THE UNIVERSITY OF ADELAIDE

DEPARTMENT OF MECHANICAL ENGINEERING

EXAMINATION FOR THE DEGREE OF B.E.

DESIGN FOR MANUFACTURE [2046]

November 1999

Time: TWO (2) HOURS

[Candidates are allowed ten minutes before the examination begins to read the paper]

[Answer all **FOUR** questions]

[Marks for parts of questions are indicated. Total marks are out of 100]

[The use of notes and textbooks is permitted]

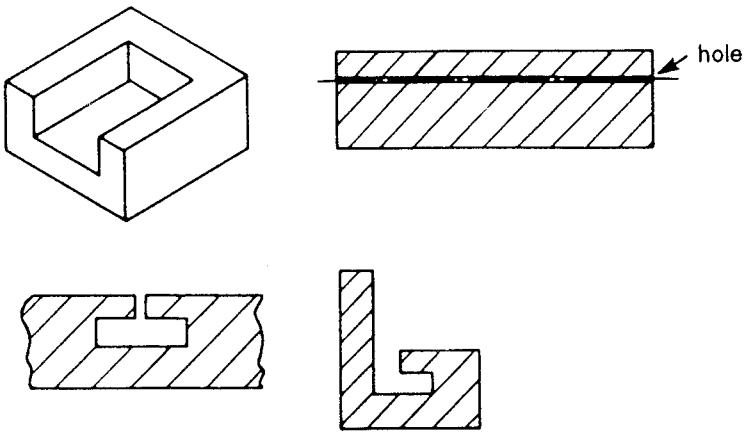
[All separate pieces of work must bear the candidate's name and must be placed inside the examination book provided]

1.1 Why should persons in manufacturing care about the way design engineers perform the design activities?

[6 Marks]

1.2 The figure below shows design features to be avoided. Briefly give your reasons for each design fault stating any assumptions made.

[8 Marks]



1.3 Explain to a layperson ("person-in-the-street") the concept of rapid prototyping and its application to the design manufacture process. Discuss the relative merits of the various types of rapid prototyping facilities currently available and recent alternatives to rapid prototyping.

[11 Marks]

Please see next page.

2.1 Discuss your experience in utilising the worldwideweb in collating product design and manufacturing data relevant to a product currently on the market. You may wish to consider the following aspects:

1. ease of navigation of the web pages,
2. customer/supplier interface,
3. website flexibility,
4. getting more out of the web,
5. advantages/disadvantages of the web with respect to traditional data collation methods.

[10 Marks]

2.2 Describe the use of the Boothroyd and Dewhurst tables to assess the type of assembly method adopted for economic application given:

1. company investment level and,
2. product details such as:

   production volume, parts in assembly, anticipated design and style changes.

What are the recommended operating conditions for manual assembly and special-purpose/dedicated assembly configurations?

State the benefits to be gained by designers using the assembly product design evaluation tool as proposed by Boothroyd and Dewhurst? List any side benefits?

[15 Marks]

3.1 Explain what is meant by the term Process Capability and what steps have to be undertaken to perform a process capability study.

[8 Marks]

3.2 A decision needs to be made regarding the purchase of new casting equipment. To aid this process, a capability study is performed to assess the performance of the current equipment. An important part that will consume much of the run time of the equipment is to be used for the study. A critical dimension of the part 3.00 +/- 0.025cm has been selected as the measure and 32 samples of 5 have been collected at regular intervals over two continuous shifts. Use this data to perform a capability study and discuss the results obtained to determine if new equipment should be purchased? Make sure that all charts that are constructed define your answer and conform to current industrial practice.

[17 Marks]

Please see next page.

Data:

Sample	Sample Average	Range	Sample	Sample Average	Range
1	2.991	0.038	17	3.005	0.039
2	3.004	0.027	18	3.008	0.054
3	2.997	0.049	19	3.0011	0.009
4	3.004	0.033	20	3.000	0.062
5	2.999	0.043	21	2.993	0.034
6	3.000	0.070	22	2.982	0.012
7	2.988	0.044	23	2.990	0.028
8	2.986	0.050	24	3.003	0.091
9	2.991	0.064	25	3.007	0.049
10	2.994	0.048	26	2.998	0.052
11	3.017	0.070	27	3.012	0.077
12	2.987	0.051	28	2.996	0.040
13	3.013	0.060	29	2.997	0.018
14	2.993	0.019	30	3.004	0.020
15	3.009	0.044	31	2.987	0.063
16	2.990	0.043	32	3.002	0.028

4. A two level full factorial design has been performed to study the amount of splay on an injection moulded part due to the effect of temperature (X1), pressure (X2) and cycle time (X3). For each of the eight unique trials, 30 parts were made and those free from splay recorded as shown in the data below.

(i). Formulate a mathematical model to represent the process using only the significant results.

[12 Marks]

(ii). From the mathematical model, determine the expected number of good products if the settings are: temperature 45, pressure 70 and cycle time 10 units.

[6 Marks]

(iii). What are your recommendations for achieving a 100% successful product.

[7 Marks]

Variable	Low Level	High Level
Temperature (X1)	40	70
Pressure (X2)	50	70
Cycle Time (X3)	5	10

Test	(X1)	(X2)	(X3)	Yield
1	40	50	5	12
2	70	50	5	15
3	40	70	5	24
4	70	70	5	17
5	40	50	10	24
6	70	50	10	16
7	40	70	10	24
8	70	70	10	28

Please see next page.

Control Chart for Variable Data

Department	Operation	Date Control Limits Calculated	Engineering Specification	Part Number
Dates	Sample Size & Frequency	Characteristic	Part Name	

$\bar{\bar{X}}$ = Average $\bar{X}$ = UCL = $\bar{\bar{X}} + A_2\bar{R}$ = LCL = $\bar{\bar{X}} - A_2\bar{R}$ =

Averages (X Bar Chart)

$\bar{R}$ = Average R = U.C.L. = $D_4\bar{R}$ = L.C.L. = $D_3\bar{R}$ =

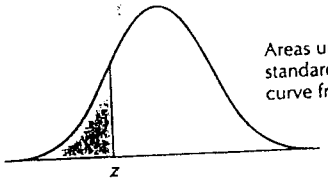
Ranges (R Chart)

* For sample sizes less than 7, there is no lower control limit for ranges

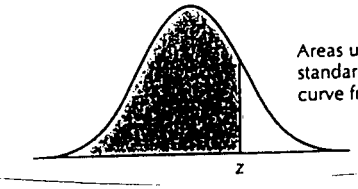
Date / Time																																
Readings	1																															
	2																															
	3																															
	4																															
	5																															
Sum																																
$\bar{X} = \frac{\text{Sum}}{\text{No. of Readings}}$																																
R = Highest - Lowest																																

TABLE A.2 Constants for Determining from $\bar{R}$ the 3 Sigma Control Limits for $\bar{X}$ and R Charts and for Estimating the Process Standard Deviation from $\bar{R}$

Number of Observations in Subgroup/Sample	d_2	A_2	D_3	D_4
2	1.128	1.880	0	3.267
3	1.693	1.023	0	2.575
4	2.059	0.729	0	2.282
5	2.326	0.577	0	2.115
6	2.534	0.483	0	2.004
7	2.704	0.419	0.076	1.924
8	2.847	0.373	0.136	1.864
9	2.970	0.337	0.184	1.816
10	3.078	0.308	0.223	1.777
15	3.472	0.223	0.348	1.652
20	3.735	0.180	0.414	1.586



Areas under the standard normal curve from $-\infty$ to z



Areas under the standard normal curve from $-\infty$ to z

TABLE A.1 Areas Under the Normal Curve

z	0.09	0.08	0.07	0.06	0.05	0.04	0.03	0.02	0.01	0.00
-4.00	0.00002	0.00002	0.00002	0.00003	0.00003	0.00003	0.00003	0.00003	0.00003	0.00003
-3.90	0.00003	0.00003	0.00004	0.00004	0.00004	0.00004	0.00004	0.00004	0.00005	0.00005
-3.80	0.00005	0.00005	0.00005	0.00006	0.00006	0.00006	0.00006	0.00007	0.00007	0.00007
-3.70	0.00008	0.00008	0.00008	0.00009	0.00009	0.00009	0.00010	0.00010	0.00010	0.00011
-3.60	0.00011	0.00012	0.00012	0.00013	0.00013	0.00014	0.00014	0.00015	0.00015	0.00016
-3.50	0.00017	0.00017	0.00018	0.00019	0.00019	0.00020	0.00021	0.00022	0.00022	0.00023
-3.40	0.00024	0.00025	0.00026	0.00027	0.00028	0.00029	0.00030	0.00031	0.00033	0.00034
-3.30	0.00035	0.00036	0.00038	0.00039	0.00040	0.00042	0.00043	0.00045	0.00047	0.00048
-3.20	0.00050	0.00052	0.00054	0.00056	0.00058	0.00060	0.00062	0.00064	0.00066	0.00069
-3.10	0.00071	0.00074	0.00076	0.00079	0.00082	0.00085	0.00087	0.00090	0.00094	0.00097
-3.00	0.00100	0.00104	0.00107	0.00111	0.00114	0.00118	0.00122	0.00126	0.00131	0.00135
-2.90	0.0014	0.0014	0.0015	0.0015	0.0016	0.0016	0.0017	0.0018	0.0018	0.0019
-2.80	0.0019	0.0020	0.0021	0.0021	0.0022	0.0023	0.0023	0.0024	0.0025	0.0026
-2.70	0.0026	0.0027	0.0028	0.0029	0.0030	0.0031	0.0032	0.0033	0.0034	0.0035
-2.60	0.0036	0.0037	0.0038	0.0039	0.0040	0.0041	0.0043	0.0044	0.0045	0.0047
-2.50	0.0048	0.0049	0.0051	0.0052	0.0054	0.0055	0.0057	0.0059	0.0060	0.0062
-2.40	0.0064	0.0066	0.0068	0.0069	0.0071	0.0073	0.0075	0.0078	0.0080	0.0082
-2.30	0.0084	0.0087	0.0089	0.0091	0.0094	0.0096	0.0099	0.0102	0.0104	0.0107
-2.20	0.0110	0.0113	0.0116	0.0119	0.0122	0.0125	0.0129	0.0132	0.0136	0.0139
-2.10	0.0143	0.0146	0.0150	0.0154	0.0158	0.0162	0.0166	0.0170	0.0174	0.0179
-2.00	0.0183	0.0188	0.0192	0.0197	0.0202	0.0207	0.0212	0.0217	0.0222	0.0228
-1.90	0.0233	0.0239	0.0244	0.0250	0.0256	0.0262	0.0268	0.0274	0.0281	0.0287
-1.80	0.0294	0.0301	0.0307	0.0314	0.0322	0.0329	0.0336	0.0344	0.0351	0.0359
-1.70	0.0367	0.0375	0.0384	0.0392	0.0401	0.0409	0.0418	0.0427	0.0436	0.0446
-1.60	0.0455	0.0465	0.0475	0.0485	0.0495	0.0505	0.0516	0.0526	0.0537	0.0548
-1.50	0.0559	0.0571	0.0582	0.0594	0.0606	0.0618	0.0630	0.0643	0.0655	0.0668
-1.40	0.0681	0.0694	0.0708	0.0721	0.0735	0.0749	0.0764	0.0778	0.0793	0.0808
-1.30	0.0823	0.0838	0.0853	0.0869	0.0885	0.0901	0.0918	0.0934	0.0951	0.0968
-1.20	0.0985	0.1003	0.1020	0.1038	0.1057	0.1075	0.1093	0.1112	0.1131	0.1151
-1.10	0.1170	0.1190	0.1210	0.1230	0.1251	0.1271	0.1292	0.1314	0.1335	0.1357
-1.00	0.1379	0.1401	0.1423	0.1446	0.1469	0.1492	0.1515	0.1539	0.1562	0.1587
-0.90	0.1611	0.1635	0.1660	0.1685	0.1711	0.1736	0.1762	0.1788	0.1814	0.1841
-0.80	0.1867	0.1894	0.1922	0.1949	0.1977	0.2005	0.2033	0.2061	0.2090	0.2119
-0.70	0.2148	0.2177	0.2207	0.2236	0.2266	0.2297	0.2327	0.2358	0.2389	0.2420
-0.60	0.2451	0.2483	0.2514	0.2546	0.2578	0.2611	0.2643	0.2676	0.2709	0.2743
-0.50	0.2776	0.2810	0.2843	0.2877	0.2912	0.2946	0.2981	0.3015	0.3050	0.3085
-0.40	0.3121	0.3156	0.3192	0.3228	0.3264	0.3300	0.3336	0.3372	0.3409	0.3446
-0.30	0.3483	0.3520	0.3557	0.3594	0.3632	0.3669	0.3707	0.3745	0.3783	0.3821
-0.20	0.3859	0.3897	0.3936	0.3974	0.4013	0.4052	0.4090	0.4129	0.4168	0.4207
-0.10	0.4247	0.4286	0.4325	0.4364	0.4404	0.4443	0.4483	0.4522	0.4562	0.4602
-0.00	0.4641	0.4681	0.4721	0.4761	0.4801	0.4840	0.4880	0.4920	0.4960	0.5000

TABLE A.1 (continued)

z	0.00	0.01	0.02	0.03	0.04	0.05	0.06	0.07	0.08	0.09
0.00	0.5000	0.5040	0.5080	0.5120	0.5160	0.5199	0.5239	0.5279	0.5319	0.5359
0.10	0.5398	0.5438	0.5478	0.5517	0.5557	0.5596	0.5636	0.5675	0.5714	0.5753
0.20	0.5793	0.5832	0.5871	0.5910	0.5948	0.5987	0.6026	0.6064	0.6103	0.6141
0.30	0.6179	0.6217	0.6255	0.6293	0.6331	0.6368	0.6406	0.6443	0.6480	0.6517
0.40	0.6554	0.6591	0.6628	0.6664	0.6700	0.6736	0.6772	0.6808	0.6844	0.6879
0.50	0.6915	0.6950	0.6985	0.7019	0.7054	0.7088	0.7123	0.7157	0.7190	0.7224
0.60	0.7257	0.7291	0.7324	0.7357	0.7389	0.7422	0.7454	0.7486	0.7517	0.7549
0.70	0.7580	0.7611	0.7642	0.7673	0.7704	0.7734	0.7764	0.7794	0.7823	0.7852
0.80	0.7881	0.7910	0.7939	0.7967	0.7995	0.8023	0.8051	0.8079	0.8106	0.8133
0.90	0.8159	0.8186	0.8212	0.8238	0.8264	0.8289	0.8315	0.8340	0.8365	0.8389
1.00	0.8413	0.8438	0.8461	0.8485	0.8508	0.8531	0.8554	0.8577	0.8599	0.8621
1.10	0.8643	0.8665	0.8686	0.8708	0.8729	0.8749	0.8770	0.8790	0.8810	0.8830
1.20	0.8849	0.8869	0.8888	0.8907	0.8925	0.8944	0.8962	0.8980	0.8997	0.9015
1.30	0.9032	0.9049	0.9066	0.9082	0.9099	0.9115	0.9131	0.9147	0.9162	0.9177
1.40	0.9192	0.9207	0.9222	0.9236	0.9251	0.9265	0.9279	0.9292	0.9306	0.9319
1.50	0.9332	0.9345	0.9357	0.9370	0.9382	0.9394	0.9406	0.9418	0.9429	0.9441
1.60	0.9452	0.9463	0.9474	0.9484	0.9495	0.9505	0.9515	0.9525	0.9535	0.9545
1.70	0.9554	0.9564	0.9573	0.9582	0.9591	0.9599	0.9608	0.9616	0.9625	0.9633
1.80	0.9641	0.9649	0.9656	0.9664	0.9671	0.9678	0.9686	0.9693	0.9699	0.9706
1.90	0.9713	0.9719	0.9726	0.9732	0.9738	0.9744	0.9750	0.9756	0.9761	0.9767
2.00	0.9773	0.9778	0.9783	0.9788	0.9793	0.9798	0.9803	0.9808	0.9812	0.9817
2.10	0.9821	0.9826	0.9830	0.9834	0.9838	0.9842	0.9846	0.9850	0.9854	0.9857
2.20	0.9861	0.9864	0.9868	0.9871	0.9875	0.9878	0.9881	0.9884	0.9887	0.9890
2.30	0.9893	0.9896	0.9898	0.9901	0.9904	0.9906	0.9909	0.9911	0.9913	0.9916
2.40	0.9918	0.9920	0.9922	0.9925	0.9927	0.9929	0.9931	0.9932	0.9934	0.9936
2.50	0.9938	0.9940	0.9941	0.9943	0.9945	0.9946	0.9948	0.9949	0.9951	0.9952
2.60	0.9953	0.9955	0.9956	0.9957	0.9959	0.9960	0.9961	0.9962	0.9963	0.9964
2.70	0.9965	0.9966	0.9967	0.9968	0.9969	0.9970	0.9971	0.9972	0.9973	0.9974
2.80	0.9974	0.9975	0.9976	0.9977	0.9977	0.9978	0.9979	0.9979	0.9980	0.9981
2.90	0.9981	0.9982	0.9983	0.9983	0.9984	0.9984	0.9985	0.9985	0.9986	0.9986
3.00	0.99865	0.99869	0.99874	0.99878	0.99882	0.99886	0.99889	0.99893	0.99897	0.99900
3.10	0.99903	0.99907	0.99910	0.99913	0.99916	0.99918	0.99921	0.99924	0.99926	0.99929
3.20	0.99931	0.99934	0.99936	0.99938	0.99940	0.99942	0.99944	0.99946	0.99948	0.99950
3.30	0.99952	0.99953	0.99955	0.99957	0.99958	0.99960	0.99961	0.99962	0.99964	0.99965
3.40	0.99966	0.99968	0.99969	0.99970	0.99971	0.99972	0.99973	0.99974	0.99975	0.99976
3.50	0.99977	0.99978	0.99978	0.99979	0.99980	0.99981	0.99982	0.99982	0.99983	0.99984
3.60	0.99984	0.99985	0.99985	0.99986	0.99986	0.99987	0.99987	0.99988	0.99988	0.99989
3.70	0.99989	0.99990	0.99990	0.99990	0.99991	0.99991	0.99992	0.99992	0.99992	0.99993
3.80	0.99993	0.99993	0.99993	0.99994	0.99994	0.99994	0.99994	0.99995	0.99995	0.99995
3.90	0.99995	0.99995	0.99996	0.99996	0.99996	0.99996	0.99996	0.99996	0.99997	0.99997
4.00	0.99997	0.99997	0.99997	0.99997	0.99997	0.99997	0.99998	0.99998	0.99998	0.99998