

Contents

Foreword	xvii
Preface.....	xix
Acknowledgments	xxiii
Author.....	xxv
List of Symbols	xxvii
List of Abbreviations	xli
1. Machining Processes	1
1.1 Introduction	1
1.2 Historical Background	2
1.3 Classification of Machining Processes.....	4
1.3.1 Machining by Cutting.....	4
1.3.1.1 Form Cutting.....	5
1.3.1.2 Generation Cutting	5
1.3.1.3 Form and Generation Cutting	6
1.3.2 Machining by Abrasion	8
1.3.3 Machining by Erosion.....	11
1.3.3.1 Chemical and Electrochemical Erosion	11
1.3.3.2 Thermal Erosion.....	11
1.3.4 Combined Machining	12
1.3.5 Micromachining.....	13
1.4 Variables of Machining Processes	14
1.5 Machining Process Selection.....	15
Review Questions	16
2. Cutting Tools	17
2.1 Introduction	17
2.2 Tool Geometry	19
2.2.1 American (ASA) (Tool-in-Hand) (Coordinate) System	21
2.2.2 Tool Angles in Orthogonal System of Planes	22
2.2.3 Relationship between the ASA and Orthogonal Systems.....	26
2.2.4 Effect of Tool Setting	27
2.2.5 Effect of Tool Feed Motion.....	28
2.2.6 Solved Example	29
2.3 Tool Materials	29
2.3.1 Requirements of Tool Materials.....	29

2.3.2	Classification of Tool Materials.....	31
2.3.2.1	Ferrous Tool Materials.....	31
2.3.2.2	Nonferrous Tool Materials.....	33
2.3.2.3	Nanocoated Tools.....	42
	Problems.....	45
	Review Questions.....	46
3.	Mechanics of Orthogonal Cutting.....	47
3.1	Introduction.....	47
3.2	Chip Formation.....	47
3.2.1	Discontinuous Chip.....	48
3.2.2	Continuous Chip.....	49
3.2.3	Continuous Chip with a Built-Up Edge.....	51
3.3	Orthogonal Cutting.....	52
3.3.1	Force Diagram.....	54
3.3.2	Shear Angle.....	56
3.3.3	Shear Stress.....	58
3.3.4	Velocity Relations.....	58
3.3.5	Shear Strain.....	59
3.3.6	Rate of Strain.....	60
3.3.7	Theory of Ernst-Merchant.....	60
3.3.8	Theory of Lee and Shaffer.....	62
3.3.9	Experimental Verification.....	63
3.3.10	Energy Consideration.....	64
3.3.11	Solved Example.....	64
3.4	Heat Generation in Metal Cutting.....	66
3.4.1	Cutting Tool Temperature.....	68
3.4.2	Temperature at Shear Plane.....	70
3.4.3	Factors Affecting the Tool Temperature.....	71
3.4.3.1	Machining Conditions.....	72
3.4.3.2	Cutting Tool.....	72
3.4.3.3	Cutting Fluids.....	72
3.4.4	Temperature Measurement.....	77
3.4.5	Solved Example.....	78
	Problems.....	80
	Review Questions.....	84
4.	Tool Wear, Tool Life, and Economics of Metal Cutting.....	87
4.1	Tool Wear.....	87
4.1.1	Introduction.....	87
4.1.2	Forms of Tool Wear.....	88
4.1.2.1	Crater Wear.....	89
4.1.2.2	Flank Wear.....	90
4.1.3	Impact of Tool Wear.....	92

4.2	Tool Life	93
4.2.1	Formulation of Tool-Life Equation	93
4.2.2	Criteria for Judging the End of Tool Life.....	95
4.2.3	Factors Affecting the Tool Life.....	96
4.2.3.1	Cutting Conditions.....	96
4.2.3.2	Tool Geometry	96
4.2.3.3	Built-Up Edge Formation	97
4.2.3.4	Tool Material	97
4.2.3.5	Workpiece Material.....	97
4.2.3.6	Rigidity of the Machine Tool	98
4.2.3.7	Coolant.....	98
4.2.4	Solved Example	98
4.3	Economics of Metal Cutting	99
4.3.1	Cutting Speed for Minimum Cost.....	100
4.3.2	Cutting Speed for Minimum Time.....	104
4.3.3	Cutting Speed for Maximum Profit Rate.....	106
4.3.4	Solved Example	108
	Problems.....	109
	Review Questions	110
5.	Cutting Cylindrical Surfaces	113
5.1	Introduction	113
5.2	Turning	113
5.2.1	Cutting Tools	114
5.2.2	Cutting Speed, Feed, and Machining Time	114
5.2.3	Elements of Undeformed Chip	117
5.2.4	Cutting Forces, Power, and Removal Rate	118
5.2.5	Factors Affecting the Turning Forces.....	120
5.2.5.1	Factors Related to Tool.....	120
5.2.5.2	Factors Related to Workpiece.....	121
5.2.5.3	Factors Related to Cutting Conditions	121
5.2.6	Surface Finish	122
5.2.7	Assigning the Cutting Variables.....	125
5.2.8	Solved Example	125
5.3	Drilling	128
5.3.1	Drill Tool	129
5.3.2	Elements of Undeformed Chip	130
5.3.3	Cutting Forces, Torque, and Power	133
5.3.4	Factors Affecting the Drilling Forces.....	135
5.3.4.1	Factors Related to the Workpiece.....	136
5.3.4.2	Factors Related to the Drill Geometry	136
5.3.4.3	Factors Related to Drilling Conditions	137
5.3.5	Drilling Time	137
5.3.6	Dimensional Accuracy.....	138

5.3.7	Surface Quality.....	140
5.3.8	Selection of Drilling Conditions.....	140
5.3.9	Solved Example.....	140
5.4	Reaming.....	144
5.4.1	Finish Reamers.....	145
5.4.2	Elements of Undeformed Chip.....	146
5.4.3	Forces, Torque, and Power in Reaming.....	148
5.4.4	Reaming Time.....	149
5.4.5	Selection of the Reamer Diameter.....	150
5.4.6	Selection of Reaming Conditions.....	151
	Problems.....	153
	Review Questions.....	157
6.	Cutting Flat Surfaces	159
6.1	Introduction.....	159
6.2	Shaping and Planing.....	159
6.2.1	Shaper and Planer Tools.....	159
6.2.2	Elements of Undeformed Chip.....	160
6.2.3	Cutting Forces, Power, and Removal Rate.....	163
6.2.4	Shaping Time.....	164
6.2.5	Selection of Cutting Variables.....	165
6.2.6	Solved Example.....	165
6.3	Milling.....	168
6.3.1	Horizontal (Plain) Milling.....	169
6.3.1.1	Plain-Milling Cutters.....	172
6.3.1.2	Cutting Speed of Tool and Workpiece Feed.....	172
6.3.1.3	Elements of Undeformed Chip.....	173
6.3.1.4	Forces and Power in Milling.....	174
6.3.1.5	Surface Roughness in Plain Milling.....	177
6.3.1.6	Milling Time.....	178
6.3.1.7	Factors Affecting the Cutting Forces.....	179
6.3.1.8	Solved Example.....	180
6.3.2	Face Milling.....	181
6.3.2.1	Face-Milling Cutters.....	182
6.3.2.2	Elements of Undeformed Chip.....	182
6.3.2.3	Surface Roughness.....	186
6.3.2.4	Machining Time.....	187
6.3.2.5	Solved Example.....	188
6.3.3	Selection of Milling Conditions.....	189
6.4	Broaching.....	190
6.4.1	Broach Tool.....	195
6.4.2	Chip Formation in Broaching.....	198
6.4.3	Broaching Force and Power.....	199
6.4.4	Broaching Time.....	200

6.4.5	Accuracy and Surface Finish.....	201
6.4.6	Broach Design.....	202
6.4.7	Solved Example.....	204
	Problems.....	205
	Review Questions.....	210
7.	High-Speed Machining.....	211
7.1	Introduction.....	211
7.2	History of HSM.....	211
7.3	Chip Formation in HSM.....	212
7.4	Characteristics of HSM.....	214
7.5	Applications.....	216
7.6	Advantages of HSM.....	218
7.7	Limitations of HSM.....	219
	Review Questions.....	219
8.	Machining by Abrasion.....	221
8.1	Introduction.....	221
8.2	Grinding.....	224
8.2.1	Grinding Wheels.....	225
8.2.1.1	Abrasive Materials.....	225
8.2.1.2	Grain Size.....	226
8.2.1.3	Wheel Bond.....	227
8.2.1.4	Wheel Grade.....	227
8.2.1.5	Wheel Structure.....	228
8.2.1.6	Grinding-Wheel Designation.....	229
8.2.1.7	Wheel Shapes.....	229
8.2.1.8	Selection of Grinding Wheels.....	229
8.2.1.9	Wheel Balancing.....	233
8.2.1.10	Truing and Dressing.....	234
8.2.1.11	Temperature in Grinding.....	235
8.2.2	Wheel Wear.....	236
8.2.3	Economics of Grinding.....	238
8.2.4	Surface Roughness.....	239
8.3	Surface Grinding.....	240
8.3.1	Elements of Undeformed Chip.....	240
8.3.2	Cutting Forces, Power, and Removal Rate.....	243
8.3.3	Factors Affecting the Grinding Forces.....	244
8.3.4	Grinding Time.....	244
8.3.5	Solved Example.....	247
8.3.6	Surface Grinding Operations.....	247
8.3.6.1	Plain (Periphery) and Face Grinding with Reciprocating Feed.....	247
8.3.6.2	Surface Grinding with a Rotating Table.....	248
8.3.6.3	Creep-Feed Grinding.....	249

8.4	Cylindrical Grinding	250
8.4.1	Elements of Undeformed Chip	250
8.4.2	Forces, Power, and Removal Rate	252
8.4.3	Factors Affecting the Grinding Forces	253
8.4.4	Factors Affecting Surface Roughness	254
8.4.5	Solved Example	255
8.4.6	Cylindrical Grinding Operations	257
8.4.6.1	External Cylindrical Grinding	257
8.4.6.2	External Centerless Grinding	260
8.4.6.3	Internal Cylindrical Grinding	262
8.4.6.4	Internal Centerless Grinding	264
8.5	Wheel Speed and Workpiece Feed	266
	Problems	266
	Review Questions	269
9.	Abrasive Finishing Processes	271
9.1	Introduction	271
9.2	Honing	272
9.2.1	Honing Kinematics	274
9.2.2	Process Components	277
9.2.3	Process Description	278
9.2.4	Process Characteristics	278
9.3	Lapping	283
9.3.1	Process Components	284
9.3.2	Mechanics of Lapping	287
9.3.3	Process Characteristics	289
9.3.4	Lapping Operations	292
9.4	Superfinishing	294
9.4.1	Kinematics of Superfinishing	297
9.4.2	Process Characteristics	300
9.5	Polishing	302
9.6	Buffing	302
	Review Questions	303
10.	Modern Abrasive Processes	305
10.1	Ultrasonic Machining	305
10.1.1	Mechanism of Material Removal	307
10.1.2	Solved Example	310
10.1.3	Factors Affecting Material Removal Rate	313
10.1.4	Dimensional Accuracy	319
10.1.5	Surface Quality	320
10.1.6	Applications	321
10.2	Abrasive Jet Machining	323
10.2.1	Material Removal Rate	324
10.2.2	Applications	328

10.3	Abrasive Water Jet Machining	329
10.3.1	Process Characteristics.....	331
10.4	Abrasive Flow Machining.....	334
10.5	Magnetic Field Assisted Finishing Processes	338
10.5.1	Magnetic Abrasive Machining.....	339
10.5.1.1	Process Description.....	342
10.5.1.2	Process Characteristics	343
10.5.1.3	Material Removal Rate and Surface Finish	343
10.5.1.4	Applications	345
10.5.2	Magnetic Float Polishing	348
10.5.3	Magnetorheological Finishing	348
10.5.4	Magnetorheological Abrasive Flow Finishing	349
	Problems.....	351
	Review Questions	352
11.	Machining by Electrochemical Erosion	355
11.1	Introduction	355
11.2	Principles of ECM	355
11.3	Advantages and Disadvantages of ECM	357
11.3.1	Advantages	357
11.3.2	Disadvantages	357
11.4	Material Removal Rate by ECM.....	358
11.5	Solved Example	365
11.6	ECM Equipment.....	366
11.7	Process Characteristics.....	368
11.8	Economics of ECM.....	370
11.9	ECM Applications.....	371
11.10	Chemical Machining	376
	Problems.....	381
	Review Questions	383
12.	Machining by Thermal Erosion	385
12.1	Introduction	385
12.2	Electrodischarge Machining	385
12.2.1	Mechanism of Material Removal	386
12.2.2	EDM Machine.....	391
12.2.3	Material Removal Rates	394
12.2.4	Surface Integrity.....	396
12.2.5	Heat-Affected Zone	397
12.2.6	Applications.....	398
12.3	Laser Beam Machining	400
12.3.1	Material Removal Mechanism.....	402
12.3.2	Applications.....	403

- 12.4 Electron Beam Machining406
 - 12.4.1 Material Removal Process407
 - 12.4.2 Applications.....412
- 12.5 Ion Beam Machining415
- 12.6 Plasma Beam Machining416
 - 12.6.1 Material Removal Rate419
 - 12.6.2 Applications.....421
- Problems.....422
- Review Questions422
- 13. Combined Machining Processes425**
 - 13.1 Introduction425
 - 13.2 Electrochemical-Assisted Processes425
 - 13.2.1 Electrochemical Grinding427
 - 13.2.2 Electrochemical Honing428
 - 13.2.3 Electrochemical Superfinishing.....429
 - 13.2.4 Electrochemical Buffing.....430
 - 13.2.5 Ultrasonic-Assisted Electrochemical Machining.....431
 - 13.3 Thermal-Assisted Processes432
 - 13.3.1 Electroerosion Dissolution Machining.....432
 - 13.3.2 Abrasive Electrodischarge Grinding434
 - 13.3.3 Abrasive Electrodischarge Machining435
 - 13.3.4 EDM with Ultrasonic Assistance.....436
 - 13.3.5 Electrochemical Discharge Grinding437
 - 13.3.6 Brush Erosion Dissolution Mechanical Machining.....438
 - Problems.....439
 - Review Questions439
- 14. Micromachining441**
 - 14.1 Introduction441
 - 14.2 Conventional Micromachining.....442
 - 14.2.1 Diamond Microturning443
 - 14.2.2 Microdrilling444
 - 14.3 Abrasive Micromachining445
 - 14.3.1 Microgrinding445
 - 14.3.2 Magnetic Abrasive Microfinishing.....445
 - 14.3.3 Micro-Superfinishing446
 - 14.3.4 Microlapping447
 - 14.3.5 Micro-Ultrasonic Machining447
 - 14.4 Nonconventional Micromachining448
 - 14.4.1 Micromachining by Thermal Erosion448
 - 14.4.1.1 Micro-EDM.....449
 - 14.4.1.2 Laser Micromachining450
 - 14.4.2 Micromachining by Electrochemical Erosion454

14.4.3	Combined Micromachining Processes.....	456
14.4.3.1	Chemical-Assisted Mechanical Polishing	456
14.4.3.2	Mechanochemical Polishing.....	458
14.4.3.3	Electrolytic In-Process Dressing of Grinding Wheels	458
	Review Questions	459
15.	Machinability.....	461
15.1	Introduction.....	461
15.2	Conventional Machining	461
15.2.1	Judging Machinability	462
15.2.2	Relative Machinability	464
15.2.3	Factors Affecting Machinability.....	464
15.2.3.1	Condition of Work Material.....	465
15.2.3.2	Physical Properties of Work Materials.....	466
15.2.3.3	Machining Parameters	467
15.2.4	Machinability of Engineering Materials	468
15.2.4.1	Machinability of Steels and Alloy Steels	468
15.2.4.2	Machinability of Cast Irons	471
15.2.4.3	Machinability of Nonferrous Metals and Alloys	471
15.2.4.4	Machinability of Nonmetallic Materials	473
15.3	Nonconventional Machining.....	474
	Review Questions	480
16.	Machining Process Selection	483
16.1	Introduction.....	483
16.2	Factors Affecting Process Selection.....	483
16.2.1	Part Features.....	483
16.2.2	Part Material.....	485
16.2.3	Dimensional and Geometric Features	486
16.2.4	Surface Texture.....	487
16.2.5	Surface Integrity.....	491
16.2.6	Production Quantity.....	495
16.2.7	Production Cost.....	497
16.2.8	Environmental Impacts.....	498
16.2.9	Process and Machine Capability	499
	Review Questions	502
	References	503
	Index	507