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BOOK OF ABSTRACT

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45	ICMIT/MM63	Materials and Mechanics in Safety Helmet Design: A Focus on Composites and Hybrids	<i>Gayathri Namboothiri, Dr S.N. Khan, Pavankumar Sonawane</i>	46
46	ICMIT/MM64	21st-century revolutionary growth of biodegradable 3d printed composite polymers.	<i>Shalini Anand, Yogesh Kumar, Ashish Kumar Srivastava</i>	47
47	ICMIT/MM65	Enhancing EDM Efficiency with Hastelloy C-276 and Bio-Based Dielectrics	<i>Narendra Kumara, Dr. P.Sudhakar Rao</i>	48
48	ICMIT/MM66	Microstructural and Mechanical Characterisation of Wire-Fed Stainless Steel in Direct Energy Deposition Additive Manufacturing	<i>Sachindra Shankar, Akash Nag, Jana Petrú</i>	49
49	ICMIT/MM67	Mechanical performance of 3D-printed AlSi10Mg honeycomb-structured protective gears	<i>Madhulika Srivastava, R Sai Ruthwique, Preeti Gautam, Akash Nag</i>	50
50	ICMIT/MM68	Microstructural and mechanical properties of the Al-Zn-Al sheet lamination through friction stir additive manufacturing	<i>Preeti Gautam, Akash Nag, Jana Petrú</i>	51
51	ICMIT/MM69	Multi-Modal Characterization of Crack Initiation Zones in Brittle Materials Under Grinding Stresses	<i>Tanmay Tiwari, Chandra Sekhar Rakurty</i>	52
52	ICMIT/MM71	The Role of WAAM Process Parameters in Engineering Titanium- Based Functionally Graded Materials	<i>Amit Kumar Mandape, Srinivasu Gangi Setti</i>	53
53	ICMIT/MM72	Thermal Analysis of Dissimilar Friction Stir Welding of Al 6061-T6 and Cu 1100 Using Finite Element Method	<i>Kumar Shambhav, Vishal, Rakesh Kumar, Somnath Chattopadhyaya, Raj Das</i>	54
54	ICMIT/MM73	Developing Scheduling Policies to reduce the Total Weighted Completion Time in additive manufacturing	<i>Advitiya Singh, Krishan Walia, Ujjwal Wadhwa, Prof/Dr. A. K. Madan</i>	55
55	ICMIT/MM74	Impact of Process Variables on Roughness of Turned Surfaces using Biodegradable Cutting Fluids	<i>Deepak Kumar, Rajeev Ranjan, Subhas Chandra Moi, Manoj Kundu</i>	56
56	ICMIT/MM77	Advancements in 3D Printing of Composite Materials: Challenges and Prospects	<i>Narinder Kumar, Hardeep Singh, Manjit Singh</i>	57
57	ICMIT/MM78	Development of TiB <sub>2</sub> -Al <sub>7</sub> Si <sub>0.3</sub> Mg in-situ Functionally Graded material through Centrifugal Casting Process	<i>Amrit Mallick, Raj Kumar Sahu, Srinivasu Gangiseti</i>	58
58	ICMIT/MM79	Effects of Process Variables and Tool Geometry on Friction Stir Welding of Similar Aluminium Alloy Joints AA5083 and AA6061	<i>Chandrakant Swain, Akash Shukla, Kedar Badheka</i>	59
59	ICMIT/MM80	Optimization of EDM Process Parameters for Al-MMC by Composite Desirability Approach	<i>Vaddepalli Pradeep, Anil Kumar Bodukuri, Pankaj Kumar</i>	60
60	ICMIT/MM81	Analysis of Calotropis Gigantea Plant Stem Fiber Reinforced Epoxy Composite Material	<i>Rajesh Kumar, Brajesh Kumar Bharti, Dharamendra Kumar, Gopal Kumar, Manish Kumar</i>	61
61	ICMIT/MM86	Influence of Process Parameters on Surface Modification Using Electric Discharge Machining: A systematic review	<i>Roli Verma, Rabesh Kumar Singh, Anuj Kumar Sharma, Ashish Kumar Srivastava, Saurabh Chauhan</i>	62
62	ICMIT/MM87	Numerical Simulation and Experimental Analysis on Cold Forging of Commercially Pure Aluminum.	<i>Khemraj, Manvandra Kumar Singh, Hemant Kumar Choudhary, and Raj Bahadur Singh</i>	63

ICMIT/MM74

## Impact of Process Variables on Roughness of Turned Surfaces using Biodegradable Cutting Fluids

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### ABSTRACT

This research focuses on improving the surface finish during mild steel turning by optimizing cutting parameters, with a particular emphasis on the role of cutting fluids. The primary goal is to achieve better surface quality and enhance machining performance by determining the best combination of speed, feed, and depth of cut. An important aspect of the study was to evaluate how biodegradable cutting fluids affect the machining process. To measure performance, surface roughness was used as the key indicator. All experimental trials were performed on a center lathe under varying machining conditions. Various cutting fluids, including sunflower, coconut, and soyabean oils, were tested to determine their effectiveness in enhancing the surface finish. Statistical methods, including Response Surface Methodology (RSM), were utilized to refine the parameters and establish the relationship between machining conditions and surface roughness. The findings indicated that cutting speed and feed had a significant impact on surface quality. Additionally, biodegradable cutting fluids demonstrated a notable influence on the surface roughness of mild steel. The best cutting fluid and ideal cutting parameters have been identified in the study. A surface roughness value of 0.2858 microns was found to be minimum with soybean oil as the cutting fluid. The associated cutting speed was 25m/min. The corresponding feed-rate and cut-depth were 0.10mm/rev and 0.7879mm respectively.

**Keywords:** Biodegradable Cutting Fluids, Turning Operations, Surface Roughness, Surface Finish Optimization, Response Surface Methodology (RSM)