

# CONTENTS

<i>Preface</i>	<i>page ix</i>
<b>1 INTRODUCTION</b>	<b>1</b>
<b>2 MECHANICS OF METAL CUTTING</b>	<b>4</b>
2.1 Introduction	4
2.2 Mechanics of Orthogonal Cutting	4
2.3 Mechanistic Modeling of Cutting Forces	15
2.4 Theoretical Prediction of Shear Angle	18
2.5 Mechanics of Oblique Cutting	19
2.5.1 Oblique Cutting Geometry	19
2.5.2 Solution of Oblique Cutting Parameters	21
2.5.3 Prediction of Cutting Forces	25
2.6 Mechanics of Turning Processes	27
2.7 Mechanics of Milling Processes	35
2.7.1 Mechanics of Helical End Mills	41
2.8 Analytical Modeling of End Milling Forces	43
2.8.1 Mechanistic Identification of Cutting Constants in Milling	46
2.9 Mechanics of Drilling	47
2.10 Tool Wear and Tool Breakage	54
2.10.1 Tool Wear	56
2.10.2 Tool Breakage	61
2.11 Problems	62
<b>3 STRUCTURAL DYNAMICS OF MACHINES</b>	<b>66</b>
3.1 Introduction	66
3.2 Machine Tool Structures	66
3.3 Dimensional Form Errors in Machining	68
3.3.1 Form Errors in Cylindrical Turning	68
3.3.2 Boring Bar	70
3.3.3 Form Errors in End Milling	71
3.4 Structural Vibrations in Machining	74
3.4.1 Fundamentals of Free and Forced Vibrations	75
3.4.2 Oriented Frequency Response Function	82

3.4.3	Design and Measurement Coordinate Systems	83
3.4.4	Analytical Modal Analysis for Multi-Degree-of-Freedom Systems	85
3.4.5	Relative Frequency Response Function between Tool and Workpiece	90
3.5	Modal Testing of Machine Structures	92
3.5.1	Theory of Frequency Response Testing	92
3.5.2	Experimental Procedures in Modal Testing	97
3.6	Experimental Modal Analysis for Multi-Degree-of-Freedom Systems	98
3.7	Identification of Modal Parameters	109
3.7.1	Global Nonlinear Optimization of Modal Parameter Identification	113
3.8	Receptance Coupling of End Mills to Spindle-Tool Holder Assembly	115
3.8.1	Experimental Procedure	118
3.9	Problems	120
<b>4</b>	<b>MACHINE TOOL VIBRATIONS</b>	<b>125</b>
4.1	Introduction	125
4.2	Stability of Regenerative Chatter Vibrations in Orthogonal Cutting	126
4.2.1	Stability of Orthogonal Cutting	126
4.2.2	Dimensionless Analysis of Stability Lobes in Orthogonal Cutting	132
4.2.3	Chatter Stability of Orthogonal Cutting with Process Damping	135
4.3	Chatter Stability of Turning Operations	139
4.4	Chatter Stability of Turning Systems with Process Damping	142
4.4.1	Metal Cutting Forces	144
4.4.2	Process Damping Gains Contributed by Flank Wear	145
4.4.3	Stability Analysis	147
4.5	Experimental Validation	148
4.6	Analytical Prediction of Chatter Vibrations in Milling	149
4.6.1	Dynamic Milling Model	149
4.6.2	Zero-Order Solution of Chatter Stability in Milling	154
4.6.3	Multi-Frequency Solution of Chatter Stability in Milling	160
4.7	Chatter Stability of Drilling Operations	172
4.7.1	Dynamic Drilling Force Model	173
4.8	Frequency Domain Solution of Drilling Stability	176
4.9	Semidiscrete Time Domain Solution of Chatter Stability	178
4.9.1	Orthogonal Cutting	178
4.9.2	Discrete Time Domain Stability Solution in Milling	182
4.10	Problems	186

<b>5</b>	<b>TECHNOLOGY OF MANUFACTURING AUTOMATION</b>	<b>191</b>
5.1	Introduction	191
5.2	Computer Numerically Controlled Unit	191
5.2.1	Organization of a CNC Unit	191
5.2.2	CNC Executive	193
5.2.3	CNC Machine Tool Axis Conventions	193
5.2.4	NC Part Program Structure	193
5.2.5	Main Preparatory Functions	196
5.3	Computer-Assisted NC Part Programming	201
5.3.1	Basics of Analytical Geometry	201
5.3.2	APT Part Programming Language	206
5.4	Trajectory Generation for Computer-Controlled Machines	211
5.4.1	Interpolation with Constant Displacement	212
5.4.2	Acceleration-Limited Velocity Profile Generation with Constant Interpolation Period	216
5.4.3	Jerk-Limited Velocity Profile Generation	220
5.5	Real-Time Interpolation Methods	229
5.5.1	Linear Interpolation Algorithm	230
5.5.2	Circular Interpolation Algorithm	234
5.5.3	Quintic Spline Interpolation within CNC Systems	239
5.6	Problems	245
<b>6</b>	<b>DESIGN AND ANALYSIS OF CNC SYSTEMS</b>	<b>250</b>
6.1	Introduction	250
6.2	Machine Tool Drives	250
6.2.1	Mechanical Components and Torque Requirements	251
6.2.2	Feedback Devices	256
6.2.3	Electrical Drives	257
6.2.4	Permanent Magnet Armature-Controlled dc Motors	258
6.2.5	Position Control Loop	263
6.3	Transfer Function of the Position Loop	264
6.4	State Space Model of Feed Drive Control Systems	268
6.5	Sliding Mode Controller	281
6.6	Active Damping of Feed Drives	285
6.7	Design of an Electrohydraulic CNC Press Brake	293
6.7.1	Hydraulic Press Brake System	293
6.7.2	Dynamic Model of Hydraulic Actuator Module	296
6.7.3	Identification of Electrohydraulic Drive Dynamics for Computer Control	299
6.7.4	Digital Position Control System Design	301
6.8	Problems	307

<b>7.1</b>	<b>SENSOR-ASSISTED MACHINING</b>	<b>313</b>
7.1	Introduction	313
7.2	Intelligent Machining Module	313
7.2.1	Hardware Architecture	314
7.2.2	Software Architecture	315
7.2.3	Intelligent Machining Application	316
7.3	Adaptive Control of Peak Forces in Milling	317
7.3.1	Introduction	317
7.3.2	Discrete Transfer Function of the Milling Process System	319
7.3.3	Pole-Placement Control Algorithm	321
7.3.4	Adaptive Generalized Predictive Control of Milling Process	325
7.3.5	In-Process Detection of Tool Breakage	330
7.3.6	Chatter Detection and Suppression	333
7.4	Intelligent Pocketing with the IMM System	334
7.5	Problems	336
<b>A</b>	<b>APPENDIX A: LAPLACE AND <math>z</math> TRANSFORMS</b>	<b>341</b>
A.1	Introduction	341
A.2	Basic Definitions	343
A.3	Partial Fraction Expansion Method	347
A.4	Partial Fraction Expansion Method to Determine Inverse Laplace and $z$ Transforms	349
<b>B</b>	<b>APPENDIX B: OFF-LINE AND ON-LINE PARAMETER ESTIMATION WITH LEAST SQUARES</b>	<b>353</b>
B.1	Off-Line Least-Squares Estimation	353
B.2	Recursive Parameter Estimation Algorithm	355
	<i>Bibliography</i>	357
	<i>Index</i>	363