

**PERFORMANCE OF COATED CARBIDE TOOL
IN LOW SPEED MILLING OF STAINLESS
STEEL UNDER FLOOD AND MIST
LUBRICATION**



SIOW PING CHUAN

UMS
UNIVERSITI MALAYSIA SABAH

**SCHOOL OF ENGINEERING AND
INFORMATION TECHNOLOGY
UNIVERSITI MALAYSIA SABAH
2009**

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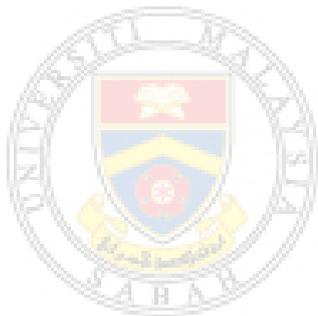
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DECLARATION

I hereby declare that the material in this thesis is my own except for quotations, excerpts, equations, summaries and references, which have been duly acknowledged.

10 August 2009

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CERTIFICATION

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ABSTRACT

PERFORMANCE OF COATED CARBIDE TOOL IN LOW SPEED MILLING OF STAINLESS STEEL UNDER FLOOD AND MIST LUBRICATION

Most of the research works on the milling of stainless steel in the past were carried out at cutting speeds of higher than 100 m/min and had reported that the optimum speeds for milling steel were in the range of 100 m/min to 150 m/min. In some cases, milling at low speeds is inevitable. Some solid end-mill tools used to produce small features such as pockets and slots have a diameter of less than 2 mm. If a tool with diameter of 2 mm is used, milling cannot be performed at speeds higher than 100 m/min if the machine employs a spindle with a maximum rotational speed of less than 16,000 rpm. However, many milling machines use spindles with rotational speeds much less than this value. The aim of the work described in the dissertation is to provide an improved understanding of the performance of AlN/TiN nano-coated solid carbide ball nose end-mill tool in milling stainless steel at low speed (below 100 m/min) under conventional flood and mist lubrication condition. The tool wear behaviour and the morphology of the surface finish obtained under different lubrication conditions were examined. In particular, the effect of the hardness of the workpiece, helix angle of the cutting tool and the effectiveness of mist and flood lubrication in low-speed milling of stainless steel were investigated. The machining were carried out at the cutting speed of 50 m/min and 88 m/min, depths of cut of 0.2 mm and 0.4 mm and feeds rate of 0.04 mm/tooth, 0.01 mm/tooth and 0.004 mm/tooth. The machining tests were performed on STAVAX (modified AISI 420 stainless steel) with the hardness of 35 and 55 HRC using Okuma milling machine under conventional flood and mist lubrication conditions. Abrasion, chipping and catastrophic failure are the wear modes encountered during machining under flood lubrication condition. The abrasive wear and the likeliness of the cutting tool to chip and fail prematurely increased with an increase in the hardness of the workpiece and a reduction in the helix angle of the tool. Small quantity of natural oil sprayed in mist form was effective in reducing the tool wear and severity of abrasion wear, and preventing catastrophic failure. Throughout the entire duration of machining of 35 and 55 HRC of stainless steel under mist lubrication condition, the cutting edge of the 25° and 40° helix angle tools only suffered small-scale edge chipping and abrasive wear. The ductility of the workpiece had significant influence on the surface finish of the workpiece. In particular, it was found that in milling STAVAX with a hardness of 55 HRC, despite the tool was being subjected to a more severe wear, the surface finish was more superior than that of the workpiece with the hardness of 35 HRC.

ABSTRAK

Kebanyakan kerja memesis keluli yang dilaporkan sebelum ini dijalankan dengan kelajuan pemesinan yang melebihi 100 m/min dan kelajuan optima untuk mengisar keluli (milling steel) adalah antara 100 m/min hingga 150 m/min. Dalam sesetengah kes, mengisar (milling) di kelajuan rendah adalah tidak dapat dielakkan. Sesetengah pisau pengisar hujung padat (solid end-mill tool) yang digunakan untuk membuat poket, lubang dan celah yang kecil mempunyai diameter yang kurang daripada 2 mm. Jika pisau pengisar dengan diameter 2 mm digunakan, proses mengisar tidak dapat dijalankan pada kelajuan yang lebih tinggi daripada 100 m/min jika gelendong mesin mengisar itu berputar pada kelajuan maksimum yang kurang daripada 16,000 rpm. Adalah didapati bahawa banyak mesin pengisar mempunyai gelendong yang berputar dengan kelajuan yang lebih kurang daripada nilai ini. Tujuan kerja dalam disertasi ini adalah untuk memberi pertambahan pemahaman prestasi pisau pengisar karbida yang bersalut dalam mengisar keluli tahan karat pada kelajuan yang perlahan (di bawah 100 m/min) dalam keadaan pelinciran banjir dan kabus semburan (flood and mist spray). Mekanisma kehausan pisau pengisar and morfologi kekemasan permukaan di bawah situasi yang berbeza akan dikaji. Kepengaruhan kekerasan bahan kerja, sudut heliks pisau pengisar and keberkesanan pelinciran banjir and kabus semburan akan diselidik. Kerja pengisaran dijalankan pada kelajuan 50 m/min dan 88 m/min, kedalaman pemotongan 0.2 mm dan 0.4 mm, dan penyaluran bahan (feed rate) 0.04 mm/gigi, 0.01 mm/gigi, dan 0.004 mm/gigi. Ujian-ujian pengisaran dijalankan di atas bahan kerja STAVAX (keluli tahan karat yang diubahsuai AISI 420) dengan kekerasan 35 dan 55 HRC dengan menggunakan mesin pengisar Okuma di dalam keadaan pelinciran banjir and kabus semburan. Lelasan (abrasion), penyerpihan (chipping) dan kegagalan (failure) adalah ciri-ciri yang ditemui semasa pemesinan di dalam keadaan pelinciran banjir. Lelasan dan kemungkinan pisau pemotong untuk menyerpih dan gagal bertambah dengan peningkatan dalam kekerasan bahan kerja dan pengurangan sudut heliks alat pemotong. Kuantiti kecil minyak semula jadi yang disembur dalam bentuk kabus adalah berkesan untuk mengurangkan kehausan pisau pengisar dan keterukan lelasan, dan mencegah kegagalan pisau pemotong. Sepanjang tempoh memesis bahan kerja 35 dan 55 HRC keluli tahan karat (HRC-SS) di dalam keadaan pelinciran kabus semburan, pisau pengisar yang bersudut heliks 25° dan 40° sudut heliks hanya dikenakan penyerpihan dan lelasan yang berskala kecil. Kemuluran bahan kerja mempunyai pengaruh yang penting kepada kemas permukaan kerja. Khususnya, adalah didapati dalam pengisaran 55 HRC-SS, walaupun kehausan pisau pengisar menjadi lebih teruk, kemas permukaan adalah lebih baik berbanding dengan pengisaran 35 HRC-SS.

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TABLE OF CONTENTS

	Page
TITLE	i
DECLARATION	ii
CERTIFICATION	iii
ACKNOWLEDGEMENT	iv
ABSTRACT	v
<i>ABSTRAK</i>	vi
TABLE OF CONTENTS	vii
LIST OF FIGURES	ix
LIST OF TABLES	xiv
LIST OF ABBREVIATIONS	xv
LIST OF SYMBOLS	xvii
LIST OF EQUATIONS	xviii
CHAPTER 1: INTRODUCTION	1
1.1 Background	1
1.2 Metal Cutting Process	3
1.3 Built-up edge	5
1.4 Problem Statements	6
1.5 Objectives of Research	7
1.6 Scope of Research	8
1.7 Work Flow of the Research	8
1.8 Organization of the Thesis	10
CHAPTER 2: LITERATURE REVIEW	11
2.1 Wear Behaviour	11
2.2 The Effects of Cutting Speed	12
2.3 Optimum Cutting Speed	14
2.4 The Effects of Coolant	16
2.5 The Effects of Tool Geometry	20
2.6 The Effects of Coating	22
2.7 Surface Finish	28
CHAPTER 3: EXPERIMENTAL PROCEDURE	30
3.1 Workpiece Specimens	30

3.2	Cutting Tools	33
3.3	Lubrications	36
3.4	Cutting Parameters	37
3.5	Cutting Tests	40
	3.5.1 Preliminary Cutting Tests	45
3.6	Tool Wear Measurement	46
CHAPTER 4: RESULT AND DISCUSSIONS		51
4.1	Maximum Flank Wear	51
4.2	Tool Wear under Flood Lubrication Condition	52
4.3	Tool Wear under Oil-Mist-Spray Lubrication Condition	55
4.4	Analysis of Wear Progression using SEM	58
	4.4.1 Rake and Flank Faces	58
	4.4.2 Tool Centre	71
4.5	The Effects of Cutting Parameter	78
	4.5.1 Cutting Speed	79
	4.5.2 Maximum Depth of Cut	82
	4.5.3 Feed rate	83
4.6	Morphology of Surface Finish	86
CHAPTER 5: CONCLUSIONS		99
5.1	Conclusion	99
5.2	Future Work	101
REFERENCES		103



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LIST OF ABBREVIATIONS

AlCrN	Aluminium chromium nitride
AlN	Aluminium nitride
AlTiCN	Aluminium titanium carbon nitride
AlTiN	Aluminium titanium nitride
BUE	built-up edge
CAD	computer aid design
CAM	computer aid manufacturing
CCNG	compressed cold nitrogen gas
CCNGOM	compressed cold nitrogen gas and oil mist
CNC	computer numerical controlled
CrN	chromium nitride
CVD	chemical vapour deposition
DLC	diamond-like carbon
DOC	depth of cut
fcc	face centred cubic
HRC	Rockwell hardness "C"
HRC-SS	stainless steel with Rockwell hardness "C"
HSM	high speed milling
m	meter
m/min	meter per minute
mm	milimeter
MQL	Minimum quantity lubrication
NaCl	natrium chloride

PVD	physical vapour deposition
rpm	revolution per minute
SS	stainless steel
TiC	titanium carbon
TiCN	titanium carbon nitride
TiN	titanium nitride
Vol	volume
WOC	cross over/ width of cut



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LIST OF EQUATIONS

	Page
Equation 2.1 $vT^2 = \text{constant}$	16
Equation 3.1 Maximum DOC = 20% X D	37
Equation 3.2 $V_c = \pi DN$	38
Equation 3.3 Feed rate (mm/min) = N x F x F_t	39
Equation 3.4 Cutting distance = $\left(\frac{\text{width}}{\text{width of cut}} \right) \times \text{length}$	43



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LIST OF FIGURES

		Page
Figure 1.1	Schematic diagram showing the location of different types of wear taking place	2
Figure 1.2	Schematic geometry of orthogonal cutting	4
Figure 1.3	Distribution of normal and shear stresses on the tool rake face	5
Figure 1.4	Schematic work flow of the research	9
Figure 2.1	The dominant of the tool wear mechanism with the cutting temperature	14
Figure 2.2	Chart shows the definition of high speed milling with different type of work material	15
Figure 3.1	The schematic of the Vickers microhardness test	32
Figure 3.2	The common shapes ground on end-mill tool	34
Figure 3.3	The schematic diagram of the oil-mist-spray lubrication	37
Figure 3.4	Schematic of the milling process	42
Figure 3.5	SEM of the (a) tool centre and (b) rake and flank faces of a new tool	44
Figure 3.6	(a) Overview and (b) coating surface of a new cutting tool	45
Figure 3.7	Overview of the cutting tool after machining	47
Figure 3.8	Flank wear formed between the notch wear and worn surface at the tool centre	48
Figure 3.9	Ball nose end-mill	49
Figure 3.10	Detail of 3.7 A and 3.7 B showing measurement of (a) maximum flank wear and (b) tool centre wear	50
Figure 4.1	Maximum flank wear always occurred at a distance close to the DOC zone	51
Figure 4.2	Contact area between tool rake face and uncut chip	52

Figure 4.3	Changes in the flank wear of the 25° and 40° helix angle tools with cutting distance in the milling of 35 and 55 HRC-SS at the cutting speed of 50 m/min, 0.2 mm of depth of cut and 0.04 mm/tooth of feed rate under flood lubrication condition	53
Figure 4.4	Changes in the tool centre wear of the 25° and 40° helix angle tools with cutting distance in the milling of 35 and 55 HRC-SS at the cutting speed of 50 m/min, 0.2 mm of depth of cut and 0.04 mm/tooth of feed rate under flood lubrication condition (A: Attrition and F: Surface fracture)	54
Figure 4.5	Flank wear of the 25° and 40° helix angle tools after machining 35 and 55 HRC-SS at the cutting speed of 50 m/min, 0.2 mm of depth of cut and 0.04 mm/tooth of feed rate for 24 m under oil-mist-spray lubrication condition	56
Figure 4.6	Tool centre wear of the 25° and 40° helix angle tools after machining 35 and 55 HRC-SS at the cutting speed of 50 m/min, 0.2 mm of depth of cut and 0.04 mm/tooth of feed rate for 24 m under oil-mist-spray lubrication condition	57
Figure 4.7	SEM of the rake face of the 40° helix angle tool used to machine 35 HRC-SS for 4 m. Layers of coating was delaminated from the tool	59
Figure 4.8	Detail 4.7 A of figure 4.7 shows that (a) patches of coating have been delaminated from the rake face, and (b) the removal of the coating exposing the substrate of the tool material	60
Figure 4.9	SEM of the 40° helix angle tool used to machine 35 HRC-SS for 24 m	61
Figure 4.10	Detail 4.9 A of figure 4.9 shows that grooves are the dominant features on the rake face	61
Figure 4.11	SEM of the rake face of the 25° helix angle tool used to machine 35 HRC-SS for (a) 8 m, (b) 16 m and (c) 24 m under flood lubrication condition	62
Figure 4.12	Initial formation of shell-like fracture	64
Figure 4.13	Fully developed shell-like fracture	64

Figure 4.14	SEM of the 40° helix angle tool used to machine 55 HRC-SS for 16 m	65
Figure 4.15	Detail 4.14 A of figure 4.14 shows that edge chipping and grooves are the dominant features on the tool surface	65
Figure 4.16	Catastrophic failure	66
Figure 4.17	The shell-like fracture still remains but the tool failed through excessive fracture	66
Figure 4.18	SEM of the 25° helix angle tool used to machine (a) 35 and (b) 55 HRC-SS for 24 m under oil-mist-spray lubrication condition	68
Figure 4.19	Surface fracture initiated at the crack sites prior to catastrophic failure	70
Figure 4.20	SEM of the centre of the 40° helix angle tool used to machine 35 HRC-SS under flood lubrication condition for 4 m. (a) Layers of coating was delaminated from the tool centre. (b) After the coating had been delaminated, the tool centre was exposed to attrition wear, resulting in the formation of small cavities	73
Figure 4.21	SEM of the centre of the 40° helix angle tool after being used to machine 35 HRC-SS for 16 m under flood lubrication condition. Cavities and abrasion grooves were the dominant wear features on the tool centre	74
Figure 4.22	SEM of the centre of the 25° helix angle tool after machining 35 HRC-SS for (a) 8 m, (b) 16 m and (c) 24 m under flood lubrication condition	75
Figure 4.23	Surface fracture was the dominant wear mechanism on the tool centre throughout the entire duration of the machining of 55 HRC-SS under flood lubrication condition using 25° and 40° helix angle tool	76
Figure 4.24	SEM of the tool centre of the (a) 25° and (b) 40° helix angle tools used to machine 35 HRC-SS for 24 m under oil-mist-spray lubrication condition	77
Figure 4.25	SEM of the tool centre of the (a) 25° and (b) 40° helix angle tools used to machine 55 HRC-SS for 24 m under oil-mist-spray lubrication condition	78

Figure 4.26	Tool life of the 25° and 40° helix angle tools when machining 55 HRC-SS at the cutting speed of 50 m/min and 88 m/min under flood lubrication condition	79
Figure 4.27	SEM of the 40° helix angle tool used to machine 55 HRC-SS at the cutting speed of (a) 50 m/min and (b) 88 m/min for 8 m under flood lubrication condition	81
Figure 4.28	Tool life of 25° and 40° helix angle tools when milling 35 and 55 HRC-SS at the depth of cut of 0.2 mm and 0.4 mm under oil-mist-spray lubrication condition	82
Figure 4.29	Tool life of 25° helix angle tools when milling 55 HRC-SS at the feed rate of 0.04 mm/tooth, 0.01 mm/tooth and 0.004 mm/tooth under oil-mist-spray lubrication condition, and 0.04 mm/tooth and 0.004 mm/tooth under flood lubrication condition	84
Figure 4.30	SEM of the 25° helix angle tool used to machine 55 HRC-SS for 24 m at (a) 0.04 mm/tooth and (b) 0.01 mm/tooth of feed rate under oil-mist-spray lubrication condition	86
Figure 4.31 (a)	Morphology of the surface of 35 HRC-SS after being cut for one time using 40° helix angle tool under flood lubrication condition	87
Figure 4.31 (b)	Morphology of the surface of 35 HRC-SS after being cut for two times using 40° helix angle tool under flood lubrication condition	88
Figure 4.31 (c)	Morphology of the surface of 35 HRC-SS after being cut for three times using 40° helix angle tool under flood lubrication condition	88
Figure 4.31 (d)	Morphology of the surface of 35 HRC-SS after being cut for four times using 40° helix angle tool under flood lubrication condition	89
Figure 4.31 (e)	Morphology of the surface of 35 HRC-SS after being cut for five times using 40° helix angle tool under flood lubrication condition	89
Figure 4.31 (f)	Morphology of the surface of 35 HRC-SS after being cut for six times using 40° helix angle tool under flood lubrication condition	90
Figure 4.32	(a) Tearing and (b) work material formed at the ridge on the 35 HRC-SS under flood lubrication condition	91

Figure 4.33 (a)	Morphology of the surface of 55 HRC-SS after being cut for one time using 40° helix angle tool under flood lubrication condition	92
Figure 4.33 (b)	Morphology of the surface of 55 HRC-SS after being cut for two times using 40° helix angle tool under flood lubrication condition	92
Figure 4.33 (c)	Morphology of the surface of 55 HRC-SS after being cut for three times using 40° helix angle tool under flood lubrication condition	93
Figure 4.34	The surface of the 55 HRC-SS machined under oil-mist-spray lubrication condition was burnished with wavy marks	94
Figure 4.35	Tearing formed at the ridge on the 35 HRC-SS under oil-mist-spray lubrication condition, and was less severe than that produced under flood lubrication condition, as shown earlier in figure 4.32	95
Figure 4.36	The adhesion of work material on (a) tool centre, (b) rake face, (c) rake and flank faces, and (d) at the notch wear on flank face	96
Figure 4.37	Adhesion of work material on rake face adjacent to tool edge led to the formation of BUE	97
Figure 4.38	Deterioration of the machined workpiece due to the formation of BUE	98

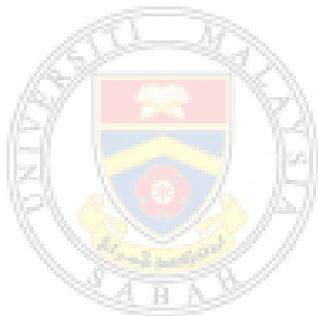
LIST OF SYMBOLS

%	percentage
±	plus or minus
Al	Aluminium
Cl	chlorine
Cr	chromium
<i>D</i>	diameter
Fe	ferrous
<i>L</i>	length
Mn	manganese
N	Nitride
<i>N</i>	revolution
Na	sodium
O	oxygen
ϕ	Shear angle
Si	Silicon
<i>T</i>	Tool life
Ti	Titanium
<i>tc</i>	chip thickness
<i>W</i>	width
α	Rake angle
β	helix angle
<i>v</i>	Cutting speed



LIST OF TABLES

	Page
Table 3.1 The cutting tools, tool geometries, specimen, workpiece hardness, lubrication method and cutting parameters used in this study	40
Table 3.2 The specification details of the milling machine	41
Table 4.1 The range of distances at which the shell-like fracture was formed and catastrophic failure occurred, and whether chipping occurred during machining under various conditions. Yes*- shell-like fracture was found to form after machining for 24 m but the range of distance at which it was formed was not determined	71



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CHAPTER 1

INTRODUCTION

1.1 Background

Nowadays, science and technology plays a very important role in manufacturing and production. Studies have been carried out to improve the advance technologies and manufacturing methods such as machine tool design, controller system, tool holding devices, and tooling technology which has significant impact on the quality of the products. The introduction of the computer aid design and computer aid manufacturing (CAD/CAM), such as computer numerical controlled (CNC) milling and turning (Chevrier *et al.*, 2003; Mansour & Abdalla, 2002; Toh, 2004) had a deep impact to the engineering industry.

Milling is a widely employed material removal process for different materials, and it is characterized by high material removal rate (Reddy & Rao, 2006). The major difficulties encountered in the milling process are the tool wear and surface finish. During the cutting process, tool wear is caused by the mechanical and chemical interaction between the tool, workpiece and environment (Attanasio *et al.*, 2006; Sokovic *et al.*, 2001). This includes the relative motion between tool-chip and tool-workpiece, and the chemical reactions induced between tool-coolant during the cutting process. Nevertheless, the tool wear in end-milling is also dependent on the length of the sliding contact between the tool and the workpiece. As the length of the sliding contact between the tool and the workpiece decreases in proportion to the increases of the feed rate, the tool wear is expected to be reduced (Rahman *et al.*, 2003). Tool wear affects the dimension accuracy and surface quality of the milled surface (Kumar *et al.*, 2006). Flank wear is the predominant wear in the determination of tool wear and tool life, where most of the researchers described the tool wear in term of flank wear and by measuring the flank wear. In milling, both tool wear and the surface finish are two important factors in evaluating the performance of cutting tool.

Generally there are two types of wear, i.e. mechanical wear and chemical wear (Sokovic *et al.*, 2001). Abrasive wear, chipping and fracture are examples of mechanical wear. Chemical wear is the thermo-chemical wear resulting from chemical interaction between the tool, workpiece and environment such as diffusion wear. Figure 1.1 shows the occurrence of different types of chemical and mechanical wear.

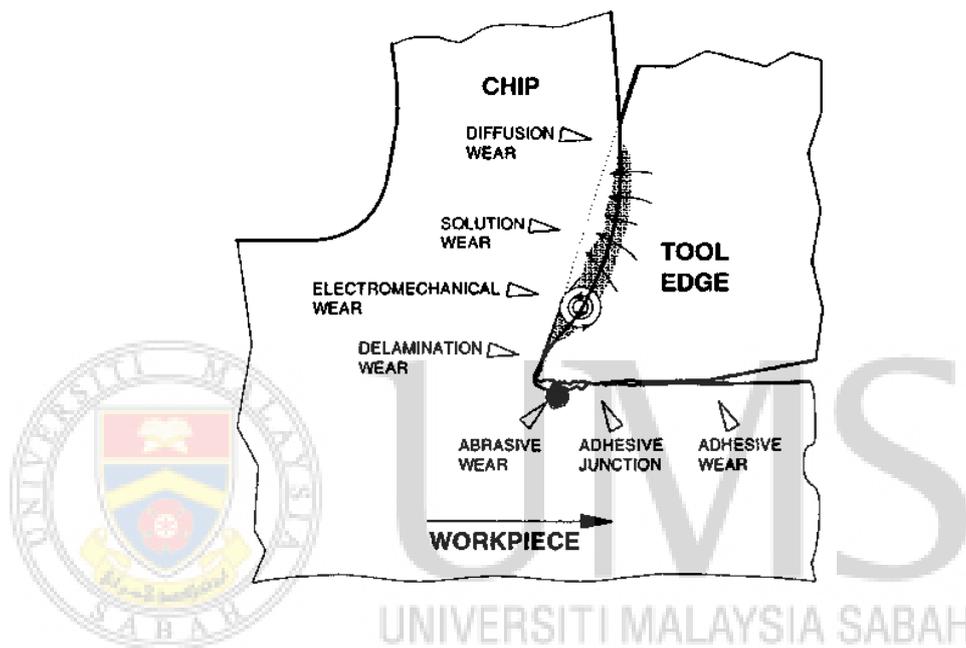


Figure 1.1: Schematic diagram showing the location of different types of wear taking place

Source: Sokovic *et al.*, (2001)

The milling condition depends on the cutting environment, cutting parameters, cutting tool and workpiece (Ema & Davies, 1989; Korkut & Donertas, 2007; Richetti *et al.*, 2004; Stanford *et al.*, 2007; Tsao & Hong, 2002; Tzeng, 2007). Hence, research is essential to determine the optimum cutting conditions. Recommendations from manufacturers should only be used as a guide because better cutting conditions for a specific situation can only be found through research (Richetti *et al.*, 2004). Various methods had been explored to improve the tool life and surface finish. These include the use of different cutting parameters,

geometries of tool, types of cutting fluids, and coating material on the tool (Rahman *et al.*, 2003).

The cutting of metal is the major metal shaping process in the production of engineering components (Sokovic *et al.*, 2001). Steel is one of the most common materials (metal) in the world and a major component in constructions, buildings, infrastructure, tools, ships, automobiles, machines and appliances (Wikipedia, 2009). Stainless steel has good mechanical and chemical properties, and it plays an extremely important role in the engineering industry. The machining of stainless steel materials generally gives short tool life, limited metal removal rate, large cutting forces and high power consumption. These could be attributed to the high temperature strength, rapid work-hardening during machining and reactivity with the tool materials at high cutting speed (Lin, 2002). Short tool life and poor surface finish are the two main problems encounter in machining stainless steel, which generally regarded as difficult-to-machine material (Shao *et al.*, 2007).

1.2 Metal Cutting Process

In machining, chip formation takes place by a process of intense plastic shearing in a region known as the primary deformation zone, as shown in figure 1.2. This zone extends from the tool cutting edge to the junction between the surface of the chip and workpiece. The chip has a freshly created clean surface and, as it flows up to the tool rake face, it is subjected to very high normal stress. Under these conditions, strong adhesion occurs between the nascent chip and the tool and this chip can results an additional shear in the region of the chip adjacent to the tool face known as the secondary shear zone. In practice, the primary shear zone is often idealized as a plane, called the shear plane. The angle of the inclination of the shear plane to the direction of cutting is called the shear angle (Liew, 2004).

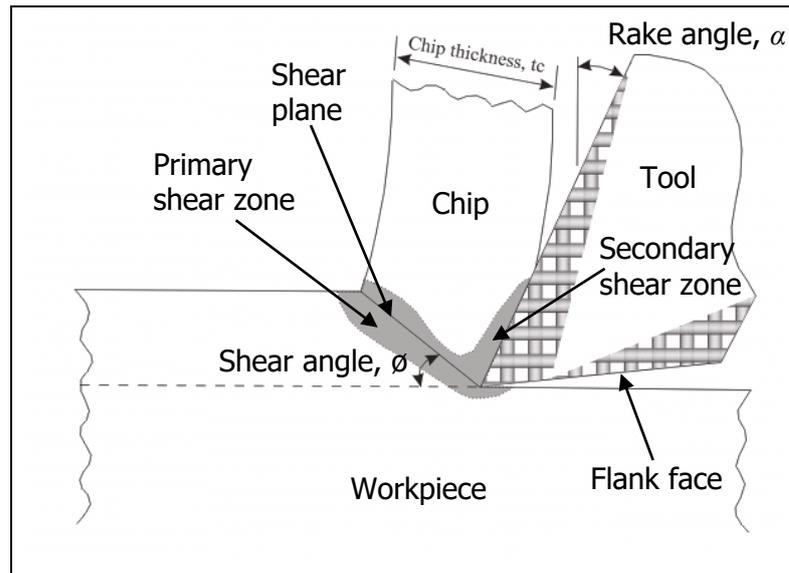


Figure 1.2: Schematic geometry of orthogonal cutting

Source: Liew (2004)

Over the secondary shear contact region, regions of both sticking and sliding friction occur. Over this part of the contact, the normal stress rises steeply to a maximum value at the cutting edge (figure 1.3). Deformation occurs in the lower layers of the chip material and the real contact area approaches the apparent area. The frictional stress is constant and independent of the normal stress, and equal to the bulk shear flow stress of the chip material. Over the remainder of the contact, at some distance away from the cutting edge, sliding friction occurs in which the coefficient of friction is constant. In this region, relative motion between the chip and the tool occurs at the interface between the contacting asperities (Liew, 2004).