MACHINING OPERATIONS AND MACHINE TOOLS

- Turning and Related Operations
- Drilling and Related Operations
- Milling
- Machining Centers and Turning Centers
- Other Machining Operations
- High Speed Machining

Machining

A material removal process in which a sharp cutting tool is used to mechanically cut away material so that the desired part geometry remains

- Most common application: to shape metal parts
- Machining is the most versatile and accurate of all manufacturing processes in its capability to produce a diversity of part geometries and geometric features
  - Casting can also produce a variety of shapes, but it lacks the precision and accuracy of machining

Classification of Machined Parts

1. *Rotational* - cylindrical or disk-like shape
2. *Nonrotational* (also called *prismatic*) - block-like or plate-like

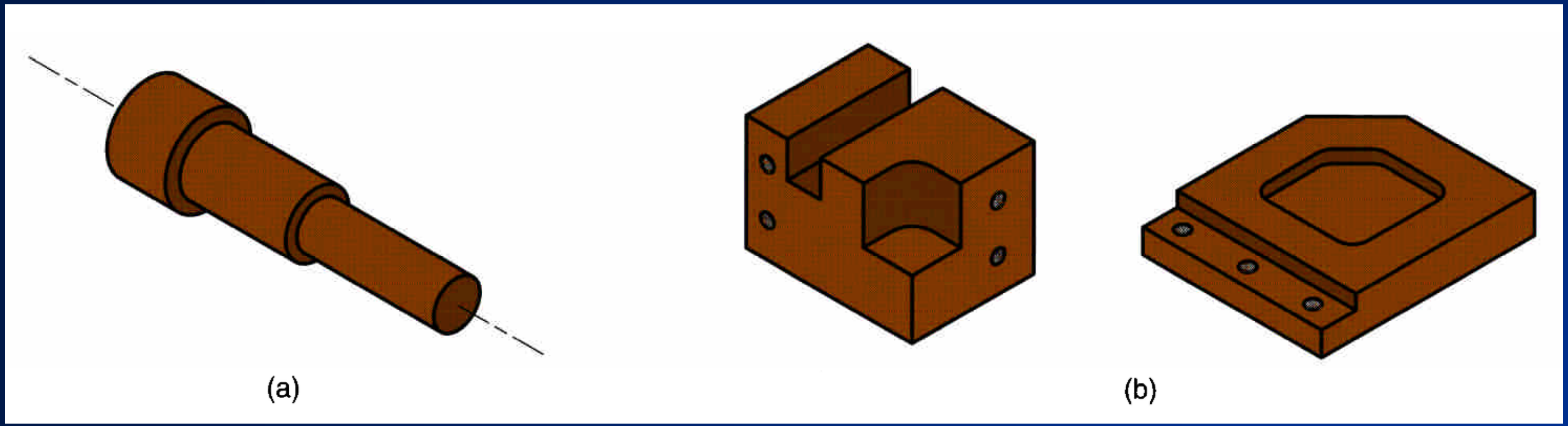


Figure 22.1 - Machined parts are classified as: (a) rotational, or (b) nonrotational, shown here by block and flat parts

Machining Operations and Part Geometry

Each machining operation produces a characteristic part geometry due to two factors:

1. Relative motions between the tool and the workpart
   - *Generating* – part geometry is determined by the feed trajectory of the cutting tool
2. Shape of the cutting tool
   - *Forming* – part geometry is created by the shape of the cutting tool

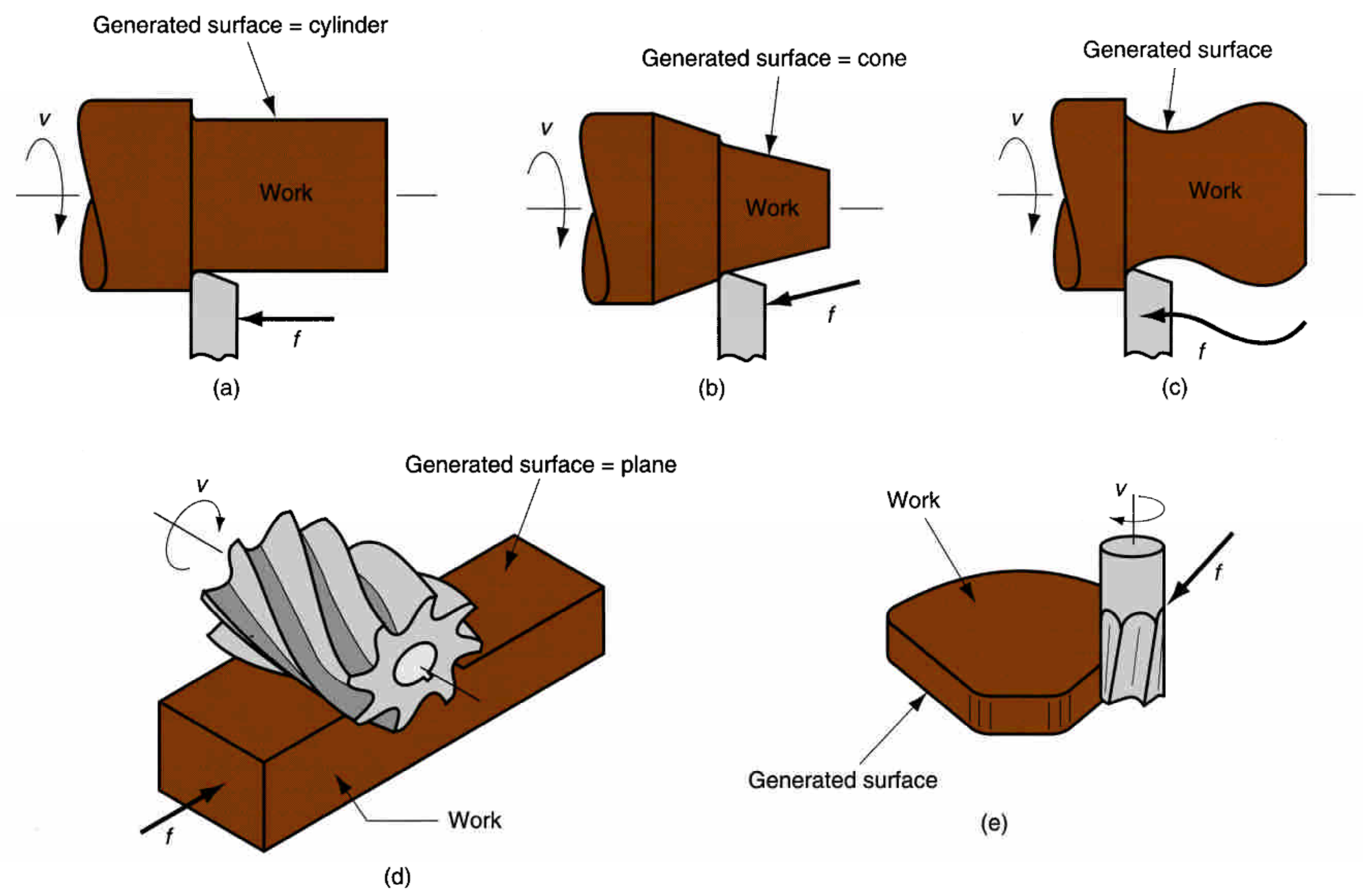


Figure 22.2 ‑ Generating shape: (a) straight turning, (b) taper turning, (c) contour turning, (d) plain milling, (e) profile milling

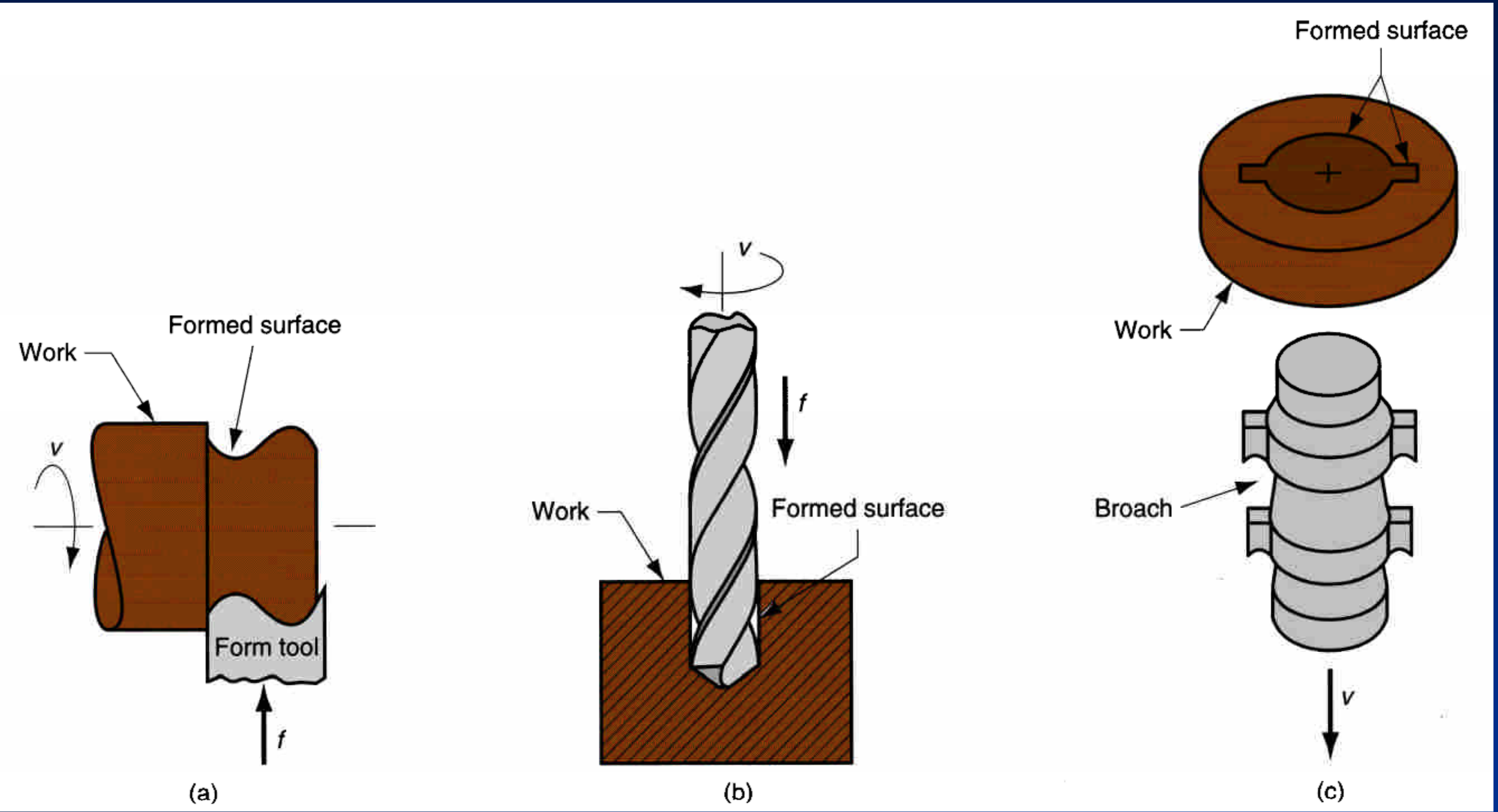


Figure 22.3 - Forming to create shape: (a) form turning, (b) drilling, and (c) broaching

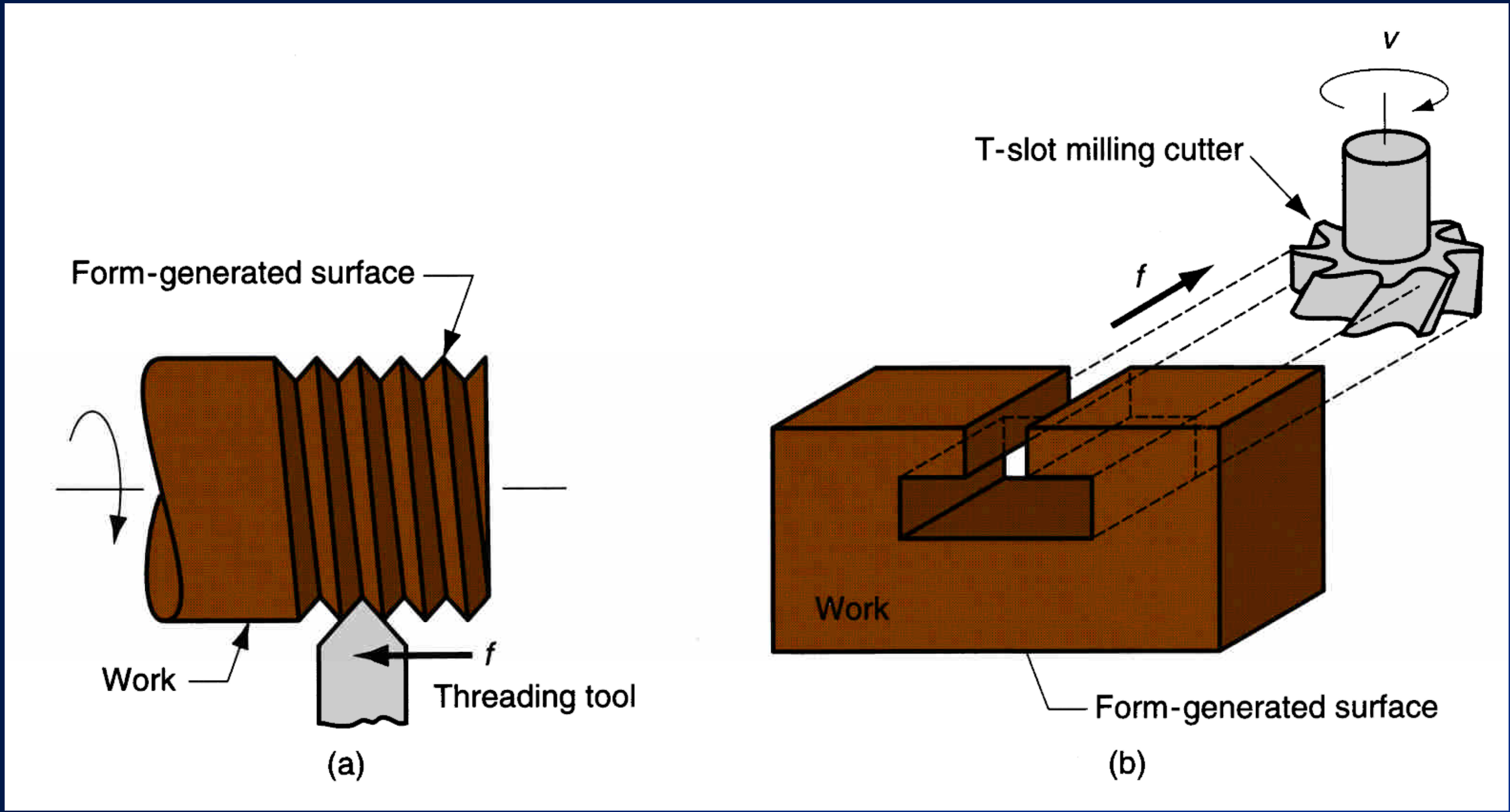


Figure 22.4 - Combination of forming and generating to create shape: (a) thread cutting on a lathe, and (b) slot milling

Turning

A single point cutting tool removes material from a rotating workpiece to generate a cylindrical shape

- Performed on a machine tool called a *lathe*
- Variations of turning that are performed on a lathe:
  - Facing
  - Contour turning
  - Chamfering
  - Cutoff
  - Threading

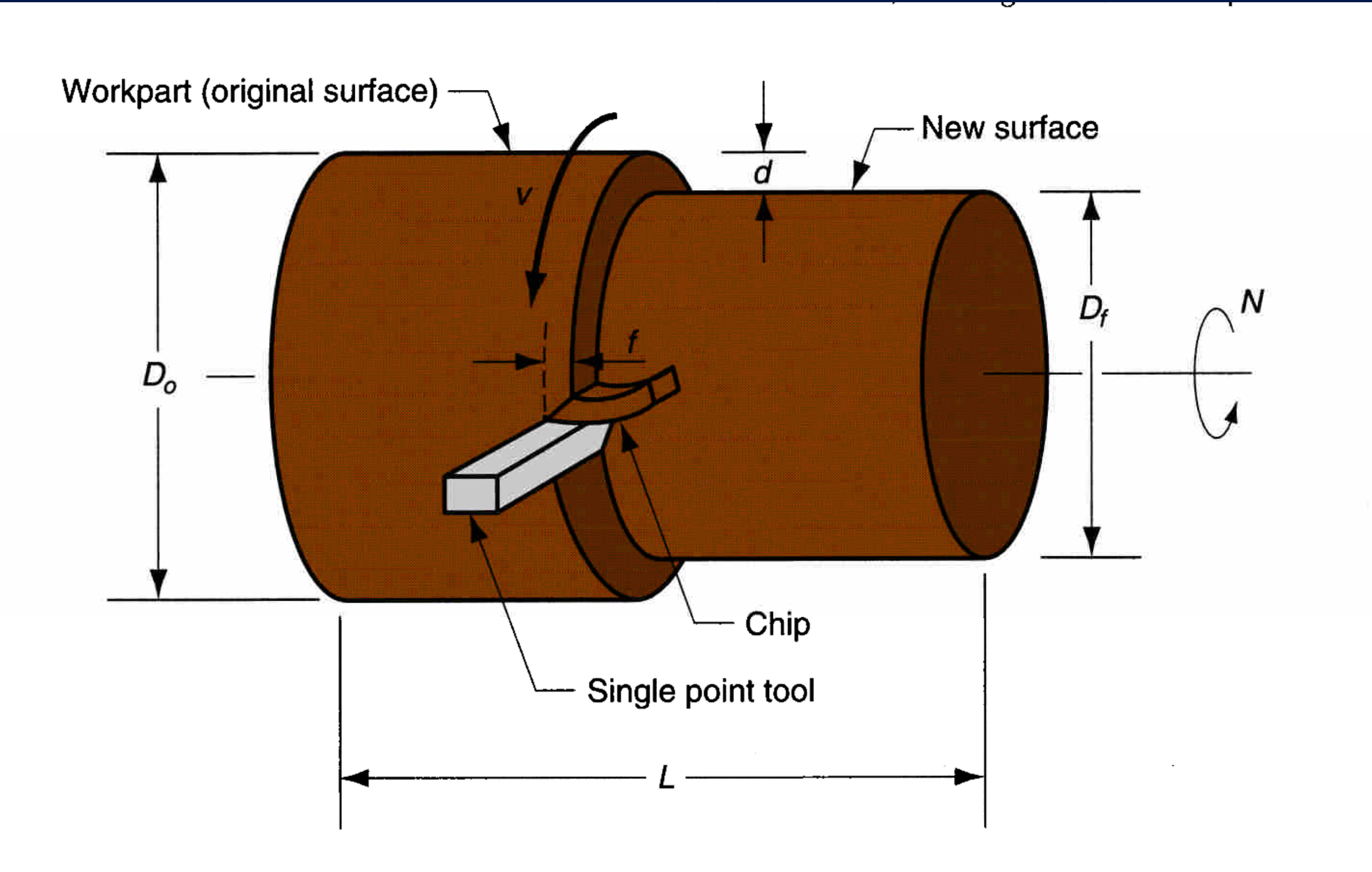


Figure 22.5 - Turning operation

Facing

Tool is fed radially inward

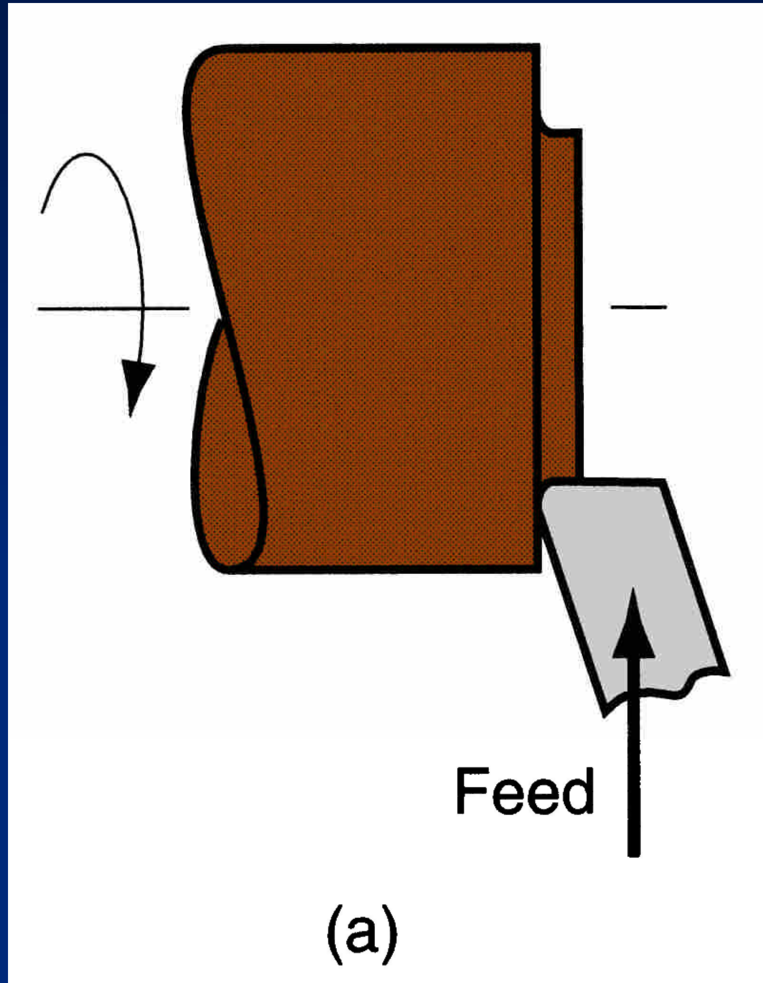


Figure 22.6 (a) facing

Contour Turning

Instead of feeding the tool parallel to the axis of rotation, tool follows a contour that is other than straight, thus creating a contoured form

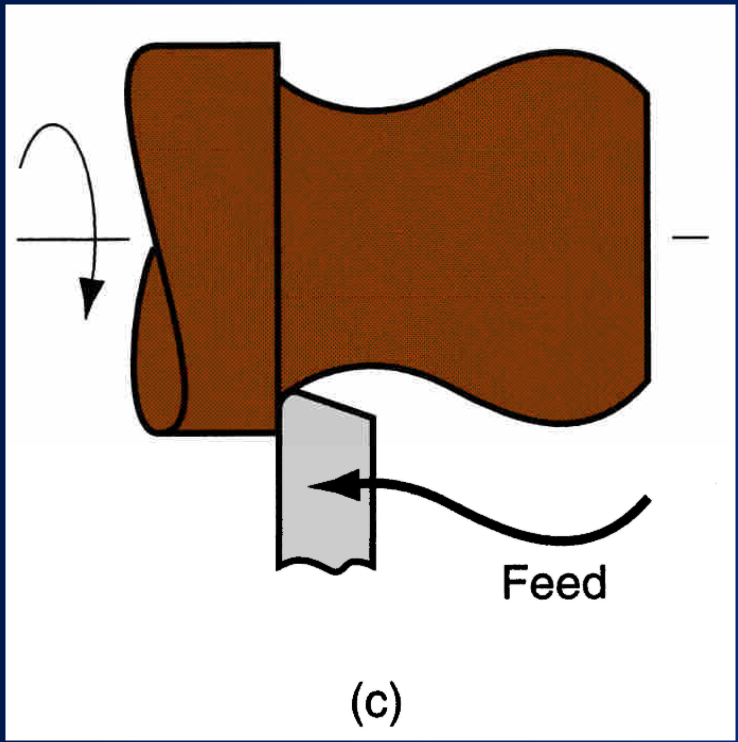


Figure 22.6 (c) contour turning

Chamfering

Cutting edge cuts an angle on the corner of the cylinder, forming a "chamfer"

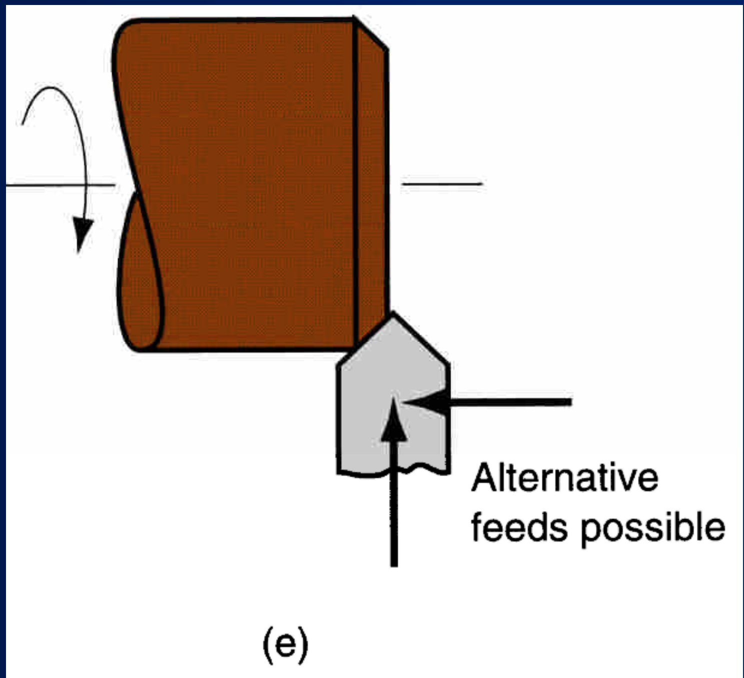


Figure 22.6 (e) chamfering

Cutoff

Tool is fed radially into rotating work at some location to cut off end of part

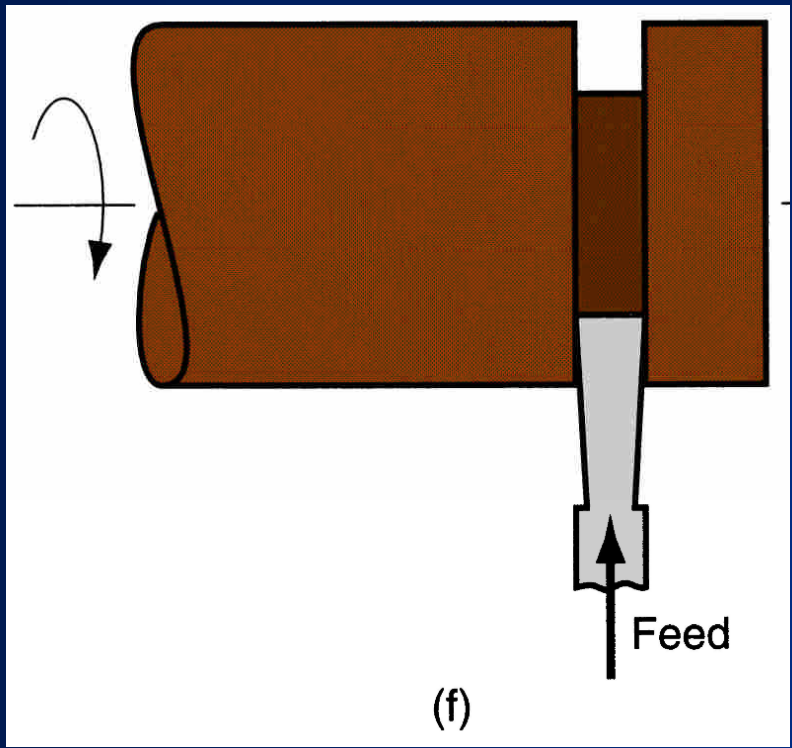


Figure 22.6 (f) cutoff

Threading

Pointed form tool is fed linearly across surface of rotating workpart parallel to axis of rotation at a large feed rate, thus creating threads

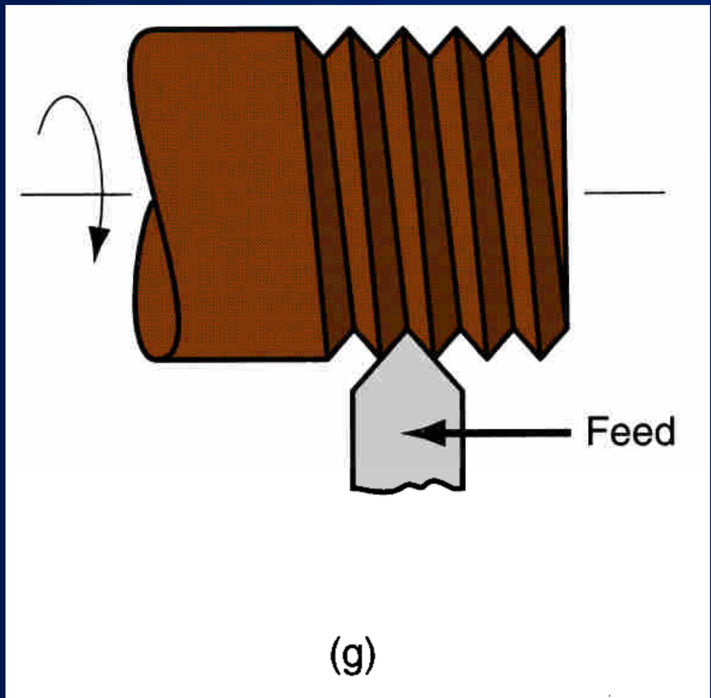


Figure 22.6 (g) threading

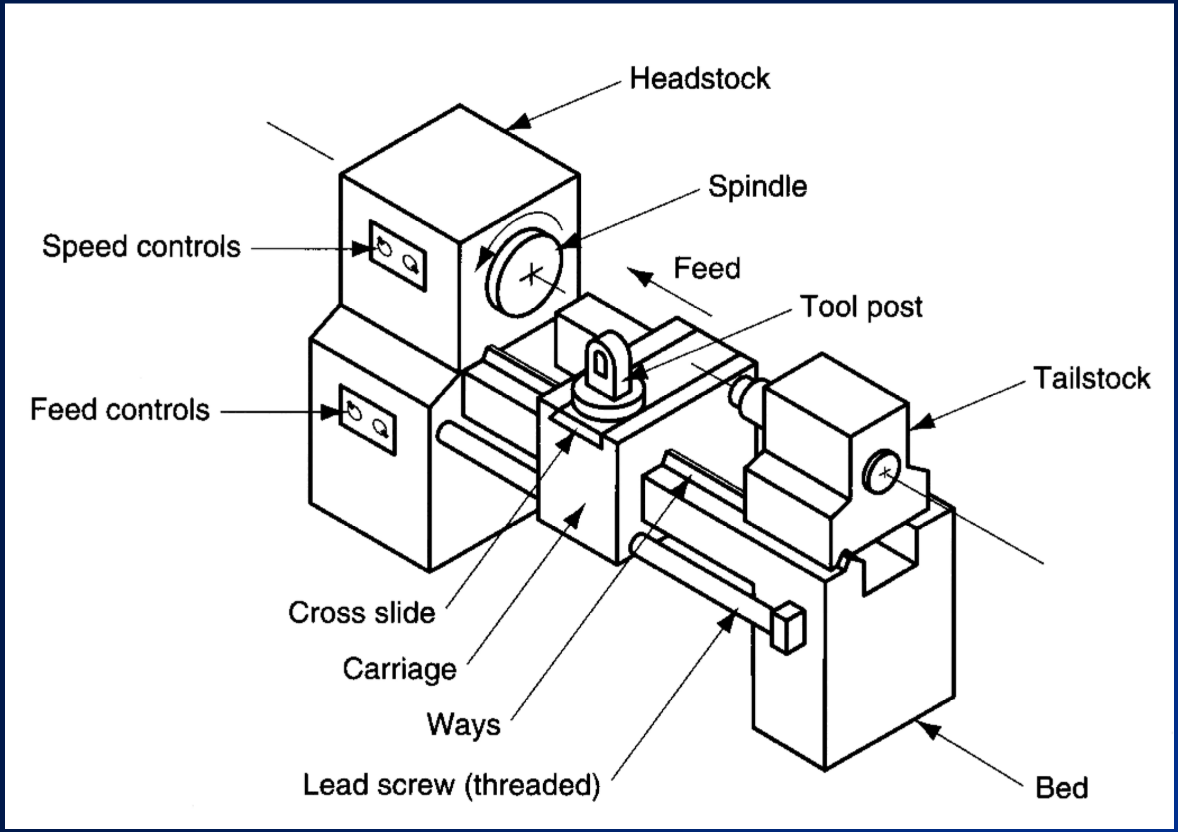


Figure 22.7 Diagram of an engine lathe, showing its principal components

Methods of Holding the Work in a Lathe

- Holding the work between centers
- Chuck
- Collet
- Face plate

Holding the Work Between Centers

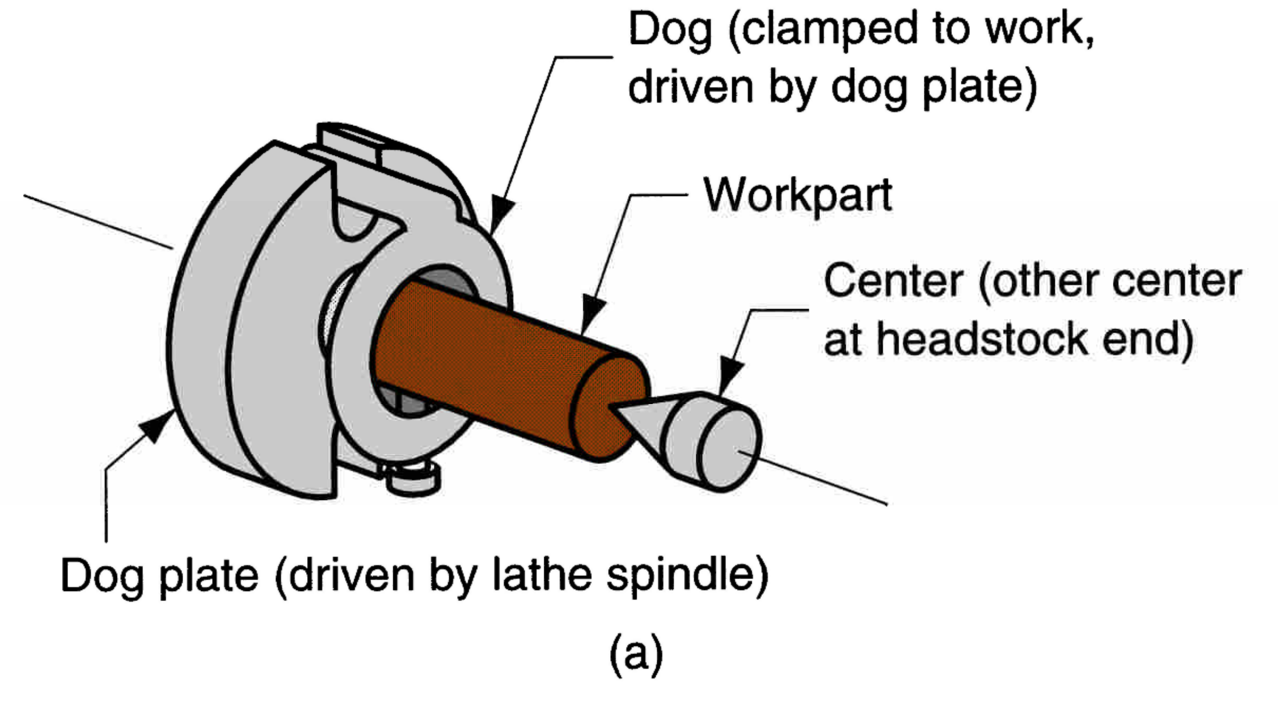


Figure 22.8 (a) mounting the work between centers using a "dog”

Chuck

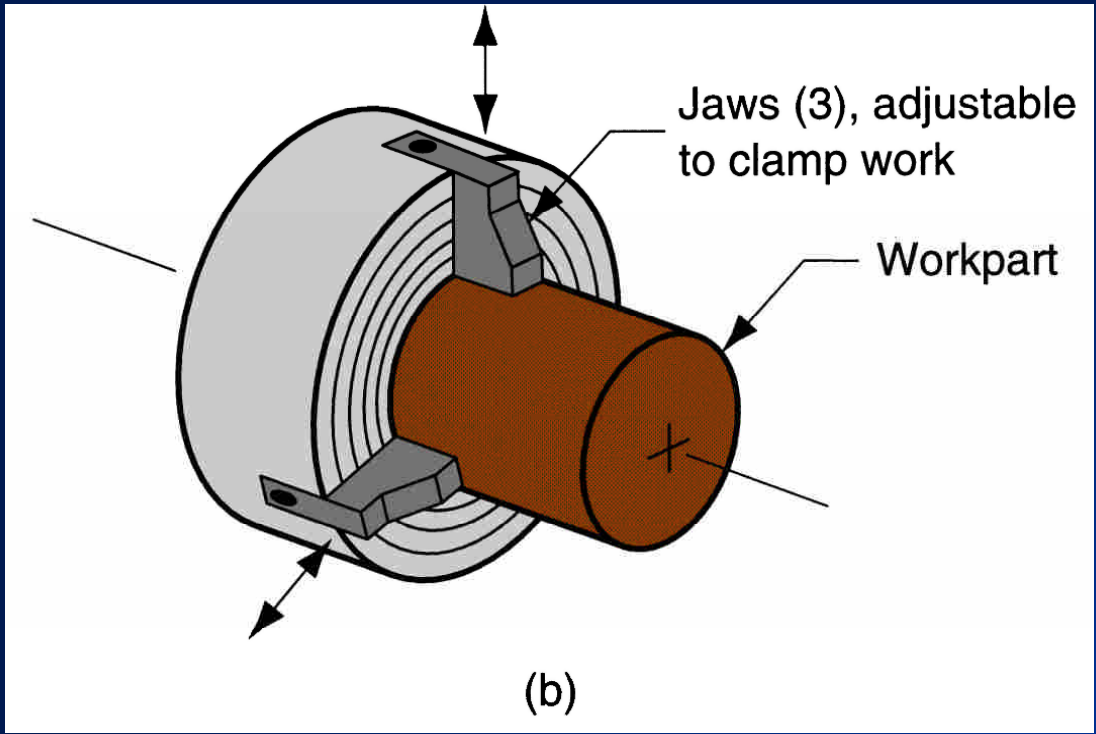


Figure 22.8 (b) three-jaw chuck

Collet

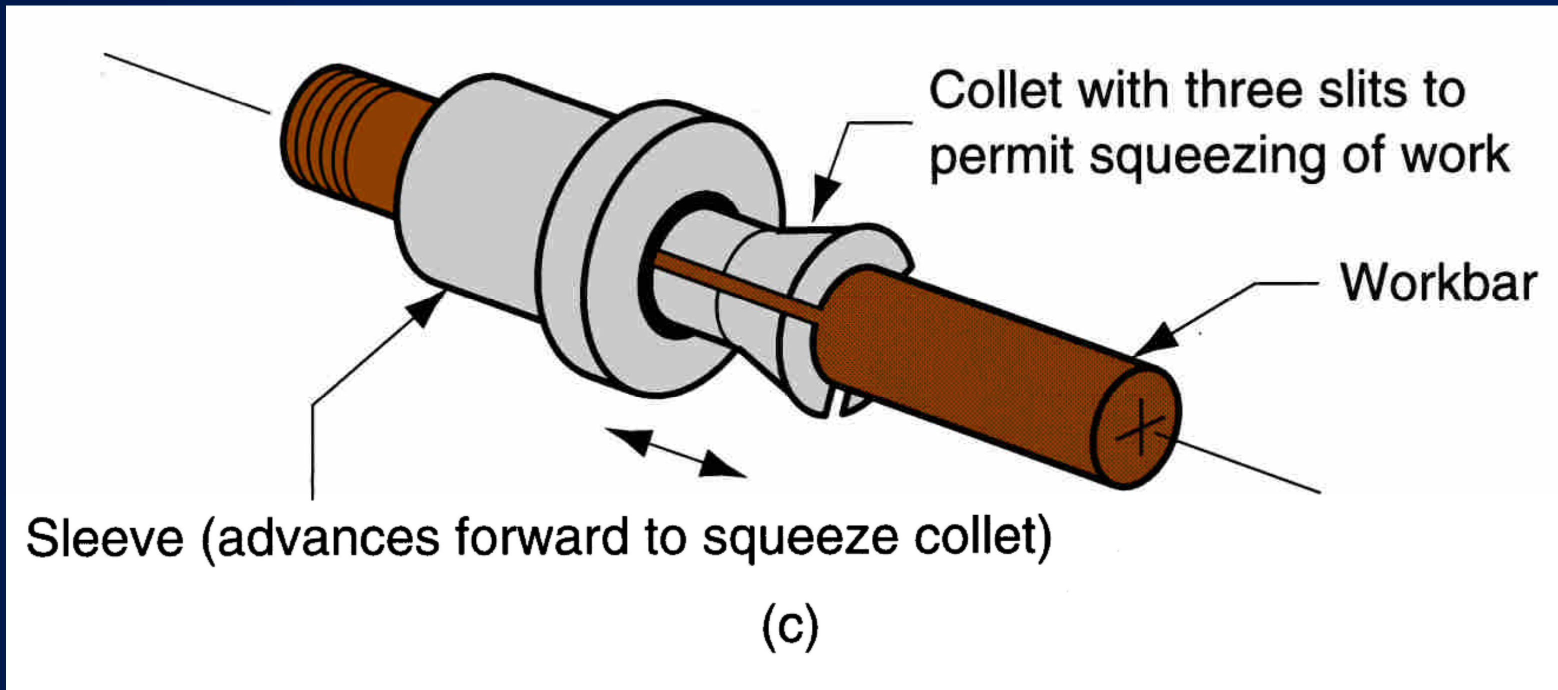


Figure 22.8 (c) collet

Face Plate

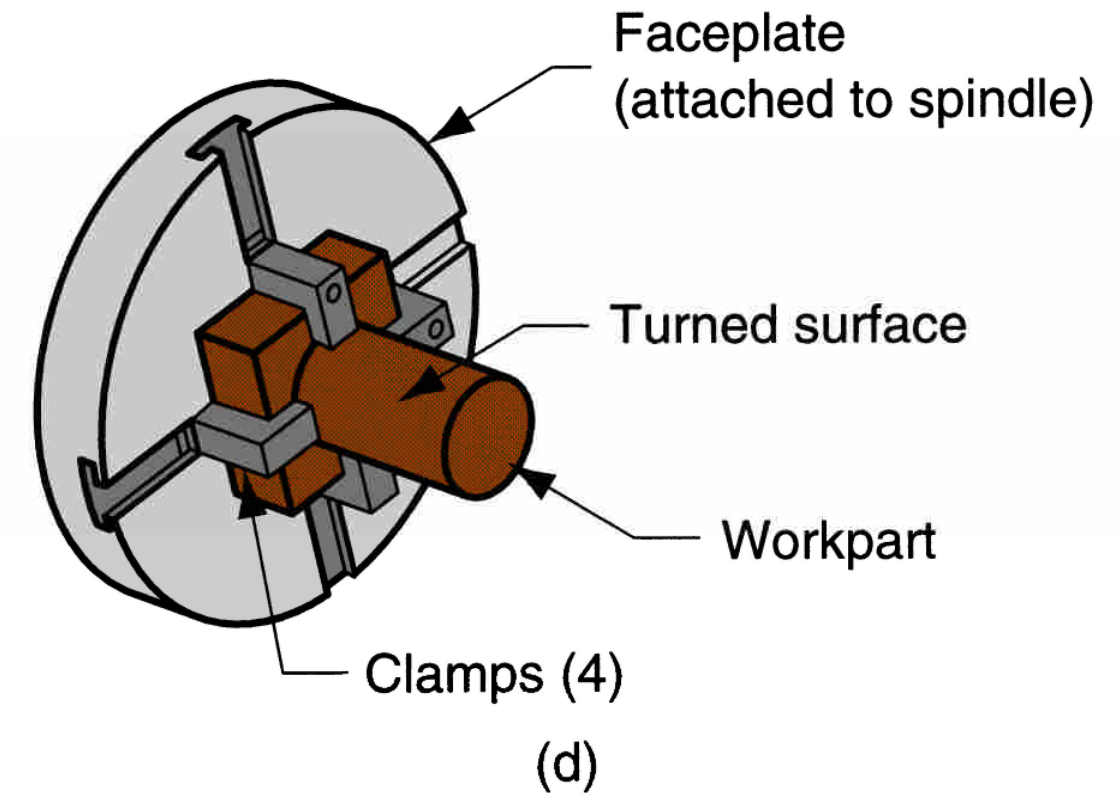


Figure 22.8 (d) face plate for non-cylindrical workparts

Turret Lathe

Tailstock replaced by “turret” that holds up to six tools

- Tools rapidly brought into action by indexing the turret
- Tool post replaced by four-sided turret to index four tools
- Applications: high production work that requires a sequence of cuts on the part

Chucking Machine

- Uses chuck in its spindle to hold workpart
- No tailstock, so parts cannot be mounted between centers
- Cutting tool actions controlled automatically
- Operator's job: to load and unload parts
- Applications: short, light-weight parts

Bar Machine

- Similar to chucking machine except collet replaces chuck, permitting long bar stock to be fed through headstock
- At the end of the machining cycle, a cutoff operation separates the new part
- Highly automated (the term *automatic bar machine* is often used)
- Applications: high production of rotational parts

Automatic Screw Machine

- Same as automatic bar machine but smaller
- Applications: high production of screws and similar small hardware items; hence, its name

Multiple Spindle Bar Machines

- More than one spindle, so multiple parts machined simultaneously by multiple tools
  - Example: six spindle automatic bar machine works on six parts at a time
- After each machining cycle, spindles (including collets and workbars) are indexed (rotated) to next position

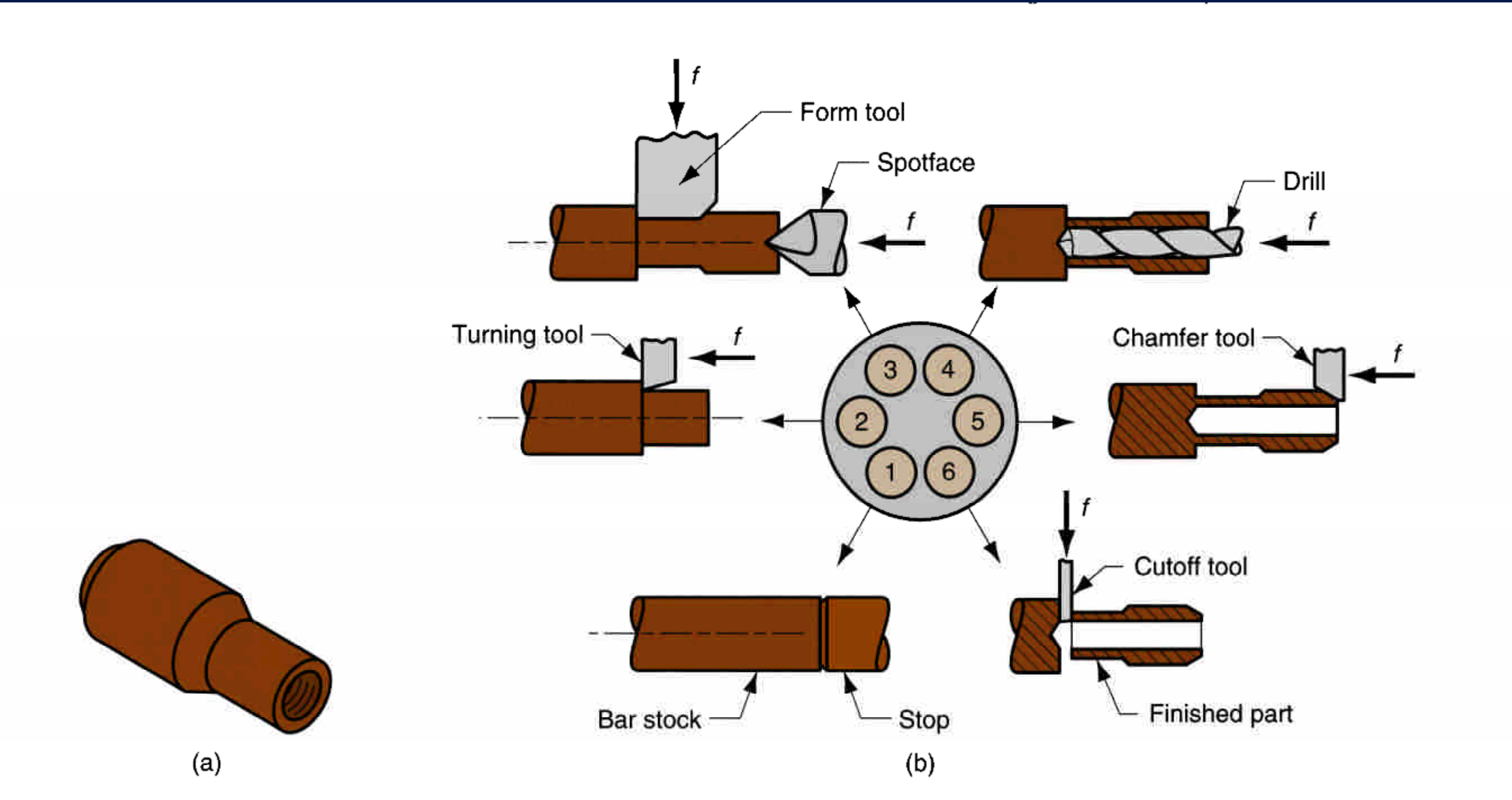


Figure 22.9 - (a) Part produced on a six-spindle automatic bar machine; and (b) sequence of operations to produce the part: (1) feed stock to stop, (2) turn main diameter, (3) form second diameter and spotface, (4) drill, (5) chamfer, and (6) cutoff

Boring

- Difference between boring and turning:
  - *Boring* is performed on the inside diameter of an existing hole
  - *Turning* is performed on the outside diameter of an existing cylinder
- In effect, boring is an internal turning operation
- Boring machines
  - Horizontal or vertical - refers to the orientation of the axis of rotation of machine spindle

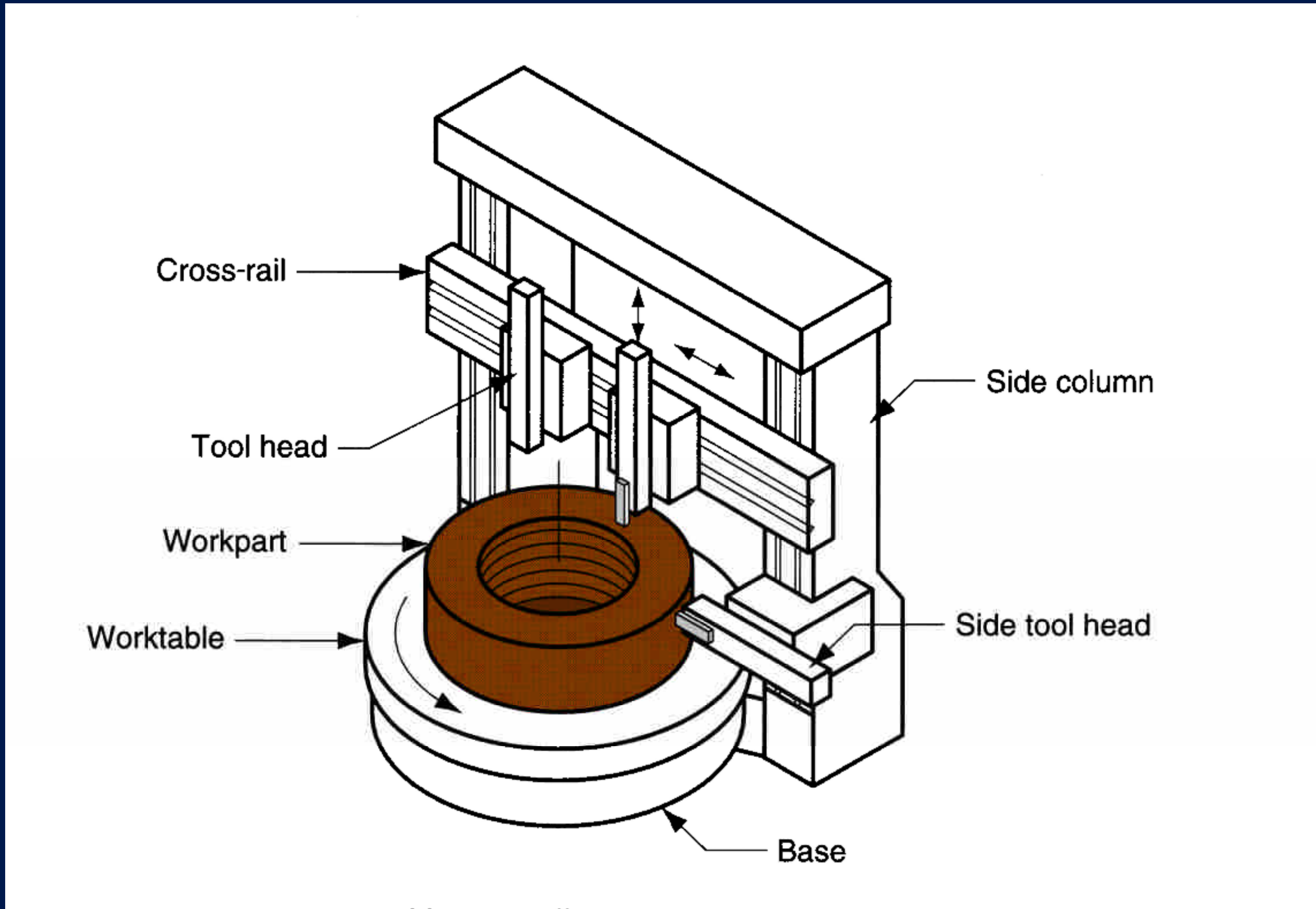


Figure 22.12 - A vertical boring mill –for large, heavy workparts

Drilling

- Creates a round hole in a workpart
- Contrasts with boring which can only enlarge an existing hole
- Cutting tool called a *drill* or *drill bit*
- Customarily performed on a *drill press*

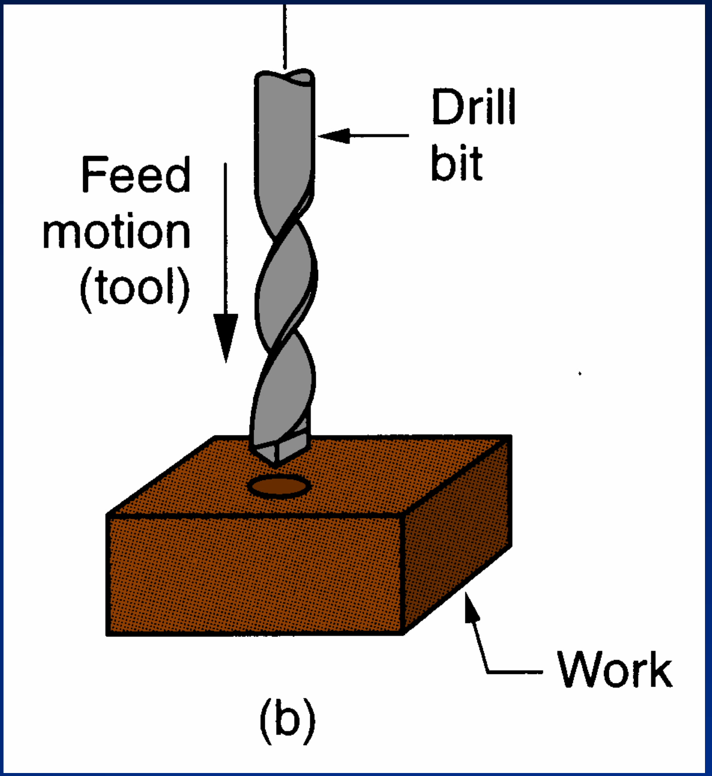


Figure 21.3 (b) drilling

Through Holes vs. Blind Holes

Through-holes - drill exits the opposite side of work

Blind-holes – drill does not exit work on opposite side

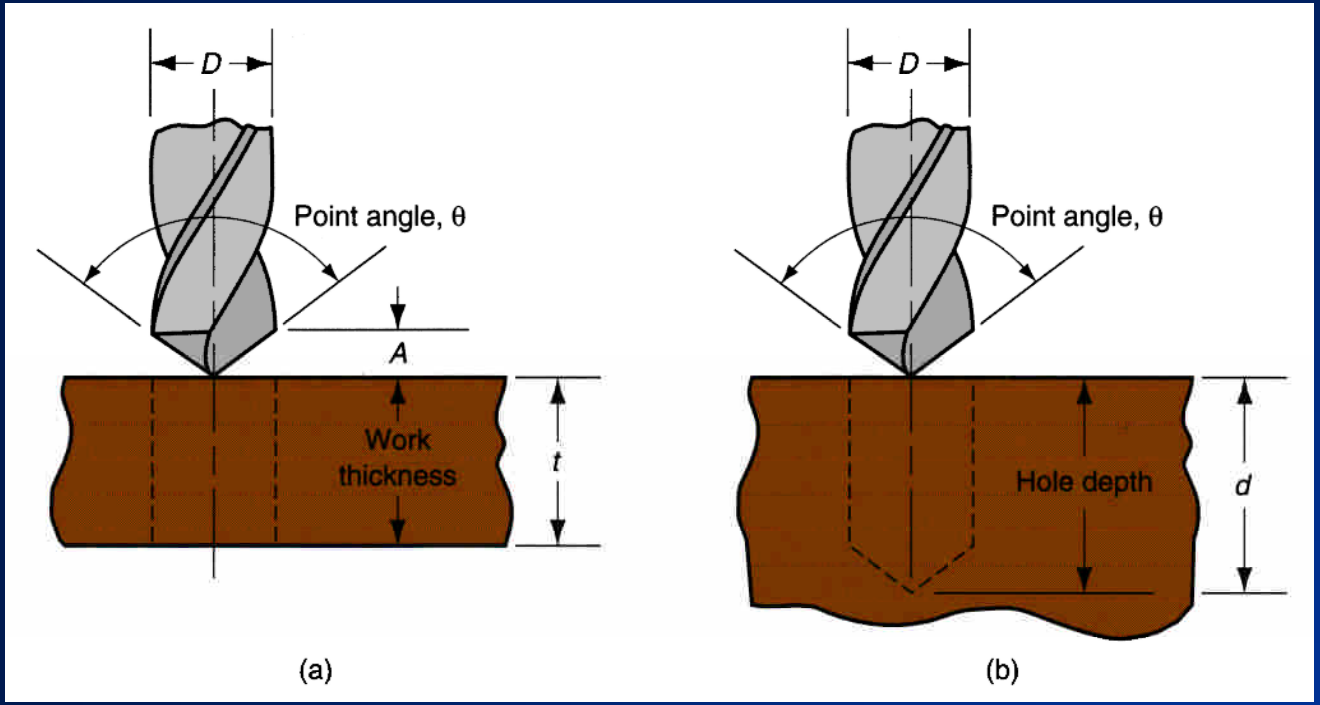
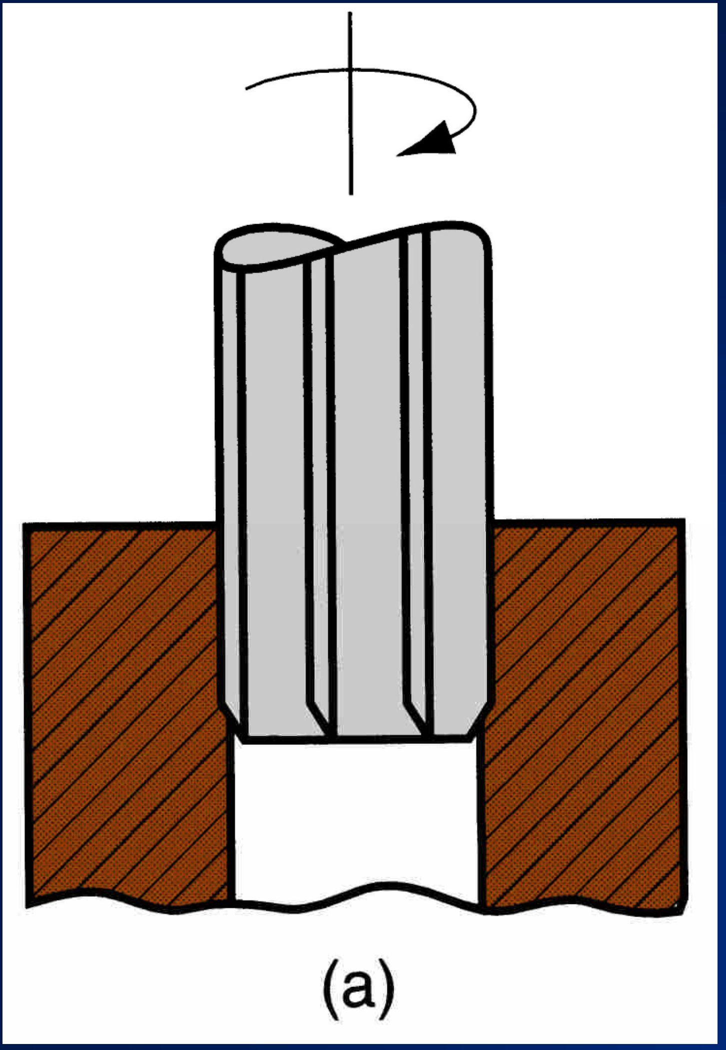


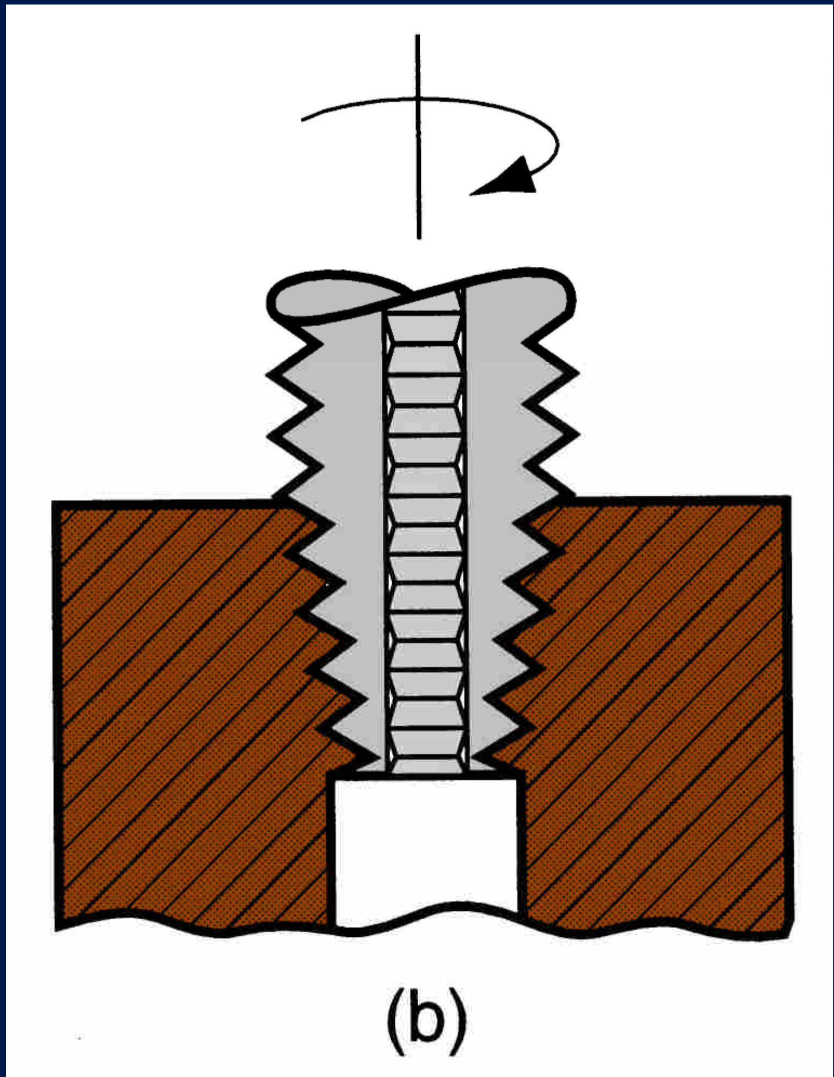
Figure 22.13 - Two hole types: (a) through-hole, and (b) blind hole



Reaming

Used to slightly enlarge a hole, provide better tolerance on diameter, and improve surface finish

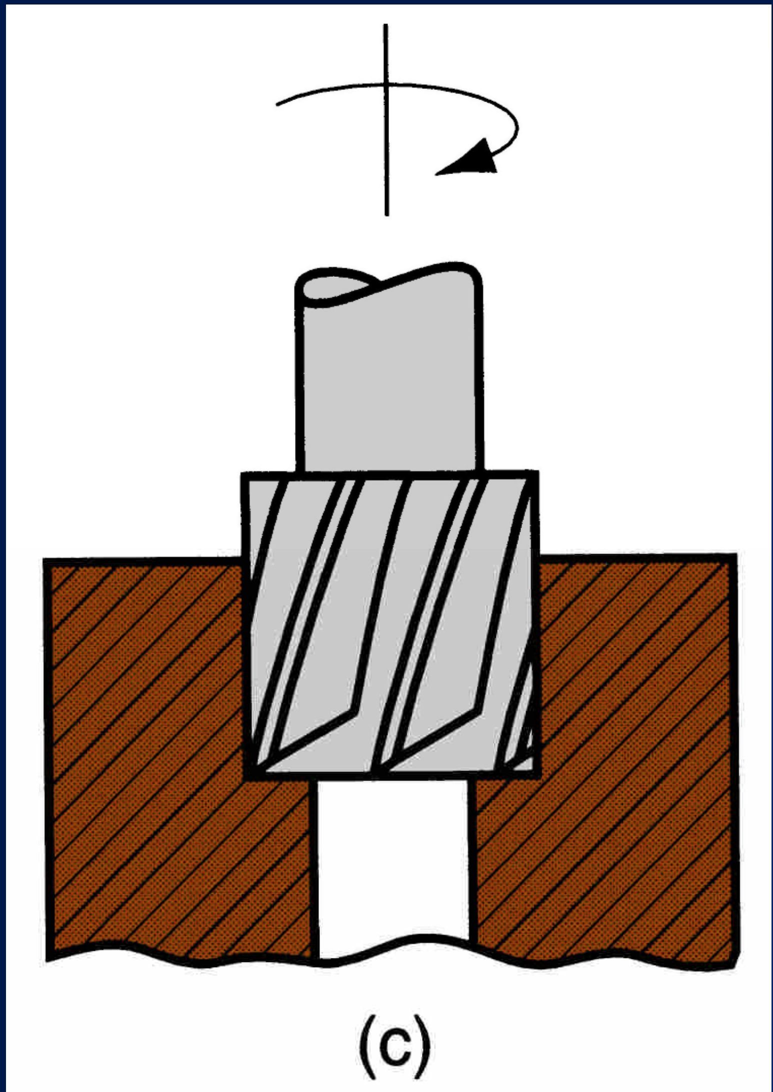
Figure 22.14 - Machining operations related to drilling:
(a) reaming



Tapping

- Used to provide internal screw threads on an existing hole
- Tool called a *tap*

Figure 22.14 (b) tapping



Counterboring

Provides a stepped hole, in which a larger diameter follows a smaller diameter partially into the hole

Figure 22.14 (c) counterboring

Upright Drill

Stands on the floor

Bench Drill

Similar but smaller and mounted on a table or bench

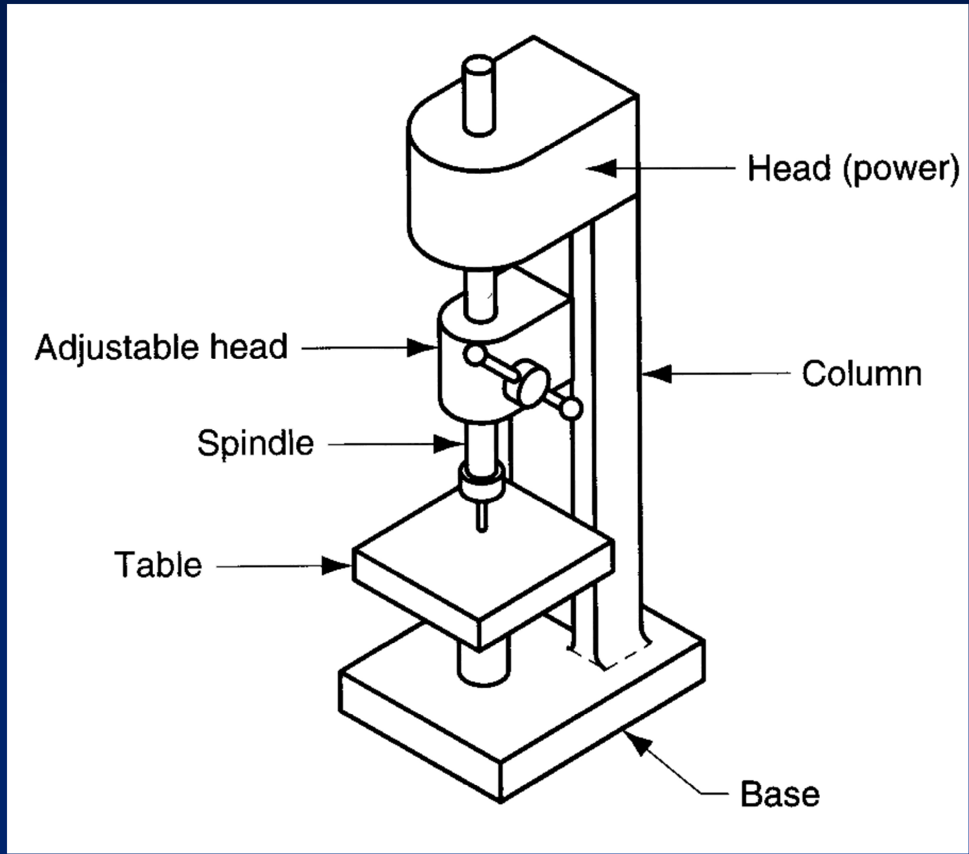


Figure 22.15 - Upright drill press

Radial Drill

Large drill press designed for large parts

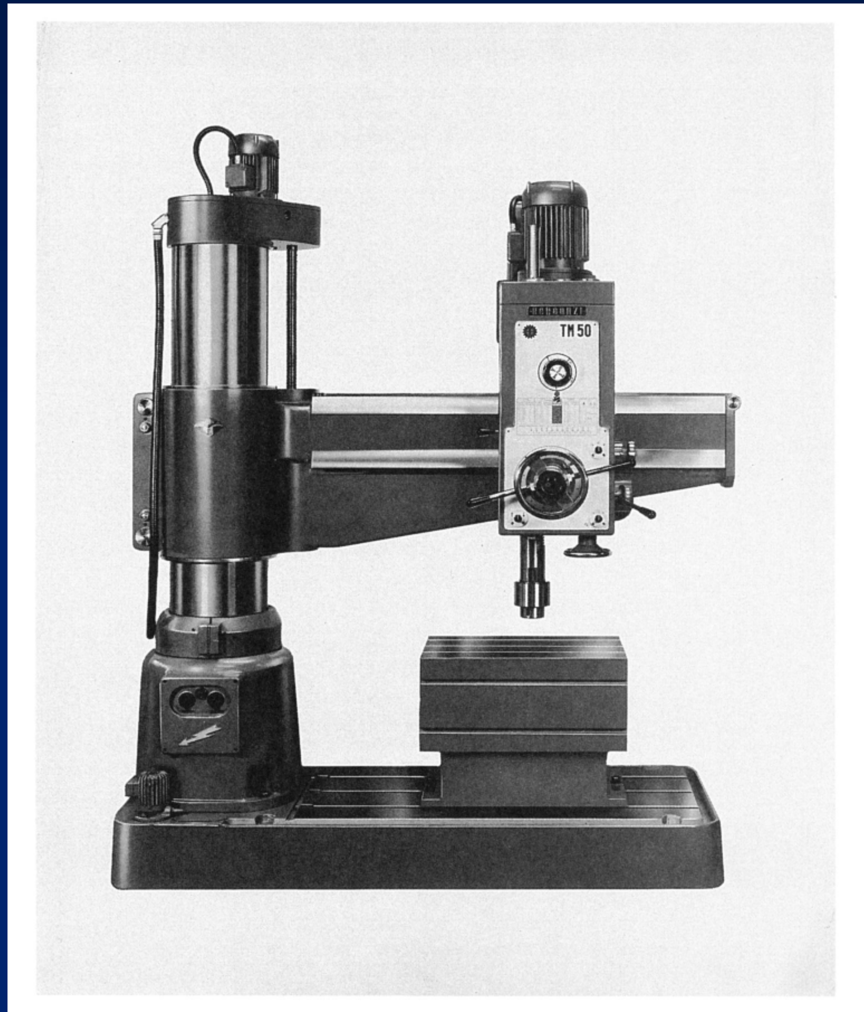


Figure 22.16 - Radial drill press (Willis Machinery and Tools)

Work Holding for Drill Presses

- Workpart can be clamped in a vise, fixture, or jig
  - *Vise* - general purpose workholder with two jaws
  - *Fixture* - workholding device that is usually custom-designed for the particular workpart
  - *Drill jig* – similar to fixture but also provides a means of guiding the tool during drilling

Milling

Machining operation in which work is fed past a rotating tool with multiple cutting edges

- Axis of tool rotation is perpendicular to feed direction
- Creates a planar surface; other geometries possible either by cutter path or shape
- Other factors and terms:
  - Milling is an *interrupted cutting* operation
  - Cutting tool called a *milling cutter,* cutting edges called "teeth"
  - Machine tool called a *milling machine*

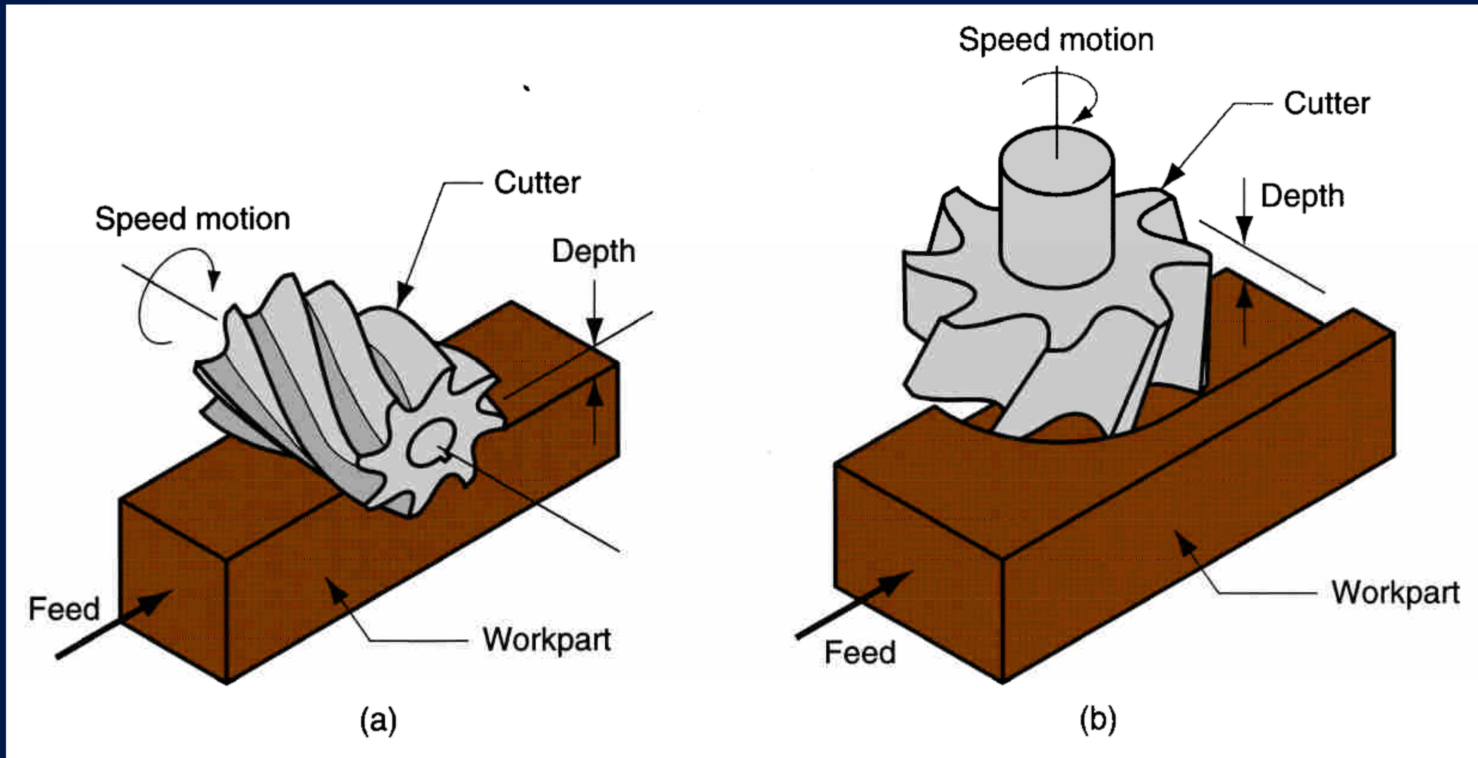


Figure 21.3 - Two forms of milling:
(a) peripheral milling, and (b) face milling

Peripheral Milling vs. Face Milling

- Peripheral milling
  - Cutter axis is parallel to surface being machined
  - Cutting edges on outside periphery of cutter
- Face milling
  - Cutter axis is perpendicular to surface being milled
  - Cutting edges on both the end and outside periphery of the cutter

Slab Milling

The basic form of peripheral milling in which the cutter width extends beyond the workpiece on both sides

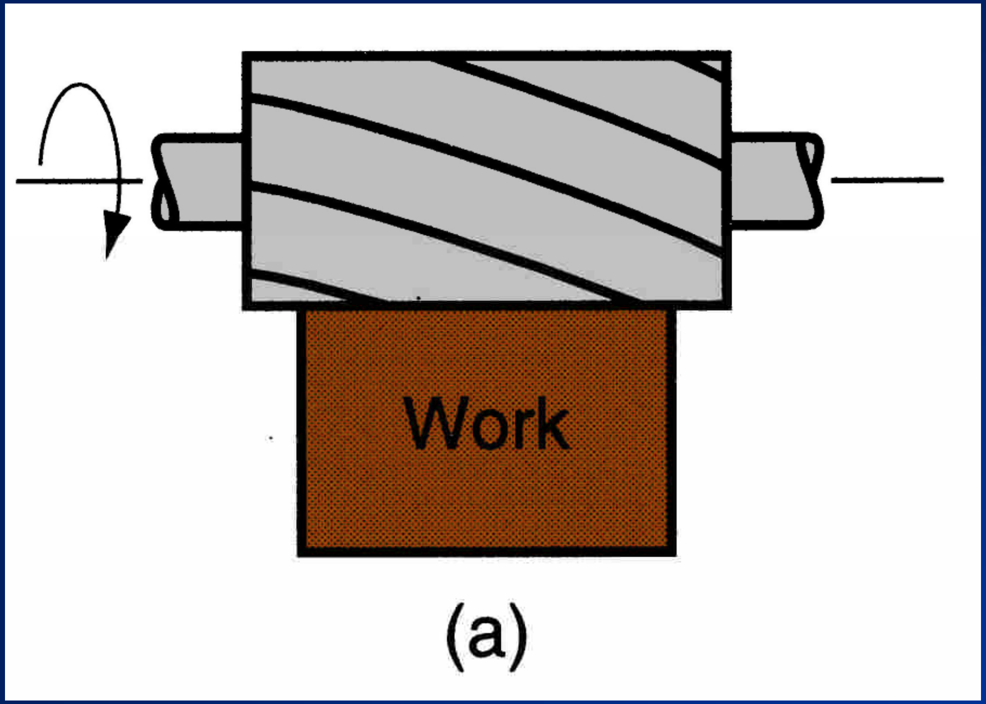
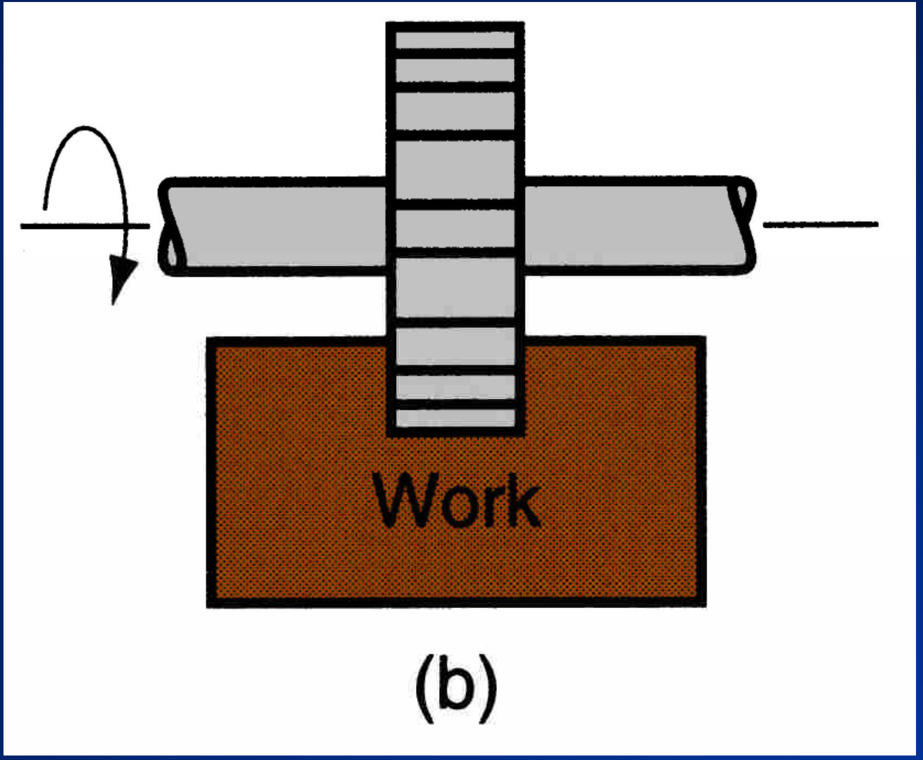


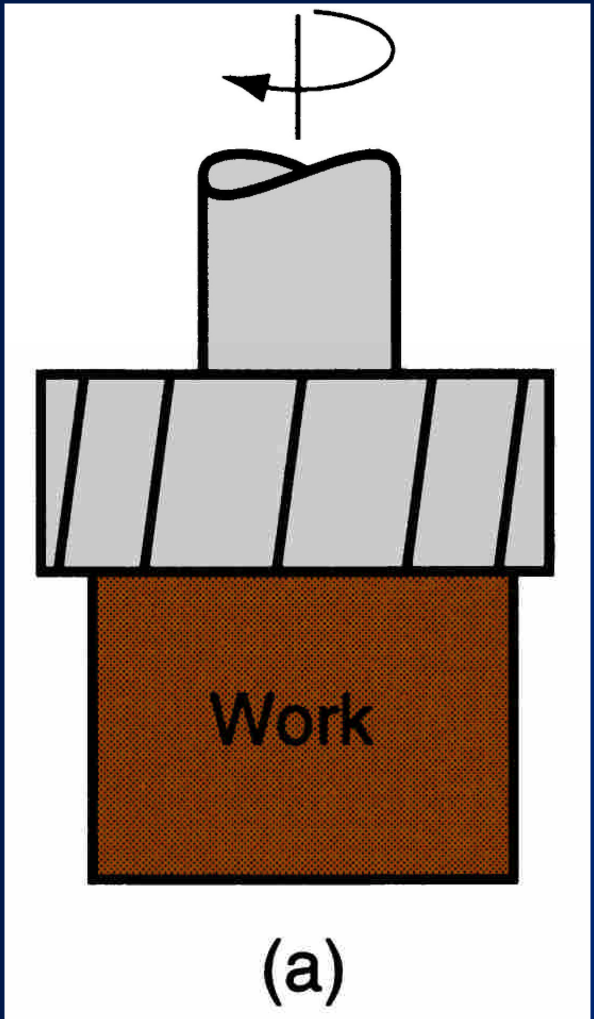
Figure 22.18
(a) slab milling

Slotting

- Width of cutter is less than workpiece width, creating a slot in the work

Figure 22.18
(b) slotting

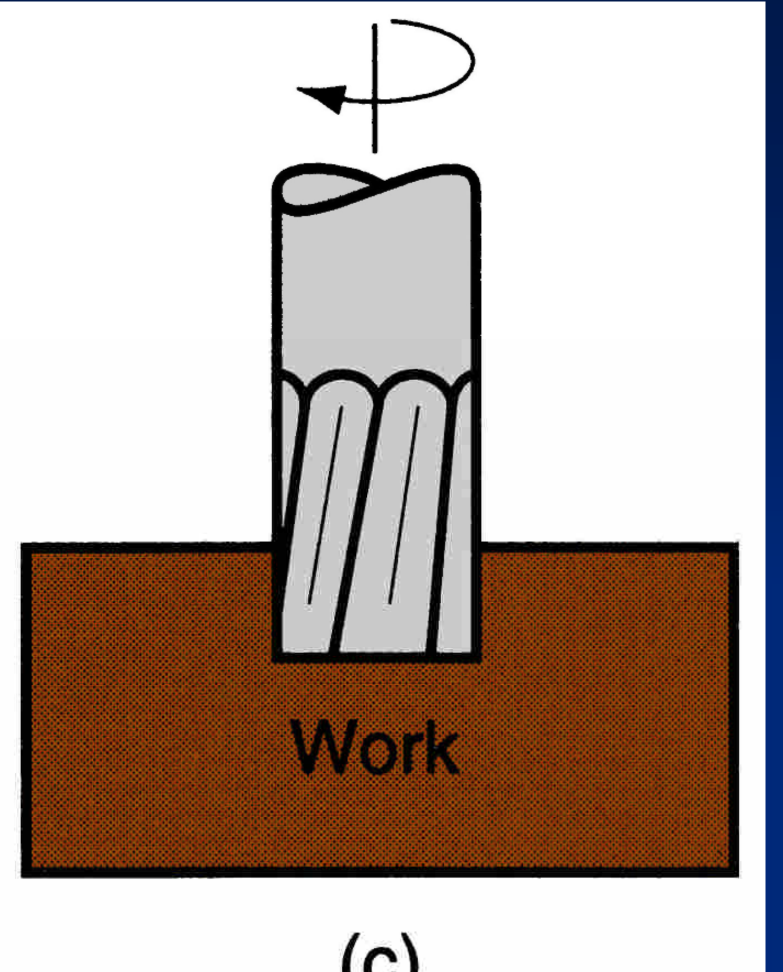




Conventional Face Milling

Cutter overhangs work on both sides

Figure 22.20
(a) conventional face milling



End Milling

Cutter diameter is less than work width, so a slot is cut into part

Figure 22.20 - (c) end milling

Profile Milling

Form of end milling in which the outside periphery of a flat part is cut

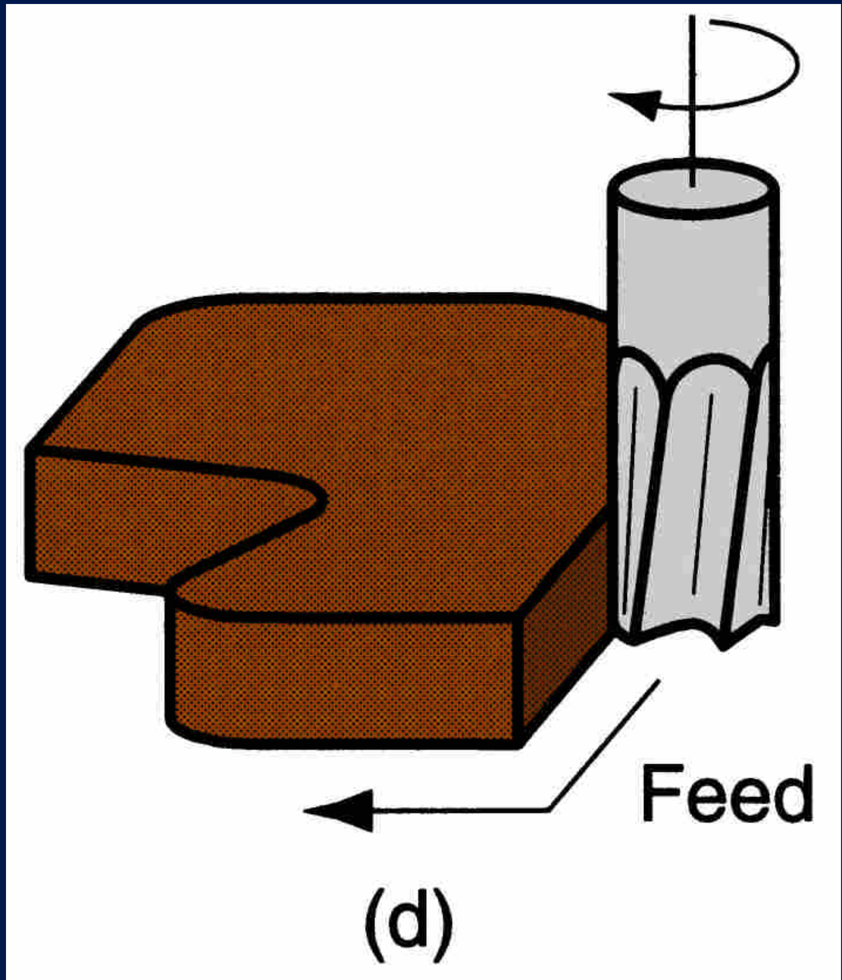
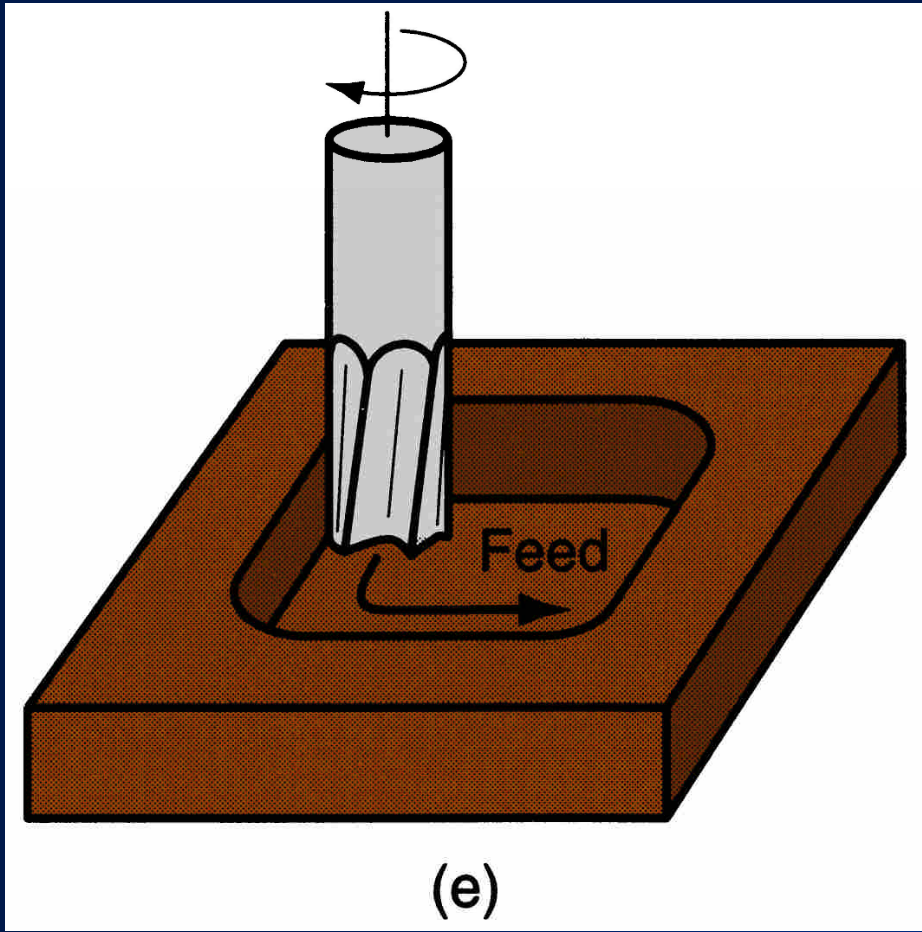


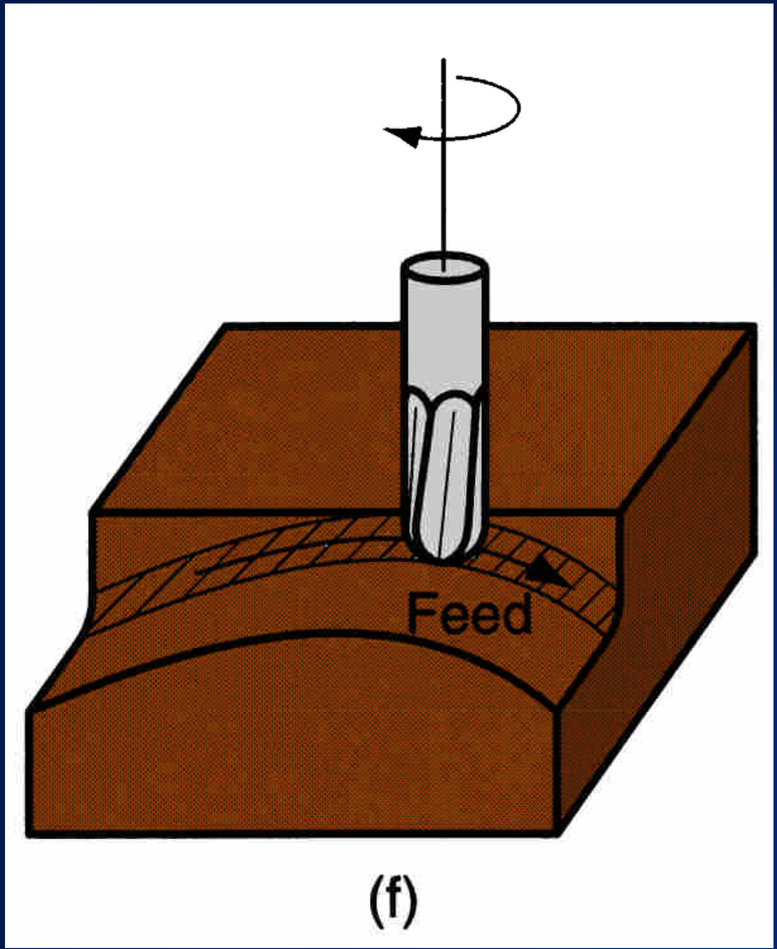
Figure 22.20 (d) profile milling



Pocket Milling

Another form of end milling used to mill shallow pockets into flat parts

Figure 22.20 (e) pocket milling



Surface Contouring

Ball-nose cutter is fed back and forth across the work along a curvilinear path at close intervals to create a three dimensional surface form

Figure 22.20 (f) surface contouring

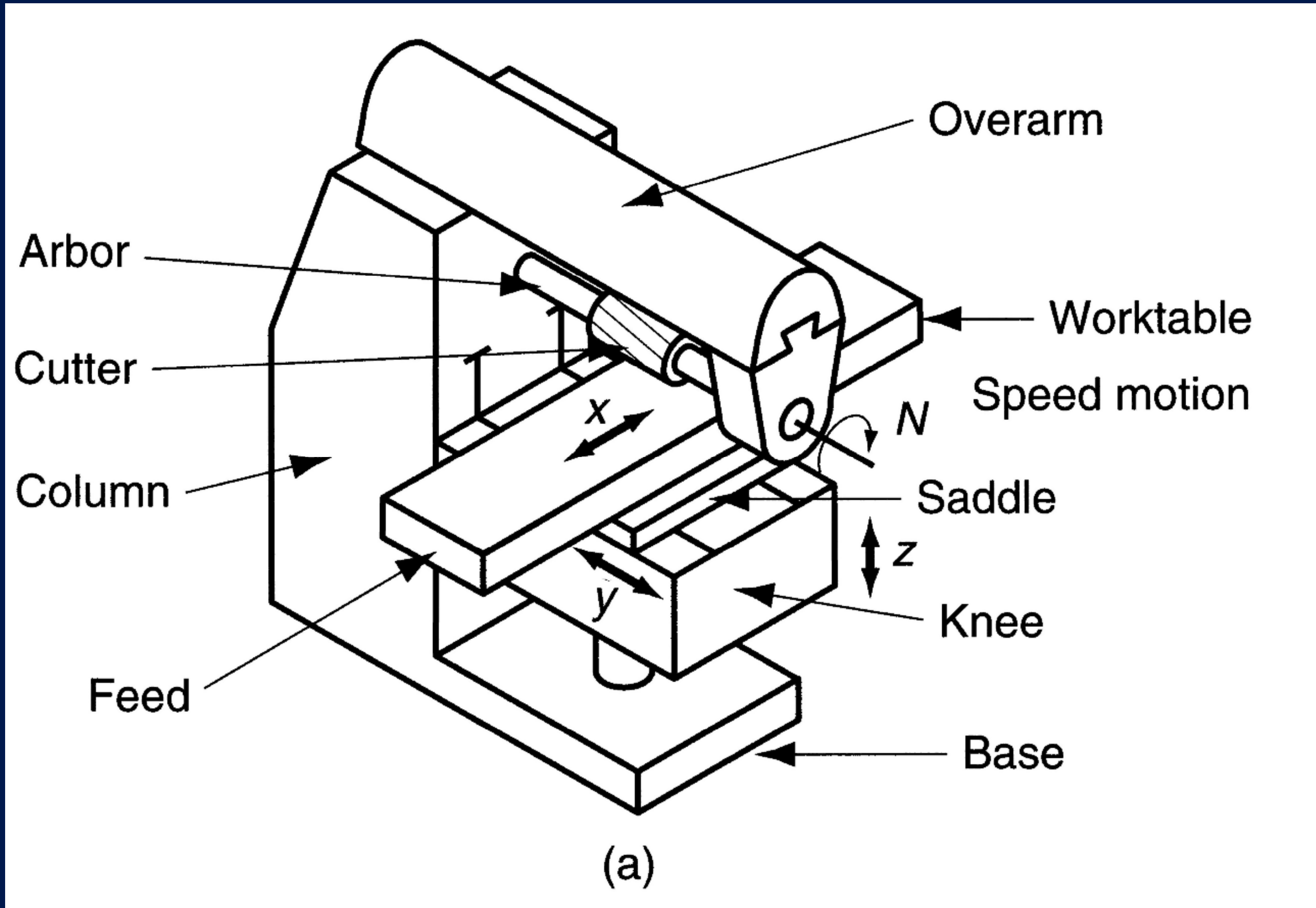


Figure 22.23 (a) horizontal knee-and-column milling machine

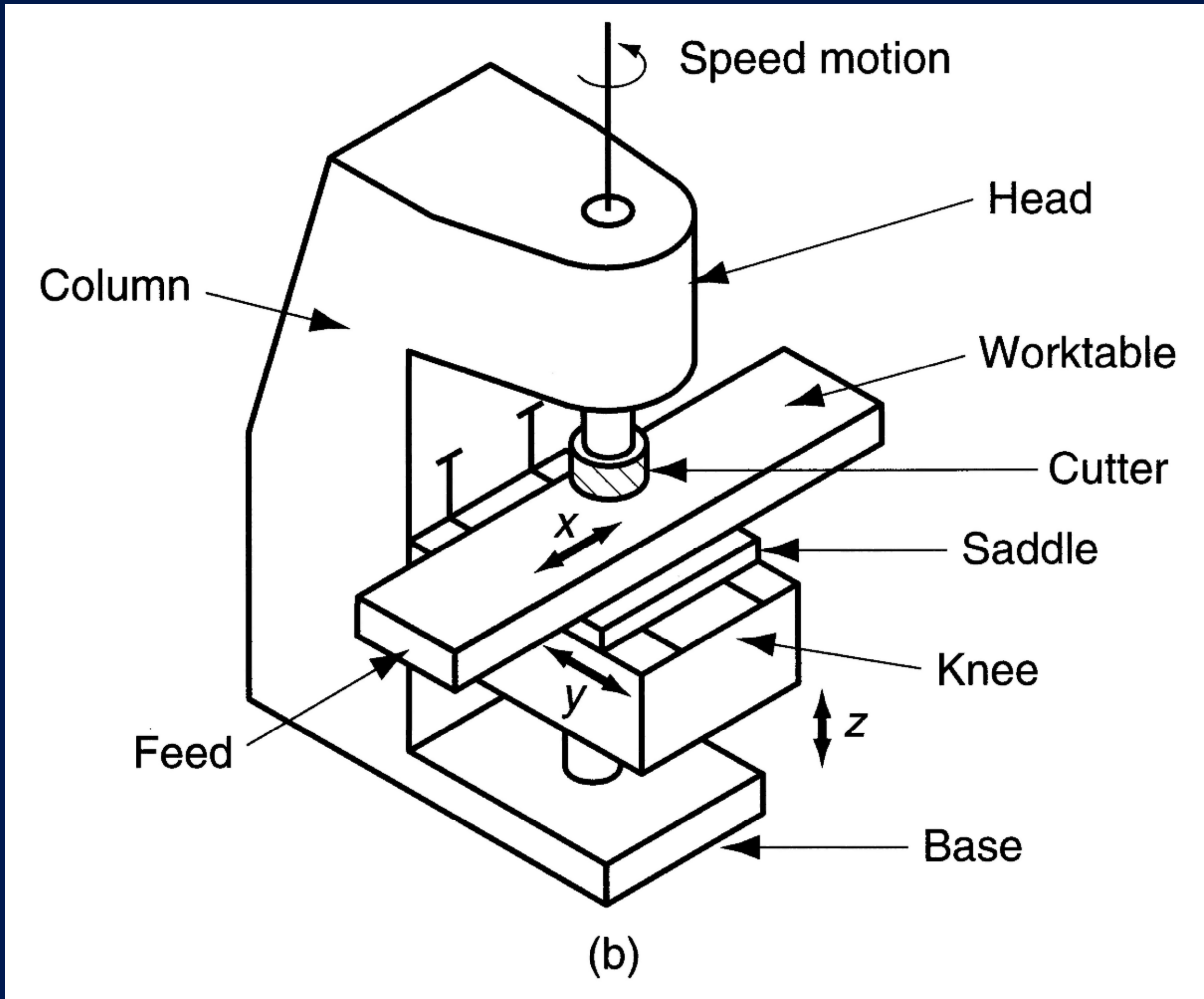


Figure 22.23 (b) vertical knee-and-column milling machine

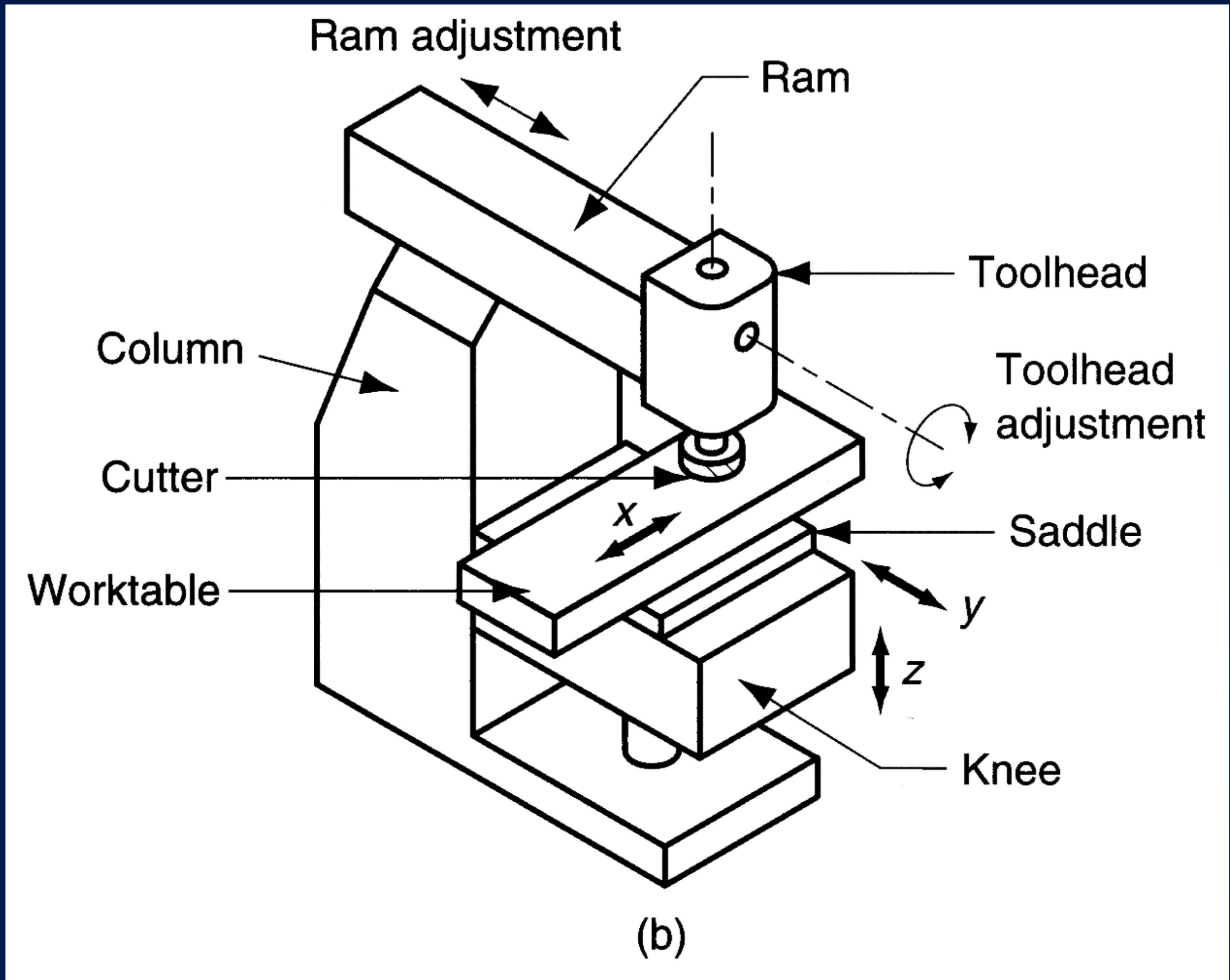


Figure 22.24 (b) ram type knee-and-column machine; ram can be adjusted in and out, and toolhead can be swiveled

Machining Centers

Highly automated machine tool capable of performing multiple machining operations under CNC control in one setup with minimal human attention

- Typical operations are milling and drilling
- Three, four, or five axes

- Other features:
  - Automatic tool-changing
  - Pallet shuttles
  - Automatic workpart positioning

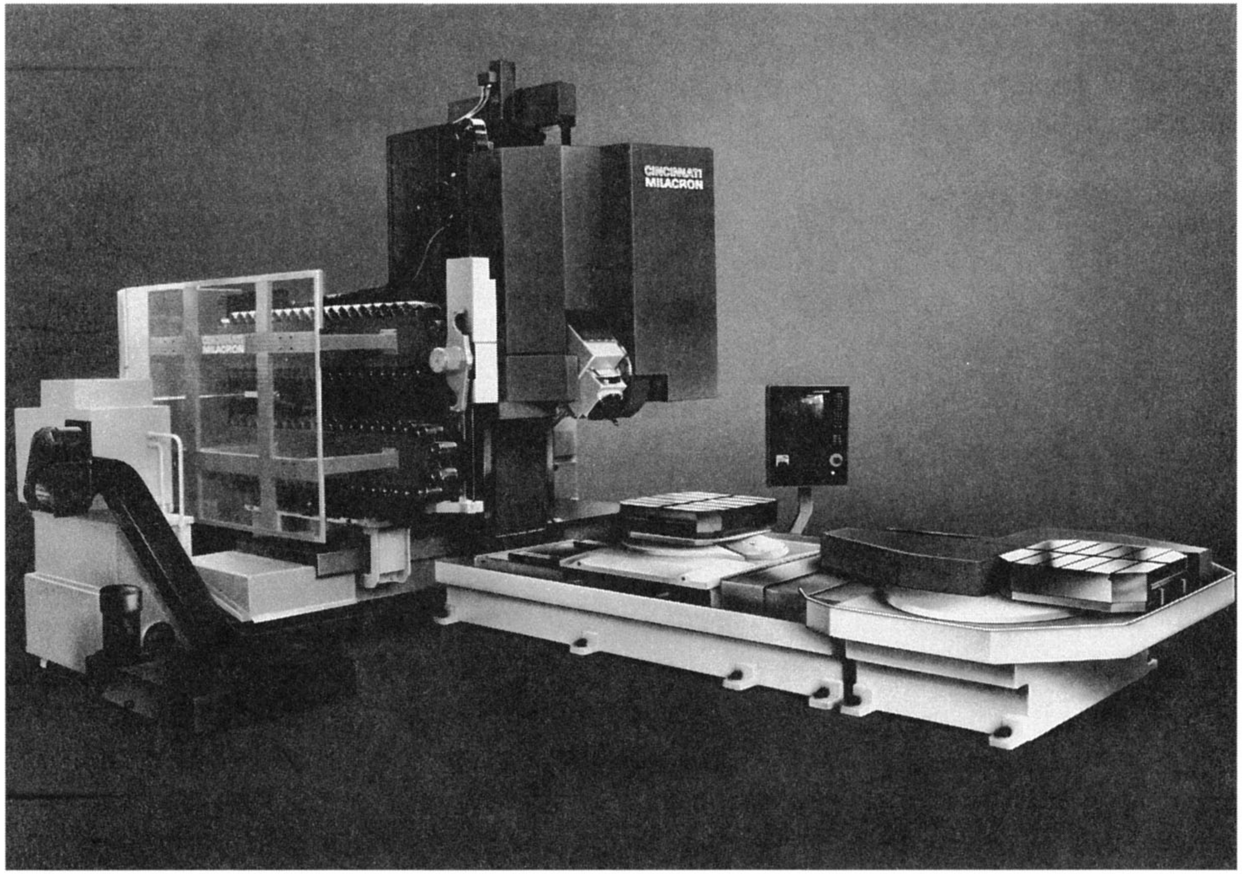


Figure 22.26 - Universal machining center (Cincinnati Milacron); highly automated, capable of multiple machining operations under computer control in one setup with minimal human attention

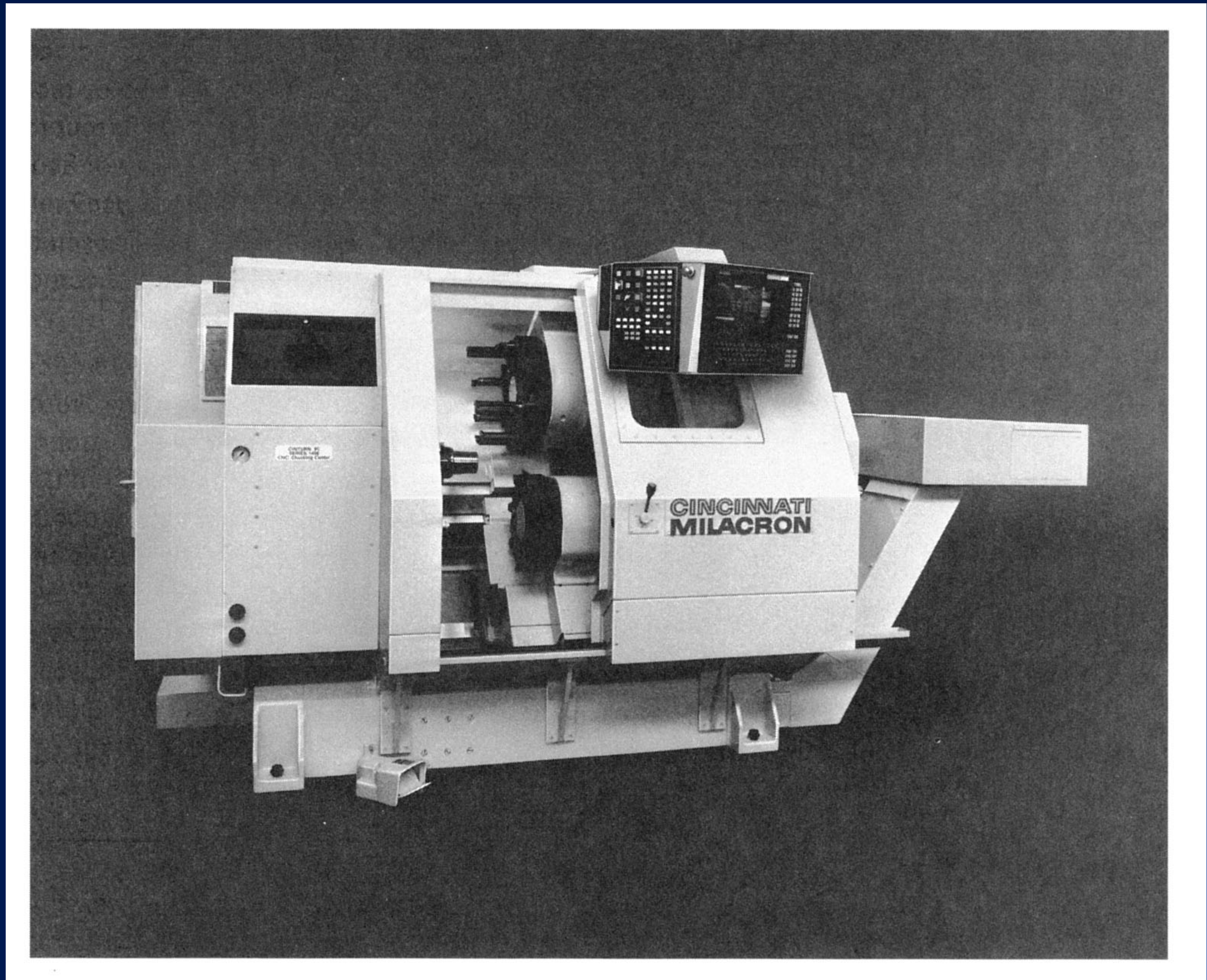


Figure 22.27 - CNC 4-axis turning center (Cincinnati Milacron); capable of turning and related operations, contour turning, and automatic tool indexing, all under computer control.

Mill-Turn Centers

Highly automated machine tool that can perform turning, milling, and drilling operations on a workpart

- General configuration of a turning center
- Can position a cylindrical workpart at a specified angle so a rotating cutting tool (e.g., milling cutter) can machine features into outside surface of part
  - A conventional turning center cannot stop workpart at a defined angular position and does not possess rotating tool spindles

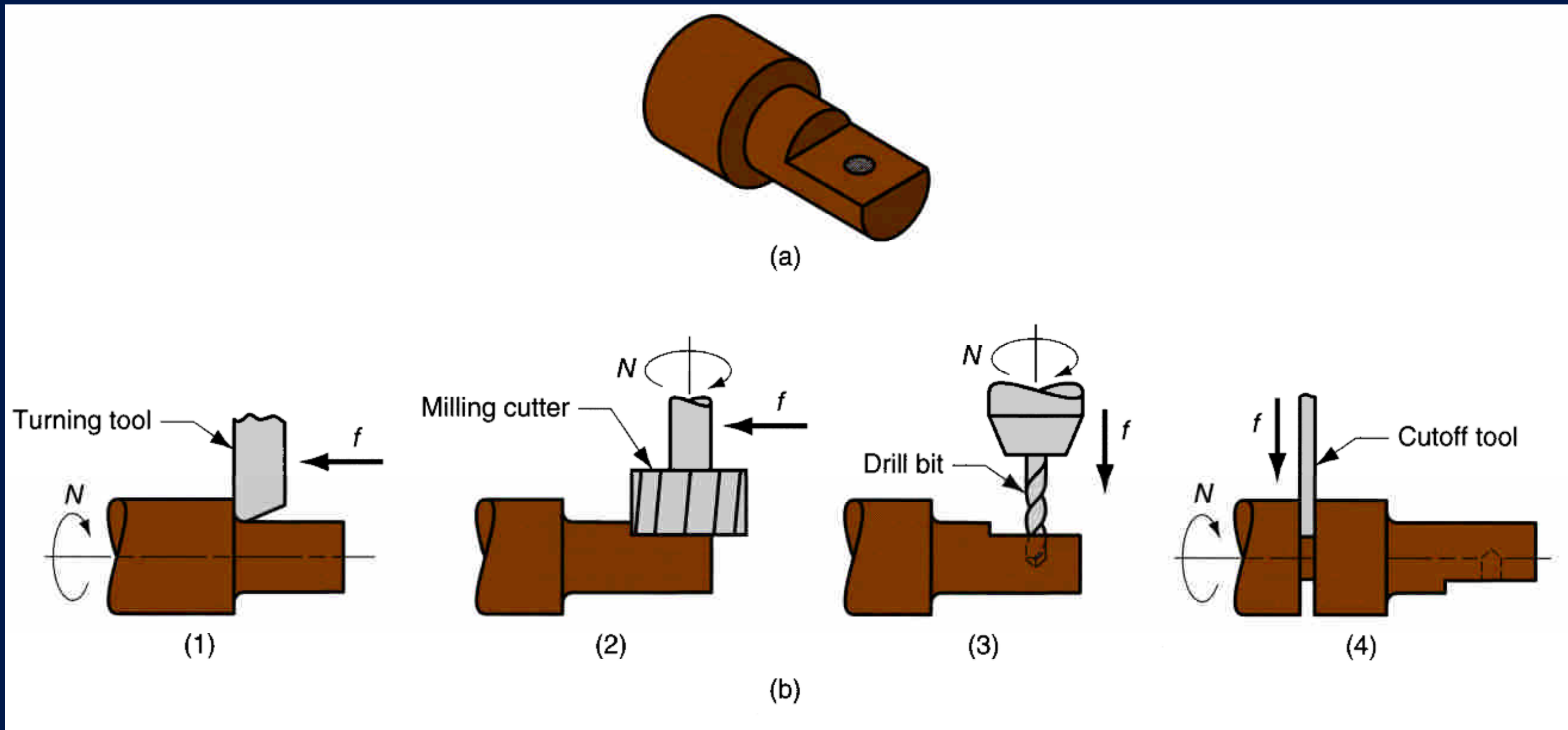


Figure 22.28 - Operation of a mill-turn center: (a) example part with turned, milled, and drilled surfaces; and (b) sequence of operations on a mill-turn center: (1) turn second diameter, (2) mill flat with part in programmed angular position, (3) drill hole with part in same programmed position, and (4) cutoff

Shaping and Planing

- Similar operations
- Both use a single point cutting tool moved linearly relative to the workpart

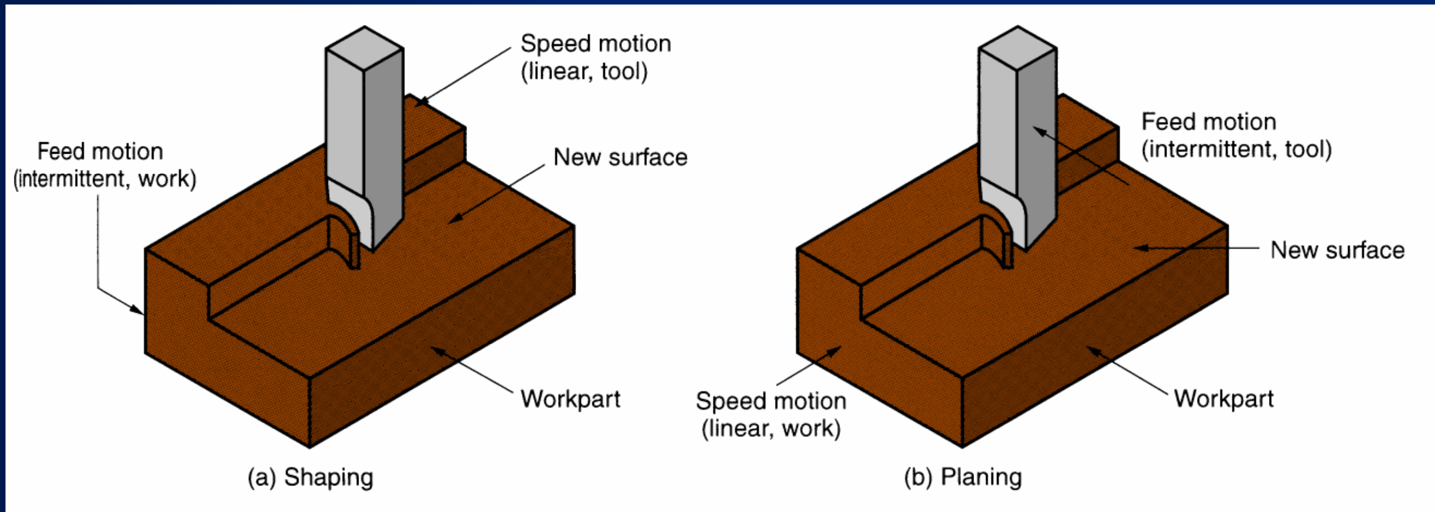


Figure 22.29 - (a) Shaping, and (b) planing

Shaping and Planing

- A straight, flat surface is created in both operations
- Interrupted cutting
  - Subjects tool to impact loading when entering work
- Low cutting speeds due to start-and-stop motion
- Usual tooling: single point high speed steel tools

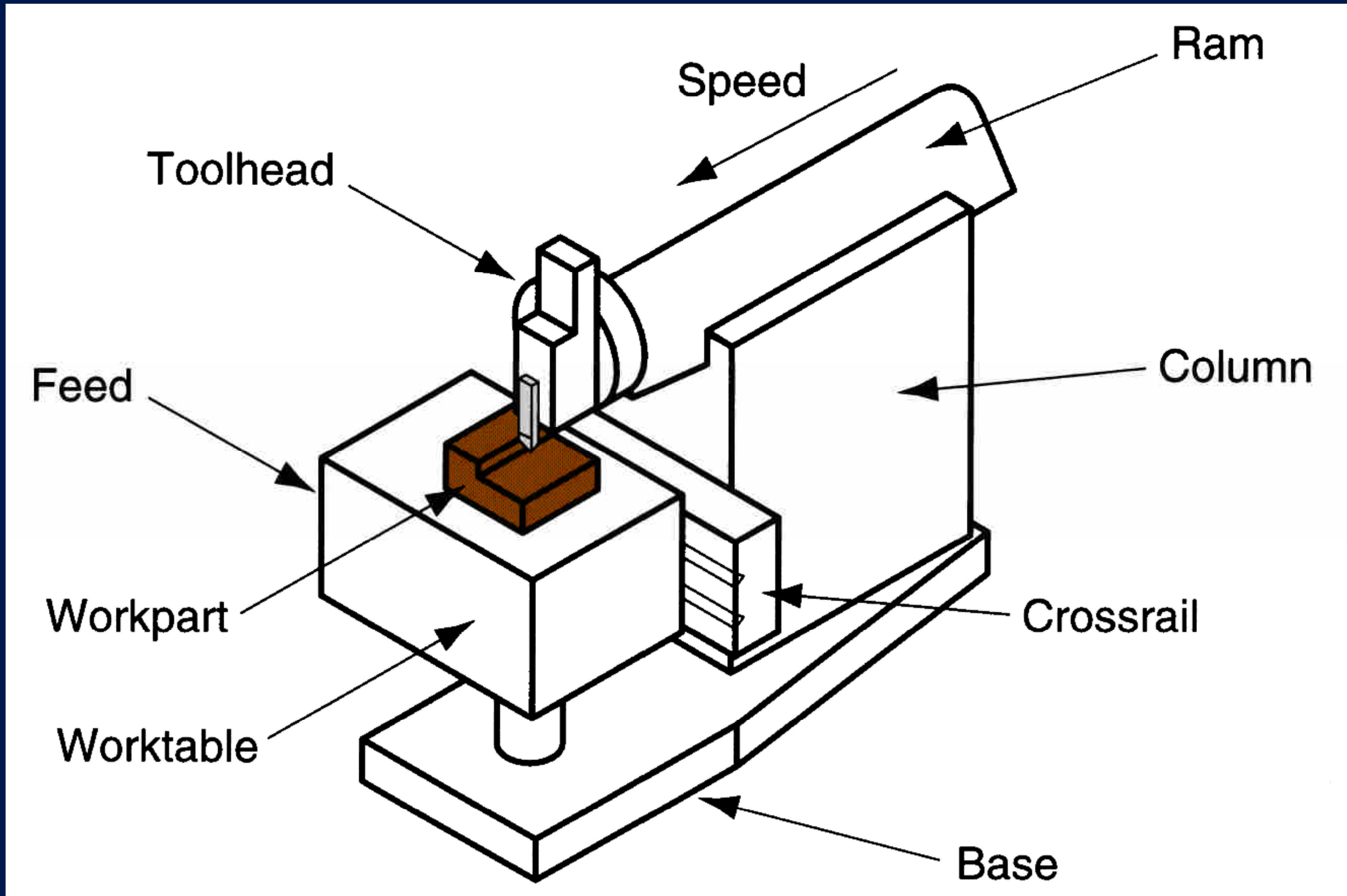


Figure 22.30 - Components of a shaper

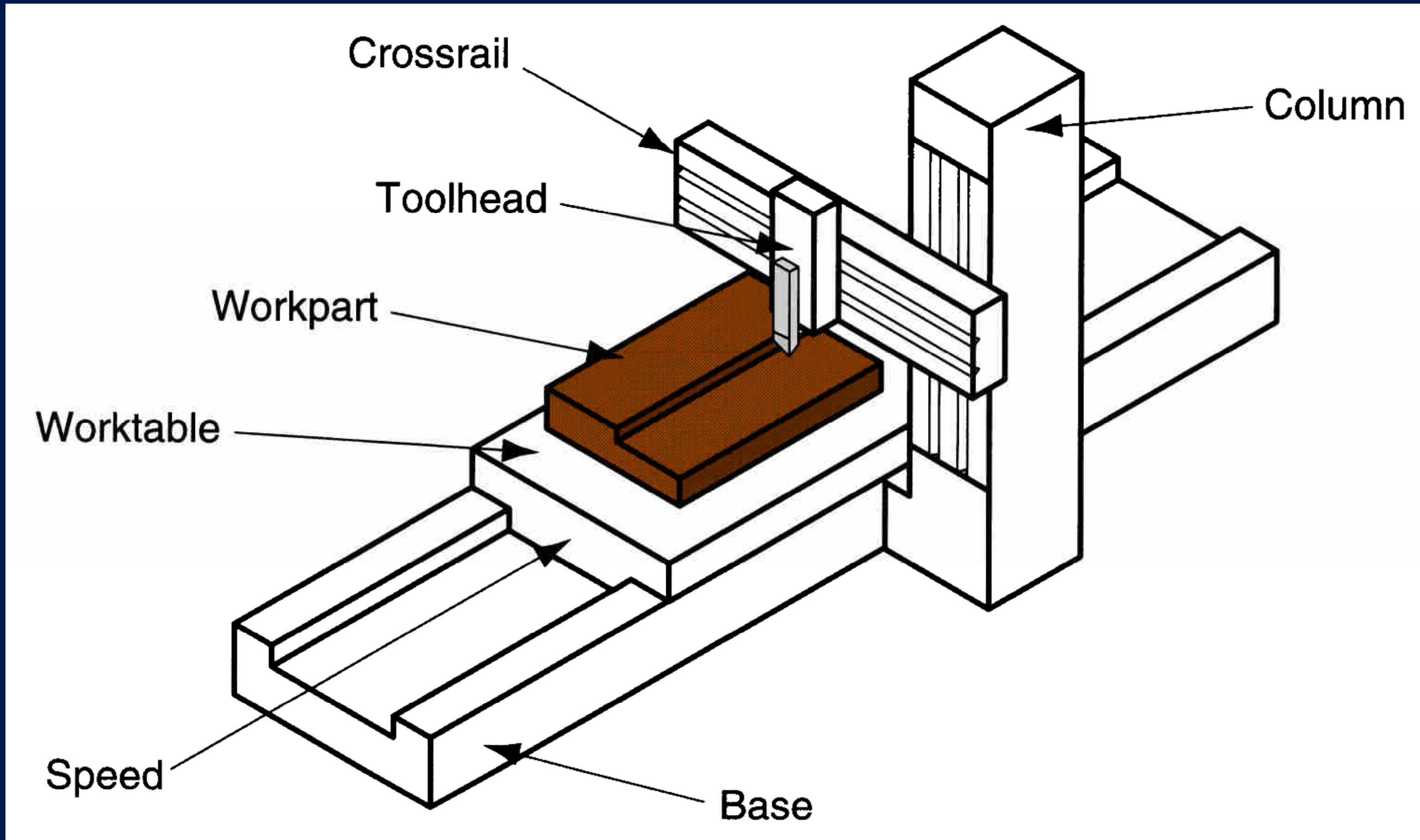


Figure 22.31 - Open side planer

Broaching

- Moves a multiple tooth cutting tool linearly relative to work in direction of tool axis

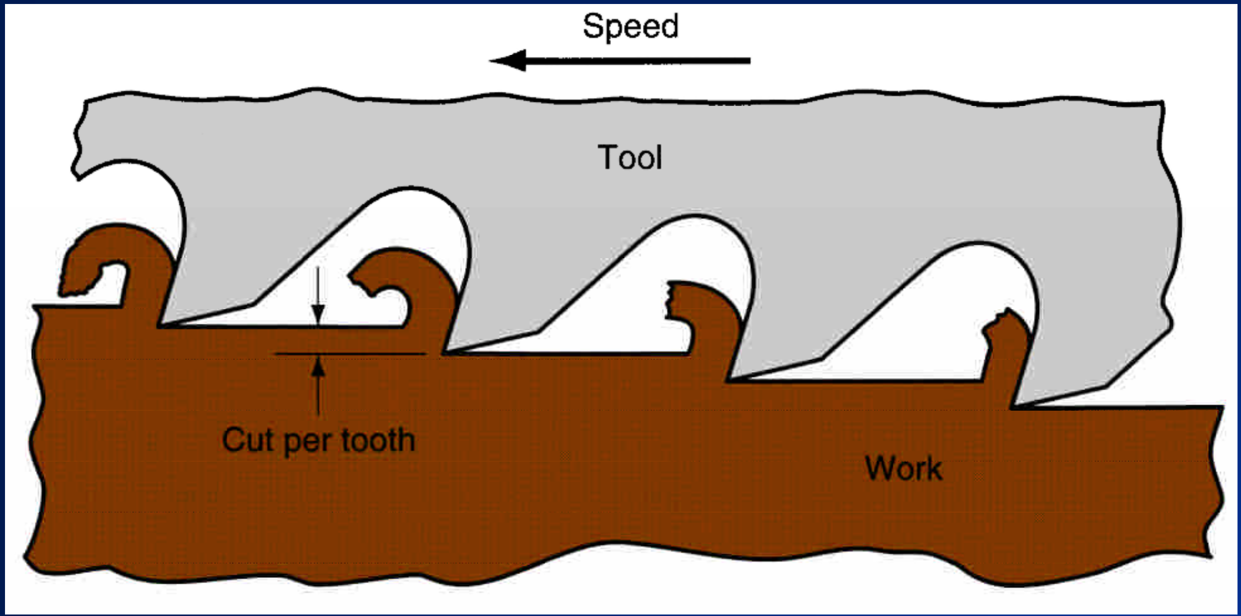


Figure 22.33 - The broaching operation

Broaching

Advantages:

- Good surface finish
- Close tolerances
- Variety of work shapes possible

Cutting tool called a *broach*

- Owing to complicated and often custom-shaped geometry, tooling is expensive

Internal Broaching

- Performed on internal surface of a hole
- A starting hole must be present in the part to insert broach at beginning of stroke

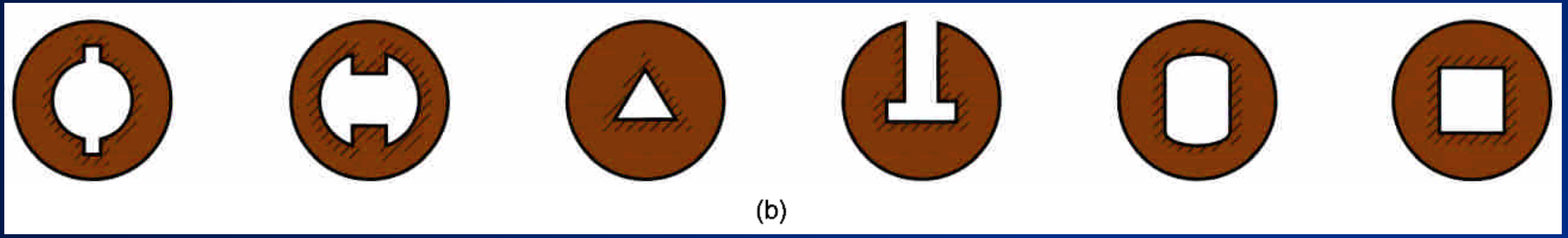


Figure 22.34 - Work shapes that can be cut by internal broaching; cross-hatching indicates the surfaces broached

Sawing

- Cuts narrow slit in work by a tool consisting of a series of narrowly spaced teeth
- Tool called a *saw blade*
- Typical functions:
  - Separate a workpart into two pieces
  - Cut off unwanted portions of part

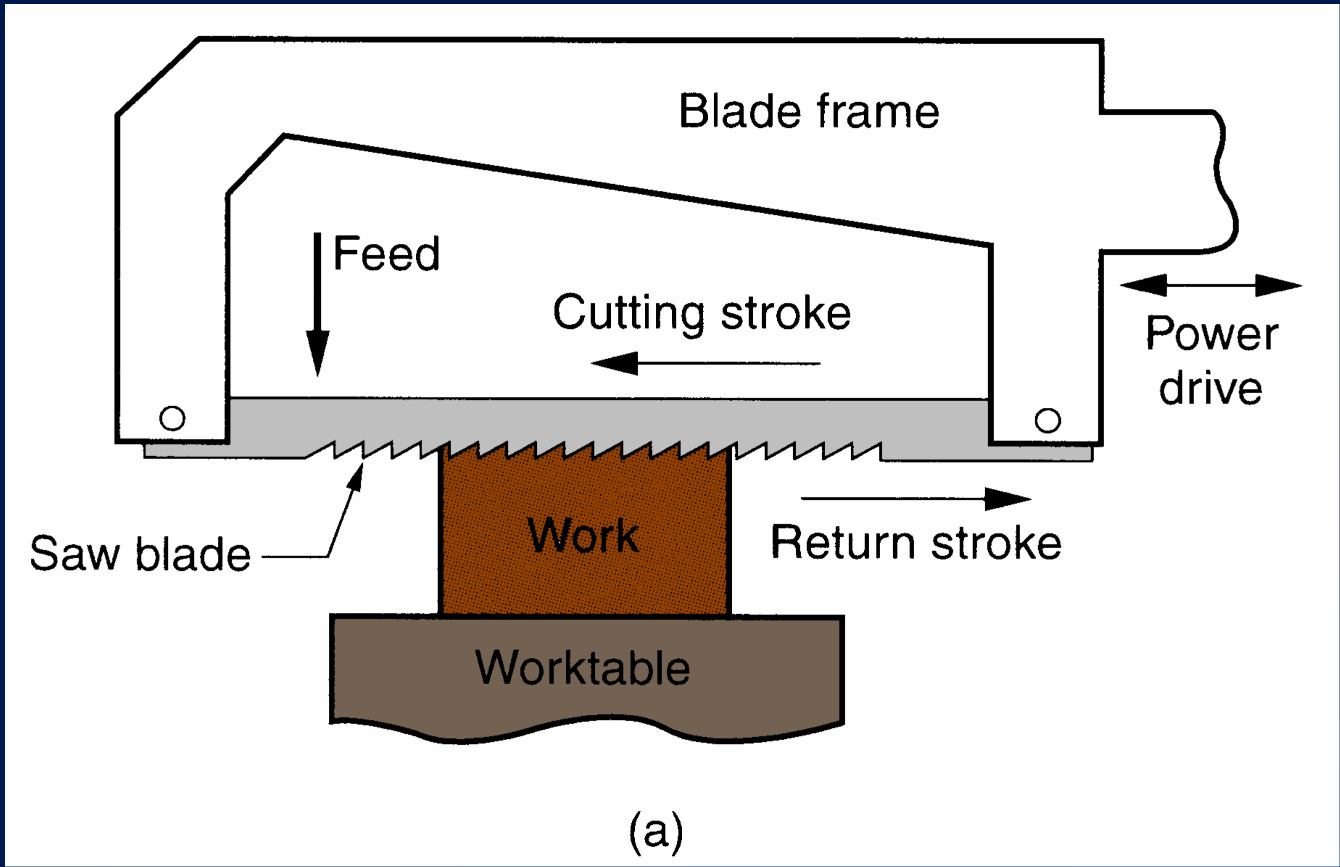


Figure 22.35 (a) power hacksaw –linear reciprocating motion of hacksaw blade against work

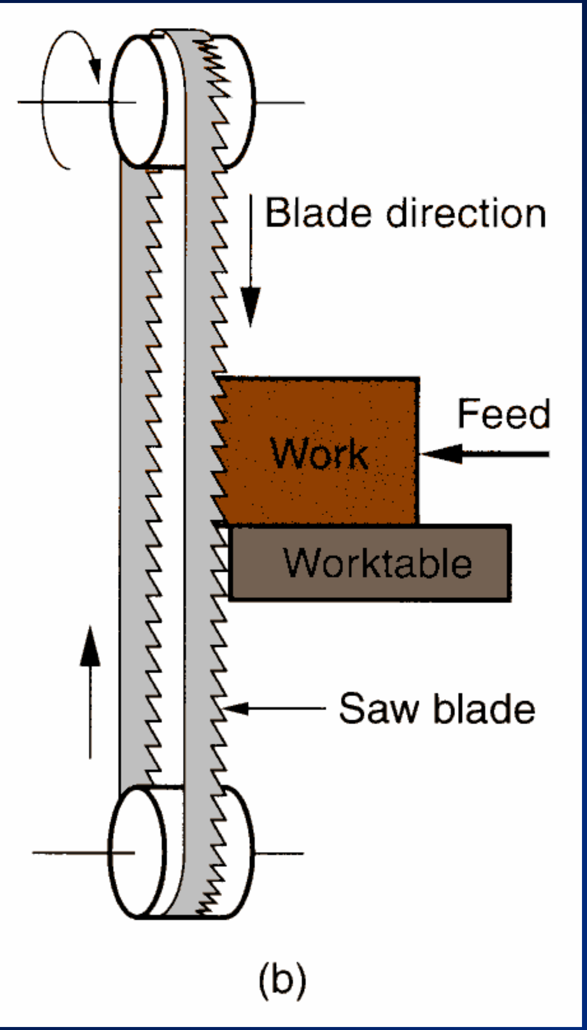


Figure 22.35 (b) bandsaw (vertical) – linear continuous motion of bandsaw blade, which is in the form of an endless flexible loop with teeth on one edge

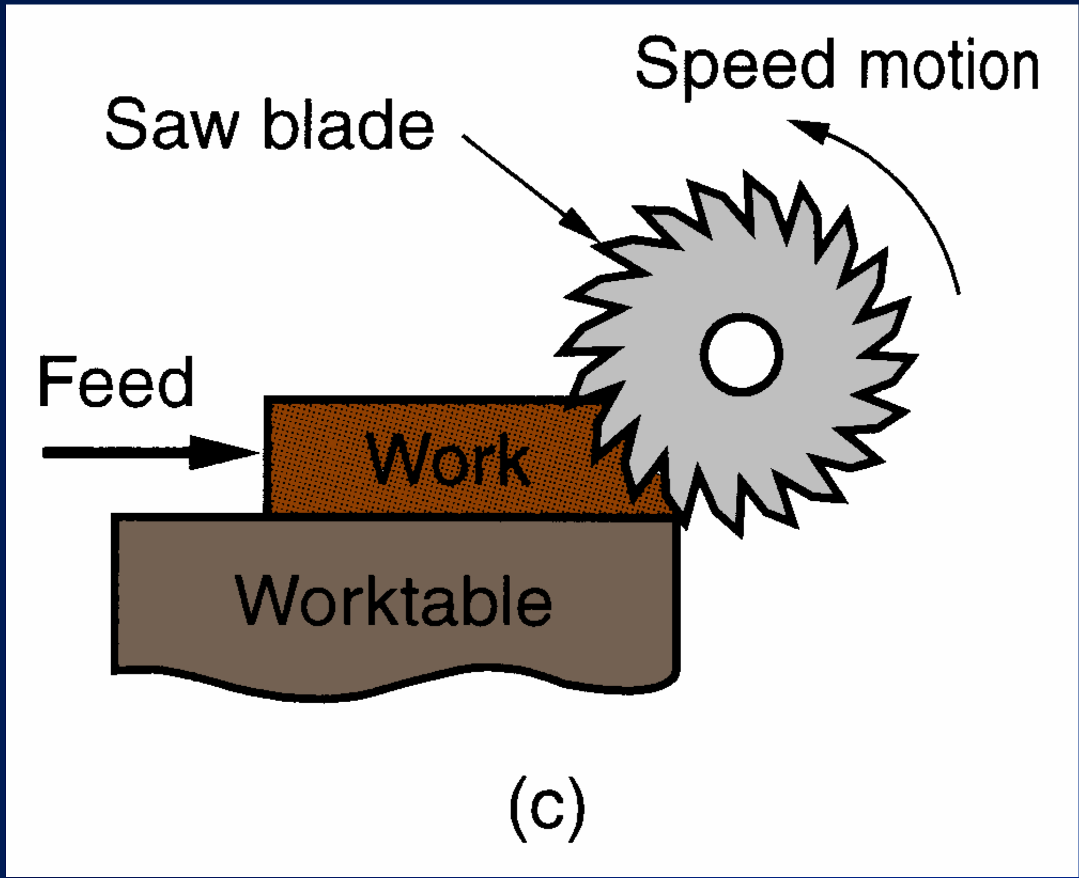


Figure 22.35 (c) circular saw – rotating saw blade provides continuous motion of tool past workpart

High Speed Machining (HSM)

Cutting at speeds significantly higher than those used in conventional machining operations

- A persistent trend throughout history of machining is higher and higher cutting speeds
- At present there is a renewed interest in HSM due to potential for faster production rates, shorter lead times, and reduced costs

High Speed Machining

Comparison of conventional vs. high speed machining

	Indexable tools (face mills)			
Work material	Conventional speed		High speed	
	m/min	ft/min	m/min	ft/min
Aluminum	600+	2000+	3600+	12,000+
Cast iron, soft	360	1200	1200	4000
Cast iron, ductile	250	800	900	3000
Steel, alloy	210	700	360	1200

Source: Kennametal Inc.

Other HSM Definitions – DN Ratio

DN ratio = bearing bore diameter (mm) multiplied by maximum spindle speed (rev/min)

- For high speed machining, typical DN ratio is between 500,000 and 1,000,000
- Allows larger diameter bearings to fall within HSM range, even though they operate at lower rotational speeds than smaller bearings

Other HSM Definitions – HP/RPM Ratio

hp/rpm ratio = ratio of horsepower to maximum spindle speed

- Conventional machine tools usually have a higher hp/rpm ratio than those equipped for HSM
- Dividing line between conventional machining and HSM is around 0.005 hp/rpm
- Thus, HSM includes 15 hp spindles that can rotate at 30,000 rpm (0.0005 hp/rpm)

Other HSM Definitions

- Emphasize:
  - Higher production rates
  - Shorter lead times
  - Rather than functions of spindle speed
- Important non-cutting factors:
  - Rapid traverse speeds
  - Automatic tool changes

Requirements for High Speed Machining

- Special bearings designed for high rpm
- High feed rate capability (e.g., 50 m/min)
- CNC motion controls with “look-ahead” features to avoid “undershooting” or “overshooting” tool path
- Balanced cutting tools, toolholders, and spindles to minimize vibration
- Coolant delivery systems that provide higher pressures than conventional machining
- Chip control and removal systems to cope with much larger metal removal rates

High Speed Machining Applications

- Aircraft industry, machining of large airframe components from large aluminum blocks
  - Much metal removal, mostly by milling
- Multiple machining operations on aluminum to produce automotive, computer, and medical components
  - Quick tool changes and tool path control important
- Die and mold industry
  - Fabricating complex geometries from hard materials