of Stainless Steel Wear Rate in The Environment of Methyl Ester Palm Oil <i>Zahrul Fuadi, Koshi Adachi, Takanori Takeno, Muhammad Tadjuddin dan Mohd Iqbal</i>	60



MT-15	Hardness Distribution of Carbon Steel under Ni-Cr Coating after Various Preheating on Substrate Material <i>I Made Widiyarta, I Putu Lokantara, I Made Parwata, Edwin Reynaldo dan Mustika</i>	64
MT-16	Quality Analysis on the Waste Mixture of Soft Drink Can and Engine Block <i>Ivan Junaidy Abdulkarim dan Kifli Umar</i>	68
MT-17	Application Temperature Annealing on Brittle Fracture Prevention on Balinese Gamelan Made of Bronze <i>I Ketut Gede Sugita, Cok Istri Putri Kusuma Kencanawati, I Gusti Ngurah Priambadi</i>	73
MT-18	Prilaku Korosi Sambungan Las FSW AA5083 dalam Larutan 3,5% NaCl dengan Penambahan Inhibitor Sodium Kromat <i>FX Arif Wahyudianto dan Erry Yadie</i>	77
MT-19	Failure Analysis on Pipeline Welded Joint of Venting Isolation High Pressure Superheater Tube <i>Sri Nugroho, Sulardjaka dan Galih Al Hadid</i>	81
MT-20	Thermal Characteristics of Matrix Composites of Aluminum - Ash Base Coal after T6 Heat Treatment <i>Rahadhian Chrisna Samudra, Harjo Seputra, Mastuki Mastuki, Imah Luluk Kusminah dan Ahmad Fauzan Adziima</i>	87
MT-21	Corrosion Detection on Reinforced Steel in Concrete Using BEIA 2D <i>Syarizal Fonna, Syifaul Huzni dan Gunawarman</i>	91
MT-22	Simulation on the Effect of Anode-Cathode Distance on Reinforced Concrete Cathodic Protection Using BEM <i>Syarizal Fonna, Muzaiyin Arika Putra dan Syifaul Huzni</i>	96
MT-23	The Effect of Span-to-depth Ratio on the Flexural Properties of Hybrid S2/E-Glass Fiber-reinforced Epoxy Composites <i>Sudarisman</i>	101
MT-24	Manufacture Process of Composite Products Made of Plantation and Industrial Wastewater <i>Hendra, A. Indriani, Hernadewita dan Hermiyetti</i>	106
MT-25	Optimasi Parameter Second Quenching dan Tempering terhadap Kekerasan dan Energi Impak Baja HRP Lokal <i>Yurianto, Pratikto, Rudy Sunoko dan Wahyono Suprpto</i>	111
MT-26	Characteristics and Early Analysis of Pine Resin under Heating Variations as Alternative Resins on Composites <i>Cok Istri Putri Kusuma Kencanawati, Ngakan Putu Gede Suardana, I Ketut Gede Sugita dan I Wayan Budiarsa Suyasa</i>	117

## Stamping Force Reduction with Inclined Punch

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**Abstract.** Ideally processing of part using stamping machine using only 70-80 % of available force to keep machine in good shape for a long periods. But in some certain case the force may equal to or exceed the available maximum force so the company must sent the process to another outsource company. A case found in a metal stamping company where a final product consist of 3 parts to assembly with one part exceeded the force of available machine. This part can only process in a 1000 tons machine while this company only have 2 of this machine with full workload. Sending this parts outsource will induce delivery problems because other parts are processed, assembled and paint inhouse, this also need additional transportation cost and extra supervision to ensure the quality and delivery schedule. The only exit action of this problem is by reducing the force tonnage. This paper using punch inclining method to reduce the force. The incline punch will distributed the force along the inclined surface that reduce stamping force as well. Inclined surface of punch also cause another major problems that the product becoming curved after process. This problems solved with additional flattening process that add more process cost but better than to outsource the process. Chisel type of inclining punch tip was choosen to avoid worst deformation of product. This paper will give the scientific recomendation to the company.

**Keywords:** metal stamping, force reduction, inclining punch, shearing process, cutting force

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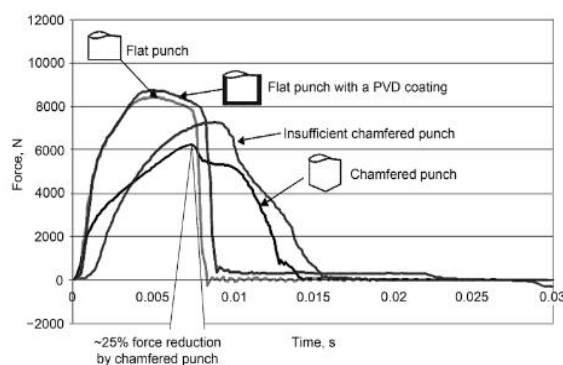
### Preface

Ideally processing of part using stamping machine using only 70-80 % of available force to keep machine in good shape for a long periods. However, in some certain case the force may equal to or exceed the available maximum force so the company must sent the process to another outsource company. A case found in a metal stamping company where a final product consist of 3 parts to assembly with one part exceeded the force of available machine. This part can only process in a 1000 tons machine while this company only have 2 units of this machine with full workload. Other machine with 500 tons force available 4 units with medium load. To process this parts in 500 Tons machine will gain effeciencies in time production cost. Sending these parts outsource will induce delivery problems because other parts are processed, assembled and paint inhouse, this also need additional transportation cost and extra supervision to ensure the quality and delivery schedule.

The only exit action of this problem is by reducing the force tonnage. Punch or die inclining method is used to reduce the force. The incline punch will distributed the force along the inclined surface that reduce stamping force as well. The company already incline the punch slightly but not reducing a lot of force. View years ago, in the late 2005, Mr. Konishi, a senior engineer from head office Japan, give his advice to use the combination

of flat and double shear type, but this advice never be applied until today. This paper will calculate theoritically the design that advised by the advisor to give the scientific recomendation to the company.

### Literature Review



**Figure 1.** Force reduction with different punch geometries [3]

**Force Reduction Methods.** Sometime we face the problem of excessive stamping force that unaffordable by available press machine. Several methods can be used to reduce the stamping force such as inclined punch and staggered punch. Staggered punch usually applied for piercing process with multi punch, the punches then staggered or set in several different height to be able to cut simultaneously one after another. For blanking process with bigger size, usually inclined punch is used. This inclined punch surface also

known as shear, because it works as the shearing process like a scissor. Inclined surface may reduce cutting force up to 25% [3].

Maximum stamping force can be reduced because punch pushing small amount of materials (b) step by step instead of pushing all materials together (a) as shown in figure 1 below.

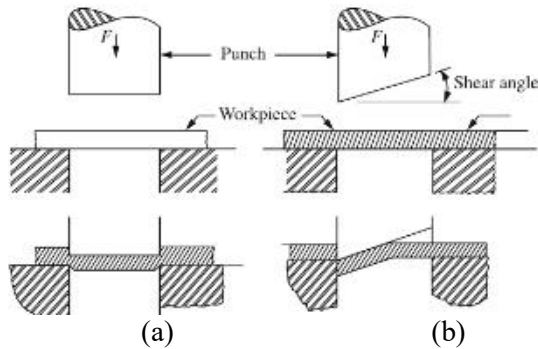


Figure 2. Material pushing in stamping process [2]

Many type of inclined surface also applicable for punch surface with some advantages and disadvantages, the slug or blanking part might be deformed into the shapes of punch.

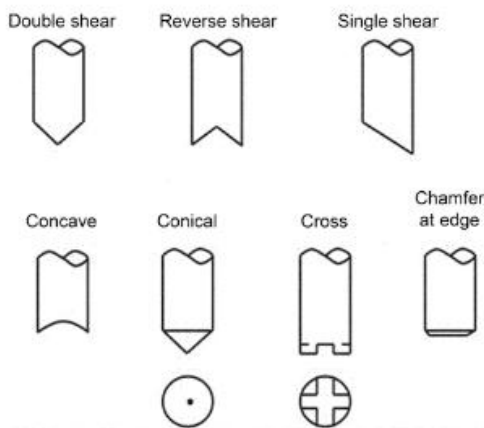


Figure 3. Punch inclined shape [3]

As the punch shape inclined, slug surface might be deformed according to inclined types. Figures below shown the slugs appearance after processed.

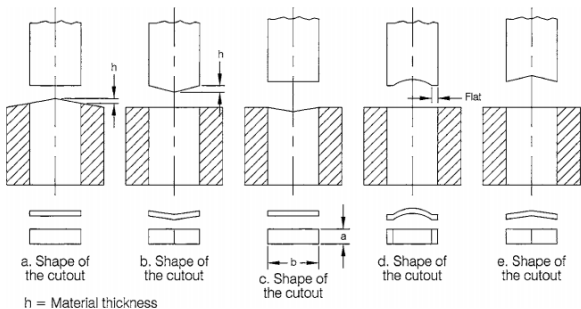


Figure 4. Slug deformation appearance [1]

As the cut-out part will be resemble the shape of it's punch, so it is advisable to use inclined punch for piercing process and inclined dies for blanking

process. Figure 4 above explained that inclined dies surface will produced flat and better slug that suitable for blanking process to avoid deformation. But machinery and maintenance difficulties will be issues to be considered. The angle of inclined punch depend on material thickness [4] :

1. For  $t \leq 3 \text{ mm} = h \leq 2t$  and  $\alpha \leq 5^\circ$
2. For  $t > 3 \text{ mm} = h = t$  and  $\alpha \leq 8^\circ$

Where  $H$  is height of inclined surface,  $t$  is material thickness.

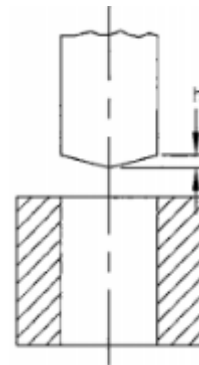


Figure 5. Inclined punch

The higher shear angle applied on the punch, bigger possibility for workpiece to be deformed. Depend on tolerances and process planning, the deformation may acceptable if under tolerance specification, otherwise additional process will be required or deformation can be fixed in next step of the process.

**Stamping force formula.** Stamping force must be determined at the beginning to decide with press machine to use. This stamping force must be slightly lower than maximum press machine capacity for maintenance reason but somehow the stamping force were slightly higher. Under this situation inclined surfaced is applied.

Stamping force calculated by considering the length of cutting edge, material thickness and shear strength of material as formulated below:

$$P = L \times t \times S_c \quad (1)$$

Where  $P$  is cutting force (kgf),  $t$  is material thickness,  $L$  is length of cut,  $S_c$  is maximum cutting strength (see Table 1) and  $S_y$  is yield strength.

Table 1. Material maximum cutting strength ( $S_c$ )

Material	Maximum cutting strength, $S_c$
Aluminum, soft	(.75-.90) $S_y$
Aluminum, hard	(.60-.65) $S_y$
Steel	(.75-.90) $S_y$
Stainless steel	(.68-.72) $S_y$
Titanium alloys	(.65-.70) $S_y$

Note: Where  $S_y$  is the yield strength of the material.

Stamping force for inclined punch or dies operation is estimated as below :

$$P = 0,7 \times k \times L \times t \times UTS \quad (2)$$

Where:

P = Cutting Force (kgf)

k = Constant value : 0,4 ~ 0,6 for h = t  
: 0,2 ~ 0,4 for h = 2t

t = Material thickness

UTS = Ultimate Tensile Strength

$$SC = (0,75-0,9) \cdot Sy \quad (3)$$

$$SC = 0,8 \cdot Sy$$

$$SC = 0,8 \cdot 240 = 192$$

### Design Implementation

**The Case.** The case was taken from Japanese owned metal stamping company located in Bekasi area, Indonesia. The assembly part consist of 4 stamping parts with welded assembly. Biggest stamping part made of 6mm thickness SPCC material is planned to have 4 stamping process. The process are: Blanking, 1<sup>st</sup> piercing, U- bending and 2<sup>nd</sup> pierce.

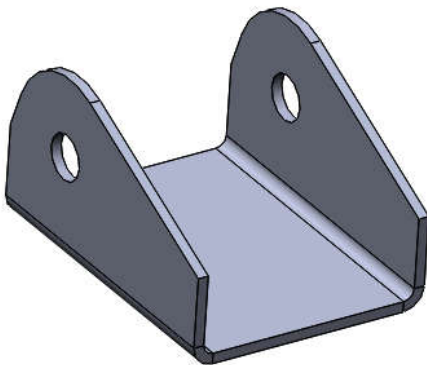


Figure 6. Finished part

The blanking process required force as estimated below:

Where t = 6 mm  
L = 703,4mm  
Sy = 240 (for SPCC)

$$Sc = 0,8 \times Sy = 0,8 \times 240 = 192$$

$$P = 703,4 \times 6 \times 192 = 810.320 \text{ kgf} \approx 811 \text{ tons}$$

From equation above means that this workpiece should be process in 1000 Tons stamping machine. Due to high utilities of 1000 Tons machine, the company tries to reduce the force by inclining the

punch surface method. To process in other company is not an option because will require higher cost for transportation and stamping fee. The target is to reduce the force to 450 tons so this can be process with 500 tons stamping machine.

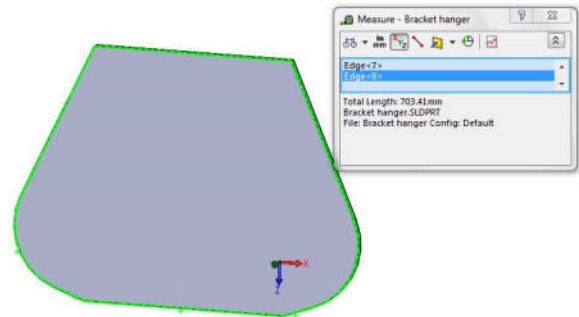


Figure 7. Total perimeter length of blank

**Case Countermeasures.** Inclined surface is chosen as force reducing method because this method may reduce the cutting force up to 50% and shear process produce lower shock and sound. With 6mm of material thickness the maximum inclined height should be equal to material thickness with inclined degree less than 8°.

Inclined punch with double shear method was chosen rather than inclined dies, the product will be deformed and buckling but the manufacturing and maintenance cost were much lower. Since the cut-out parts will deform to shape of punch double shear punch then will produce NG blank parts. In the late 2005, Mr. Konishi, a senior engineer from head office Japan, give his advice to use the combination of flat and double shear type (Figure 7). This advice considering how to gain high force reduction but still keeping the good surface of the middle surface.

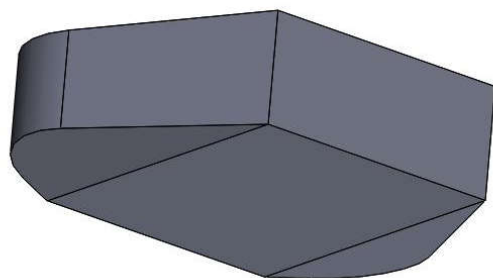


Figure 8. Inclined shape of punch

With this type cutting force and deformation of material can be reduce. Flat surface will act as conventional stamping and then continue by shearing to the rest of it. Double shear punch is suitable for piercing process because the scraps will deform to “V” shape and disposable while for blanking it will deformed the workpiece.

**Stamping Force Calculation.** The punch is divided into 3 parts (Fig. 3). Flat surface punch taken along 140mm, this is the position of flat

surface of part after bending. With this type, blanking process is divided into two stages; first stage is the flat surface punching then follow with shear punching.

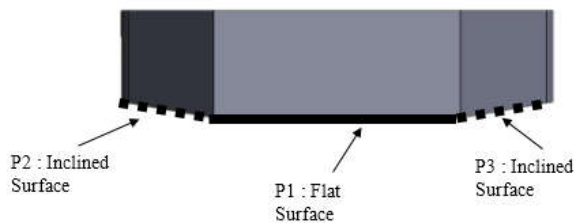


Figure 9. Design of punch shapes

Cutting force will be P1 and P2+P3. Cutting force at P1:

$$\begin{aligned} \text{Where: } t &= 6 \text{ mm} \\ L1 &= 140 \times 2 = 280 \text{ mm} \\ S_y &= 240 \text{ (SPCC)} \\ S_c &= 0,8 \times S_y \\ &= 0,8 \times 240 \\ &= 192 \end{aligned}$$

$$\begin{aligned} P1 &= 280 \times 6 \times 192 \\ &= 322.560 \text{ kgf} \approx 323 \text{ tons} \end{aligned}$$

Cutting force at inclined punch (P2 & P3) is estimated as below:

$$P2 = P3 \quad (4)$$

$$\begin{aligned} \text{Where: } h &= t = 6 \text{ mm} \\ k &= 0,5 \\ t &= 6 \text{ mm (SPCC)} \\ L2 &= 213 \\ UTS &= 270 \text{ (JIS G3141)} \end{aligned}$$

$$P2 = 0,7 \cdot 0,5 \cdot 106,6 \cdot 6 \cdot 270$$

$$P2 = 120.771 \text{ kgf} \approx 120,8 \text{ tons}$$

$$P2 + P3 = 241,6 \text{ tons}$$

First stage cutting will require 323 tons of force and second stage form inclined punch required 121 tons of force so still applicable to process in 500 tons stamping machine.

This combination type cutting process are divided into two stages, where first stage required 323 tons of force and then follow by second process with shear method required 121 tons of force. Therefore, this process will be able to work in 500 tons stamping machine.

## Conclusions

The design use combination type of flat and inclined cutting surface. The calculation shows that cutting force reduced significantly and this part can be process in 500 tons machine compare with 1000

tons before. This combination may reduce the deformation of blank part rather than double incline (V-shaped). Inclined punch is choose for it ease of maintenance and manufacture. This design is theoretically acceptable and recommended to be manufactured.

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