LIST OF FIGURES

Figure 2.1	Arrangement of magnetic domain in (a) 180^o Domain Wall (b) 90^o Domain Wall	34
Figure 2.2	(a) Domain in the absence of magnetic field (b) Arrangement of domain after magnetization	35
Figure 2.3	A typical hysteresis loop formation (Srivastava *et al.* 2017)	36
Figure 2.4	The influence of grain size on peak height of Barkhausen noise (Pal'a and Bydzovsky, 2013)	40
Figure 2.5	The variation in Barkhausen noise parameter with tempering induced hardness change (Deng *et al.*, 2018)	41
Figure 2.6	The influence of surface roughness on Barkhausen noise parameter (Deng *et al.*, 2018)	41
Figure 2.7	(a) Correlation between MBN energy and residual stress (Gauthier *et al.* 1998) (b) The effect of residual stress on MBN (RMS) value (Kleber and Vincent, 2004)	43
Figure 2.8	The effect of grinding process parameter on Barkhausen noise emission (Thanedar *et al.*, 2017)	43
Figure 2.9	The relation between residual stress and Barkhausen emission under different condition of heat treatment (Correa *et al.*, 2016)	44
Figure 2.10	The relation between residual stress and BN emission in different zones of welded steel (Vourna *et al.*, 2015)	45
Figure 2.11	Magnetic hysteresis loop for the sample subjected to (a) tensile deformation (b) Compressive deformation (Piotrowski *et al.*, 2017)	46
Figure 2.12	Correlation between reciprocal of MBN amplitude with (a) applied stress (b) residual stress (Mierczak *et al.*, 2011)	46
Figure 2.13	Variation in BN (RMS) with rise in grinding temperature (Sridharan *et al.*, 2017)	47

Figure 2.14	Variation in event and count with residual stress during grinding of hardened bearing steel (Vashista and Paul, 2011)	48
Figure 3.1	Heat treatment cycle for pack carburizing process	53
Figure 3.2	shows the steps followed during carburizing/hardening process (a) arrangement of sample inside box (b) sealing/packing of box using fire clay and sodium silicate (c) steel box inside muffle furnace (d) steel box in heated condition	53
Figure 3.3	H455 HMT (Hindustan Machine Tools Ltd., India) surface grinding machine	55
Figure 3.4	Micrograph showing the cross section of the ground sample	63
Figure 3.5	Effect of tensile and compressive residual stress on XRD peak position (Gazzara, 1983)	64
Figure 3.6	Magnetic Barkhausen noise set-up	66
Figure 3.7	Typical Barkhausen noise burst as received from ground unhardened low carbon steel	66
Figure 3.8	Typical Barkhausen noise burst as received from ground hardened low carbon steel	67
Figure 3.9	Typical hysteresis loop as received from ground steel	68
Figure 4.1	Variation in tangential grinding forces with downfeed under different work velocity conditions for (a) dry grinding (b) wet grinding	70
Figure 4.2	Variation in normal grinding forces with downfeed under different work velocity conditions for (a) dry grinding (b) wet grinding	71
Figure 4.3	Variation of specific grinding energy with downfeed under different work velocity conditions (a) dry grinding (b) wet grinding	72
Figure 4.4	Variation of grinding zone temperature with downfeed under different work velocity conditions (a) dry	73

grinding (b) wet grinding

Figure 4.5 Variation of surface roughness with downfeed under different work velocity conditions (a) dry grinding (b) wet grinding 75

Figure 4.6 SEM images of ground surface for (a) dry grinding, (V_w-12m/min, downfeed- 6μm) (b) dry grinding, (V_w-12m/min, downfeed- 24μm) (c) wet grinding, (V_w-12m/min, downfeed- 6μm) (d) wet grinding, (V_w-12m/min, downfeed- 24μm) 76

Figure 4.7 Variation in subsurface microstructure of ground sample at 200x and at a downfeed of 24μm and work velocity of 12m/min for (a) dry grinding (b) wet grinding 77

Figure 4.8 Variation of microhardness under different downfeed, work velocity and grinding condition (dry and wet) 79

Figure 4.9 Microhardness profile of ground surface along the depth from the surface under different grinding conditions 79

Figure 4.10 X-ray diffraction profile of ground surface at highest work velocity with lowest and highest downfeed condition (a) dry grinding (b) wet grinding 81

Figure 4.11 Variation in peak shift with grinding zone temperature 82

Figure 4.12 Effect of grinding parameter on Barkhausen noise (a) dry grinding (b) wet grinding 83

Figure 4.13 Effect of surface roughness on Barkhausen noise 84

Figure 4.14 Variation in as received Barkhausen noise signal acquired from software for (a) higher peak shift/residual stress (b) lowest peak shift/residual stress conditions 85

Figure 4.15 Variation in root mean square value of Barkhausen noise signal with peak shift 85

Figure 4.16 Effect of grinding parameter on average permeability (a) dry grinding (b) wet grinding 86

Figure 4.17 Effect of surface roughness on average permeability 87

Figure 4.18 Variation in as received hysteresis loop acquire from software for different peak shift condition for different work velocity (a) 8m/min (b) 12m/min 88

Figure 4.19 Variation in average permeability value derived from hysteresis loop with peak shift 89

Figure 4.20 Variation in tangential grinding forces with downfeed under different work velocity conditions for (a) dry grinding (b) wet grinding 91

Figure 4.21 Variation in normal grinding forces with downfeed under different work velocity conditions for (a) dry grinding (b) wet grinding 92

Figure 4.22 Variation in specific grinding energy with downfeed under different work velocity conditions (a) dry grinding (b) wet grinding 93

Figure 4.23 Variation of grinding zone temperature with downfeed under different work velocity conditions (a) dry grinding (b) wet grinding 94

Figure 4.24 Variation of surface roughness with downfeed under different work velocity conditions (a) dry grinding (b) wet grinding 95

Figure 4.25 SEM images of ground hardened steel for (a) dry grinding, (V_w -12m/min, downfeed-6µm) (b) dry grinding, (V_w -12m/min, downfeed-24µm) (c) wet grinding, (V_w -12m/min, downfeed-6µm) (d) wet grinding, (V_w -12m/min, downfeed-24µm) 96

Figure 4.26 Variation in subsurface microstructure of ground sample at 200x for highest thermal damage (a) dry grinding (V_w -8m/min, downfeed-24 µm) (b) wet grinding (V_w-12m/min, downfeed-24 µm) 97

Figure 4.27 Variation of microhardness under different downfeed, work velocity and grinding condition (dry and wet) 98

Figure 4.28 Microhardness profile of ground surface along the depth from the surface under different grinding 99

conditions

Figure 4.29 X-ray diffraction profile of ground hardened surface (a) dry grinding (b) wet grinding 100

Figure 4.30 Variation in peak shift with grinding zone temperature for hardened steel 101

Figure 4.31 Effect of grinding parameter on Barkhausen noise (a) dry grinding (b) wet grinding 102

Figure 4.32 Variation in root mean square value of Barkhausen noise signal with peak shift for ground hardened steel 103

Figure 4.33 A snapshot showing the Barkhausen noise signal obtained from hardened steel 104

Figure 4.34 Effect of grinding parameter on average permeability for hardened steel (a) dry grinding (b) wet grinding 105

Figure 4.35 Variation in average permeability value derived from hysteresis loop with peak shift during grinding of hardened steel 106

Figure 5.1 The correlation between (a) BN (rms), peak shift and grinding temperature (b) Average permeability, peak shift and grinding temperature in unhardened steel 108

Figure 5.1 The correlation between (a) BN (rms), peak shift and grinding temperature (b) Average permeability, peak shift and grinding temperature in hardened steel 109