

A Finite Element Study of Chip Formation Process in Orthogonal Machining

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ABSTRACT

This paper examines the plane strain 2D Finite Element (FE) modeling of segmented, as well as continuous chip formation while machining AISI 4340 with a negative rake carbide tool. The main objective is to simulate both the continuous and segmented chips from the same FE model based on FE code ABAQUS/Explicit. Both the adiabatic and coupled temperature displacement analysis has been performed to simulate the right kind of chip formation. It is observed that adiabatic hypothesis plays a critical role in the simulation of segmented chip formation based on adiabatic shearing. The numerical results dealing with distribution of stress, strain and temperature for segmented and continuous chip formations were compared and found to vary considerably from each other. The simulation results were also compared with other published results; thus validating the developed model.

Keywords: Adiabatic Shearing, ALE, Finite Element Simulation, Machining, Segmented Chip

INTRODUCTION

Machining is a term that covers a large collection of manufacturing processes designed to remove material from a workpiece. This is one of the most important mechanical processes in industry because almost all the products get their final shape and size by material removal either directly or indirectly. Although metal cutting process is commonplace, the underlying physical phenomena are highly complex.

Therefore, this area has always been of great interest to the researchers. During the cutting process, the unwanted material is removed from the workpiece with the aid of a machine tool and a cutting tool by straining a local region of the workpiece by the relative motion of the tool and the workpiece. As the tool advances, the material ahead of it is sheared continuously along a narrow zone called the shear plane; thus, removing the excess material in the form of chip that flows along the rake surface of the tool.

Chip formation and its morphology are the key areas in the study of machining process

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Machining Processes provides a concise study on the way the Finite Element Method FEM is used in the case of manufacturing processes primarily in machining The basics of this kind of modeling are detailed to create a reference that will provide guidelines for those who start to study this method now but also for scientists already involved in FEM and want to expand their research A discussion on FEM formulations and techniques currently in use is followed up by machining case studies Orthogonal cutting oblique cutting 3D simulations for turning and milling grinding and state of the art topics such as high speed machining and micromachining are explained with relevant examples This is all supported by a literature review and a reference list for further study As FEM is a key method for researchers in the manufacturing and especially in the machining sector Finite Element Method in Machining Processes is a key reference for students studying manufacturing processes but also for industry professionals

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