PERFORMANCE EVALUATION OF UNCOATED AND COATED CARBIDE TOOLS WHEN END MILLING OF TITANIUM ALLOY USING RESPONSE SURFACE METHODOLOGY

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PERFORMANCE EVALUATION OF UNCOATED AND COATED CARBIDE TOOLS WHEN END MILLING OF TITANIUM ALLOY USING RESPONSE SURFACE METHODOLOGY

AMRIFAN SALADIN MOHRUNI

A thesis submitted in fulfilment of the requirements for the award of the degree of Doctor of Philosophy (Mechanical Engineering)

> Faculty of Mechanical Engineering Universiti Teknologi Malaysia

> > MARCH 2008

I declare that this thesis entitled "*Performance Evaluation of Uncoated and Coated Carbide Tools when End Milling of Titanium Alloy using Response Surface Methodology*" is the result of my own research except as cited in the references. The thesis has not been accepted for any degree and is not concurrently submitted in candidature of any other degree.

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To my grandfathers, my parents, my brothers, my beloved wife and sons, Alif Tias Mangkunegara, Anugerah Al-Amin Mangkunegara, Noordin As-Shiddiq Mangkunegara and M. Rafif Al-Farouq Mangkunegara for their supports and understandings

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ABSTRACT

Titanium alloys are being constituted in modern aerospace structure, marine, automotive and chemical industry due to their strength-to-weight ratio, excellent corrosion and fracture resistance and low modulus of elasticity. However, titanium and its alloys are considered very difficult-to-machine material due to its highly chemical reactivity and tendency to weld to the cutting tool. These result in edge chipping and rapid tool failure. Although in the past, many studies had been carried out to predict the tool performance during end milling operation in terms of primary machining parameters, the effect of tool geometry was not taken into consideration. Therefore, an effort has been made in this research to evaluate the influence of tool geometry (radial rake angle), feed and cutting speed when end milling titanium alloy, Ti-6Al-4V. Machining trials were performed under flood condition with a constant axial and radial depth of cut. The cutting tools used were uncoated solid carbide tools grade K30 and coated with a physical vapor deposition (PVD) TiAlN and Supernitride. Tool performance of the above mentioned tools were investigated under various cutting conditions, while the surface roughness of the milled parts and cutting forces were measured. The performance of cutting tools was described using response surface methodology. It was found that, the cutting speed, feed rate and radial rake angle have a significant effect on various responses investigated such as tool life, surface roughness and cutting forces. The developed mathematical models were validated statistically using analysis of variances (ANOVA), which can be used for predicting the optimum cutting conditions within the limits of the factors In general, coated solid carbide tools performed better than the investigated. uncoated tools when end milling Ti-6Al-4V.

ABSTRAK

Aloi titanium digunakan di dalam struktur bidang aerospace moden, marin, automotif dan industri kimia, disebabkan oleh kadar berat dan kekuatannya, ketahanan terhadap kakisan dan keretakan serta modulus elastik yang rendah. Walau bagaimanapun titanium dan aloinya dikategorikan sebagai bahan yang sukar untuk dimesin, disebabkan oleh kereaktifan kimia yang tinggi, dan becenderungan untuk terkimpal ke matalat dengan pantas. Walaupun pada masa yang lalu telah banyak kajian dilakukan untuk menjangka prestasi matalat semasa proses kisar hujung terhadap parameter permesinan utama, kesan dari geometri matalat tidak pernah dipertimbangkan. Oleh itu, usaha telah dibuat dalam penyelidikan ini untuk menilai pengaruh geometri matalat pemotong (sudut sadak jejarian), uluran dan kelajuan pemotongan ketika pengisaran hujung aloi titanium, Ti-6Al-4V. Percubaan permesinan telah dilakukan di bawah keadaan basah serta kedalaman pemotongan tujah dan jejarian yang tetap. Matalat pemotong yang digunakan adalah matalat karbida padu tanpa salut dengan gred K30 dan matalat bersalut PVD-TiAlN dan Supernitride. Kebolehan matalat pemotong yang disebut di atas diselidiki di bawah pelbagai keadaan pemotongan, sementara kekasaran permukaan benda kerja dan daya pemotong diukur. Kebolehan matalat pemotong digambarkan menggunakan kaedah permukaan respon (RSM). Didapati kelajuan pemotongan, kadar uluran dan sudut sadak jejarian mempunyai kesan yang besar terhadap tindak balas yang diselidiki seperti hayat matalat, kekasaran permukaan dan daya potong. Model matematik yang dibangunkan, disahkan secara statistik menggunakan analisa varian (ANOVA) dan ianya dapat digunakan untuk menjangkakan keadaan pemotongan optimum di dalam julat faktor yang diselidiki. Secara umumnya matalat bersalut menunjukkan prestasi yang lebih baik berbanding matalat tidak bersalut ketika pengisaran hujung Ti-6Al-4V.

TABLE OF CONTENTS

CHA	P	ΓER
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1

TITLE

PAGE

DECLARATION	ii
DEDICATION	iii
ACKNOWLEDGEMENTS	iv
ABSTRACT	V
ABSTRAK	vi
TABLE OF CONTENTS	vii
LIST OF TABLES	xvi
LIST OF FIGURES	xvii
LIST OF ABBREVIATIONS	xxvii
LIST OF SYMBOLS	xxviii
LIST OF APPENDICES	xxix
INTRODUCTION	1
1.1 Overview	1
1.2 Background of the Problem	1
1.3 Statement of the Problem	2
1.4 Objective of the Study	4
1.5 Significance of the Study	4
1.6 Scope of the Study	5

LIT	ERAT	URE RE	VIEW	6
2.1	Introd	uction to	Metal Cutting	6
2.2	End N	lilling		6
	2.2.1	Cutting	Force	8
	2.2.2	The Star	tic Cutting Force	8
	2.2.3	Cutting	Force in End Milling	10
	2.2.4	Relatior	ship between Table and Cutter System	
		of Cutti	ng Force	12
2.3	Cuttin	g Tool		13
	2.3.1	Cutting	Tool Materials	15
		2.3.1.1	Unalloyed and Low-Alloy Tool Steel	16
		2.3.1.2	High Speed Steel (HSS)	16
		2.3.1.3	Tungsten Carbide (WC)	17
		2.3.1.4	Ceramics	19
		2.3.1.5	Cermets	20
		2.3.1.6	Cubic Boron Nitride (CBN)	20
		2.3.1.7	Diamond (D)	21
		2.3.1.8	Polycrystalline Diamond (PD)	22
	2.3.2	Cutting	Tool Coatings	22
		2.3.2.1	Chemical Vapors Deposition (CVD)	23
		2.3.2.2	Physical Vapors Deposition (PVD)	25
		2.3.2.3	Composite CVD + PVD Coatings	27
		2.3.2.4	TiAlN Based Coated Tools	28
2.4	Tool V	Wear in E	nd Milling	29
	2.4.1	Tool W	ear and Tool Failure Modes	30
		2.4.1.1	Flank Wear	30
		2.4.1.2	Crater Wear	31
		2.4.1.3	Notch Wear	32
		2.4.1.4	Nose Radius Wear	32
		2.4.1.5	Plastic Deformation	32
		2.4.1.6	Edge Chipping or Frittering	33
		2.4.1.7	Tool Fracture	33
	2.4.2	Tool W	ear Mechanism	33
		2.4.2.1	Adhesive or Attritional Wear	34

			2.4.2.2	Abrasive Wear	34
			2.4.2.3	Diffusion or Solution Wear	35
			2.4.2.4	Oxidation	35
			2.4.2.5	Chemical Wear or Corrosion	36
	2.5	Surfac	e Roughr	less	36
3	DES	IGN O	F EXPE	RIMENT AND	
	RES	PONSI	E SURFA	ACE METHODOLOGY	39
	3.1	Design	n of Expe	riment (DOE)	39
	3.2	Respon	nse Surfa	ce Methodology	40
		3.2.1	The Res	ponse Function and the Response Surface	41
		3.2.2	Represe	ntation of the Response Surface by Contours	42
	3.3	Centra	l Compos	site Design (CCD)	44
		3.3.1	General	Steps Involved in Application of CCD	47
			3.3.1.1	Postulation of Mathematical Models	47
			3.3.1.2	Coding for the Independent Variables	50
			3.3.1.3	Estimation of Model Parameters	51
			3.3.1.4	Analysis of Results	52
4	EXP	ERIM	ENTAL	SETUP AND METHOD OF	
	EXP	PERIM	ENTATI	ON	53
	4.1	Introdu	uction		53
	4.2	Cutting	g Tool		53
	4.3	Workp	viece Mat	erial	54
	4.4	Experi	mental D	esign and Planning	55
	4.5	Experi	mental W	⁷ orks	57
		4.5.1	Cutting	Force Measurement	57
		4.5.2	Tool We	ear Measurement and Tool Life	59
		4.5.3	Surface	Roughness Measurement	60
5	EXP	PERIM	ENTAL]	RESULTS FOR UNCOATED TOOLS	62
	5.1	Develo	opment of	Tool Life Models for Uncoated Carbide	
		Tools			62
		5.1.1	Introduc	tion	62

	5.1.2	Postulat	ion of the Mathematical Models	63		
	5.1.3	Experin	nental Design	65		
	5.1.4	Coding	of the Independent Variables	66		
	5.1.5	Analysi	s of the Tool Life Results	68		
		5.1.5.1	Development of the First Order Model			
			using 2 ^k -Factorial Design	68		
		5.1.5.2	Development of the Second Order Model			
			using CCD	72		
		5.1.5.3	Development of the First Order Model			
			using CCD	75		
5.2	Devel	opment o	f Surface Roughness Models			
	for Un	coated C	arbide Tools	78		
	5.2.1	Introduc	etion	78		
	5.2.2	Postulat	ion of the Mathematical Models	79		
	5.2.3	Analysi	s of the Surface Roughness Results	81		
		5.2.3.1	Development of the mathematical model			
			using 2 ^k -factorial design	81		
		5.2.3.2	Development of the Second Order Model			
			using CCD	83		
		5.2.3.3	Development of the First Order Surface			
			Roughness Model using CCD	85		
5.3	Devel	opment o	f Cutting Force Models for Uncoated			
	Carbic	le Tools		87		
	5.3.1	Introduc	ction	87		
	5.3.2	Postulat	ion of the Mathematical Models	88		
	5.3.3	Analysi	s of Cutting Force Results	89		
		5.3.3.1	Development of the Mathematical Model			
			using 2 ^k -Factorial Design	89		
		5.3.3.2	Development of the First Order Model			
			using CCD	93		
		5.3.3.3	Development of the Second Order Model			
			using CCD	97		
5.4	Optim	ization of	f the Mathematical Models for Uncoated			
	Carbide Tools 1					

	5.4.1	Introduc	ction	102
	5.4.2	Selectio	n of Validated Model Combinations	103
	5.4.3	First Co	mbination of Validated Model	104
	5.4.4	Second	Combination of Validated Model	106
EXI	PERIM	ENTAL	RESULTS OF TIAIN-COATED TOOLS	109
6.1	Devel	opment o	f Tool Life Models for TiAlN	
	Coate	d Carbide	Tools	109
	6.1.1	Tool Lit	fe Results	109
	6.1.2	Analysi	s of the Tool Life Results for TiAlN	
		Coated	End Mills	110
		6.1.2.1	Development of the Tool Life Model	
			using 2 ^k -Factorial Design	111
		6.1.2.2	Development of the Tool Life Model	
			using 2nd Order CCD	114
		6.1.2.3	Development of the Tool Life Model	
			using 1st Order CCD	117
6.2	Devel	opment o	f Surface Roughness Models for TiAlN	
	Coate	d Carbide	Tools	121
	6.2.1	Surface	Roughness Results	121
	6.2.2	Analysi	s of the Surface Roughness Results	122
		6.2.2.1	Development of the Surface Roughness	
			Model using 2 ^k -Factorial Design	122
		6.2.2.2	Development of the Surface Roughness	
			Model using 2 nd Order CCD	126
		6.2.2.3	Development of the Surface Roughness	
			Model using 1 st order CCD	130
6.3	Devel	opment o	f Cutting Force Models for TiAlN	
	Coate	d Carbide	Tools	132
	6.3.1	Cutting	Force Results	132
	6.3.2	Analysi	s of Cutting Force Results	133
		6.3.2.1	Development of the Cutting Force	
			Model using 2 ^k -Factorial Design	133

		6.3.2.2	Development of the First Order	
			Cutting Force Model using CCD	13'
		6.3.2.3	Development of the Second Order	
			Cutting Force Model using CCD	14
6.4	Optim	ization of	f the Mathematical Models for TiAlN	
	Coate	d Carbide	Tools	14
	6.4.1	Selectio	n of Validated Model Combinations	14
	6.4.2	First Co	mbination of Validated Model	14
	6.4.3	Second	Combination of Validated Model	15
EXI	PERIM	ENTAL	RESULTS FOR SUPER NITRIDE	
CO	ATED	TOOLS		15
7.1	Devel	opment o	f Tool Life Models for SN_{TR} coated	
	Carbic	de Tools		15
	7.1.1	The Too	ol Life Experimental Results	15
	7.1.2	Analysi	s of the Tool Life Results for SN_{TR}	
		Coated	End Mills	15
		7.1.2.1	Development of the Tool Life Model	
			using 2 ^k -Factorial Design	15
		7.1.2.2	Development of the Tool Life Model	
			using 2 nd Order CCD	15
		7.1.2.3	Development of the Tool Life Model	
			using 1st Order CCD	16
7.2	Devel	opment o	f Surface Roughness Models for SN_{TR}	
	Coate	d Carbide	Tools	16
	7.2.1	The Sur	face Roughness Experimental Results	16
	7.2.2	Analysi	s of the Surface Roughness Results	16
		7.2.2.1	Development of the Surface Roughness	
			Model using 2 ^k -Factorial Design	16
		7.2.2.2	Development of the Surface Roughness	
			Model using 2 nd Order CCD	16
		7.2.2.3	Development of the Surface Roughness	
			Model using 1 st Order CCD	17

7.3	Devel	opment o	f Cutting Force Models for SN _{TR}	
	Coated	d Carbide	Tools	175
	7.3.1	The Cut	ting Force Experimental Results	175
	7.3.2	Analysi	s of Cutting Force Results	176
		7.3.2.1	Development of the Cutting Force Model	
			using 2 ^k -Factorial Design	176
		7.3.2.2	Development of the First Order Model	
			using CCD	180
		7.3.2.3	Development of the Second Order Model	
			using CCD	184
7.4	Optim	ization of	f the Mathematical Models for SN_{TR}	
	Coated	d Carbide	Tools	190
	7.4.1	Selectio	n of Validated model combinations	190
	7.4.2	First Co	mbination of Validated Model	191
	7.4.3	Second	Combination of Validated Model	194
DIS	CUSSI	ON		197
8.1	Comp	arison of	Validated Tool Life Models	197
	8.1.1	Compar	ing Response Surfaces of Validated	
		Tool Lit	fe Models	198
		8.1.1.1	Comparison Response Surface of	
			Validated Tool Life Models	
			for Cutting Speed and Feed	198
		8.1.1.2	Comparison of Response Surface of	
			Validated Tool Life Models	
			for Cutting Speed and Radial Rake Angle	203
		8.1.1.3	Comparison Response Surface of	
			Validated Tool Life Models	
			for Feed and Radial Rake Angle	205
	8.1.2	Compar	ison of Optimum Cutting Condition	
		for Vali	dated Tool Life Models	207
8.2	Comp	arison of	Validated Surface Roughness Models	208
	8.2.1	Compar	ing Response Surfaces of Validated Surface	
		Roughn	ess Models	209

			8.2.1.1	Comparison Response Surface of	
				Validated Surface Roughness Models	
				for Cutting Speed and Feed	210
			8.2.1.2	Comparison Response Surface of	
				Validated Surface Roughness Models	
				for Cutting Speed and Radial Rake Angle	212
			8.2.1.3	Comparison Response Surface of Validated	t
				surface Roughness Models for	
				Feed and Radial Rake Angle	214
		8.2.2	Compari	ng Optimum Cutting Condition of	
			Validate	d Surface Roughness Models	216
	8.3	Compa	rison of V	Validated Cutting Force Models	217
		8.3.1	Compari	ng Response Surfaces of Validated	
			Cutting	Force Models	218
			8.3.1.1	Comparison Response Surface of Validated	t
				Cutting Force Models for	
				Cutting Speed and Feed	218
			8.3.1.2	Comparison Response Surface of Validated	t
				Cutting Force Models for Cutting Speed	
				and Radial Rake Angle	221
			8.3.1.3	Comparison Response Surface of Validated	t
				Cutting Force Models for Feed	
				and Radial Rake Angle	223
		8.3.2	Compari	ng Optimum cutting Condition of validated	
			Cutting l	Force Models	225
9	CON	ICLUS	IONS		226
	9.1	Conclu	isions		226
		9.1.1	The Best	Performer for All Types of Cutting Tools	226
		9.1.2	Optimum	n Cutting Conditions for All Types	
			of Cuttin	g Tools	227
		9.1.3	The Best	Mathematical Models for All Types	
			of Cuttin	g Tools	228
	9.2	Future	Works		229

REFERENCES		230
Appendices A – C	、	242

LIST OF TABLES

TABLE NO	. TITLE	PAGE
3.1	ANOVA for significance of regression in multiple regression	52
4.1	Properties of cutting tool used in the experiments	54
4.2	Mechanical properties of Ti-6Al-4V at room temperature	55
4.3	Chemical properties of Ti-6Al-4V	55
4.4	Coding of the cutting conditions for experimentations	57
5.1	Levels of the independent variables and coding for tool life mod	els 67
5.2	Tool life results for uncoated carbide tools	67
5.3	Surface roughness results for uncoated carbide tools	80
5.4	Cutting force results for uncoated carbide tools	89
6.1	Tool life results for TiAlN-coated carbide tools	110
6.2	Surface roughness results for TiAlN coated carbide tools	121
6.3	Cutting force Fc when using TiAlN coated carbide tools	133
7.1	Tool life results for SNTR coated solid carbide tools	153
7.2	Surface roughness results for SNTR coated carbide tools	164
7.3	Cutting force results for SNTR coated carbide tools	176
8.1	Summary of validated tool life models	201
8.2	Summary of validated Surface Roughness Models	209
8.3	Summary of validated Cutting Force Models	217
9.1	Optimum cutting conditions for all types of tools.	227
9.2	Optimum cutting conditions for all types of tools.	227
9.3	The best tool life prediction models for all types of tools.	228
9.4	The best surface roughness prediction models for all types of too	ols.228
9.5	The best cutting force prediction models for all types of tools.	229

LIST OF FIGURES

FIGURE NO	. TITLE	PAGE
2.1	Type of milling operation (Stephenson and Agapiou, 1997)	7
2.2	Schematic view of the up- and down milling approaches	
	(Stephenson and Agapiou, 1997)	8
2.3	Cutting force components acting on one tooth of an end mill	
	(Alauddin, 1993; Alauddin and El-Baradie, 1996;	
	Alauddin et.al., 1996ab)	10
2.4	End mill geometry (Stephenson and Agapiou, 1997)	14
2.5	Toughness and hardness for each cutting tools material	
	(Stephenson and Agapiou, 1997)	16
2.6	Differences in deposition techniques	
	(Toenshoff and Blawit, 1997)	25
2.7	Deposition techniques (Prengel et. al., 1998)	27
2.8	PVD deposition process for TiAlN coatings	
	(Prengel et. al., 1997)	29
2.9	Type of wear on end mill after ISO8688-2	30
2.10	Variation of the flank wear rate with cutting time,	
	showing the initial wear, steady wear, and severe wear periods	
	(Stephenson and Agapiou, 1997)	31
2.11	Wear mechanisms in cutting tools	
	(Koenig, 1990; Toenshoff, 1995)	34
2.12	Fishbone diagram with the parameter that affect	
	surface roughness profile (Colak et. al. 2007)	37

2.13	Classification of surface roughness formation related	
	to DIN 4760 (Colak et. al. 2007)	38
2.14	Surface roughness profile (Colak et. al. 2007)	38
3.1	A three dimensional response surface showing the expected	
	yield (η) as a function of temperature (x_1) and pressure (x_2)	
	(Myers and Montgomery, 2002)	43
3.2	A contour plot of response surface	
	(Myers and Montgomery, 2002)	43
3.3	The 2 ³ -factorial design augmented with 4 center points	45
3.4	The second order CCD for $k = 3$	46
4.1	The 2 ³ -factorial design augmented with 4 center points and	
	linear CCD design	56
4.2	The second order CCD for $k = 3$	56
4.3	CNC MAHO MH 700S machine centre	58
4.4	Experimental set-up	58
4.5	A multi component force measuring system	59
4.6	Nikon tool makers' microscope for wear measurement	60
4.7	Zeiss Stemi 2000-C microscope for capturing micrograph	
	images	60
4.8	Taylor Hobson Surftronic+3 for measuring surface roughness	61
5.1	Contour of standard error design for 3F1-model	68
5.2	Main effect occurred in 3F1-model	69
5.3	ANOVA for 3F1-model with $n_c = 4$	69
5.4	Box-Cox plot analysis for 3F1-model with $n_c = 4$	70
5.5	Response surface for 3F1-tool life model with $n_c = 4$	71
5.6	Standard deviation for the second order CCD model	72
5.7	Fit and summary test for the second order CCD model	73
5.8	ANOVA for the second order CCD model	73
5.9	Box-Cox Plot Analysis for the second order CCD model	74
5.10	Response surface of CCD quadratic-tool life model	75
5.11	Standard deviation for the first order CCD model	76
5.12	Fit and summary test for the first order CCD design	76
5.13	ANOVA for the first order CCD design	77
5.14	Response surface for the first order CCD design	78

5.15	Main effect occurred in 3F1- surface roughness model	81
5.16	ANOVA for 3F1-surface roughness model	82
5.17	Response surface for 3F1-surface roughness model	83
5.18	Fit and summary test for CCD-surface roughness model	84
5.19	ANOVA for CCD-surface roughness model	84
5.20	Response surface for surface roughness second order	
	CCD model	85
5.21	Fit and summary test for the first order surface roughness	
	CCD model	86
5.22	ANOVA for the first order surface roughness CCD model	87
5.23	Main Effect occurred in 3F1-cutting force model	90
5.24	ANOVA for 3F1-cutting force model	91
5.25	Response surface of AC for 3F1-cutting force model	92
5.26	Response surface of BC for 3F1-cutting force model	92
5.27	Fit and summary test for the first order cutting force	
	CCD model	93
5.28	ANOVA for the first order cutting force CCD model	94
5.29	Response surface of AB for the first order cutting force	
	CCD model	95
5.30	Response surface of AC for the first order cutting force	
	CCD model	95
5.31	Response surface of BC for the first order cutting force	
	CCD model	96
5.32	ANOVA for the second order cutting force CCD model	97
5.33	Response surface AB for the second order cutting force	
	CCD model	98
5.34	Response surface AC for the second order cutting force	
	CCD model	99
5.35	Response surface BC for the second order cutting force	
	CCD model	100
5.36	ANOVA elimination for the second order cutting force	
	CCD model	101
5.37	Optimization combination of validated mathematical model	103
5.38	First numerical optimization of validated mathematical model	104

5.39	First desirability of validated mathematical model	105
5.40	Overlay plot of desirable first optimized mathematical model	105
5.41	Second numerical optimization of validated mathematical	
	model	106
5.42	Second desirability of validated mathematical model	107
5.43	Overlay plot of desirable second optimized mathematical	
	model	108
6.1	Main effect occurred in 3F1-model for TiAlN coated end mil	111
6.2	ANOVA for 3F1-model of TiAlN coated end mills with $n_c = 4$	112
6.3	Response Surface of 3F1-model with $n_c = 4$ for V and f_z	
	using TiAlN coated end mills	113
6.4	Response Surface of 3F1-model with $n_c = 4$ for f_z and γ	
	using TiAlN coated end mills	113
6.5	Fit summary test for the 2nd order CCD using TiAlN	
	coated end mills	114
6.6	ANOVA for the second order CCD tool life model	
	using TiAlN coated tools	115
6.7	Response surface of CCD quadratic-tool life model	
	for V and f_z using TiAlN coated end mills	116
6.8	Response surface of CCD quadratic-tool life model	
	for f_z and γ using TiAlN coated end mills	117
6.9	Fit and summary test for the first order CCD tool life model	
	using TiAlN coated end mills	118
6.10	ANOVA for the first order CCD tool life model	
	using TiAlN coated tools	119
6.11	Response surface of the first order CCD tool life model	
	for $V \text{ an } f_z$ using TiAlN coated tools	119
6.12	Response surface of the first order CCD tool life model	
	for f_z and γ using TiAlN coated tools	120
6.13	Main effect occurred in 3F1- surface roughness model	
	for TiAlN coated tools	122
6.14	ANOVA for 3F1-surface roughness model	
	for TiAlN coated tools	123

6.15	Response surface of 3F1-surface roughness model	
	for V and f_z using TiAlN coated tools	124
6.16	Response surface for 3F1-surface roughness model	
	for f_z and γ using TiAlN coated tools	125
6.17	Response surface for 3F1-surface roughness model	
	for V and γ using TiAlN coated tools	125
6.18	Fit and Summary Test for CCD-surface roughness model	
	for TiAlN coated tools	126
6.19	ANOVA for the 2nd order CCD-surface roughness model	
	for TiAlN coated tools	127
6.20	Response surface of the 2nd order CCD -surface roughness	
	model for V and f_z using TiAlN coated tools	128
6.21	Response surface of the 2nd order CCD -surface roughness	
	model for V and γ using TiAlN coated tools	128
6.22	Response surface of the 2nd order CCD -surface roughness	
	model for f_z and γ using TiAlN coated tools	129
6.23	ANOVA for the simplified 2nd order CCD-surface	
	roughness model for TiAlN coated tools	130
6.24	Fit and Summary Test for the first order surface roughness	
	CCD model for TiAlN coated tools	131
6.25	ANOVA for the first order surface roughness CCD model	
	for TiAlN coated tools.	132
6.26	Main effect occurred in 3F1-cutting force model	
	for TiAlN coated tools	134
6.27	ANOVA for 3F1-cutting force model for TiAlN coated tools	135
6.28	Response surface of the 3F1-cutting force model for	
	for V and f_z using TiAlN coated tools	135
6.29	Response surface of the 3F1-cutting force model for	
	f_z and γ using TiAlN coated tools	136
6.30	Response surface of the 3F1-cutting force model for	
	V and γ using TiAlN coated tools	136
6.31	Fit and Summary Test for the first order cutting force	
	CCD model for TiAlN coated tools	138

6.32	ANOVA for the first order cutting force CCD model	
	for TiAlN coated tools	139
6.33	Response surface of the first order cutting force CCD model	
	for V and f_z using TiAlN coated tools	139
6.34	Response surface of the first order cutting force CCD model	
	for V and γ using TiAlN coated tools	140
6.35	Response surface of the first order cutting force CCD model	
	for f_z and γ using TiAlN coated tools	140
6.36	ANOVA of the second order cutting force CCD model	
	for TiAlN coated tools	142
6.37	Response surface of the second order cutting force CCD	
	model for V and f_z using TiAlN coated tools	143
6.38	Response surface of the second order cutting force CCD	
	model for V and γ using TiAlN coated tools	143
6.39	Response Surface of the second order cutting force CCD	
	model for f_z and γ using TiAlN coated tools	144
6.40	ANOVA elimination of the second order cutting force	
	CCD model for TiAlN coated tools	145
6.41	Optimization combination of validated mathematical model	
	for TiAlN coated tools	147
6.42	First numerical optimization of validated mathematical model	148
6.43	First desirability of validated mathematical model	148
6.44	Overlay plot of desirable first optimized mathematical model	149
6.45	Second numerical optimization of validated mathematical	
	model	150
6.46	Second desirability of validated mathematical model	151
6.47	Overlay plot of desirable second optimized mathematical	
	model	151
7.1	Main effect occurred in $3F1$ -model for SN_{TR} coated end mil.	154
7.2	ANOVA for 3F1-model of SN _{TR} coated end mills with $n_c = 4$.	155
7.3	Response surface for 3F1-model with $n_c = 4$ for	
	V and f_z using SN _{TR} coated tools	156
7.4	Response surface for 3F1-model with $n_c = 4$ for	
	V and γ using SN _{TR} coated tools	156

7.5	Response surface for 3F1-model with $n_c = 4$ for	
	f_z and γ using SN _{TR} coated tools	157
7.6	Fit and summary test for the 2 nd order tool life CCD model	
	using SN_{TR} coated tools.	158
7.7	ANOVA for the 2 nd order CCD tool life model	
	using SN _{TR} coated tools.	158
7.8	Response surface of CCD quadratic-tool life model	
	for V and f_z using SN _{TR} coated solid carbide tools.	159
7.9	Response surface of CCD quadratic-tool life model	
	for V and γ using SN _{TR} coated solid carbide tools.	160
7.10	Response surface of CCD quadratic-tool life model	
	for f_z and γ using SN _{TR} coated solid carbide tools.	160
7.11	Fit and summary test for the first order CCD design	
	using SN_{TR} coated solid carbide tools.	162
7.12	ANOVA for the first order CCD tool life model	
	using SN_{TR} coated solid carbide tools.	163
7.13	Main effect occurred in 3F1- surface roughness model	
	using SN_{TR} - coated solid carbide tools.	165
7.14	ANOVA for 3F1-surface roughness model using SN_{TR}	
	coated solid carbide tools	166
7.15	Response surface of 3F1-surface roughness model	
	for V and f_z using SN _{TR} coated solid carbide tools.	167
7.16	Response surface of 3F1-surface roughness model	
	for V and γ_o using SN _{TR} coated solid carbide tools.	167
7.17	Response surface for 3F1-surface roughness model	
	for f_z and γ_o using SN _{TR} coated solid carbide tools.	168
7.18	Fit and summary test for CCD-surface roughness model	
	for SN_{TR} coated tools.	169
7.19	ANOVA for the 2 nd order CCD-surface roughness model	
	for SN_{TR} coated tools.	170
7.20	Response surface of the 2 nd order CCD -surface roughness	
	model for V and f_z using SN _{TR} coated solid carbide tools.	170
7.21	Response surface of the 2 nd order CCD -surface roughness	
	model for V and γ using SN _{TR} coated solid carbide tools.	171

7.22	Response surface of the 2 nd order CCD -surface roughness	
	model for f_z and γ using SN _{TR} coated solid carbide tools.	171
7.23	Fit and summary test for the first order surface roughness	
	CCD model using SN_{TR} coated solid carbide tools.	172
7.24	ANOVA for the first order surface roughness CCD	
	model using S-Nitride coated solid carbide tools.	173
7.25	Response surface of the 1 st order CCD -surface roughness	
	model for V and f_z using SN _{TR} coated solid carbide tools.	174
7.26	Response surface of the 1 st order CCD -surface roughness	
	model for V and f_z using SN _{TR} coated solid carbide tools.	174
7.27	Response surface of the 1 st order CCD -surface roughness	
	model for f_z and γ using SN _{TR} coated solid carbide tools.	175
7.28	Main effect occurred in 3F1-cutting force model	
	for SN_{TR} coated tools.	177
7.29	ANOVA for 3F1-cutting force model using SN_{TR} coated	
	solid carbide tools.	178
7.30	Response surface of the 3F1-cutting force model	
	for V and f_z using SN _{TR} coated solid carbide tools.	178
7.31	Response surface of the 3F1-cutting force model	
	for V and γ using SN _{TR} coated solid carbide tools.	179
7.32	Response surface of the 3F1-cutting force model	
	for f_z and γ using SN _{TR} coated solid carbide tools.	179
7.33	Fit and summary test for the first order cutting force	
	CCD model using SN_{TR} coated solid carbide tools.	181
7.34	ANOVA for the first order cutting force CCD model	
	using SN _{TR} coated solid carbide tools.	182
7.35	Response surface of the first order cutting force CCD	
	model for V and f_z using SN _{TR} coated solid carbide tools.	182
7.36	Response surface of the first order cutting force CCD	
	model for V and γ using SN _{TR} coated solid carbide tools.	183
7.37	Response surface of the first order cutting force CCD	
	model for f_z and γ using SN _{TR} coated solid carbide tools.	183
7.38	The fit and summary test for the 2 nd order CCD cutting	
	force model using SN_{TR} coated solid carbide tools.	185

7.39	ANOVA for the second order CCD cutting force model	
	using SN_{TR} coated solid carbide tools.	186
7.40	Response surface of the second order CCD cutting force	
	model for V and f_z using SN _{TR} coated solid carbide tools.	186
7.41	Response surface of the second order CCD cutting force	
	model for V and γ using SN _{TR} coated solid carbide tools.	187
7.42	Response surface of the second order CCD cutting force	
	model for f_z and γ using SN _{TR} coated solid carbide tools.	188
7.43	ANOVA elimination for the second order CCD cutting	
	force model using SN_{TR} coated solid carbide tools.	189
7.44	Optimization combination of validated mathematical model	
	using SN_{TR} coated solid carbide tools.	191
7.45	First numerical optimization of validated mathematical model.	192
7.46	First desirability of validated mathematical model	
	using SN_{TR} coated solid carbide tools.	193
7.47	Overlay plot of desirable first optimized mathematical model	
	using SN_{TR} coated solid carbide tools.	194
7.48	Second numerical optimization of validated mathematical	
	model using S-Nitride coated solid carbide tools.	195
7.49	Second desirability of validated mathematical model	
	using SN_{TR} coated solid carbide tools.	196
7.50	Over lay plot of desirable second optimized mathematical	
	model using SN_{TR} coated solid carbide tools.	196
8.1	Response surface comparison of tool life models	
	in terms of cutting speed V and feed f_z .	199
8.2	Quadrant definition in Cartesian coordinate.	203
8.3	Response surface comparison of tool life models	
	in terms of cutting speed V and radial rake angle γ_0 .	204
8.4	Response surface comparison of tool life models	
	in terms of feed f_z and radial rake angle γ_0 .	206
8.5	Comparison of optimum cutting conditions for validated	
	tool life models.	207
8.6	Response surface comparison for surface roughness	
	models in terms of cutting speed V and feed f_z .	211

Response surface comparison for surface roughness models	
in terms of cutting speed V and radial rake angle γ_0 .	213
Response surface comparison fo surface roughness models	
in terms of feed f_z and radial rake angle γ_0 .	215
Comparison of optimum cutting conditions for validated	
surface roughness models	216
Response surface comparison for cutting force models	
in terms of cutting speed V and feed f_z .	220
Response surface comparison for cutting force models	
in terms of cutting speed V and radial rake angle γ_0 .	222
Nose radius for uncoated and coated	
tools (Boudzakis et. al., 2003).	223
Response surface comparison for cutting force models	
in terms of feed f_z and radial rake angle γ_0 .	224
Comparison of optimum cutting conditions for validated	
cutting force models	225
	Response surface comparison for surface roughness models in terms of cutting speed V and radial rake angle γ_0 . Response surface comparison fo surface roughness models in terms of feed f_z and radial rake angle γ_0 . Comparison of optimum cutting conditions for validated surface roughness models Response surface comparison for cutting force models in terms of cutting speed V and feed f_z . Response surface comparison for cutting force models in terms of cutting speed V and radial rake angle γ_0 . Nose radius for uncoated and coated tools (Boudzakis <i>et. al.,</i> 2003). Response surface comparison for cutting force models in terms of feed f_z and radial rake angle γ_0 . Comparison of optimum cutting conditions for validated cutting force models

LIST OF ABBREVIATIONS

ANOVA	-	Analysis of Variance
CCD	-	Central Composite Design
CIMS	-	Computer Integrated Manufacturing Systems
CVD	-	Chemical Vapor Deposition
FMS	-	Flexible Manufacturing Systems
DOE	-	Design of Experiments
HIP	-	High Isostatic Presses
HIS	-	High Ionization Sputtering
LOF	-	Lack of Fit
LSM	-	Least Squares Method
MSE	-	Mean Squares Errors
MSR	-	Mean Squares Regression
PVD	-	Physical Vapor Deposition
RSM	-	Response Surface Methodology
SSE	-	Sum of Squares Errors
SSR	-	Sum of Squares Regression
SST	-	Sum of Squares Total
SN _{TR}	-	Supernitride
TRS	-	Transfer Rupture Strength
TiAlN	-	Titanium Aluminum Nitrate

LIST OF SYMBOLS

α	-	Distance of Stars Points from Center.
β	-	Model Parameter
γ	-	Radial rake Angle
ξ	-	Natural Independent Variables
ε'	-	Multiplicative Random Errors.
k	-	Number of Independent Variables (Factors)
С	-	Model Parameter
F_c	-	Calculated Cutting Force
R_s	-	Measured Response
x_i	-	Coded Variables

LIST OF APPENDICES

APPENDIX

TITLE

PAGE

А	List of Publications	242
В	Example Calculation of Coded Variable V	244
С	Example Transformation of Coded Variable for Linear CCD	245

CHAPTER 1

INTRODUCTION

1.1 Overview

This research is carried out to evaluate the machining performance of uncoated and coated physical vapor disposition (PVD) TiAlN and Supernitride (SN_{TR}) solid carbide tools when end milling titanium alloy. The research involves the development of mathematical models for tool life, surface roughness and cutting force, which describe the relationship between the independent variables and the machinability parameters. The results obtained from this research will provide the suitable cutting conditions and cutting tool geometry when machining titanium alloy Ti-6Al-4V.

1.2 Background of the Problem

The development of better and more advanced materials is crucially important for the advancement in technology. This is especially true in high technology industries like aerospace, defense, nuclear power engineering etc. The trend in the aerospace industry in the recent past has been towards the development of materials for constructions that are:

- (i) of greater strength
- (ii) resistant to oxidation, particularly at high temperature
- (iii) exhibit small deformations at high temperatures
- (iv) of lighter weight
- (v) not brittle at low temperature

One of the advanced materials such as titanium alloys have been introduced to meet these requirements. Hence, nowadays the demand on machining this advanced material increases rapidly. Even though new cutting tools like coated carbides, ceramics, diamond etc. have been developed, titanium alloys are still considered "difficult to machine" materials due to rapid failure of the faults (Kramer, 1987; Komanduri *et.al.*, 1981; Hartung *et.al.*, 1982).

1.3 Statement of the Problem

It was often thought that coatings offer better productivity advantages to carbide tools when machining steels and aluminium. However, most of the coatings developed so far including diamonds, ceramics and CBN are highly reactive with titanium alloys, causing rapid wear on the cutting tools (Kramer, 1987; Komanduri *et.al.*, 1981; Hartung *et.al.*, 1982).

The most recent coating material TiAlN has proven to offer higher hardness, increased toughness and improved wear resistance. TiAlN coated tools are also much more chemically stable and therefore suitable for high speed machining (Erkens, 2003, 2004).

Nevertheless, the suitability of TiAlN coated tools when machining titanium alloys is yet to be investigated. This work is aimed to evaluate the performance of TiAlN and Supernitride coated tools as compared to uncoated carbide (WC/Co) tools when end milling titanium alloy, Ti-6Al-4V.

The basic aim of tool performance assessment is the provision of sufficient technological data to ensure the efficient use of machine tools and other manufacturing resources. The tool performance data system is essential for the selection of cutting conditions during process planning and it has become an important component in the implementation of Flexible Manufacturing System (FMS) and Computer Integrated Manufacturing Systems (CIMS).

Computerized tool performance data systems have been classified into two general types:

- (i) Simple data retrieval system
- (ii) Mathematical model system

The simple data retrieval systems are based on the systematic collection and storage of large quantities of data from laboratory and industry resulting in so called "tool performance or machining data banks" and simply the retrieving system recommended the cutting speeds, feed rates and cost information for any specific cutting operation (Balakrishan and Deviries, 1983, 1985; Alauddin, 1997).

The mathematical model systems attempt to predict the optimum cutting conditions for a specific operation. The machining responses data such as tool-life, surface roughness, cutting forces, power, etc., are used as the primary data. Then mathematical models of these machining responses are developed as a function of the machining variables using a model building module, the model parameters and other relevant economic factors being used to derive the optimum set of cutting conditions (Wu, 1964; Taraman, 1974; El-Baradie, 1994).

1.4 Objective of the Study

The objective of this study comprising the following:

- To develop a mathematical model for tool life, surface roughness and cutting force of uncoated and coated carbide tools when end milling titanium alloy, Ti-6Al-4V.
- (ii) To determine the optimum machining conditions in end milling of a titanium alloy, Ti-6Al-4V using uncoated and coated carbide tools.
- (iii) To evaluate the effect of cutting conditions on tool life, surface roughness and cutting force of uncoated and coated carbide tools in end milling of titanium alloy, Ti-6Al-4V.

1.5 Significance of the Study

Most published research works on the development of mathematical model systems are concerned mainly on turning process, whilst end milling has received little attention due to the complexity of the process and the high cost involved.

Currently, reports on end milling of Ti-6Al-4V using the new hard coatings such as TiAlN and Supernitride are still lacking. Hence, this work is undertaken to carry out the investigation.

1.6 Scope of the Study

The scope of this research was focused on end milling of Ti-6Al-4V using three types of cutting tools, they are uncoated carbide and two coated carbide tools (TiAlN and SN_{TR}). The processes were conducted under various independent variables which include cutting speed, feed rate and coatings materials and tool geometries. At the end of the study the performance of each cutting tool was compared by means of response surface methodology, the mathematical models (empirical equations) for tool life, surface roughness and cutting force were developed. Ultimately, the optimum cutting conditions for carbide tool in end milling of Ti-6Al-4V were established.

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 Optimum Surface Roughness Prediction Model when End Milling Titanium

APPENDIX A List of Publications

Alloy (Ti-6Al-4V). International Conference on Manufacturing Science and Technology (ICOMAST). 28-30 August. Melaka, Malaysia: 55-58.

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