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Diseño y fabricación de un alimentador de varillas de aporte para proceso de soldadura GTAW

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CAPÍTULO 1

1 Introducción

En este capítulo se analizan las necesidades que tiene la industria para convertir el Proceso de Soldadura con Electrodo de Tungsteno y Protección de Gas (*GTAW, Gas Tungsten Arc Weld*) a un proceso semiautomático, también se analizan algunos trabajos que se han realizado dentro de la Universidad Autónoma de Querétaro en algunos de los cuales se han diseñado y fabricado nuevos dispositivos y en otros se han automatizado procesos o se han semiautomatizado dichos eventos. También se expone el objetivo general de este proyecto y los objetivos particulares de dicho trabajo. Al concluir el capítulo podemos conocer el porqué de éste trabajo, exponiendo algunas de las necesidades por las cuales se realiza.

1.1 Estado del Conocimiento

De acuerdo a la última publicación del INEGI (2011) acerca del Producto Interno Bruto (PIB) por entidad federativa, la industria en Querétaro participa con el 36.7% del PIB total y está compuesto por cuatro sectores: Industria manufacturera que representa el 25.8%, Construcción con 9.2%, Electricidad, Gas y agua con 1.1% y Minería con 0.6%.

De acuerdo a las estadísticas publicadas en SEDESU (2010), existen 669 empresas maquiladoras en el estado de Querétaro, de las cuales 177 son exclusivas del área metal-mecánica, las cuales son clientes potenciales para el uso del dispositivo a desarrollar.

En la actualidad no hay un dispositivo que se haya hecho o probado para este proceso, sin embargo, se tiene conocimiento que en la Universidad Autónoma de Querétaro se han hecho trabajos de diseño y construcción de nuevos dispositivos mecánicos o mecatrónicos.

2011, *Duarte Galván* en tesis de Maestría en instrumentación y control Automático, implemento un sistema de control climático de bajo costo para invernadero basado en FPGA. El factor más importante en este trabajo es resaltar el controlador de temperatura eficaz y eficiente pero a un costo accesible para poder implementarlo en un invernadero.

2009, *Govea Valladares* en su tesis de maestría en instrumentación y control automático Genero el diseño y control de un inyector para prototipado rápido en 3D, Este proyecto nos genera otra opción para el prototipado rápido, además de generar independencia de usar un software comercial.

En la facultad de ingeniería, campus san Juan del Rio en el año 2006, Mejía, *et al.*, hicieron el diseño y fabricación de un molino híbrido. Este trabajo trata del rediseño y determinación de velocidades óptimas de operación en un molino ensilador de baja sobrecarga. El molino utilizado para esta investigación fue propuesto en primera instancia en la tesis *"fabricación de un molino híbrido"*. En dicho trabajo se presenta el rediseño y manufactura de algunas partes que mejorarán la operación del molino.

En 2005, Ríos Moreno, hizo el diseño y construcción de una tarjeta controladora de servomotores mediante bus ISA. Este trabajo de investigación tiene como primer objetivo generar una independencia tecnológica en el área relacionada con los controles de posicionamiento y servosistemas ya que con la independencia tecnológica se puede generar la integración a la medida para mejorar el desempeño general de los sistemas. Se desea avanzar hacia la construcción de tarjetas didácticas de control, en este caso de movimiento, que sean competitivas en tecnología, con los productos comerciales existentes pero además que sean generadas a bajo costo. Se persigue con el desarrollo de este trabajo, la utilización de componentes digitales económicos para optimizar la velocidad de procesamiento de la información.

En 1995, Nieves, *et al.*, Desarrollaron la automatización de un proceso para lavado de tela. La tesina tuvo como principal objetivo el modernizar el proceso de lavado para telas ya que el proceso era realizado y supervisado por personas, por lo cual, el proceso de producción era peligroso y pesado a lo largo de un gran periodo de tiempo, lo cual traía como consecuencias una baja eficiencia y efectividad teniendo bajos rendimientos en la industria. Dicho proceso se logró mediante la aplicación de un controlador lógico programable por ser estos los controladores de mayor difusión.

En 1995, Gutiérrez, *et al.*, diseñaron una segueta electromecánica. Dicha segueta cumple con los requerimientos que se plantearon: ser eficiente, compacta, que su costo fuera mínimo y que sirviera para los trabajos que en un futuro se realizaran en el laboratorio de ingeniería. Una de las etapas finales consistió en la fabricación de las piezas como poleas, ejes de transmisión, bancada y la preparación de las piezas que no fueron fabricadas para su posterior ensamble del prototipo. Finalmente se escribió un manual de mantenimiento en el cual se indican los componentes que se deben cambiar periódicamente así como las partes a las que se les debe poner atención en su lubricación para su conservación, sin dejar de por medio la seguridad del usuario.

En el año de 1994, Estrada, *et al.*, hicieron el automatizado de un sistema de bombeo, dicho trabajo, nos da un ejemplo de la construcción de un sistema de control de acuerdo a su modelado matemático, nos plantea las ecuaciones que rigen el sistema como la planta y los elementos con los que cuenta el sistema de control, nos dice que el sistema de control se llevó a cabo de acuerdo al inverso de modelado. Mediante un prototipo en estado físico que representa una aproximación al modelo matemático se puso en marcha, y al no ser satisfactorio se modifico y probo nuevamente el sistema de control, el proceso continuó hasta que el prototipo resultó completamente satisfactorio.

De la misma manera se pueden encontrar más trabajos en los que se han diseñado y construido nuevos dispositivos, sin dejar a un lado las mejoras a procesos que los hacen más eficientes y eficaces que cumplen con el objetivo de mejorar los tiempos de producción en la industria.

1.2 Objetivos

General

Diseñar y construir un dispositivo que permita controlar el flujo de las varillas de aporte para el proceso de soldadura GTAW contribuyendo a la semi-automatización del proceso en su aplicación manual.

Particulares

- Analizar y diseñar el dispositivo empleando un software de diseño asistido por computadora (*CAD, Computer Aideed Design*).
- Implementar el control del dispositivo por medio de un microcontrolador.
- Realizar el ensamble digital de los componentes del mecanismo para determinar su funcionamiento.
- Realizar pruebas del proceso GTAW con y sin el dispositivo a fin de hacer un análisis comparativo visual de diversas probetas.

1.3 Justificación

Debido a que los procesos industriales evolucionan de manera ininterrumpida nos vemos en la necesidad de valernos de nuevas herramientas. La modernización industrial implica inversiones muy altas, por lo que surge la necesidad de generar tecnología propia. Los nuevos dispositivos nos ayudan a que procesos industriales en este caso la soldadura GTAW sea en cierta forma un proceso semiautomático.

En el presente trabajo se diseñará y fabricará un dispositivo que nos proporcione de manera continua la varilla de aporte para semiautomatizar el proceso de soldadura GTAW, dicho dispositivo debe cumplir con las necesidades que la industria requiere para hacer éste proceso más eficiente y versátil.

1.4 Planteamiento general

De acuerdo al planteamiento del problema, el control se realizará mediante un microcontrolador utilizando el modulador por ancho de pulso *PWM, (Pulse Width Modulation*). Éste modulador será activado en el gatillo del dispositivo, y de acuerdo a la presión ejercida en el mismo, el PWM del microcontrolador dará la velocidad deseada del motor para que así el operador controle la velocidad de salida de la varilla instantáneamente. También se propone que el dispositivo cuente con un selector, el cual nos podrá dar las opciones de la salida o alimentación de la varilla, una de ellas es obtener la varilla de forma continua e ininterrumpida, la otra de ellas, será que el dispositivo nos dé la varilla en forma de pulsos. La etapa de potencia será de fabricación propia teniendo como principal objetivo aislar la etapa de potencia de la etapa de control mediante optoacopladores.

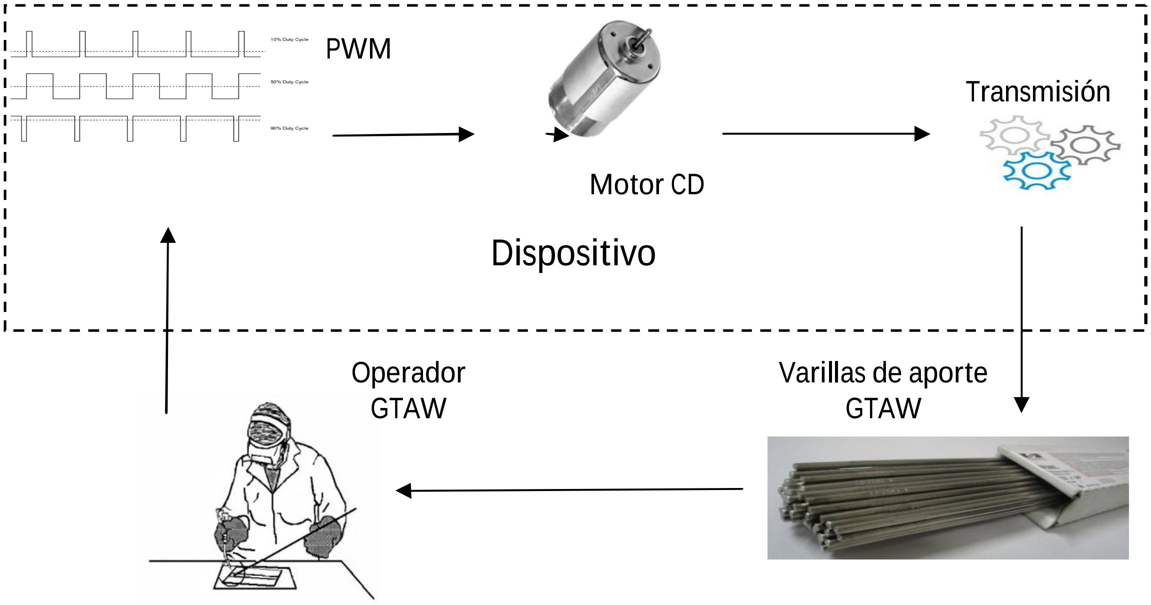


Figura 1.1 Planteamiento general del proceso del dispositivo.

CAPÍTULO 2

2 Revisión de literatura

En este capítulo se abordan algunos de los procesos de soldadura existentes y que son utilizados en la industria manufacturera, también hablaremos de la aplicación de éstos procesos y algunos de los inconvenientes que se tienen, especialmente en la aplicación de soldadura para el proceso GTAW. También se hablará de los elementos usados para el desarrollo del presente trabajo como lo son, sensores de posición, optoacopladores, rectificadores etc. Daremos las definiciones de las palabras que se utilizan para el control de procesos, mencionaremos una breve reseña de los alimentadores que actualmente existen en el mercado de los insumos para soldadura. Todos los términos que a continuación se mencionan son de acuerdo a la *American Welding Society (AWS).* Que es la sociedad americana de soldadura que se encarga de regular los procesos de soldadura.

2.1 Soldadura con arco eléctrico

La soldadura con arco eléctrico consiste en un arco sostenido que genera el calor para fundir el material de la pieza de trabajo en la cual es utilizada una varilla de aporte. Dichos eventos se muestran mejor en el ejemplo de la soldadura con electrodo de tungsteno y gas (*GTAW*).

Cuando el electrodo de tungsteno se conecta la terminal negativa de una fuente de poder (en modo de *polaridad directa* o de corriente directa de electrodo negativo, DCEN), se convierte en el cátodo; la pieza de trabajo, conectada a la terminal positiva se transforma en el ánodo (Figura 2.1 a). Un gas inerte protege a ambos electrodos. El cátodo se calienta con la corriente de soldado hasta que se alcanza la función de trabajo (la energía necesaria para desalojar los electrones) del tungsteno. La emisión inducida térmicamente (termoiónica) crea una carga espacial (una nube de electrones) en la que los electrones fluyen a la pieza de trabajo (ánodo), donde se genera la mayoría del calor (el flujo de electrones es responsable de 85% de la transferencia calorífica). En el espacio entre la punta del electrodo y la pieza de trabajo, la alta temperatura ioniza un poco el gas: los electrones son desalojados y se forma un plasma conductor de la electricidad (una mezcla neutra de electrones e iones positivos). La energía de los electrones incidentes calienta la pieza de trabajo. La zona de la soldadura a menudo es profunda y angosta (figura 2.1 b).

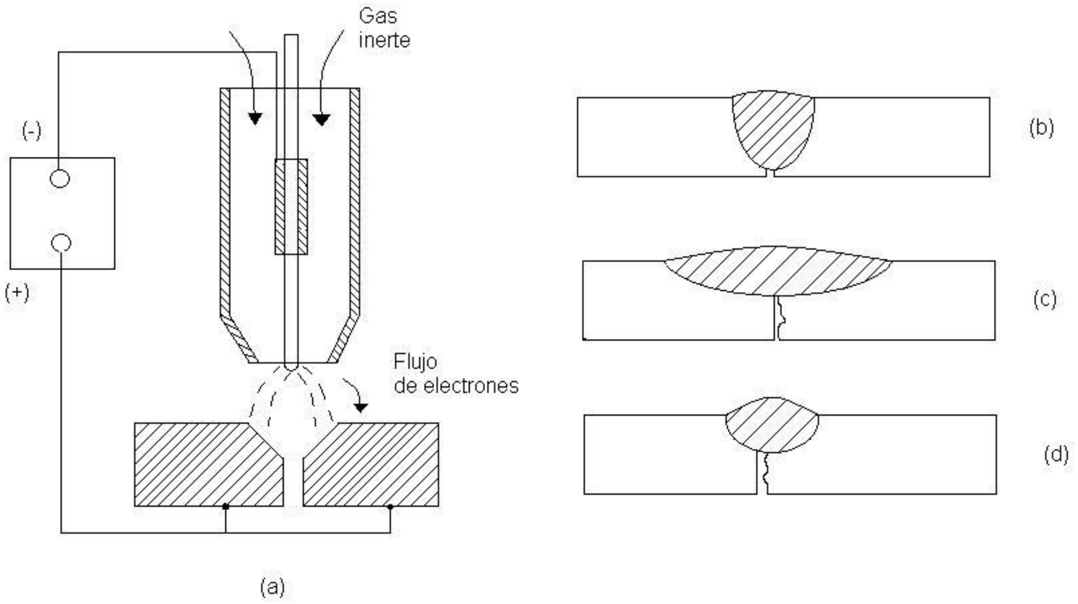


Figura 2.1 Soldadura GTAW. a) Configuración en polaridad directa; b) penetración del cordón en polaridad directa; c) polaridad inversa y d) con corriente alterna.

Cuando la polaridad se invierte, con el electrodo conectado a la terminal positiva (modo de polaridad invertida de o corriente directa de electrodo positivo, DCEP), la pieza de trabajo se convierte en el cátodo. La zona de la soldadura es más amplia y menos profunda (Figura 2.1 c); por lo tanto, este modo de operación es más adecuado para material de calibre delgado, que se quemaría completamente en el modo DCEN. La polaridad inversa tiene un efecto adicional: Las películas de óxido en las superficies de piezas de trabajo de Aluminio y Magnesio son desalojadas; de esta manera, la superficie se puede limpiar, ya sea invirtiendo la polaridad brevemente en el modo DCEN o usando una corriente CA (Figura 2.1 d).

La entrada nominal de calor *H* es la potencia dividida entre la velocidad de viaje (*v*); para un arco eléctrico, potencia = *E x I*, donde *E* es el voltaje *(v)* e *I* la corriente (A). Así,

$$H = \frac{EI}{v}\left(\frac{J}{mm}\right) \tag{2.1}$$

Como se indico anteriormente, no todo este calor alcanza la pieza de trabajo (la eficiencia del arco es menor que 1) y más calor se pierde en la zona adyacente a la soldadura. La entrada permisible de calor se limita por consideraciones metalúrgicas, y es menor cuando la pieza de trabajo es precalentada. Las altas temperaturas se mantienen por algún tiempo; por lo tanto, es esencial tener protección completa contra la atmósfera. En algunos procesos y con algunos materiales, también hay necesidad de un fundente que disuelva óxidos y los retire de la zona fundida. En forma muy general, los procesos de soldadura con arco incluyen métodos de electrodo consumible y no consumible.

2.1.1 Soldadura con electrodo consumible

En este grupo de procesos el electrodo consumible es un metal que se funde par hacerse parte del cordón de soldadura. A menudo su composición es diferente de la de los metales base. La zona de la soldadura está protegida por un gas o un fundente.

Soldadura con arco metálico y gas (GMAW)

El electrodo metálico consumible, alimentado por medio de la pistola para soldar, está protegido por un gas inerte, de ahí el viejo acrónimo soldadura MIG (*metal-gas inerte)*. Es adecuada para la mayoría de los metales. Igual que con la GTAW, no se forma escoria y se pueden acumular varias capas con poca o ninguna limpieza intermedia. El argón es un gas adecuado para todos los materiales; algunas veces se prefiere helio debido a su mayor potencial de ionización y, por lo tanto, mayor rapidez de generación de calor- para la soldadura de aluminio y cobre; el Ar con entre 2 y 3% de CO_2 o CO_2 puro generalmente se emplea para aceros al carbono; también se están introduciendo los gases especiales, adaptados para tareas especificas.

El electrodo de alambre se suministra en longitudes grandes enrolladlas que permiten soldaduras en cualquier posición de soldado. En la soldadura semiautomática, el soldador guía la pistola y ajusta los parámetros del proceso; en la soldadura automática, todas las funciones son asumidas por la máquina de soldar o robot, La soldadura en el sitio puede ser difícil porque las corrientes de aire soplan el gas protector de la zona de soldadura.

Soldadura con electrodo revestido (SMAW)

Este tipo de soldadura es uno de los procesos de unión de metales más antiguos que existe, su inicio data de los años 90 del siglo XVIII. En la que se utilizaba un electrodo de carbón para producir el arco eléctrico, pero no es sino hasta 1907, cuando se desarrolla el método de soldadura con electrodo recubierto (*SMAW, Shielded Metal Arc Welding*). Fue el primer método aplicado con grandes resultados, no solo de orden técnico, sino también de orden económico, ya que este proceso permitió el desarrollo de procesos de fabricación mucho más eficaces, y que hasta hoy en día solamente han sido superados por modernas aplicaciones, pero que siguen basándose en el concepto básico de la soldadura al arco con electrodo auto protegido.

2.1.2 Soldadura con electrodo no consumible

En estos procesos, el electrodo no se funde y el metal del a soldadura es suministrado por el flujo de metal base (soldadura autógena) o, para lámina gruesa (> 3 mm de espesor), por medio de una varilla separada de material de aporte.

Soldadura de Tungsteno con arco eléctrico y gas (GTAW)

Como se indicó, el arco se mantiene entre la pieza de trabajo y el electrodo de tungsteno protegido por un gas inerte (de ahí el antiguo nombre de *soldadura de tungsteno con gas inerte* o *soldadura TIG, (*Figura 2.2).

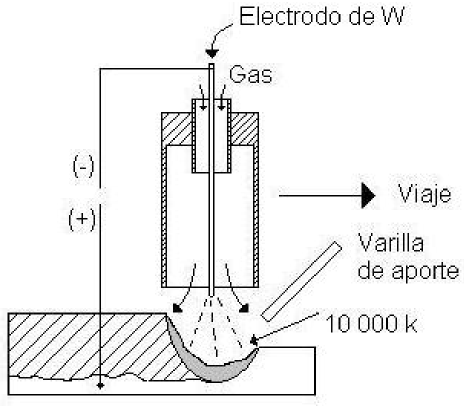


Figura 2.2 El arco se protege con gas en los procesos de soldadura con arco y gas inerte

La atmósfera protectora es provista por el argón, el cual tiene un potencial de ionización menor y por ello precisa menos voltaje (alrededor de 10v), pero proporciona un arco eléctrico menos caliente y una penetración menos profunda que el helio. La polaridad es DCEN excepto para aluminio y magnesio, donde la CA es útil para quitar el óxido.

Para producir el arco eléctrico. La emisión de electrones y la ionización del gas se inician retirando el electrodo de la superficie de trabajo de manera controlada, o con la ayuda de un arco iniciador. Una corriente de alta frecuencia, superpuesta a la corriente alterna o directa de soldado, ayuda a comenzar el arco y también lo estabiliza.

Las operaciones manuales como automáticas son posibles. El proceso exige una habilidad considerable, pero produce soldaduras de muy alta calidad en casi cualquier material, en cualquier posición de soldado y también en calibres delgados (menores de 6 mm). La zona de la soldadura es visible y no hay chisporroteo de soldadura o formación de escoria, aunque las partículas del electrodo pueden entrar a la soldadura si el electrodo se sobrecalienta o toca el baño de soldadura

Actualmente no hay en el mercado de los insumos de soldadura algún dispositivo que nos proporcione de manera semiautomática la varilla de aporte para el proceso de soldadura GTAW.

Soldadura con arco de plasma (PAW)

Primero, el arco se produce entre el electrodo y la boquilla aplicando un voltaje de alta frecuencia. Luego se acerca el soplete a la pieza de trabajo (Método de operación de arco de plasma transferido). A densidades bajas de corriente, en el modo de fusión interna, la zona de la soldadura es similar en forma a la soldadura con arco; a altas densidades de corriente, el modo agujero de cerradura prevalece y el metal resolidifica atrás del haz de plasma móvil. En la técnica de arco transferido, la boquilla de construcción es conectada a la terminal positiva; el arco se produce entre el electrodo y la boquilla y calienta la pieza de trabajo por radiación. Esta técnica también se utiliza para el rocío de plasma. (Schey, 2005).

2.2 Sensores y actuadores

La creciente presencia de sistemas digitales para el tratamiento y presentación de la información en los sistemas de medida y control, hace muy atractivos aquellos sensores que ofrecen directamente a su salida una señal en forma digital, por la simplificación que suponen en el acondicionamiento de señales y su mayor inmunidad a las interferencias electromagnéticas en determinados casos. Ofrecen directamente una señal digital a partir de una entrada analógica.

2.3 Controladores

El control automático ha desempeñado un papel vital en el avance de la ingeniería y la ciencia. Además de su gran importancia en los sistemas de vehículos espaciales, de guiado de misiles, robóticos, el control automático se ha convertido en una parte importante e integral de los procesos modernos industriales y de fabricación. Por ejemplo el control automático es esencial en el control numérico de las máquinas-herramienta de las industrias de manufactura, en el diseño de sistemas de pilotos automáticos en la industria aeroespacial, y en el diseño de automóviles y camiones en la industria automotriz. También es esencial en las operaciones industriales como el control de presión, temperatura, humedad, viscosidad y flujo en las industrias de proceso.

2.3.1 Microcontroladores

Los microcontroladores están conquistando el mundo. Están presentes en nuestro trabajo, en nuestra casa y en nuestra vida, en general. Se pueden encontrar controlando el funcionamiento de los ratones y teclados de las computadoras, en los teléfonos, en los hornos de microondas y los televisores de nuestro hogar.

Controlador y microcontrolador

Recibe el nombre de controlador el dispositivo que se emplea para el gobierno de uno o varios procesos. Por ejemplo, el controlador que regula el funcionamiento de un horno dispone de un sensor que mide constantemente su temperatura interna y, cuando traspasa los límites prefijados, genera las señales adecuadas que accionan los actuadores que intentan llevar el valor de la temperatura dentro del rango estipulado.

Aunque el concepto de controlador ha permanecido invariable a través del tiempo, su implementación física ha variado frecuentemente. Hace tres décadas, los controladores se construyan exclusivamente con componentes de lógica discreta, posteriormente se emplearon los microprocesadores, que se rodeaban con chips de memoria y E/S sobre una tarjeta de circuito impreso.

Aplicaciones de los microcontroladores

Cada vez existen más productos que incorporan un microcontrolador con el fin de aumentar sustancialmente sus prestaciones, reducir su tamaño y costo, mejorar su fiabilidad y disminuir el consumo. Algunos fabricantes de microcontroladores superan el millón de unidades de un modelo determinado producidas en una semana. Este dato puede dar una idea de la masiva utilización de estos componentes. Los microcontroladores están siendo empleados en multitud de sistemas presentes en nuestra vida diaria, como pueden ser juguetes, hornos de microondas, frigoríficos, televisores, computadoras, impresoras, módems, el sistema de arranque de nuestro coche, etc. Y otras aplicaciones con las que seguramente no estaremos tan familiarizados como instrumentación electrónica, control de sistemas en una nave espacial, etc. Una aplicación típica podría emplear varios microcontroladores para controlar pequeñas partes del sistema. Estos pequeños controladores podrían comunicarse entre ellos y con un procesador central, probablemente más potente, para compartir la información y coordinar sus acciones, como, de hecho, ocurre ya habitualmente en cualquier PC. (Barrón Zambrano José Hugo, Gustavo Cerda Villafaña. Manual de Microcontrolador 16F873. Universidad de Guanajuato. F I M E E)

2.4 Transmisión de movimiento

En muchas máquinas, se hace necesaria la transmisión de movimiento de rotación entre dos ejes, y a menudo se requiere que la relación entre las velocidades angulares entre estos dos ejes sea constante e independiente de la configuración. Para conseguirlo, se utilizan ruedas de fricción, correas, cadenas o engranajes.

2.4.1 Transmisión de la rotación entre ejes

La transmisión de la rotación de un eje a otro es necesario por motivos tales como:

La existencia de ejes no coincidentes por razones funcionales. Este es el caso del diferencial de un vehículo con motor longitudinal, necesario para transmitir el movimiento de la salida de la caja de cambios a las ruedas.

La necesidad de establecer una relación de velocidades precisa entre dos ejes. Por ejemplo el ciclo termodinámico de un motor de 4 tiempos impone que el árbol de levas gire exactamente a la mitad de velocidad que el cigüeñal, o la aguja horaria de un reloj mecánico ha de girar a una velocidad angular 1/60 de la correspondiente a la minutera.

2.4.2 Relación de transmisión

En un mecanismo de transmisión, el cociente τ entre la velocidad angular ω_2 del eje conducido o de la salida y la velocidad angular ω_1 del eje conductor o de entrada se denomina *relación de transmisión.*

$$\tau = \frac{\omega_2}{\omega_1}$$

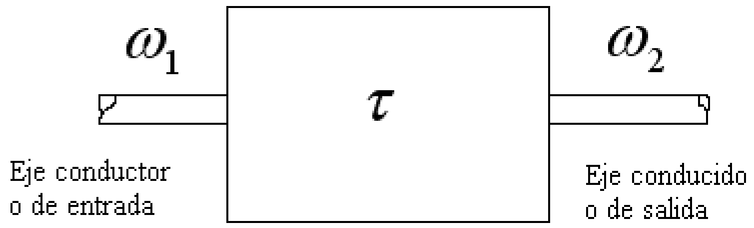


Figura 2.3 Relación de transmisión τ

El signo de esta relación de transmisión depende del criterio de signos escogido para definir las velocidades angulares.

En este trabajo es importante conocer la relación de transmisión que cuenta el mecanismo utilizado para determinar la velocidad a la que sale la varilla de aporte, ya que una alta velocidad de salida nos puede traer consecuencias perjudiciales en la aplicación de el aporte.

2.4.3 Tornillo sin fin

En los engranajes sin fin los arboles se cruzan formando un Angulo de 90°. Estos engranes permiten grandes relaciones de transmisión y producen autoretención cuando el tornillo es de un hilo.

El tornillo sin fin es la parte impulsora de un mecanismo y es similar a un tornillo de movimiento. El tornillo sin fin impulsa una rueda helicoidal. Puede ser de uno o varios pasos y a derechas o a izquierdas. Los dientes de la rueda helicoidal pueden compararse con una parte de una tuerca que engrane parcialmente sobre un perno roscado. Los engranes de tornillo sin fin son apropiados para grandes relaciones de transmisión de de hasta τ = 60:1 (60 vueltas del tornillo sin fin : una vuelta de la rueda helicoidal). Esta relación es válida también para las fuerzas a transmitir. Los engranes sin fin marchan silenciosamente y pueden transmitir grandes potencias. (Carmona Foix, 2001.)

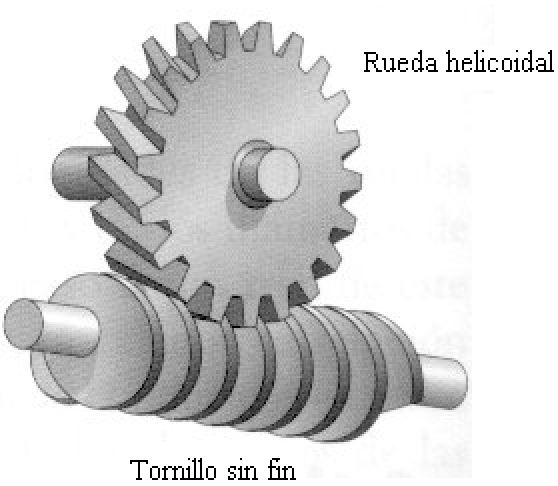


Figura 2.4 Engrane de tornillo sin fin.

2.5 Alimentadores de alambre

A continuación se muestran algunos de los alimentadores de alambre que se encuentran en el mercado de los insumos de soldadura, dichos alimentadores solo sirven para procesos de soldadura GMAW los cuales no se pueden utilizar en el proceso GTAW. De hecho, no existen en el mercado local e internacional alimentadores de varillas o de alambre para realizar el proceso GTAW semiautomático. Existen únicamente alimentadores especializados de aporte para soldadura GTAW robotizada.

MODELOR-115

Alimentador universal que puede ser conectado a cualquier fuente de poder que suministra 115 VCA a través del cable de interconexión adecuado, ver Figura 2.5.

Precio aprox: $1301.8 USD.

Figura 2.5 Maquina de alimentación de alambre de aluminio marca Miller modelo R-115

Spoolmate™ 3035

Pistola tipo "Spool" diseñada para aplicaciones industriales ligeras con capacidad nominal de 150 A al 60% ciclo de trabajo para alimentación de alambres de aluminio Figura 2.6.

Precio aprox: $616.40 USD

Figura 2.6 Pistola para alimentación de alambre marca Miller modelo Spoolmate™ 3035.|

Spoolmatic-15a

Pistola para alimentar alambre de aluminio para aplicaciones livianas e industriales pesadas. Reparaciones automotrices y marinas Figura 2.7.

Precio aprox: $ 972.44 USD

Figura 2.7 Pistola para alimentación de alambre de aluminio de la marca Miller modelo Spoolmatic-15ª

De la misma manera podemos encontrar muchos más accesorios que nos proporcionen el alambre utilizado para el tipo de soldadura antes mencionado. Cabe señalar que el precio de estas herramientas es en dólares y además deben de contar con un sistema de control que les ayude a regular la velocidad, corriente, flujo de gas y demás cosas necesarias para su correcto funcionamiento, lo cual incluye controladores que van desde 1500 hasta 2100 USD.

Es por ello que surge la necesidad de hacer un alimentador de varillas a bajo costo y que cumpla con los estándares de calidad de los productos antes mencionados, y que además cumpla el objetivo de semiautomatizar el proceso de soladura GTAW.

2.6 Diseño y manufactura asistida por computadora

Para el Diseño del dispositivo se utilizó un software de CAD, De acuerdo a las necesidades, el más adecuado para el diseño y ensamble del dispositivo es el sofware llamado Inventor en su versión 2008, en el cual es posible dibujar y simular las partes móviles que contiene el dispositivo.

Una de las ventajas que ofrece dicho software es el diseño de partes móviles para su posterior ensamble que nos acerca a la realidad del funcionamiento de partes móviles y además dar restricciones de distancias y tolerancias en partes no móviles, dicho software permite analizar el dimensionamiento y dar una aproximación a las medidas deseadas para un usuario estándar.

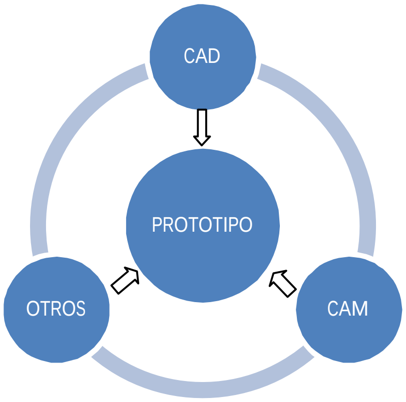


Figura 2.8 proceso para proceso de manufactura asistida por computadora

Para la fabricación del dispositivo se utilizó un software CAM (*Computer aided Manufacturing)* que es Visi CAM, siendo este un software que se adapta a las necesidades de manufactura de las carcasas del dispositivo en *Naylamid*. Dicho software nos permite observar los movimientos de las herramientas que se utilizan para poder generar una pieza con simulaciones que nos aproximan a la realidad de un centro de maquinado CNC(*Control numérico por computadora)* dicho software es capaz de generar un código con las instrucciones necesarias para la manufactura que posteriormente es enviado al centro de maquinado para la manufactura de cualquier pieza.

CAPÍTULO 3

Diseño a detalle

Este capítulo se enfoca a la construcción del dispositivo comenzando por las necesidades que se tienen y de las limitantes que tenemos tanto para la obtención de los materiales así como de la disponibilidad en el mercado de dichos materiales. También se describen los elementos utilizados y su justificación de por qué fueron utilizados para el dispositivo.

3.1 Descripción de necesidades

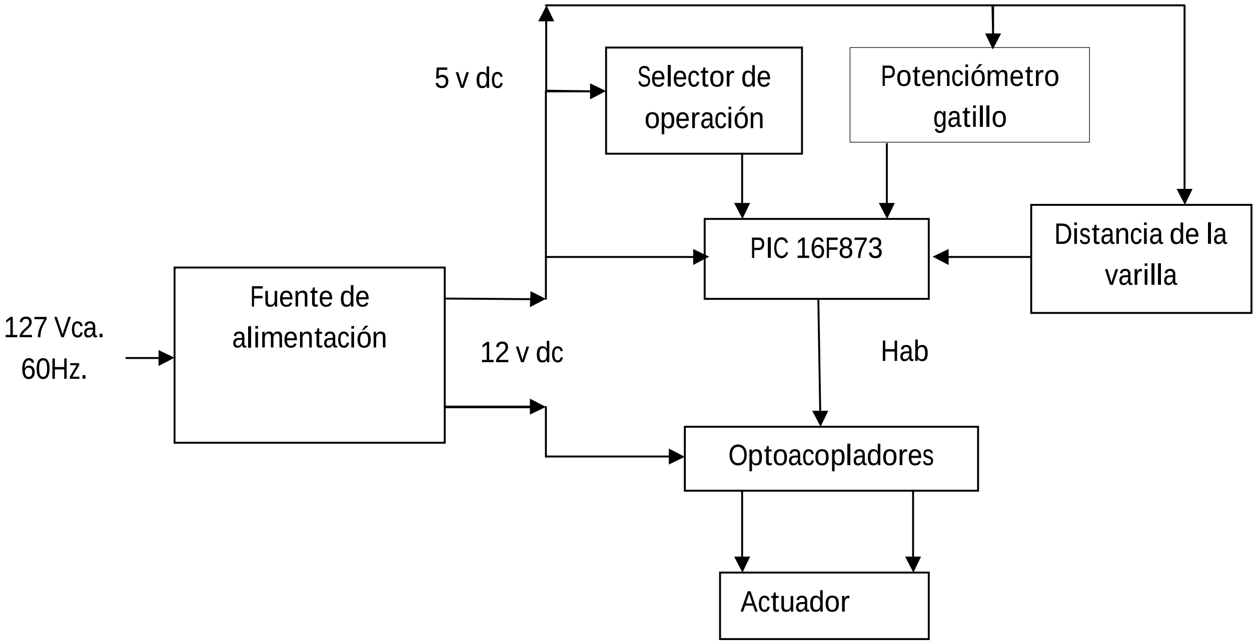
Anteriormente se expuso el proceso de soldadura GTAW, y los objetivos del presente trabajo. La primera necesidad que se tuvo para el comienzo del proyecto fue el diseñar una transmisión para poder impulsar la varilla de aporte. Al principio del proyecto se propuso realizar la transmisión, sin embargo el desarrollo de una transmisión para el dispositivo nos implicaría un mayor tiempo para el desarrollo del mismo. Al adentrarnos al proyecto se nos hizo notar que los dispositivos comerciales para la aplicación de la soldadura GMAW contaban con dicha transmisión, por lo cual, se optó por comprar una pistola para la aplicación de la soldadura GMAW y modificarla para su uso en el proceso GTAW.

En la Figura 3.1 se muestra la transmisión adquirida para la utilización en el nuevo dispositivo.

Figura 3.1 Transmisión de movimiento adquirida para la impulsión de varilla de aporte.

Dicha transmisión cuenta con un motor impulsor de corriente directa y un tornillo sin fin para la reducción de velocidad y poder aumentar el torque del motor. Debemos resaltar una de las ventajas de adquirir dicha transmisión, ya que cuenta con un tornillo sin fin para el cambio de dirección del eje impulsor, lo cual nos da una ventaja al ser una transmisión autobloqueante. Otra de las ventajas es que el motor que utiliza es un motor de corriente directa que para fines de control es óptimo para utilizar el control de velocidad por medio de un PWM.

A continuación en la figura 3.2 se muestra el diagrama general a bloques de todos los elementos con los que va a contar nuestro dispositivo.



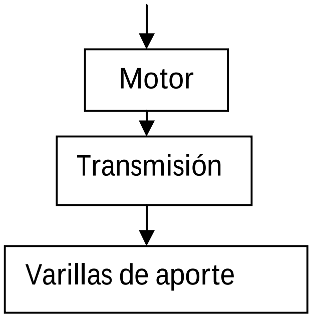


Figura 3.2 Diagrama a bloques de todos los elementos del dispositivo

El dispositivo planteado consiste en una forma de pistola en la que se le introduzca la varilla de aporte y de acuerdo a la presión que se haga en el gatillo, la pistola irá dando gradualmente el aporte, dicho dispositivo se plantea de la siguiente forma (figura 3.3).

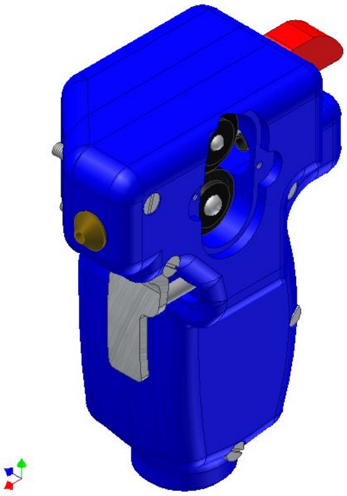


Figura 3.3 modelo del dispositivo para la semiautomatización del proceso de soldadura GTAW.

3.2 Implementación del control

De acuerdo a la investigación de proceso de soldadura GTAW no existen datos de la semiautomatización del proceso por lo cual no hay datos de velocidades de avance u otros que puedan datos precisos para la aplicación semiautomática del proceso, es por eso que el sistema de control a utilizar en este proyecto es un sistema de control en lazo abierto, ya que en este caso es única mente criterio del operador, el dar la velocidad de avance y cantidad de material de aporte en un proceso de soldadura, por lo cual el control será un controlador proporcional. En laso abierto, teniendo como criterio de retroalimentación únicamente al soldador.

Para el control del dispositivo se propuso el uso de un microcontrolador *PIC* por ser estos de un costo accesible y por tener en su estructura de programación un modulador por ancho de pulso.

El PIC propuesto es el PIC16F873,dicho PIC contiene dos puertos habilitados con un convertidor analógico-digital (*ADC*, *Analogic Digital Converter)*. La ventaja de tener el ADC es que con el uso de un potenciómetro podemos dar una referencia de entrada y así poder controlar el PWM del PIC.

El lenguaje de programación para el microcontrolador es en código C, por contener librerías y arquitecturas predefinidas para este tipo de microcontroladores.

El control a utilizar se procederá a hacer mediante un control clásico en lazo abierto como se muestra en la figura 3.1

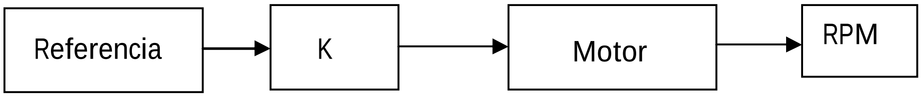


Figura 3.4 Diagrama a bloques del control del dispositivo

En donde:

- La referencia es suministrada por el usuario en el potenciómetro
- El bloque proporcional (K) se encuentra en el PIC.

Para el sistema de control que se utiliza en el dispositivo es necesario tomar en cuenta las funciones que se necesitan para un funcionamiento correcto del mismo.

Parámetros de operación

Para la fabricación del control debemos tener en cuenta los parámetros de operación que se requieren en los distintos tipos de procesos de soldadura, en la fabricación del dispositivo se engloban dichos parámetros, los cuales deben ser tomados en cuenta para la implementación del control.

- El dispositivo nos entregará las varillas de aporte a una velocidad máxima de 1 metro por minuto.
- El gatillo del dispositivo controlará la velocidad de salida de la varilla de aporte.
- El dispositivo nos entregara las varilla de aporte de forma continua o de forma pulsada, dichos parámetros se han establecido de acuerdo a algunos procesos de soldadura ya que así lo requieren.

En la Figura 3.2 se muestra el diagrama de flujo del programa en el PIC, dicho programa empieza con la lectura de un pin del puerto B, dicha lectura es para determinar si existe una señal en alto o bajo, esto para determinar qué tipo de función va a realizar el programa, realizado esto, si el PIC detecta que existe una señal en alto entra a la función de dar la varilla de aporte de forma continua, estableciendo así la frecuencia del PWM y estableciendo el puerto A como entradas analógicas, para poder leer la referencia del potenciómetro en el gatillo. De otra manera, si al encender el dispositivo el programa detecta la señal del puerto B en bajo, el programa entra a la rutina de dar la varilla de forma pulsada, esta función inicializa el puerto A como entradas analógicas estableciendo el puerto AN0 como la referencia del potenciómetro del gatillo y la entrada AN1 como la entrada del potenciómetro de la caja, para este modo el potenciómetro controla el ciclo activo del PWM, y el potenciómetro de la caja controla la frecuencia del PWM. La selección de la función en el PIC mediante la señal en alto o bajo del puerto B se lleva a cabo con un *switch* rotatorio en la parte superior de la caja.

En la Figura 3.5 se muestra el diagrama de flujo que se realizo para obtener el control del dispositivo, dicho diagrama sirvió para realizar el programa de control en el PIC.

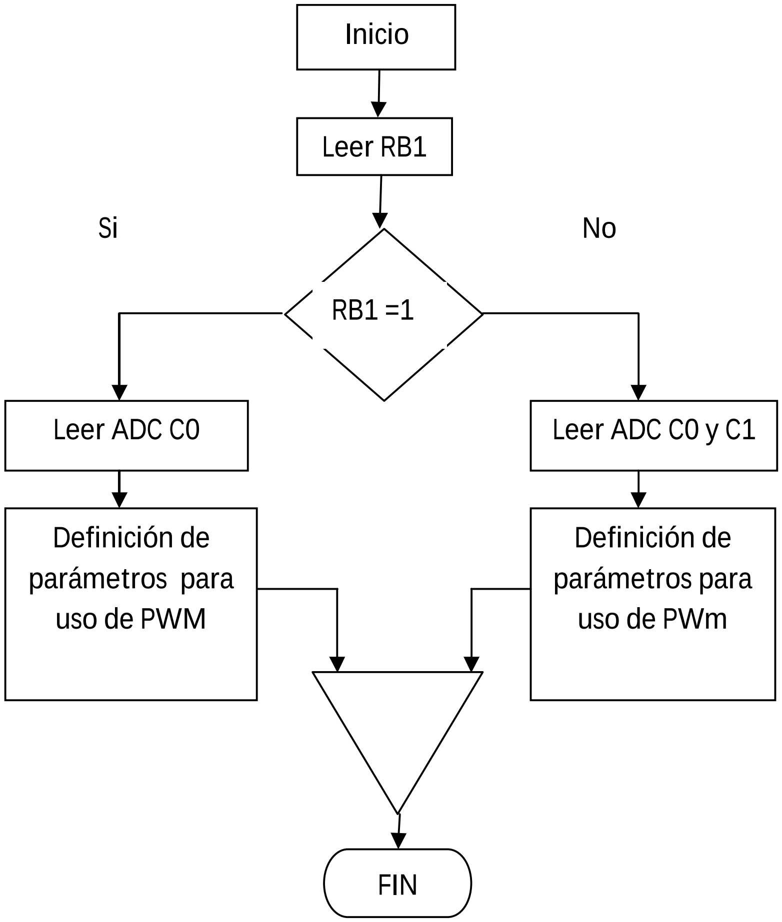


Figura 3.5 Diagrama de flujo del programa en el PIC

En la Figura 3.6 se puede observar en su forma esquemática la primer tarjeta de control diseñada para el prototipo, dicha tarjeta fue realizada a través de un circuido esquemático en *ISIS* de *Proteus* en su versión 7.6.

Para la fabricación de la tarjeta se tomaron en cuenta parámetros que se requieren para ciertos tipos de soldadura, el principal problema fue que el proceso de soldadura de aluminio requiere de una alta frecuencia interpuesta en la corriente de soldadura, esta alta frecuencia enciende el arco eléctrico a una distancia aproximada de 1.5 cm de la pieza de trabajo, con lo cual al hacer pruebas preliminares, el sistema de control resulto dañado a causa de la alta frecuencia aún estando el sistema aislado por medio de optoacopladores, por ello se llegó a la conclusión de tener un sistema de potencia totalmente aislado de la etapa de control, por lo cual se opto por tener el sistema de optoacoplamiento por medio de un LED Infrarrojo, ya que estos nos permiten tener una distancia más grande que la que nos puede proporcionar un sistema de acoplamiento encapsulado en un circuito integrado.

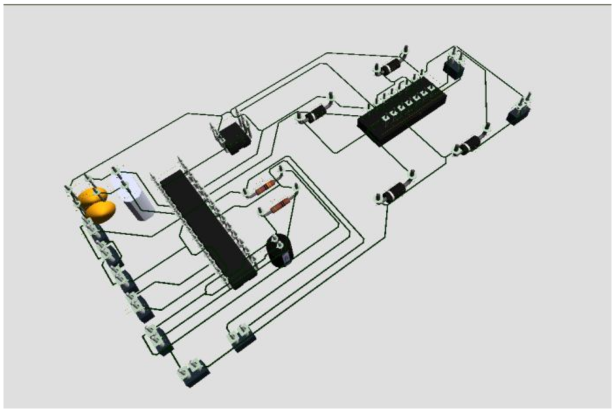


Figura 3.6 Modelo esquematico de primer tarjeta de control.

Por lo antes mencionado se realizó una tarjeta de control, y una de potencia totalmente separadas, ambas optoacopladas por LEDs infrarrojos, también lo mejor posible aisladas y separadas de la caja que las contiene, para esto ambas se colocaron sobre madera que posteriormente se instaló mediante pernos que la separan totalmente de la superficie de aluminio, en la Figura 3.7 se muestra la disposición final de las tarjetas de control y potencia.

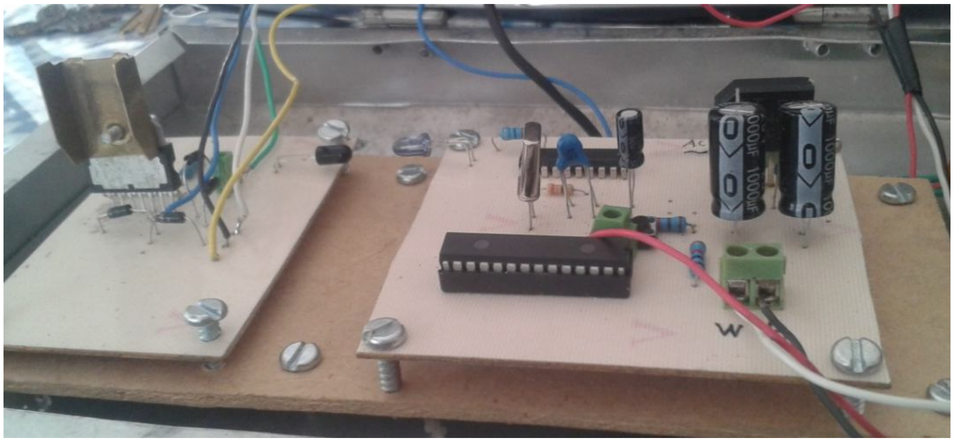


Figura 3.7 Tarjetas de control (derecha) y potencia (izquierda).

Todos los elementos se introdujeron en una caja de aluminio de fabricación propia, en dicha caja se encuentran la fuente de alimentación de 5 v y 12 v, también el botón de encendido, el potenciómetro para la función de pulsos y la perilla para la selección de operación.

En la Figura 3.8 se muestran las partes de las que consta la caja que contienen la fuente de alimentación y el control del dispositivo.

Figura 3.8 Caja de aluminio que contiene los elementos de control.

La comunicación del dispositivo con la caja de control y potencia se hiso mediante un cable blindado de 6 hilos, utilizando solo 5 de ellos, 3 para la utilización del potenciómetro y 2 para la conexión del motor, el blindaje del cable se adecuó y se aterrizó a la caja de aluminio. En la figura 3.9 se muestra el conector DB9 que se utilizo para la conexión del dispositivo y la caja, se optó por este conector, ya que no existe la posibilidad de conectar de manera errónea el dispositivo. En caso de realizar una conexión equivocada, esto pudiera dañar seriamente tanto al potenciómetro como a los circuitos electrónicos de control del proyecto.

Figura 3.9 Conector DB9 para la comunicación con dispositivo.

3.3 Ensamble digital del prototipo en inventor

El ensamble del prototipo se hizo totalmente en el software *Inventor* por proporcionarnos una gran cantidad de utilidades para este proceso, a continuación se muestran los ensambles de las tapas y de los elementos mecánicos que contiene el dispositivo.

Anteriormente mencionamos que para la transmisión mecánica de nuestro dispositivo utilizaremos una reducción de un dispositivo para la aplicación de microalambre, dicha transmisión ha sido dibujada y planteada en el software de CAD antes mencionado.

Aunque la transmisión no fue de fabricación propia se opto por modelar las partes adquiridas, ya que para tener un idea del dimensionamiento general de las tapas, es necesario tener las medidas apropiadas de las partes que contendrá el dispositivo. Por tal razón a continuación se muestran las partes del modelado de la transmisión del dispositivo.

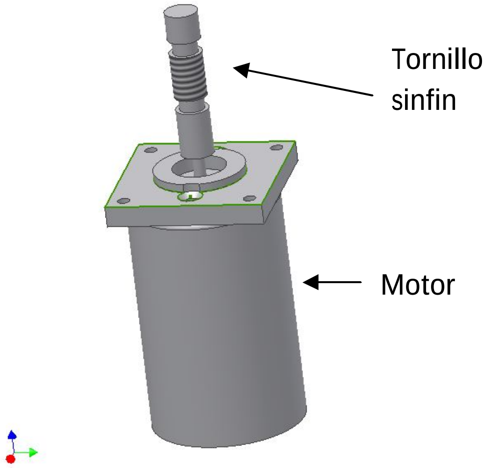


Figura 3.10 Modelado del motor adquirido .

El motor mencionado anteriormente es un motor de corriente continua, el motor se probó adecuadamente a voltajes de 9v y 12v. Se eligió trabajar a los 12 v ya que a este voltaje nos proporciona la velocidad de la varilla sin algún problema de tiempo.

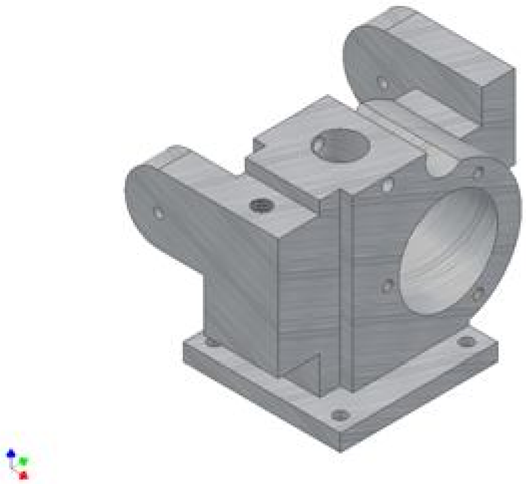


Figura 3.11 Modelo de la caja de transmisión adquirida para el prototipo.

La caja de transmisión adquirida mostrada en la Figura 3.11 es una pieza sólida de aluminio, se observa que fue fabricada por vaciado y después algunas partes de contacto fueron rectificadas para un mejor acoplamiento de las piezas.

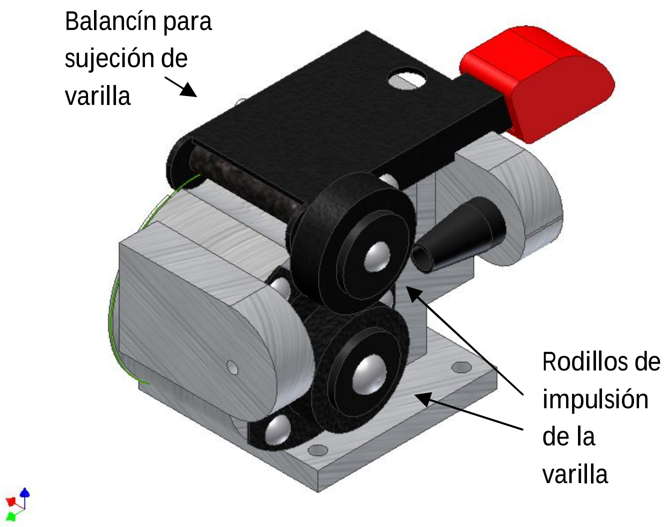


Figura 3.12 Modelo de la caja de transmisión.

En la Figura 3.12 se muestran los componentes de la transmisión con el ensamble de los rodillos impulsor e impulsado así como el balancín que ayuda a la sujeción de la varilla de aporte, dicha caja de transmisión aloja el tornillo sin fin y la rueda helicoidal que se acopla al eje de el rodillo impulsor.

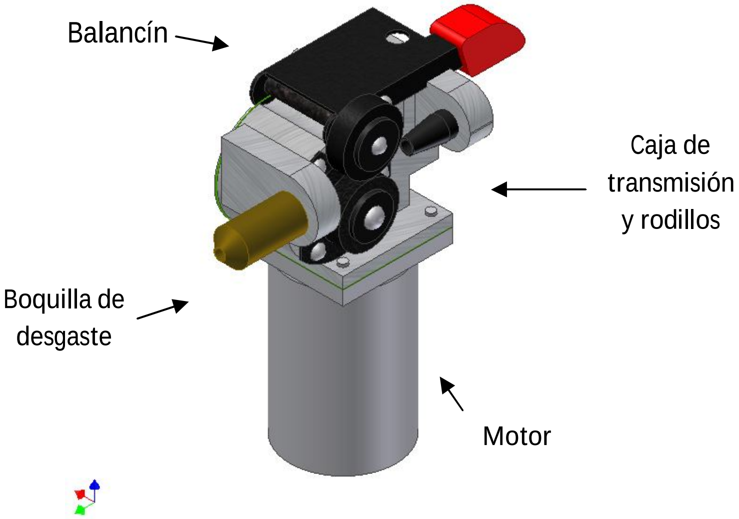
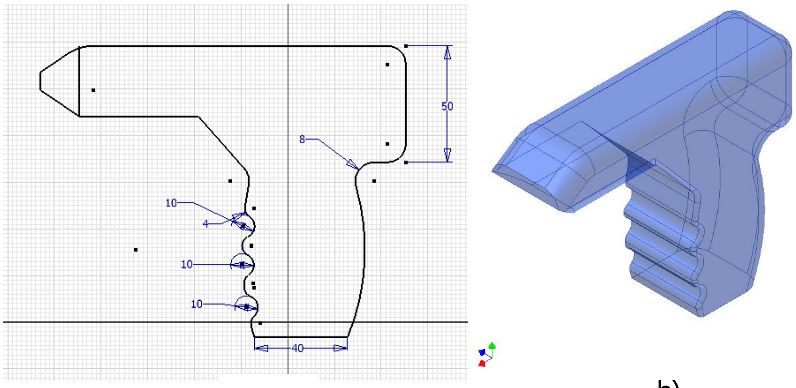


Figura 3.13 Ensamble total de la transmisión.

En la Figura 3.13 se muestra el ensamble total de la trasmisión mecánica para la impulsión de las varillas de aporte, a dicha transmisión se le fabricó una boquilla de latón para evitar el desgaste del aluminio de la caja de transmisión. Dicha boquilla se fabrico en latón por ser este material de una baja dureza y por ser utilizado para aplicaciones en las que se requiere se desgaste el material que no afecte el funcionamiento del dispositivo.

Para el modelado de las tapas se partió de las necesidades que se tenían para alojar la transmisión que se adquirió para dicho dispositivo. En la figura 3.14 se muestra el primer modelo que se propuso para alojar la transmisión mecánica.



a)

b)

Figura 3.14 Primer modelo de las tapas del dispositivo a) Sketch de origen b) Diseño final .

A dicho modelo se le ajustaron algunos requerimientos; que la parte de la salida de la varilla no fuera tan larga para evitar así un desperdicio de material de aporte, el mango no necesita tener la forma para dedos, ya que al soldar con el proceso GTAW el operador debe usar una protección en las manos generalmente guantes de carnaza, con lo anterior se modifico el diseño anterior y se obtuvo el modelo mostrado en la figura 3.15

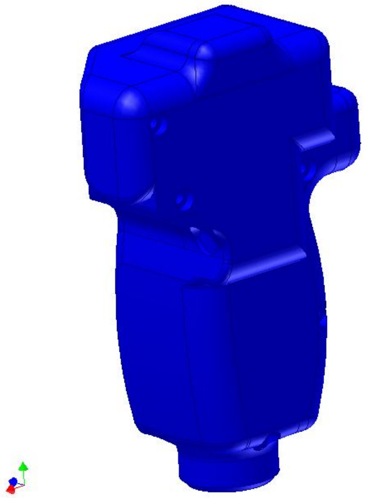
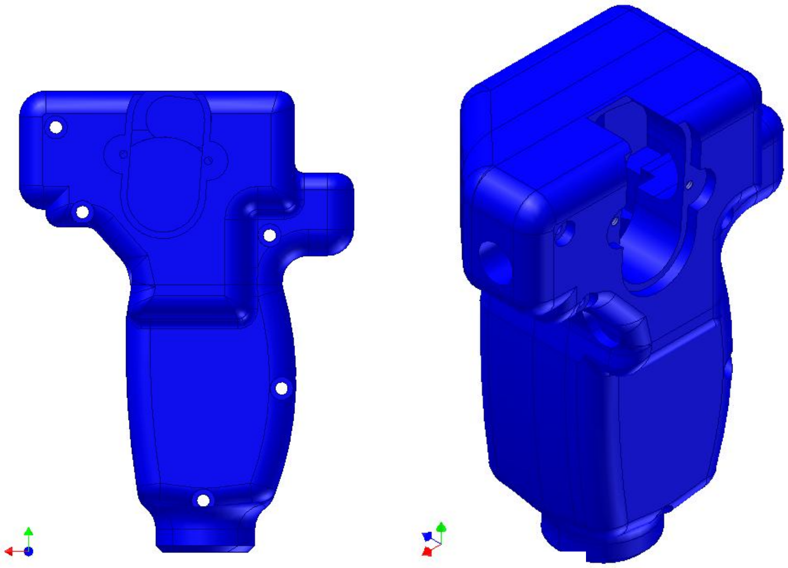


Figura 3.15 Segundo modelo de las tapas del dispositivo.

En la Figura 3.16 se muestra el segundo modelo de las tapas del dispositivo, a dicho modelo se le corrigió la distancia de la salida de la varilla para evitar un desperdicio innecesario de material de aporte, también se eliminaron las partes de las formas de los dedos por no tener alguna función, ni de poder sujetar realmente y con ergonomía el dispositivo, dicha supresión facilito el maquinado de las tapas al no tener formas tan complejas para la generación de los códigos.

En este modelo se consideraron los requerimientos que se tenían de alojar la transmisión de movimiento, también se considero el lugar donde va montado el potenciómetro para la referencia del usuario, también se consideraron los espacios de los rodillos, estos espacios se hicieron totalmente hasta la parte de afuera, considerando que para cambiarlos por unos de tamaño de impulsión mayor o menor no sea necesario abrir todo el dispositivo para un cambio de rodillos, también se considero el espacio del gatillo, dicho espacio fue considerado para alojar el gatillo y de la misma manera sostener las tapas del dispositivo, la sujeción del gatillo se hiso mediante el tornillo que también sostiene a las tapas.



a) b)

Figura 3.16 Modelo final de las tapas del dispositivo; a) vista de planta, b) vista isométrica.

Finalmente y pensando en el ensamble de las tapas, se optó por partir por la mitad el modelo del dispositivo, sin embargo al ver la forma de ensamble, éste no permitía la correcta adecuación de los componentes internos como la transmisión y el potenciómetro por lo cual el modelo se izo de tal forma que dichos elementos pudieran ensamblar sin ningún problema quedando una especie de escalón siendo esta la forma óptima en tanto a ensamblado y el maquinado del material.

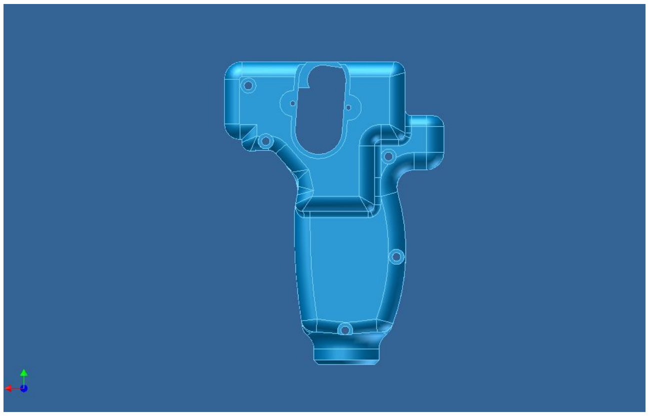
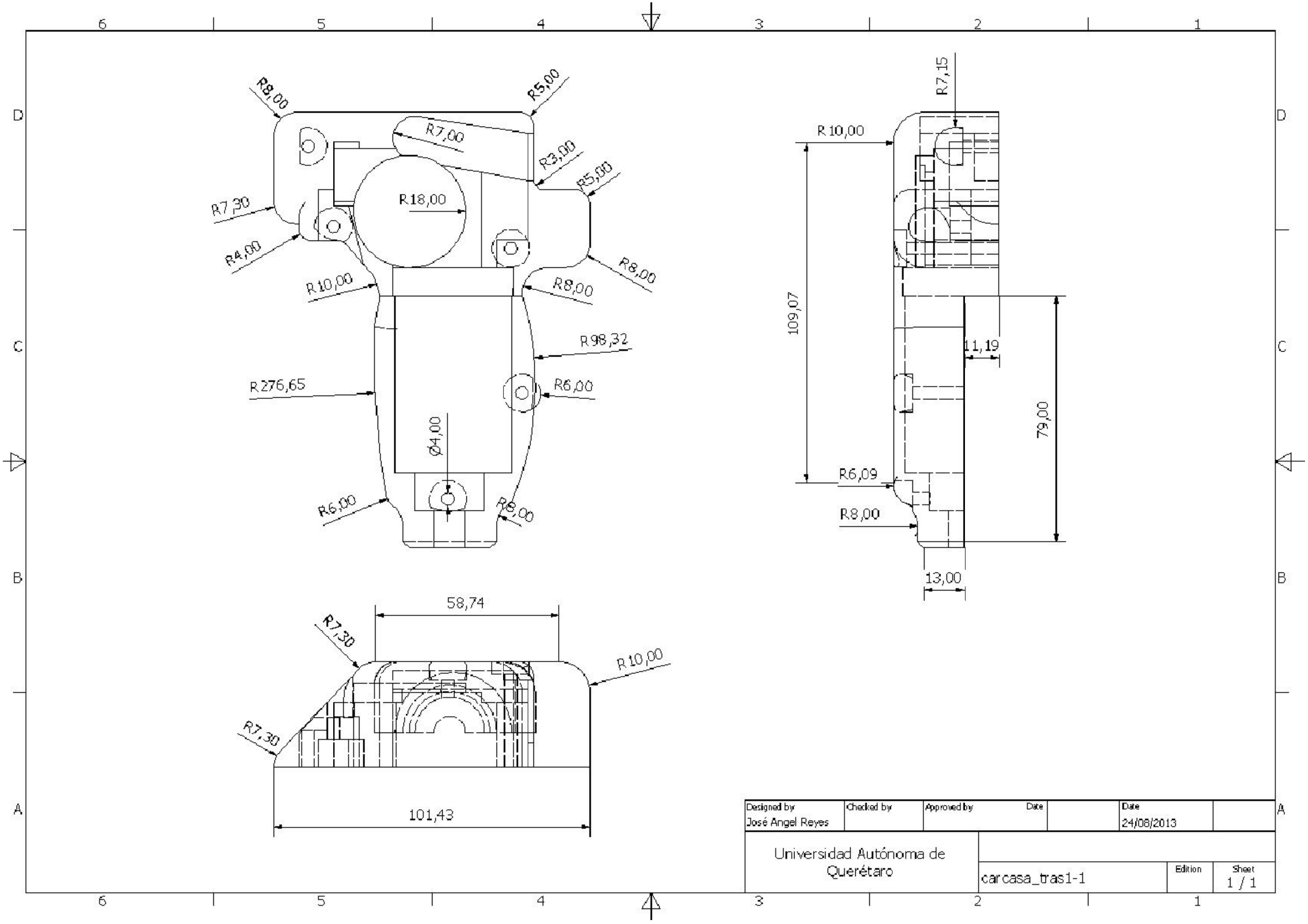


Figura 3.17 Modelado de la tapa derecha del dispositivo

En la figura 3.17 se muestra la tapa derecha del dispositivo, en dicha figura se pueden observar algunas partes importantes para el funcionamiento del dispositivo; se puede observar la cavidad de los rodillos, dicha cavidad se diseño para que los rodillos pudieran girar libremente sin que alguna parte de las tapas pudieran bloquear el giro de los mismos, también se opto por dejar la parte de arriba libre para evitar que al introducir una varilla de aporte el rodillo impulsado se viera obstruido por material sobrante de la tapa.

3.4 Planos del dispositivo



Designed by	Checked by	Approved by	Date	Date
José Angel Reyes				24/08/2013

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Querétaro

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CAPÍTULO 4

Fabricación e integración

En este capítulo se describe la fabricación de nuestro dispositivo, el cual para ser desarrollado se utilizó un software de CAM. En este capítulo se abordan también los procesos que se llevaron a cabo para la manufactura del dispositivo, y los procesos que se hicieron para la integración de las partes del dispositivo en el software de CAD. Se hace una explicación de la generación de códigos G para la manufactura en un centro de maquinado CNC y de algunas limitantes que se tuvieron durante y después de dichos maquinados.

4.1 Proceso de manufactura

La manufactura de las tapas del dispositivo fue realizada totalmente en las instalaciones de la facultad de ingeniería, teniendo como principal dificultad el vaciado del material base para el alojamiento de la transmisión y de los elementos mecánicos como los rodillos de impulsión, y de los demás componentes como la varilla de aporte, del potenciómetro y del gatillo del dispositivo. Para hacer las cavidades, se hiso un análisis visual de los componentes que deben alojar las tapas del dispositivo, para así poder retirar material del modelado de las tapas, ya que el modelado fue hecho en un sólido.

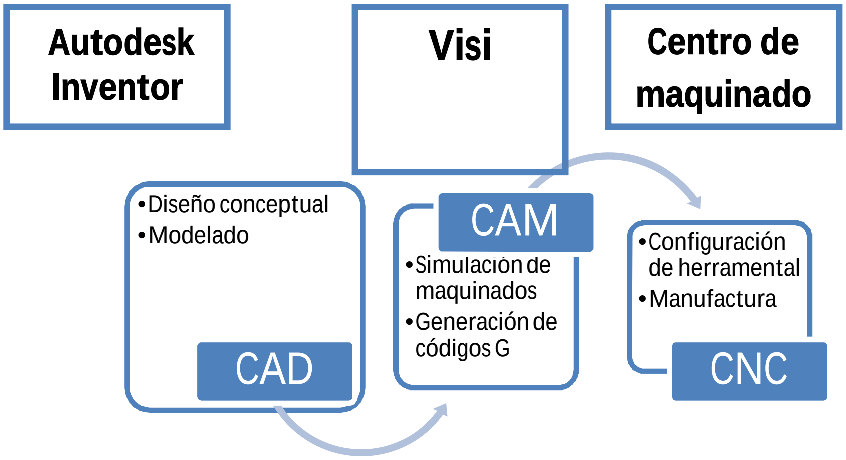


Figura 4.1 Proceso de manufactura con ayuda de software CAD CAM.

Para el proceso de maquinado del material base fue necesario analizar los procesos de corte desbaste y acabado del dispositivo, con lo que se opto por realizar 4 procesos de maquinado, 2 para cada tapa de dispositivo, una para la parte interna y otra para la parte externa que es la que queda expuesta y a la vista del usuario.

En la Figura 4.1 se muestra el proceso de manufactura a seguir para la fabricación del dispositivo, como se puede observar hay una secuencia y una serie de pasos para cada una de la etapas del proceso de manufactura.

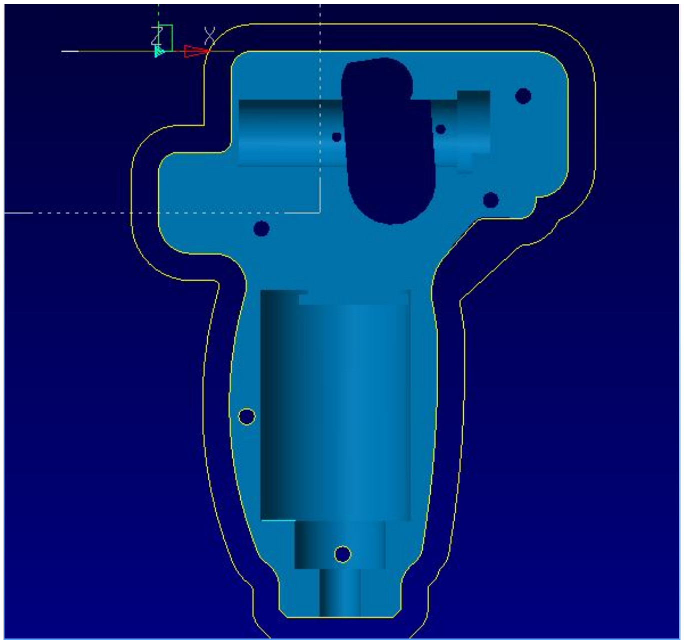


Figura 4.2 Modelado de la mitad derecha del dispositivo

Para llevarse a cabo el proceso de manufactura a partir de un modelado físico se deben tener conocimiento en el área de maquinas y herramientas, además de un conocimiento en el área de herramientas de corte y desbaste. Para el proceso que se lleva a cabo en este proyecto se hicieron básicamente 3 tipos de maquinados, habiendo entre ellos cambios de herramientas para la remoción de materiales con distintos diámetros para la remoción de material en el material base.

Figura 4.3 Procesos a seguir para el maquinado de las tapas de dispositivo.

En la Figura 4.3 se describe el proceso para un proceso de maquinados de desbaste y de remoción de material restante en las piezas a maquinar.

Para comprender mejor el proceso de manufactura partiremos de la selección de las herramientas necesarias para un proceso rápido y que deje acabados para su posterior ciclo de maquinado.

Partimos de la selección de herramienta y pasamos a la sujeción del material base a la mesa de coordenadas del centro de maquinado, dicha sujeción fue hecha con *clamps*, aunque dicha sujeción fue echa solo para el primer ciclo de maquinado, ya que esto permitió solo la sujeción de una parte del maquinado ya que para tener una sujeción de la parte posterior se vio en la necesidad de sujetar la pieza de trabajo con tornillos, mismos que en la parte de modelado se diseñaron para sujetar a las tapas del dispositivo ya terminadas.

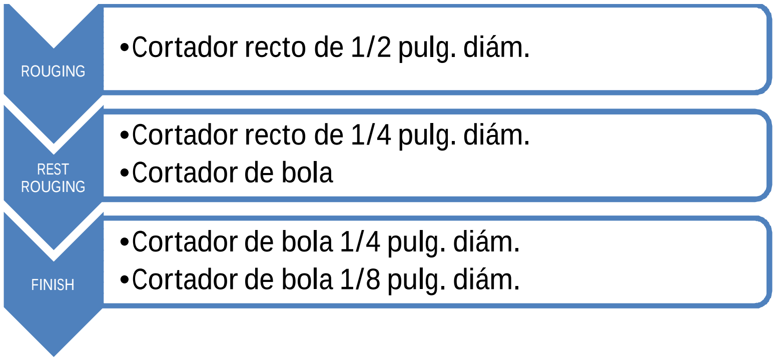
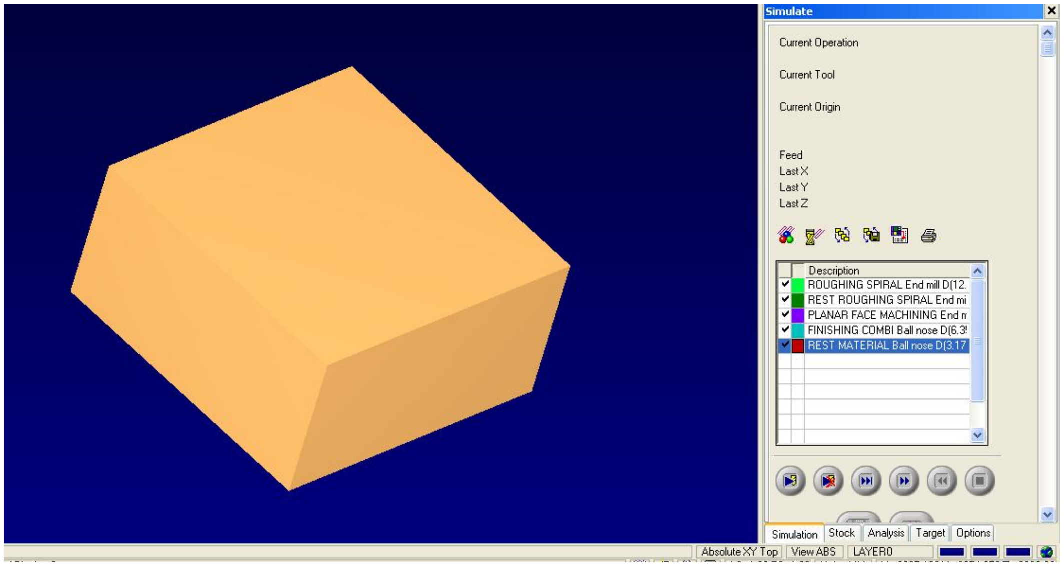


Figura 4.4 Proceso de maquinados con diferentes herramientas.

En la Figura 4.4 se muestra el ciclo de maquinado para cada una de las caras de las tapas, comenzando con un cortador vertical de 12.7 mm (1/2 in) para la eliminación de la mayor cantidad de material posible en el material base, posteriormente se hiso un ciclo de eliminación de material restante con cortadores verticales de 6.35 mm (1/4) y un cortador de bola *ball nose* de 3.175 mm (1/8in) para retirar a mayor cantidad de material en partes pequeñas y esquinas de la pieza.

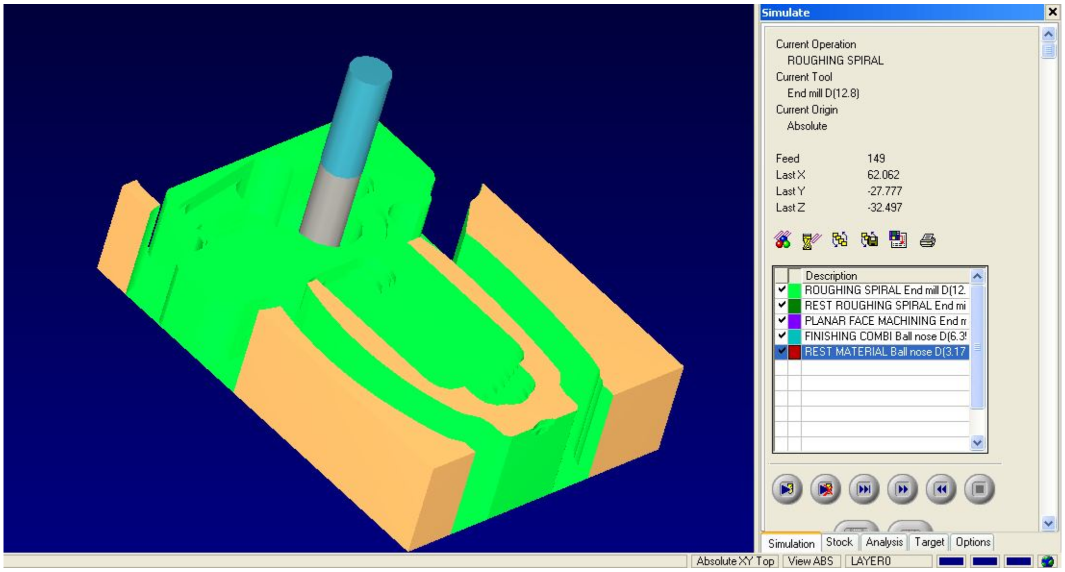
La ventaja de usar el software de CAM es poder visualizar los cortes y maquinados y y nos da una aproximación muy real a la pieza de trabajo, a continuación se presentan imágenes de las simulaciones que se hicieron para la manufactura de las tapas.



Description
- ✓ 🟩 ROUGHING SPIRAL End mill D(12.
- ✓ 🟩 REST ROUGHING SPIRAL End mi
- ✓ 🟪 PLANAR FACE MACHINING End m
- ✓ 🟦 FINISHING COMBI Ball nose D(6.3!
- ✓ 🟥 REST MATERIAL Ball nose D(3.17

Figura 4.5 Inicio de simulación de códigos generados para la mitad derecha del dispositivo

En la Figura 4.5 se muestra la primer imagen de la simulación para el inicio de los maquinados; como se aprecia en la figura, el programa nos indica que es una pieza solida. Partiendo de esto alineamos los cortadores para obtener un cero pieza que nos da origen a las coordenadas de maquinado de la pieza de trabajo.



Current Operation
ROUGHING SPIRAL
Current Tool
End mill D(12.8)
Current Origin
Absolute

Feed 149
Last X 62.062
Last Y -27.777
Last Z -32.497

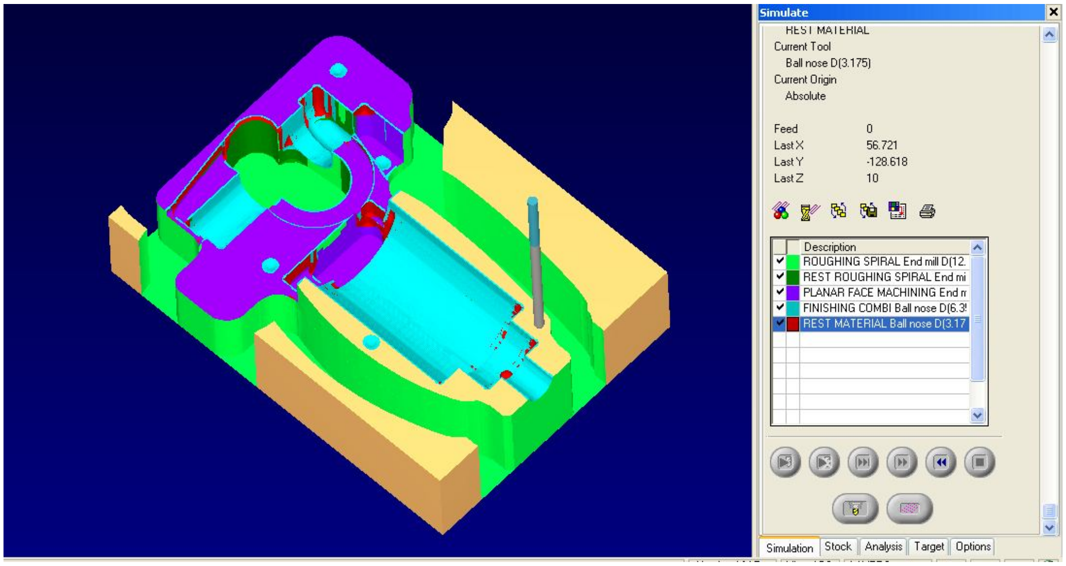
		Description
✓	🟩	ROUGHING SPIRAL End mill D(12.
✓	🟩	REST ROUGHING SPIRAL End mi
✓	🟪	PLANAR FACE MACHINING End m
✓	🟦	FINISHING COMBI Ball nose D(6.3!
✓	🟥	REST MATERIAL Ball nose D(3.17

Figura 4.6 Inicio de simulación parte derecha.

En la Figura 4.6 se observa parte de la simulación de los códigos generados por un *roughing spiral* con un cortador vertical *end mill* de 12.7 mm (1/2in) para hacer los maquinados necesarios y así poder hacer la forma del dispositivo, dicho maquinado permite retirar la mayor cantidad de material con un solo cortador. Sin embargo este maquinado no permite dejar un buen acabado por lo que hay la necesidad de generar otro código para dar una mayor proximidad a las medidas requeridas.

El segundo maquinado fue un *rest roughing spiral* con un cortador vertical *end mill* de 6.35 mm (1/4 in) con este maquinado en el material base los ciclos de trabajo de desbaste permiten dar un mejor acabado a la tapa del dispositivo, dicho maquinado nos permite dar una mayor aproximación en las esquinas del dispositivo por ser este de un diámetro menor, el cortador permite retirar aún mas material para dar una mayor aproximación a las medidas requeridas para el alojamiento de la transmisión mecánica para el impulso de las varillas de aporte.

En la Figura 4.7 se muestra un maquinado llamado *finishing combi* con un cortador vertical *Ball nose* de 3.175 mm (1/8 in), este maquinado ayudo a la eliminación de material en las partes que contienen alguna redondez de la tapa, como se puede observar en la figura el código generado por el software CAM nos ayuda dar los acabados finales para las partes redondas del interior del dispositivo. Al ser este maquinado con un cortador de diámetro pequeño, pudimos retirar aún más cantidad de material sobrante en las esquinas internas de la tapa del dispositivo. Dicho maquinado nos da el acabado final del dispositivo y nos da la medida más aproximada posible para la tapa del dispositivo.



REST MATERIAL
Current Tool
Ball nose D(3.175)
Current Origin
Absolute

Feed 0
Last X 56.721
Last Y -128.618
Last Z 10

		Description
✓	🟩	ROUGHING SPIRAL End mill D(12.
✓	🟩	REST ROUGHING SPIRAL End mi
✓	🟪	PLANAR FACE MACHINING End n
✓	🟦	FINISHING COMBI Ball nose D(6.3!
✓	🟥	REST MATERIAL Ball nose D(3.17

Figura 4.7 Fin de la simulación parte derecha.

Finalmente se genero un maquinado con la función *rest material* con el mismo cortador vertical *ball nose* de 3.175 mm (1/8 in) dicho maquinado nos permitió retirar todo el material restante del interior de la tapa, quedando así la manufactura de la parte interior de la tapa derecha de nuestro dispositivo.

En la Figura 4.8 se muestra la sujeción inicial del material base a la mesa de coordenadas del centro de maquinado.

Figura 4.8 Sujeción del material base a mesa de coordenadas.

Al final del primer ciclo de maquinado se hiso una revisión rápida del vaciado de material, y se pudo notar que el maquinado había dejado una pequeñas rebabas, con lo cual se pudo ajustar la velocidad de corte para el siguiente ciclo de maquinado.

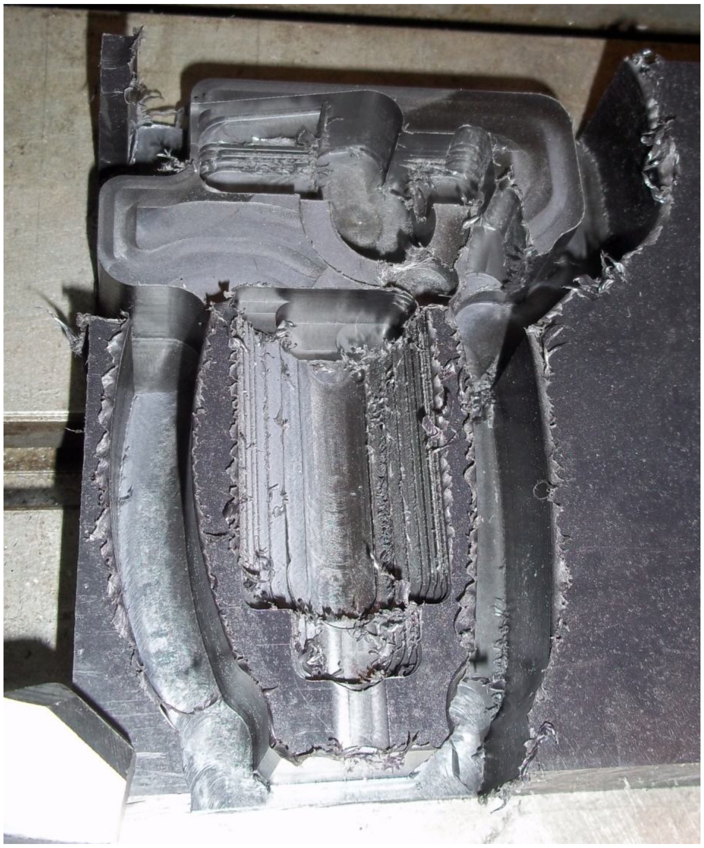


Figura 4.9 Primer ciclo de maquinado.

En la figura 4.10 se puede apreciar el proceso del segundo ciclo de maquinado con el cortador vertical *end mill* de 6.35 mm (1/4 in) dicho maquinado realizo la remoción de material excedente y además de la eliminación de las rebabas que quedaron del primer maquinado.

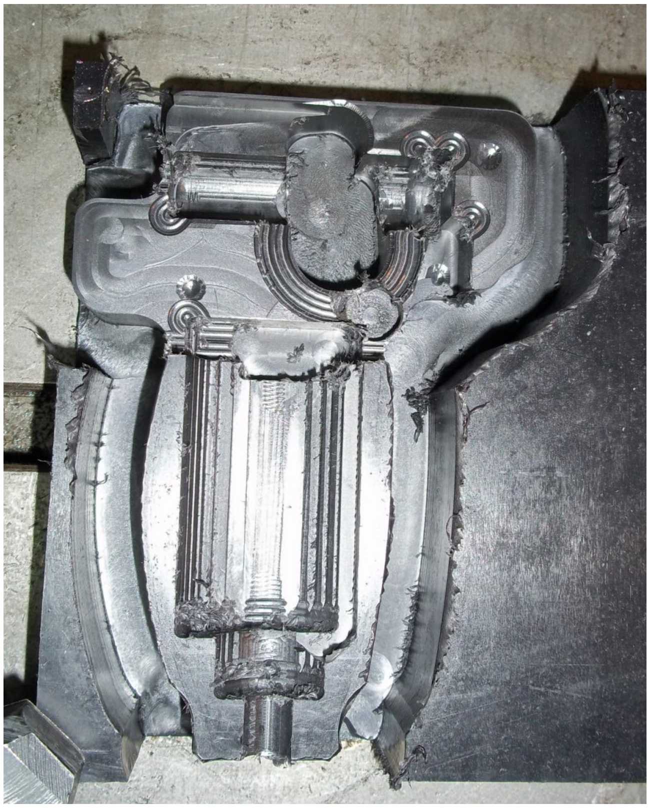
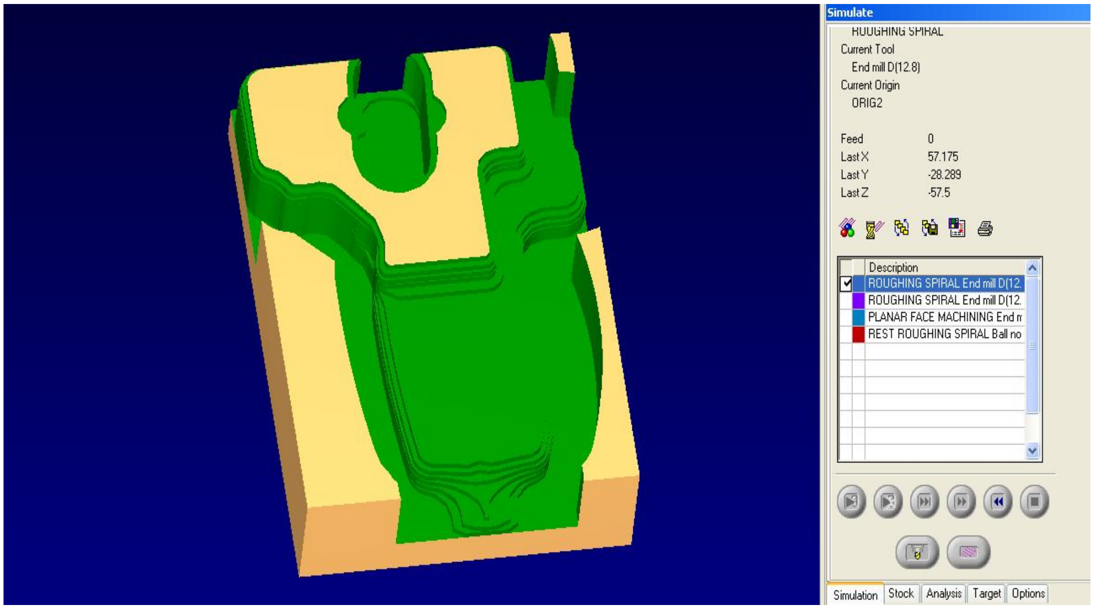


Figura 4.10 Fin del segundo ciclo de trabajo.

Para poder manufacturar la parte exterior de la tapa del dispositivo se cambiaron las coordenadas de origen respecto al primer maquinado y se hicieron nuevas operaciones, tomando en cuenta que la parte exterior es la que va a estar expuesta, se generaron códigos que nos dieran una excelente presentación en los acabados.



ROUGHING SPIRAL
Current Tool
End mill D(12.8)
Current Origin
ORIG2

Feed 0
Last X 57.175
Last Y -28.289
Last Z -57.5

		Description
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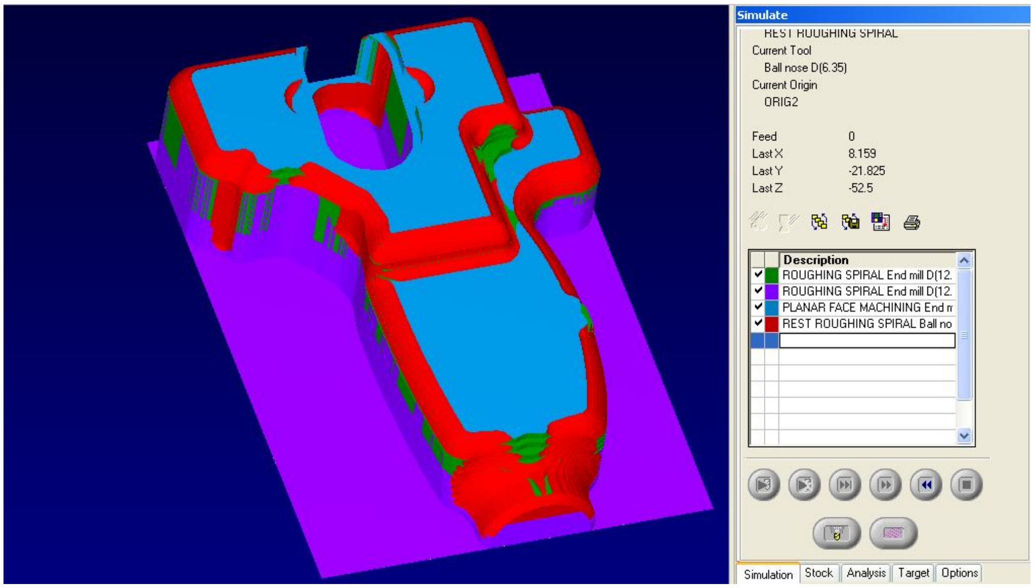
		ROUGHING SPIRAL End mill D(12.
		PLANAR FACE MACHINING End m
		REST ROUGHING SPIRAL Ball no

Figura 4.11 Inicio de maquinado de la parte externa de tapa derecha

Tomando en cuenta que se estaba maquinando la parte externa de las tapas se procedieron a hacer maquinados de desbaste más detallados, con ello se le dio un terminado exacto pero a su vez un acabado que permitió darle estética a las tapas del dispositivo.

En la figura 4.12 se puede observar la simulación completa de los maquinados que permitieron darle los acabados que se requieren para el dispositivo.



REST ROUGHING SPIRAL
Current Tool
Ball nose D(6.35)
Current Origin
ORIG2

Feed 0
Last X 8.159
Last Y -21.825
Last Z -52.5

		Description
☑	🟩	ROUGHING SPIRAL End mill D(12.
☑	🟪	ROUGHING SPIRAL End mill D(12.
☑	🟦	PLANAR FACE MACHINING End m
☑	🟥	REST ROUGHING SPIRAL Ball no

Figura 4.12 Fin de la simulación parte externa.

En la figura 4.13 se muestra el comienzo del maquinado de la parte externa de las tapas, para poder manufacturar la parte externa de la tapa del dispositivo, se dio la vuelta a la parte anteriormente maquinada y se fijo con los tornillos que posteriormente sujetaran ambas partes de las tapas para su correcto ensamblaje. Como se puede observar se establecieron limites de corte para evitar dañar los cortadores y tornillos de sujeción, ya que si esto sucedía las coordenadas de nuestro cero pieza cambiarían y los cortes de las herramientas no corresponderían a los requeridos para la obtención de la pieza.

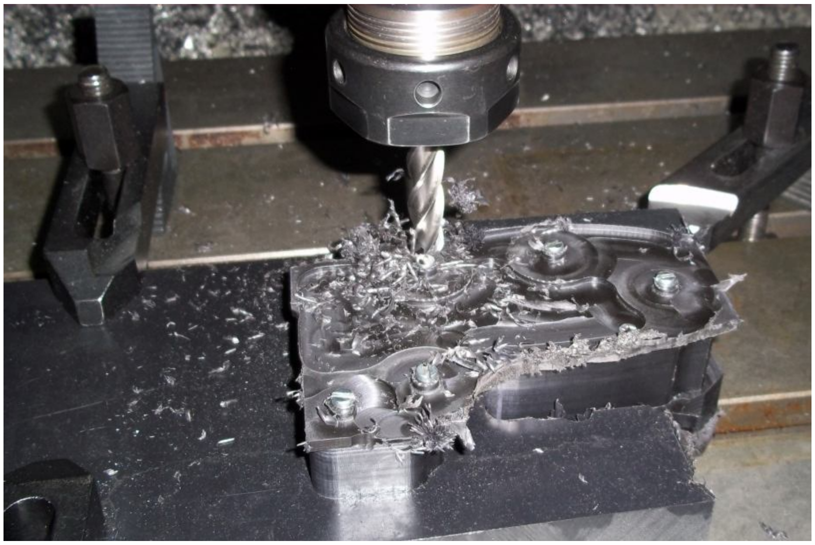


Figura 4.13 Inicio de maquinados de la parte exterior del dispositivo

4.2 Integración y ensamble módulos

Para la fabricación de las tapas se hicieron simulaciones de los ensambles en Autodesk Inventor lo cual nos permitió dar las tolerancias para un correcto funcionamiento del dispositivo. Sin embargo como se menciono antes el modelado de las tapas fue en una pieza solida, y para poder determinar su armado físico se vio en la necesidad de hacer secciones en dicho sólido, estos cortes se ensamblaron posteriormente en el software Visi, el modelo final se determino de tal forma que el software CAM pudiera hacer todos los ciclos de maquinado sin que algún ciclo de maquinado no pudiera llegar a algún lugar que estuviera por debajo de las tolerancias de las herramientas.. Dichos cortes se muestran en la Figura 4.14

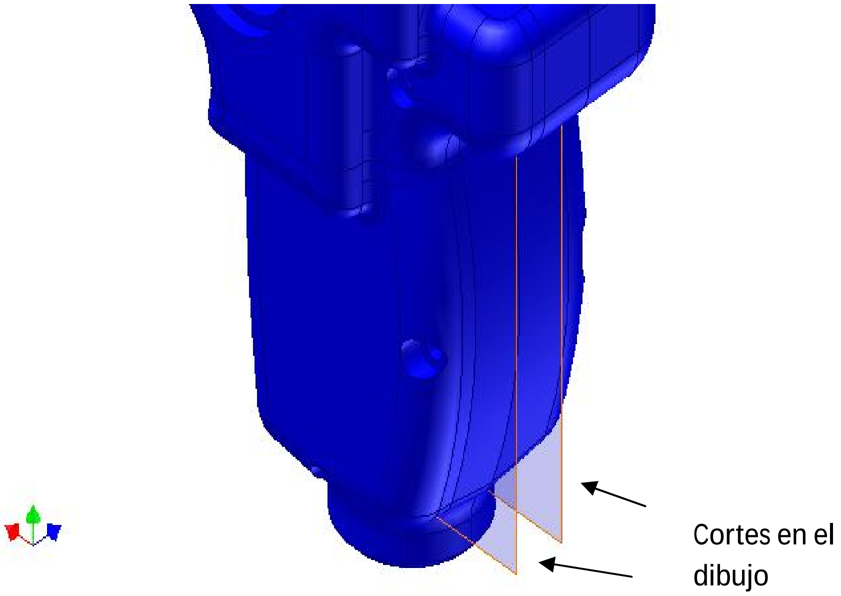
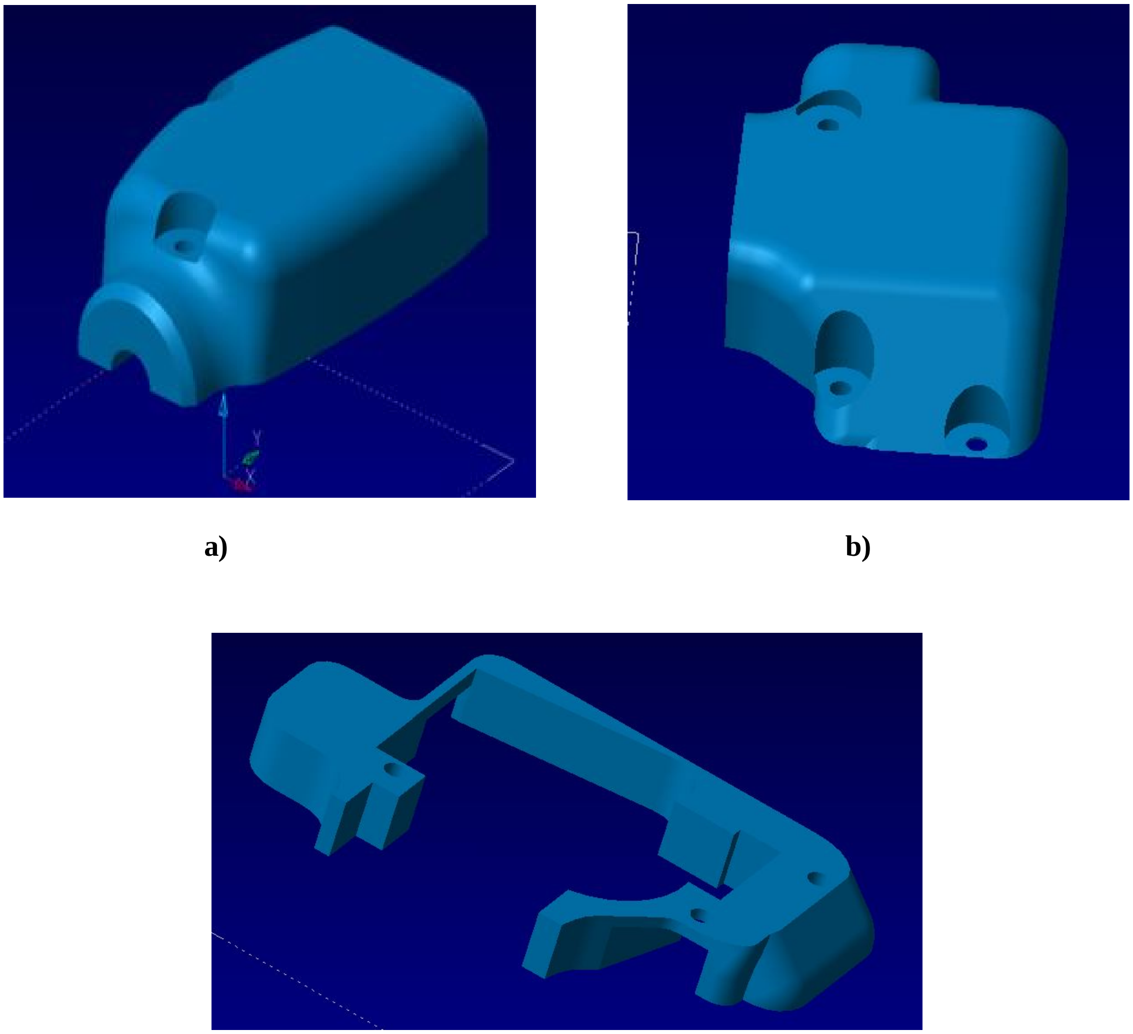


Figura 4.14 Secciones en el dibujo de solido

Cada una de las partes seccionadas se exportaron a Visi para su ensamble de las partes obtenidas del fraccionamiento del sólido, a continuación en la Figura 4.15 se muestran lagunas de las partes exportadas para la creación de la parte derecha de las tapas.



a) b)

c)

Figura 4.15 Partes seccionadas a) mitad de empuñadura b) cubierta de caja c) portagatillo

Como se puede observar en la Figura 4.9 las partes seccionadas corresponden a parte de la mitad de cada una de las tapas, para su posterior unión se utilizo el mismo software CAM partiendo de las coordenadas de ensamble.

4.3 Ajustes y pruebas preliminares

Para el uso del dispositivo se requiere que el operador maneje el gatillo con un guante de carnaza puesto, para hacer las pruebas de soldadura se requirió que el gatillo tuviera la medida y forma necesaria para que éste no fuera accionado de manera inadecuada o accidental, la forma que se presento permite dar un buen agarre del dispositivo, pero a su vez dar una manera fácil de poder presionarlo, sin que existiera la posibilidad de que este saliera de su lugar y así evitar algún accidente.

Se requirió rebajar los rodillos de impulsión de la transmisión adquirida para la impulsión de varilla, ya que dichos rodillos vienen ajustados para la impulsión de alambre delgado, dicha operación se llevó a cabo en el torno convencional, en la cual se maquino una barra de acero que en sus extremos contiene los diámetros adecuados para la introducción de los rodillos, a dicha barra también se le hizo un roscado para la sujeción de los rodillo y evitar así que a la hora de maquinar los rodillos giraran en la barra evitando el desbaste. Todo esto se muestra en la Figura 4.16


a)
b)

Figura 4.16 a) barra para rebajar rodillos b) rodillos rebajados

Como se menciono anteriormente no existen en el mercado insumos de soldadura para la aplicación semiautomática del proceso GTAW, es por ello que surge la necesidad de generar los parámetros propios para la correcta aplicación de dicha soldadura.

En las pruebas de soldadura las pruebas de avance de varilla se hicieron mediante el ajuste de la frecuencia del PWM, se había calculado una frecuencia inicial de 200 Hz para el correcto funcionamiento del motor y por ello la velocidad adecuada de salida en la varilla, sin embargo a dicha frecuencia cuando el ciclo activo del modulador era muy bajo, el motor no percibía la señal y no avanzaba o el ciclo activo del PWM era muy alto y la varilla salía a una velocidad alta para la prueba realizada.

En la segunda prueba se cambio la frecuencia del PWM a 300 Hz y después a 320 Hz ya que esta última frecuencia cumplía los requerimientos de velocidad para el aporte de la varilla para el proceso que se cito, ésta resulto ser la mejor frecuencia para que el motor trabajara de una manera adecuada sin presentrarse vibraciones o algún tipo de distracciones que pudieran influir en el correcto funcionamiento del dispositivo.

Una parte importante fue que el potenciómetro en la parte del gatillo era accionada con una gran sensibilidad, por ello se procedió a agregar una resistencia en la entrada del potenciómetro esto para darle un mayor rango de variación del voltaje a la entrada del ADC también se opto por poner un pequeño resorte al gatillo para hacer rígido el potenciómetro y así darle rigidez al potenciómetro.

Con los parámetros obtenidos en la parte de ajustes y pruebas preliminares se procedió a hacer la tarjeta controladora y de potencia, programando en la parte del PIC una frecuencia de 300 HZ aproximadamente, con lo que se procedió a realizar las pruebas de soldadura.

CAPÍTULO 5

Pruebas y análisis de resultados

El siguiente capítulo se presentan la pruebas realizadas en 6 probetas de acero inoxidable, 3 de manera completamente manual y 3 de manera semiautomatizada. También se presentan las comparaciones entre la aplicación manual y semiautomática, dando las recomendaciones para el uso eficiente del dispositivo.

5.1 Aplicación manual del proceso GTAW

Se decidió a realizar las pruebas de soldadura en acero inoxidable con material de aporte de acero inoxidable 718 er 316 ya que este es un material ampliamente utilizado en este tipo de proceso, con lo que se decidió a realizar las pruebas a 3 probetas de manera manual, y a tres probetas de manera semiautomática en lámina de acero inoxidable, como se muestra en la Figura 5.1. en estas pruebas se utiliza una atmosfera protectora de argón, ya este gas es el más utilizado para la aplicación de dicha soldadura.

No	Material	Tipo de junta	Aplicación
1	Acero inoxidable	Traslape 1F	M
2	Acero inoxidable	Traslape 1F	M
3	Acero inoxidable	Traslape 1F	M
4	Acero inoxidable	Traslape 1F	SA
5	Acero inoxidable	Traslape 1F	SA
6	Acero inoxidable	Traslape 1F	SA

Figura 5.1 Aplicaciones de soldadura y pruebas

En la Figura 5.2 se muestra la imagen de la primer prueba de soldadura aplicada manualmente, se puede observar que la soldadura presenta irregularidades en la continuidad del cordón de soldadura. También se puede observar que al ser aplicada la soldadura manualmente la varilla de aporte sale de la atmósfera protectora de gas teniendo como consecuencia la contaminación de la soldadura, se puede decir que el cordón es de una calidad regular.

Figura 5.2 aplicación manual de soldadura

La imagen de la Figura 5.3 muestra la segunda probeta soldada de manera manual. La aplicación manual de soldadura es evidente, en dicha figura se resaltan los problemas más recurrentes del proceso de soldadura, es que al tener la varilla de aporte en la mano, se requiere de una habilidad extraordinaria para poder dar el avance requerido en el aporte, como dicho avance es muy complicado de dar, el tiempo que se calienta la pieza de trabajo es mayor al requerido por lo cual se forman una especie de puntos de mayor tamaño en comparación a los del cordón regular.

Figura 5.3 aplicación manual de soldadura

La Figura 5.4 muestra la tercer probeta de aplicación de soldadura manual, en esta probeta se muestra un cordón regular y de una apariencia continua, sin embargo se puede observar una cierta cantidad de contaminantes en algunas partes de la soldadura, lo cual no es recomendable, ya que la soldadura es de mayor aplicación a la industria alimentaria.

Figura 5.4 aplicación manual de soldadura

5.2 Aplicación semiautomática del proceso GTAW

Las pruebas realizadas para el proceso semiautomático se realizaron de acuerdo a lo establecido en la tabla de la figura 5.1, lo cual podemos comprobar en la imagen 5.4

Figura 5.5 aplicación semiautomática de soldadura

La Figura 5.6 muestra la primer probeta de soldadura en su aplicación semiautomática, con este método se puede observar una continuidad del cordón más precisa en los puntos de soldadura, al ser el aporte de varilla continuo, ésta no sale de la atmósfera protectora de gas, evitando así la introducción de algún contaminante en la soldadura, se puede observar también una mayor consistencia en el tamaño de los puntos.

Figura 5.6 aplicación semiautomática de soldadura

En la Figura 5.7 se resaltan los puntos a favor de utilizar el dispositivo, como lo son la continuidad de tamaño en el cordón de soldadura sin presentarse irregularidades como puntos más grandes por el sobrecalentamiento de la pieza por no dar a tiempo el aporte al cordón de soldadura. Además se presenta una coloración uniforme en los puntos de soldadura.

Figura 5.7 aplicación semiautomática de soldadura

La Figura 5.8 muestra la última probeta de soldadura en su aplicación semiautomática se puede observar una consistencia en los tamaños de los puntos del cordón, se puede observar también una regularidad en la continuidad de la separación de los puntos.

|

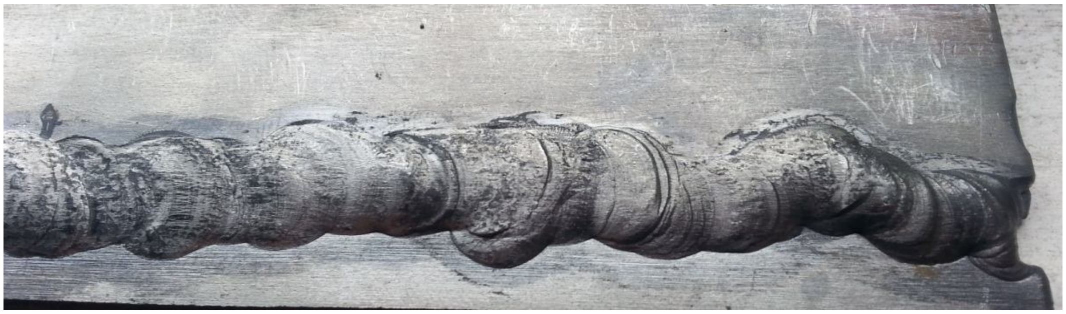


Figura 5.8 aplicación semiautomática de soldadura

5.3 Análisis comparativo y discusión

Figura 5.9 Probetas de soldadura a) aplicación semiautomática de soldadura b) aplicación manual de soldadura

En las imágenes de la Figura 5.9 se puede observar las pruebas realizadas en probetas de acero inoxidable, se pueden observar cambios en la aplicación de soldadura. El cordón de la aplicación manual contiene irregularidades en el tamaño de los puntos de soldadura en comparación en el tamaño de los puntos realizados en forma semiautomática, también se observa que en el proceso manual se depositan contaminantes provenientes de la varilla de aporte, dichos contaminantes se adhieren a la varilla cuando el soldador al recorrer la varilla, ésta se mueve fuera de la atmósfera de gas inerte.

También cabe resaltar que los cordones aplicados de forma manual presentan una cierta interrupción al momento de realizar cordones de una longitud aproximada de 2 cm.

Los cordones que fueron aplicados de manera semiautomática presentan cierta uniformidad respecto a los que se aplicaron de manera manual, los cordones realizados de manera semiautomática presentan una regularidad de tamaño en los puntos del cordón.

5.4 Conclusiones y recomendaciones

A través del proyecto realizado se obtienen distintas observaciones y puntos de vista en la aplicación del proceso, cabe mencionar que el dispositivo realizado fue probado solo en las instalaciones de la universidad, por lo cual las recomendaciones que a continuación se dan se basan en la experiencia y la práctica de cada persona con el proceso de soldadura que se pretende semiautomatizar.

Debido a la practica con la soldadura antes mencionada, se logra apreciar mayor facilidad para sostener la varilla de aporte, con lo cual ésta no se mueve tanto como si se sostuviera meramente con la mano, con el dispositivo se puede apreciar que la varilla no "baila" tanto como si se diera el aporte recorrido con la mano. La primer ventaja visible de la aplicación semiautomática es, la mencionada anteriormente, ya que la varilla al no salir de la atmosfera protectora de gas inerte, no se contamina y por lo tanto, los cordones de soldadura se observan más limpios.

Otra ventaja de utilizar el dispositivo es la continuidad de dar el aporte con lo cual, los puntos de soldadura son más consistentes en tamaño y forma, ya que al ser el aporte continuo el material base no sufre de un sobrecalentamiento los puntos de soldadura no se degradan ni se deforman presentando los puntos característicos de una soldadura aplicada de forma manual.

Sin embargo al ser el dispositivo un prototipo, se presentan también recomendaciones para la mejora del mismo. Si bien, el tamaño del dispositivo no es un problema, es de cierta manera incomodo, ya que a la hora de soldar es necesario usar equipo de protección personal como lo son guantes de carnaza, dichos guantes impiden una sujeción cómoda al dispositivo, por lo cual es recomendable reducir el tamaño del mango del dispositivo.

Otra recomendación es reducir el peso del dispositivo. Como se menciono anteriormente la transmisión de fuerza a los rodillos es por medio de una transmisión y un motor eléctrico, dicho motor es de un tamaño grande para la fuerza requerida que se necesita para mover las varillas de aporte. Por lo cual se recomienda que en un trabajo futuro el motor sea reemplazado por uno de menor tamaño para que el peso del dispositivo en la aplicación de cordones no provoque distracciones que puedan ser perjudiciales para operadores que no estén familiarizados con el dispositivo lo cual pueda causar mayor tiempo de adaptación para la realización de trabajos de manufactura.

Como conclusiones podemos decir que el uso del dispositivo también requiere de una habilidad para dar el aporte, sin embargo la habilidad de poder presionar el gatillo no se compara en lo mínimo en la de poder dar el aporte de manera manual. Es necesaria la adaptación por un corto periodo de práctica.

Otra recomendación es que para el uso del dispositivo los rodillos de impulsión deben estar lubricados de manera correcta lo cual debe de cuidarse que no haya un exceso de lubricante, en este caso aceite de origen mineral, ya que si esto existiera, la varilla de aporte podría contaminarse y nos traería consecuencias perjudiciales a la soldadura.

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ANEXOS

A continuación se muestran los códigos de los tres maquinados básicos que se realizaron y simularon para el maquinado del dispositivo, desde el proceso de desbaste y vaciado de material base hasta los maquinados de acabado. Se incluye el tipo de herramienta así como también su diámetro.

```
O1
N1 G0 G40 G80 G90 G98
N2 (END MILL DIAM. 12.8)
N3 T1 M6
N4 M3 S1000
N5 G80 G90
N6 G54
N7 ( ROUGHING SPIRAL)
N8 G0 X30.566 Y44.022
N9 G43 Z25. H1
N10 Z15.812
N11 G1 Z9.412 F149.
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N13 X30.191 Y44.117 Z7.223
N14 X29.734 Y44.232 Z6.212
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N16 X28.349 Y44.583 Z4.509
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N19 X25.439 Y45.32 Z3.109
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N258 Y50.091
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