
Contents

List of Contributors	xvii
1 Introduction	1
1.1 Scope of the Subject	1
1.2 Scientific and Technological Challenges and Needs	2
1.3 Emerging Trends	4
References	6
2 Basic Concepts and Theory	7
2.1 Introduction	7
2.2 Loop Stiffness within the Machine-tool-workpiece System.....	7
2.2.1 Machine-tool-workpiece Loop Concept.....	7
2.2.2 Static Loop Stiffness	8
2.2.3 Dynamic Loop Stiffness and Deformation.....	9
2.3 Vibrations in the Machine-tool System	10
2.3.1 Free Vibrations in the Machine-tool System.....	10
2.3.2 Forced Vibrations.....	13
2.4 Chatter Occurring in the Machine Tool System	15
2.4.1 Definition	15
2.4.2 Types of Chatters	16
2.4.3 The Suppression of Chatters	16
2.5 Machining Instability and Control.....	17
2.5.1 The Conception of Machining Instability	17

- 2.5.2 The Classification of Machining Instability..... 19
- Acknowledgements 19
- References 19
- 3 Dynamic Analysis and Control..... 21**
 - 3.1 Machine Tool Structural Deformations 21
 - 3.1.1 Machining Process Forces 22
 - 3.1.2 The Deformations of Machine Tool Structures and Workpieces 30
 - 3.1.3 The Control and Minimization of Form Errors 39
 - 3.2. Machine Tool Dynamics 43
 - 3.2.1 Experimental Methods 43
 - 3.2.2 The Analytical Modelling of Machine Tool Dynamics 47
 - 3.3. The Dynamic Cutting Process 54
 - 3.3.1. Mechanic of Dynamic Cutting 55
 - 3.3.2. The Dynamic Chip Thickness and Cutting Forces..... 59
 - 3.4. Stability of Cutting Process 63
 - 3.4.1 Stability of Turning 64
 - 3.4.2. The Stability of the Milling Process..... 68
 - 3.4.3. Maximizing Chatter Free Material Removal Rate in Milling 74
 - 3.4.4. Chatter Suppression-Variable Pitch End Mills 79
 - 3.5. Conclusions 82
 - References 83
- 4 Dynamics Diagnostics: Methods, Equipment and Analysis Tools..... 85**
 - 4.1 Introduction 85
 - 4.2 Theory 86
 - 4.2.1 An Example 88
 - 4.2.2 The Substructure Analysis 90
 - 4.3 Experimental Equipment 92
 - 4.3.1 The Signal Processing 92
 - 4.3.2 Excitation Techniques 93
 - 4.3.3 The Measurement Equipment 93
 - 4.3.4 Novel Approaches..... 94
 - 4.3.5 In-process Sensors 96

4.3.6 Dynamometers	96
4.3.7 The Current Monitoring	97
4.3.8 The Audio Measurement.....	97
4.3.9 Capacitance Probes	97
4.3.10 Telemetry and Slip Rings.....	98
4.3.11 Fibre-optic Bragg Grating Sensors.....	98
4.4 Chatter Detection Techniques	98
4.4.1 The Topography.....	100
4.4.2 The Frequency Domain.....	100
4.4.3 Time Domain	105
4.4.4 Wavelet Transforms	109
4.4.5 Soft Computing.....	110
4.4.6 The Information Theory.....	111
4.5 Summary and Conclusions	111
Acknowledgements	112
References	112
5 Tool Design, Tool Wear and Tool Life	117
5.1 Tool Design	118
5.1.1 The Tool-workpiece Replication Model	118
5.1.2 Tool Design Principles.....	120
5.1.3 The Tool Design for New Machining Technologies.....	123
5.2 Tool Materials	124
5.2.1 High Speed Steel.....	124
5.2.2 Cemented Carbide.....	124
5.2.3 Cermet.....	125
5.2.4 Ceramics	125
5.2.5 Diamond.....	126
5.2.6 Cubic Boron Nitride.....	127
5.3 High-performance Coated Tools	127
5.3.1 Tool Coating Methods	128
5.3.2 The Cutting Performance of PVD Coated Tools	129
5.3.3 The Cutting Performance of CVD Coated Tools.....	132

5.3.4 Recoating of Worn Tools	133
5.4 Tool Wear.....	133
5.4.1 Tool Wear Classification	134
5.4.2 Tool Wear Evolution.....	136
5.4.3 The Material-dependence of Wear.....	138
5.4.4 The Wear of Diamond Tools	139
5.5 Tool Life.....	142
5.5.1 The Definition of Tool Life	142
5.5.2 Taylor’s Tool Life Model	142
5.5.3 The Extended Taylor’s Model	144
5.5.4 Tool Life and Machining Dynamics	145
References	148
6 Machining Dynamics in Turning Processes	151
6.1 Introduction	151
6.2 Principles	151
6.2.1 The Turning Process	153
6.3 Methodology and Tools for the Dynamic Analysis and Control.....	154
6.4 Implementation Perspectives.....	155
6.5 Applications.....	156
6.5.1 The Rigidity of the Machine Tool, the Tool Fixture and the Work Material	156
6.5.2 The Influence of the Input Parameters	162
6.6 Conclusions	164
References	164
7 Machining Dynamics in Milling Processes	167
7.1 Introduction	167
7.1.1 Forced Vibration	167
7.1.2 Self-excited Vibration.....	168
7.1.3 The Scope of This Chapter	169
7.1.4 Nomenclature in This Chapter	170
7.2 The Dynamic Cutting Force Model for Peripheral Milling	171
7.2.1 Oblique Cutting.....	172

7.2.2 The Geometric Model of a Helical End Mill	173
7.2.3 Differential Tangential and Normal Cutting Forces.....	174
7.2.4 Undeformed Chip Thickness	175
7.2.5 Differential Cutting Forces in X and Y Directions	178
7.2.6 Total Cutting Forces in X and Y Directions	180
7.2.7 The Calibration of the Cutting Force Coefficients.....	181
7.2.8 A Case Study: Verification	186
7.3 A Dynamic Cutting Force Model for Ball-end Milling	186
7.3.1 A Geometric Model of a Ball-end Mill.....	186
7.3.2 Dynamic Cutting Force Modelling	188
7.3.3 The Experimental Calibration of the Cutting Force Coefficients	194
7.3.4 A Case Study: Verification	198
7.4 A Machining Dynamics Model	200
7.4.1 A Modularisation of the Cutting Force	200
7.4.2 Machining Dynamics Modelling.....	203
7.4.3 The Surface Generation Model	205
7.4.4 Simulation Model.....	207
7.5 The Modal Analysis of the Machining System	207
7.5.1 The Mathematical Principle of Experimental Modal Analysis	208
7.5.2 A Case Study	209
7.6 The Application of the Machining Dynamics Model	213
7.6.1 The Machining Setup	213
7.6.2 Case 1: Cut 13.....	214
7.6.3 Case 2: Cut 14.....	219
7.7 The System Identification of Machining Processes.....	224
7.7.1 The System Identification	225
7.7.2 The Machining System and the Machining Process	226
7.7.3 A Case Study	227
7.7.4 Summary	231
References	231
8 Machining Dynamics in Grinding Processes.....	233
8.1 Introduction	233

- 8.2 The Kinematics and the Mechanics of Grinding236
 - 8.2.1 The Geometry of Undeformed Grinding Chips 236
- 8.3 The Generation of the Workpiece Surface in Grinding242
- 8.4 The Kinematics of a Grinding Cycle248
- 8.5 Applications of Grinding Kinematics and Mechanics253
- 8.6 Summary259
- References261
- 9 Materials–induced Vibration in Single Point Diamond Turning263**
 - 9.1 Introduction263
 - 9.2 A Model-based Simulation of the Nano-surface Generation.....264
 - 9.2.1 A Prediction of the Periodic Fluctuation of Micro-cutting Forces.....265
 - 9.2.2 Characterization of the Dynamic Cutting System269
 - 9.2.3 A Surface Topography Model for the Prediction
of Nano-surface Generation271
 - 9.2.4 Prediction of the Effect of Tool Interference275
 - 9.2.5 Prediction of the Effect of Material Anisotropy.....277
 - 9.3 Conclusions278
 - Acknowledgements279
 - References279
- 10 Design of Precision Machines283**
 - 10.1 Introduction283
 - 10.2 Principles284
 - 10.2.1 Machine Tool Constitutions284
 - 10.2.2 Machine Tool Loops and the Dynamics of Machine Tools288
 - 10.2.3 Stiffness, Mass and Damping.....290
 - 10.3 Methodology293
 - 10.3.1 Design Processes of the Precision Machine293
 - 10.3.2 Modelling and Simulation.....295
 - 10.4 Implementation298
 - 10.4.1 Static Analysis298
 - 10.4.2 Dynamic Analysis298
 - 10.4.3 A General Modelling and Analysis Process Using FEA.....300

10.5 Applications.....303

 10.5.1 Design Case Study 1: A Piezo-actuator
 Based Fast Tool Servo System303

 10.5.2 Design Case Study 2: A 5-axis Micro-milling/
 grinding Machine Tool313

 10.5.3 Design Case Study 3: A Precision Grinding Machine Tool.....317

Acknowledgements320

References320

Index323