

IZDELOVALNE TEHNOLOGIJE 2

UČNI NAČRT PREDMETA/COURSE SYLLABUS

Predmet:	Izdelovalne tehnologije 2
Course title:	Manufacturing Technologies 2
Članica nosilka/UL Member:	UL FS

Študijski programi in stopnja	Študijska smer	Letnik	Semestri	Izbirnost
Strojništvo - razvojno raziskovalni program, prva stopnja, univerzitetni (od študijskega leta 2026/2027 dalje)	Ni členitve (študijski program)	3. letnik	1. semester	obvezni

Univerzitetna koda predmeta/University course code:	0562766
Koda učne enote na članici/UL Member course code:	2029-U

Predavanja /Lectures	Seminar /Seminar	Vaje /Tutorials	Klinične vaje /Clinical tutorials	Druge oblike študija /Other forms of study	Samostojno delo /Individual student work	ECTS
45		30			50	5

Nosilec predmeta/Lecturer:	izr. prof. dr. Damjan Klobčar, doc. dr. Uroš Trdan, izr. prof. dr. Joško Valentinčič
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Izvajalci predavanj:	
Izvajalci seminarjev:	
Izvajalci vaj:	
Izvajalci kliničnih vaj:	
Izvajalci drugih oblik:	
Izvajalci praktičnega usposabljanja:	

Vrsta predmeta/Course type:	Obvezni splošni predmet / Compulsory general course
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Jeziki/Languages:	Predavanja/Lectures:	Slovenščina
	Vaje/Tutorial:	Slovenščina

Pogoji za vključitev v delo oz. za opravljanje študijskih obveznosti:

Izpolnjevanje pogojev za vpis v Univerzitetni študijski program I. stopnje Strojništvo - Razvojno raziskovalni program.

Prerequisites:

Meeting the enrollment conditions for the Academic study programme of Mechanical Engineering - Research and Development program.

Vsebina:

1. Osnove tehnologij spajanja in obločnega varjenja;
 - pomen tehnologij spajanja in vrste tehnologij,
 - aktivacijska energije mehanizmov spajanja,
 - delitev zvarnih spojev, lege pri varjenju,

Content (Syllabus outline):

1. Fundamentals of joining technologies and arc welding;
 - the importance of joining technologies and types of technologies,

- izkoristki pri obločnem varjenju, - varilni oblok in pihalni učinek, - viri varilnega toka 2. Ročno obločno varjenje, varjenje pod praškom (EPP) in pod žilindro (EPŽ); - principiellne sheme postopkov in statične karakteristike virov varilnega obloka, - vžig varilnega obloka, - varilni parametri in njihov izbor, - dodajni in pomožni materiali, - lege pri varjenju, - vrste zvarnih spojev, - uporaba postopkov. 3. Varjenje v zaščiti plinov (MIGMAG in TIG) in varjenje z visoko gostoto energije (plasma, laser in elektronski snop); - principiellne sheme postopkov in statične karakteristike virov varilnega obloka, - vžig varilnega obloka, - varilni parametri in njihov izbor, - dodajni in pomožni materiali, - lege pri varjenju, - vrste zvarnih spojev, - uporaba postopkov 4. Uporovno varjenje; - principiellne sheme postopkov: točkovno, bradavično, sočelno, obžigalno, visokofrekvenčno; - osnovni fizikalni principi, - vrste zvarnih spojev, - lastnosti elektrod za varjenje, - uporaba postopkov 5. Varjenje s kemično energijo in z mehansko energijo; - fizikalne osnove postopkov spajanja: plamensko varjenje, aluminotermično varjenje, eksplozijsko varjenje, kovaško varjenje, varjenje s trenjem, FSW, ultrazvočno varjenje, difuzijsko varjenje, - načini izvedbe, - vrste zvarnih spojev in primernost materialov, - prednosti in omejitve, - uporaba postopkov. 6. Spajkanje, lepljenje in hibridno spajanje; - osnovni fizikalni principi (omočljivost, difuzija, kapilarni učinek, površinska napetost, adhezijske in kohezijske sile), - delitve postopkov in načini ogrevanja pri spajkanju, - vrste spojev, - dodajni materiali in lastnosti spojev, - priprava površin, - uporaba postopkov. 7. Tehnike mehanskega spajanja, metalizacije in navarjanja ter 3D navarjanje kovin; - pregled in fizikalno ozadje postopkov mehanskega spajanja: kovičenja, samokovičenje, robljenje, - delitev postopkov metalizacije, - pregled in fizikalno ozadje postopkov nabrizgavanja (plamensko, plazemsko, lasersko),	• activation energies of joining mechanisms, • welding joints classification, welding positions, • arc welding efficiency, • welding arc and blowing effect, • welding power sources 1. Shielded metal arc welding, submerged arc welding (SAW) and electroslag welding; • schematic diagrams and static characteristics of welding power sources, • welding arc ignition, • welding parameters and their selection, • filler and auxiliary materials, • welding positions, • types of welding joints, • applications. 1. Shielding gas welding (GMAW and GTAW) and welding with high energy density (plasma, laser and electron beam); - schematic diagrams and static characteristics of welding power sources, - welding arc ignition, - welding parameters and their selection, - filler and auxiliary materials, - welding positions, - types of welding joints, - applications. 4. Resistance welding; - schematic diagrams of procedures: spot, projection, butt, flash, high frequency; - basic physical principles, - types of welding joints, - welding electrode properties, - applications. 5. Welding with chemical and mechanical energy; - the physics of the joining process: oxi-fuel welding, aluminothermic welding, explosion welding, forge welding, friction welding, FSW, ultrasonic welding, diffusion welding, - the implementation types, - the types of welding joints and the suitability of the materials, - advantages and limitations, - applications. 6. Soldering, adhesive bonding and hybrid joining; - basic physical principles (wettability, diffusion, capillary effect, surface tension, adhesion and cohesion forces), - the classification of processes and the methods of heating during soldering, - types of joints, - filler materials and joint properties, - surface preparation, - applications. 7. Technologies of mechanical joining, metallization, cladding and 3D cladding of metals; - overview and physical background of mechanical joining processes: riveting, self-riveting, roller hemming,
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pregled in fizikalno ozadje postopkov navarjanja, - vrste in posebnosti spojev ter lastnosti, - oprema za izvedbo spojev, - uporaba postopkov mehanskega spajanja, nabrizgavanja in navarjanja. 8. Tehnologije spajanja polimernih materialov; - delitev postopkov spajanja polimerov, - posebnosti postopkov in fizikalno ozadje nastanka spojev, - vrste zvarnih spojev in lastnosti mesta spajanja, - prednosti in omejitve postopkov, - uporaba postopkov, - varivost polimernih materialov. 9. Osnove varivosti materialov; - varivost jekel in barvnih kovin, - ogljikov ekvivalent za jeklo, pomen temperature predgrevanja in medvarkovne temperature, - TTT diagrami in hitrosti ohlajanja zvarov, - Shaefflerjev diagram za nerjavno jeklo, - izbor dodatnih materialov in izbor tehnologij za spajanje določenih materialov in izdelkov, - varivost različnih materialov med seboj. 10. Toplotno rezanje materialov ter mehanizacija in robotizacija varjenja; - plamensko, plazemsko in lasersko rezanje materialov, - fizikalno ozadje pri toplotnem rezanju materialov, - sheme robotskih in CNC sistemov za varjenje in rezanje, - pomožne naprave za varjenje (vrtljive mize, sistemi za pozicioniranje, senzorji za uporabo v varilstvu) 11. Nekonvencionalni obdelovalni postopki in aditivne tehnologije; - primerjava procesov odrezavanja in odnašanja, - delitev postopkov odnašanja materiala glede na energijo in njihova primerjava, - uvod v aditivne tehnologije. 12. Delitev aditivnih tehnologij po standardu ISO/ASTM 52900-2015; - fotopolimerizacija v kadi, - brizganje veziva, - brizganje materiala, - ekstrudiranje materiala, - spajanje slojev praškastega materiala, - nalaganje krojenih plasti, - direktno energijsko odlaganje. 13. Potopna in žična elektroerozija: - mehanizmi odnašanja materiala (fizikalni opis enotskega dogodka), - nadzor in krmiljenje procesa, - obdelovalni parametri, - značilnosti obdelave, - stroji koncepti in pregled trga, - trendi razvoja. 14. Rezanje z vodnim in abrazivnim curkom: - oblikovanje visokohitrostnega vodnega in abrazivnega vodnega curka,	- classification of metallization processes, - overview and physical background of the spraying processes (oxi-flame, plasma, laser), overview and physical background of the weld cladding processes, - types and specificities of joints and properties, - equipment for joining technologies, - applications of mechanical joining, thermal spraying and weld cladding. 8. Joining technologies of polymers; - classification of polymer joining processes, - the specificities of the procedures and the physical background of the joint formations, - welding joints types and characteristics of the joining area, - advantages and limitations of procedures, - applications, - weldability of polymers. 9. Material weldability fundamentals; - weldability of steels and non-ferrous metals, - carbon equivalent for steel, the importance of preheating and inter-pass temperature, - TTT diagrams and weld cooling rates, - Shaeffler diagram for stainless steel, - the selection of filler materials and joining technologies for the materials and products, - weldability of dissimilar materials. 10. Thermal cutting of materials and mechanization and robotization of welding; - oxi-fuel, plasma and laser cutting of materials, - physical background in thermal cutting of materials, - schematics of the robotic and CNC systems for welding and cutting, - Welding auxiliaries (rotary tables, positioning systems, sensors for welding) 11. Non-conventional machining processes and additive manufacturing: • comparison of conventional and non-conventional machining processes, • classification of non-conventional machining processes according to the energy used in material removal, brief comparison, • introduction to additive manufacturing. 12. Classification of additive technologies according to the standard ISO/ASTM 52900-2015: • vat photopolymerisation, • binder jetting, • material jetting, • material extrusion, • powder bed fusion, • sheet lamination, • direct energy deposition. 13. Die-sinking EDM: • material removal mechanisms (physical description of the unit event), • monitor and control of the process, • machining parameters, • machining characteristics, • machine tools: concepts and market overview,
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- energija curka in mehanizmi odnašanja materiala (fizikalni opis enotskega dogodka), - obdelovalni parametri - značilnosti obdelave (standard SN 214001), - 5-osna obdelava, področja uporabe, - stroji: koncepti in pregled trga, - trendi razvoja. 15. Ekonomika nekonvencionalnih postopkov obdelave; - izračun časa obdelave, - cene strojne ure in stroškov izdelave, - analiza postavk v ceni strojne ure za potopno in žično elektroerozijo, rezanje z abrazivnim vodnim curkom in lasersko rezanje.	• development trends. 14. Water jet and abrasive water jet machining: • formation of high-speed water and abrasive water jet, • jet energy and material removal mechanisms (physical description of the unit event), • machining parameters, • machining characteristics (standard SN 214001), • 5-axis machining, applications, • machine tools: concepts and market overview. 15. Economics of non-conventional machining processes: • calculation of the machining time, • cost of machining hour and manufacturing costs, • analysis of machining hour costs for die-sinking EDM, wire EDM, abrasive water jet machining, and laser beam machining.
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Temeljna literatura in viri/Readings:

1. J. Tušek: Varjenje in sorodne tehnike spajanja materialov v neločljivo zvezo, Fakulteta za strojništvo, 2014, [COBISS.SI-ID [282414848](#)], ISBN - 978-961-6536-75-2.
2. L. Jeffus: Welding: Principles and applications, 6th ed., Clifton Park, Thomson Delmar Learning 2008, [COBISS.SI-ID [29767429](#)].
3. D. Klobčar: Izdelovalne tehnologije 2 : gradivo za predavanja iz tehnologije spajanja materialov : Raziskovalno razvojni program I. stopnje Strojništvo, letnik. Ljubljana: Fakulteta za strojništvo, 2023, Datoteka PDF (363 str.), [COBISS.SI-ID [168879619](#)].
4. J. Valentinčič idr.: Alternativne tehnologije, učbenik za tretji letnik visokošolskega strokovnega študijskega programa I. stopnje, Fakulteta za strojništvo, Ljubljana 2012. [COBISS.SI-ID [264698624](#)]
5. B. Guitrau, E.: The Electrical Discharge Machining Handbook. - Hanser Gardner Publications, Cincinnati, OH, USA, 1997. [COBISS.SI-ID [12200731](#)]
6. VALENTINČIČ, Joško, KLOBČAR, Damjan, LEBAR, Andrej. Nekonvencionalne tehnologije in tehnologije spajanja : izdelovalne tehnologije 2 : gradivo za vaje. Ljubljana: Fakulteta za strojništvo, 2014. [COBISS.SI-ID [13346843](#)]
7. A.W. Momber and R. Kovačević: Principles of Abrasive Water Jet Machining – Springer-Verlag London, 1998. [COBISS.SI-ID [18888453](#)]
8. Gibson, Ian idr.: Additive manufacturing technologies : 3D printing, rapid prototyping and direct digital manufacturing, New York : Springer, 2015 [COBISS.SI-ID [13909019](#)]
9. M.P. Groover idr.: Fundamentals of Modern Manufacturing – Materials, Processes, and Systems, 7th edition, John Wiley and Sons, 2020. [COBISS.SI-ID [146641667](#)]

Cilji in kompetence:

Cilji: 1. Identificirati in izbirati procese spajanja materialov in nekonvencionalnih izdelovalnih postopkov glede na zahtevane lastnosti materiala izdelka in njegovih obremenitev. 2. Spoznati načine za opredelitev in izbiro osnovnih parametrov procesov spajanja materialov in nekonvencionalnih izdelovalnih postopkov ter izvedbe aplikativnih tehnoloških rešitev. 3. Razumevati specifične tehnološke procese spajanja materialov ter njihovo ustrezno umeščanje v obstoječe proizvodne procese. 4. Spoznati ustrezne stroškovno-tehnološko učinkovite izbire procesov spajanja materialov in nekonvencionalnih izdelovalnih postopkov. Kompetence:	Objectives and competences: Goals: 1. Identification and selection of the joining processes and unconventional fabrication processes according to the required material properties of the product and its loads. 2. Learn ways to define and select the basic parameters of materials joining processes and unconventional manufacturing processes and implementation of applied technological solutions. 3. Understand the specifics of technological processes for joining materials and their proper placement in existing production processes. 4. Learn the appropriate cost-technologically efficient choices of materials joining processes and unconventional manufacturing processes.
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1. S1-RRP+ S2-RRP+P2- RRP: Sposobnost identifikacije in izbire procesa spajanja materialov in nekonvencionalnih izdelovalnih postopkov skladno z zahtevanimi lastnostmi materiala izdelka, okolja delovanja in obremenitev ter namena uporabe 2. S4-RRP+ S5-RRP+P3- RRP: Sposobnost opredelitve osnovnih tehnoloških parametrov posameznega procesa spajanja materialov in nekonvencionalnih izdelovalnih postopkov izdelave na osnovi strokovnega sporazumevanja in pisnega izražanja tudi v tujem jeziku 3. S6-RRP+ S7-RRP+P5- RRP: Sposobnost umestitve procesov spajanja v tehnološki proces proizvodnje na osnovi samostojnega pridobivanja znanj in kritične presoje informacij	Competencies: 1. S1-RRP + S2-RRP + P2-RRP: Ability to identify and select the process of joining materials and unconventional fabrication processes in accordance with the required material characteristics of the product, the operating environment and the load and purpose of use 2. S4-RRP + S5-RRP + P3- RRP: Ability to define the basic technological parameters of an individual process of joining materials and unconventional manufacturing processes based on professional communication and written expression even in a foreign language 3. S6-RRP + S7-RRP + P5-RRP: Ability to integrate joining processes into a technological production process based on independent knowledge acquisition and critical information assessment
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Predvideni študijski rezultati:	Intended learning outcomes:
Znanja: Poglobljeno strokovno teoretično in praktično znanje na področju tehnologij spajanja materialov in nekonvencionalnih izdelovalnih postopkov, podprto s širšo teoretično in metodološko osnovo. Spretnosti: S1.1 Izvajanje kompleksnih operativno-strokovnih opravil s področja tehnologij spajanja materialov in nekonvencionalnih izdelovalnih postopkov, ki vključujejo tudi uporabo metodoloških orodij. S1.3 Diagnosticiranje in reševanje izzivov v različnih specifičnih delovnih okoljih, povezanih s področjem tehnologij spajanja materialov in nekonvencionalnih izdelovalnih postopkov pridobljenih med izobraževanja in usposabljanja.	Knowledge: In-depth professional theoretical and practical knowledge in the field of materials joining technologies and unconventional manufacturing processes, supported by a broader theoretical and methodological basis. Skills: S1.1 Performing complex operational and technical tasks in the field of materials joining technologies and unconventional manufacturing processes, which also include the use of methodological tools. S1.3 Diagnosing and solving challenges in a variety of specific work environments related to the field of materials joining technologies and unconventional manufacturing processes acquired during education and training.

Metode poučevanja in učenja:	Learning and teaching methods:
P1 Avditorna predavanja z reševanjem izbranih - za področje značilnih - teoretičnih in praktično uporabnih primerov. P2 Obravnava snovi po urejeni in vnaprej razloženi sistematiki. P3 Avditorne vaje, kjer se teoretično znanje s predavanj podkrepi z računskimi primeri. P5 Uporaba študijskega gradiva v obliki: knjige, e-verzija predstavitve predavanj. P6 Interaktivna predavanja P7 Študij literature in razprava P8 Izdelava in predstavitev aplikativnih seminarskih nalog P10 Uporaba anket v realnem času P15 Uporaba video vsebin kot priprava na predavanja in vaje	P1 Lectures by solving selected – typical for the field - theoretical and practical examples. P2 Subject matter treatment according to an orderly and pre-explained systematics. P3 Practical classes where theoretical knowledge from lectures is backing by computational examples. P5 Use of study materials in the form of: books, e-version of lecture presentation. P6 Interactive Lectures P7 Literature studies and discussion P8 Design and presentation of applied seminar papers P10 Use of surveys in real time P15 Use of video content to prepare for lectures and tutorials

Načini ocenjevanja:

Delež/Weight Assessment:

Teoretične vsebine (predavanja).	60,00 %	Theoretical content (lectures).
Delo na laboratorijskih vajah (vključno s poročili).	40,00 %	Laboratory work (including reports).

Ocenjevalna lestvica:

5 - 10, pri čemer velja, da je pozitivna ocena od 6 - 10

Grading system:

5 - 10, a student passes the exam if he is graded from 6 to 10

Reference nosilca/Lecturer's references:

Damjan Klobčar:

1. TRDAN, Uroš, **KLOBČAR, Damjan**, BERTHE, Laurent, ŠTURM, Roman, BERGANT, Zoran. High-cycle fatigue enhancement of dissimilar 2017A-T451/7075-T651 Al alloy joint fabricated by a single pass FSW without any post-processing. *Journal of Materials Research and Technology*. Jul.-Aug. 2023, vol. 25, str. 2333-2352, ilustr. ISSN 2238-7854. <https://www.sciencedirect.com/science/article/pii/S2238785423013443>, <https://repozitorij.uni-lj.si/IzpisGradiva.php?id=147129>, DOI: [10.1016/j.jmrt.2023.06.096](https://doi.org/10.1016/j.jmrt.2023.06.096). [COBISS.SI-ID [156182275](https://cobiss.si/156182275)]
2. ĐURIĆ, Aleksija, MILČIĆ, Dragan, BURZIĆ, Zijah, **KLOBČAR, Damjan**, MILČIĆ, Miodrag, MARKOVIĆ, Biljana, KRSTIĆ, Vladislav. Microstructure and fatigue properties of resistance element welded joints of DP500 steel and AW 5754 H22 aluminum alloy. *Crystals*. Feb. 2022, vol. 12, iss. 2, str. 1-15, ilustr. ISSN 2073-4352. <https://www.mdpi.com/2073-4352/12/2/258>, <https://repozitorij.uni-lj.si/IzpisGradiva.php?id=137698>, DOI: [10.3390/cryst12020258](https://doi.org/10.3390/cryst12020258). [COBISS.SI-ID [112978691](https://cobiss.si/112978691)]
3. ZDRAVKOVIĆ, Nataša, **KLOBČAR, Damjan**, MILČIĆ, Dragan, ZUPANČIČ, Matevž, ŽUŽEK, Borut, MILČIĆ, Miodrag, ĐURIĆ, Aleksija. Influence of surface preparation of aluminum alloy AW-5754 and stainless steel X5CRNI18-10 on the properties of bonded joints. *Materials*. May 2024, vol. 17, iss. 11, [article no.] 2561, str. 1-19, ilustr. ISSN 1996-1944. <https://www.mdpi.com/1996-1944/17/11/2561>, DOI: [10.3390/ma17112561](https://doi.org/10.3390/ma17112561). [COBISS.SI-ID [197248003](https://cobiss.si/197248003)]
4. ŠČETINEC, Aljaž, **KLOBČAR, Damjan**, NAGODE, Aleš, VUHERER, Tomaž, BRAČUN, Drago, TRDAN, Uroš. Optimisation of precipitation hardening for 15-5 PH martensitic stainless steel produced by wire arc directed energy deposition. *Science and technology of welding and joining*. 2023, vol. 28, iss. 7, str. 558-568, ilustr. ISSN 1362-1718. <https://www.tandfonline.com/doi/full/10.1080/13621718.2023.2202979>, DOI: [10.1080/13621718.2023.2202979](https://doi.org/10.1080/13621718.2023.2202979). [COBISS.SI-ID [150180355](https://cobiss.si/150180355)]
5. LOGAR, Andraž, **KLOBČAR, Damjan**, TRDAN, Uroš, NAGODE, Aleš, ČERNIVEC, Gregor, VUHERER, Tomaž. Impact of ultrasonic welding parameters on weldability and sustainability of solid copper wires with and without varnish. *Materials*. 2024, vol. 17, iss. 20, art. 5033, str. 1-17, ilustr. ISSN 1996-1944. <https://www.mdpi.com/1996-1944/17/20/5033>, DOI: [10.3390/ma17205033](https://doi.org/10.3390/ma17205033). [COBISS.SI-ID [212105475](https://cobiss.si/212105475)]

Joško Valentinčič:

1. SABOTIN, Izidor, **VALENTINČIČ, Joško**, PLETERSKI, Matej, JERMAN, Marko, LEBAR, Andrej, DREŠAR, Pavel. An apparatus and a method for loosening a tube section from a tube plate : UK Patent GB 2576062 B, 2021-01-13. South Wales: Intellectual Property Office, 2021. [18] str., ilustr. [COBISS.SI-ID [17020955](https://cobiss.si/17020955)]
2. **VALENTINČIČ, Joško**, SABOTIN, Izidor, RESNIK, Matic, DREŠAR, Pavel, MATJAŽ, Nejc, JERMAN, Marko, LEBAR, Andrej, PLETERSKI, Matej. Apparatus and method for cutting an electrically conductive tube = Vorrichtung und verfahren zum schneiden eines elektrisch leitenden Rohres = Appareil et procédé pour couper un tube électriquement conducteur : European patent specification EP 3 603 866 B1, 2020-12-30. München: Europäisches Patentamt, 2020. 17 str [COBISS.SI-ID [17020699](https://cobiss.si/17020699)]
3. JERMAN, Marko, KRINKE, Stefan, KÜHNEL, Lisa, MÜLLER, Magdalena, **VALENTINČIČ, Joško**, ZEIDLER, Henning. Additive manufacturing using renewable materials: concept of upcycling peach kernels for use in Binder Jetting and FFF. V: LEACH, Richard K. (ur.). Proceedings of the 20th International Conference of the European Society for Precision Engineering and Nanotechnology : June 8th - 12th June 2020, virtual conference. Bedford: Euspen. 2020, str. 123-124. [COBISS.SI-ID [34360835](https://cobiss.si/34360835)]
4. PARTHIBAN, M., KRISHNARAJ, V., SINDHUMATHI, R., **VALENTINČIČ, Joško**. Investigation on manufacturing of microtools made of tungsten carbide using wire electric discharge grinding (WEDG). *Journal of the Brazilian Society of Mechanical Sciences and Engineering*, ISSN 1678-5878. [Print ed.], Sept. 2017, vol. 39, iss. 9, str. 3571-3580. [COBISS.SI-ID [15600667](https://cobiss.si/15600667)]

5. JERMAN, Marko, LEBAR, Andrej, SABOTIN, Izidor, DREŠAR, Pavel, **VALENTINČIČ, Joško**. *Peskanje z lednim abrazivnim vodnim curkom (IceJet)*. Ljubljana: Fakulteta za strojništvo, 2019. 24 f., ilustr. [COBISS.SI-ID [17021979](#)].

Uroš Trdan:

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