MACHINING AND TURNING OPERATION QUESTIONS

PROBLEM 1

A shaper tool, making an orthogonal cut, has a 10° rake angle. The depth of cut to = 0.6 mm, the width of cut = 3 mm. The cutting speed V = 40 m/min. Two components dynamometer is used to determine the main cutting force (Ps = 3600 N), and the thrust force (Pt = 2400 N). A high speed photograph shows a shear plane angle $\phi = 20^\circ$. Calculate:

- The expected chip thickness.
- 2. The shearing stress on the shear plane.
- 3. The machining power.
- The specific cutting energy.

PROBLEM 2

An orthogonal cut with 3.0 mm depth is made at a speed of 45 m/min and a feed rate of 0.25 mm/rev, with a high-speed steel tool having a 15° rake angle. The chip thickness ratio is found to be 0.58, the main cutting force is 1000 N and the thrust force is 280 N. Calculate:

- 1. chip thickness.
- 2. shear plane angle
- 3. resultant cutting force
- 4. machining power
- 5. specific cutting energy

PROBLEM 3

A workpiece is being cut at V = 100 m/min. The machining power is found to be 3 kW. The feed rate = 0.2 mm/rev, and depth of cut = 0.5 mm.

- 1. What is the main cutting force in Newtons.
- What is the spec. cutting energy in N/mm2.
- Estimate the necessary machining time if the diameter of the machined bar is D = 50 mm and its length = 250 mm.

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