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3 **Research highlights**
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- 7 • Oxidation wear is reduced by the application of HPC.
- 8 • An increase in the heat generation by plastic deformation for the HPC condition.
- 9 • Coolant pressure and maximum flank wear are inversely proportional to each other.
- 10 • The chip formation process is facilitated by the application of HPC.
- 11 • Chips are strain hardened with the application of HPC.
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The role of high-pressure coolant in the wear characteristics of WC-Co tools during the cutting of Ti-6Al-4V

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Abstract

Aeronautic applications have been making use of titanium alloys for decades. Ti-6Al-4V is one of the most commonly applied alloys, and although its mechanical properties warrant its acceptance for many applications, the machinability of this alloy remains a challenge. So far, the most successful technique in facilitating this alloy's machining has been the application of High-Pressure Coolant Supply (HPC) on account of its influence on the tribological aspects of the cutting operation. On that premise, this work employs experimental and computational resources to advance the current understanding of the wear mechanism in terms of the tool-chip contact conditions and establish a correlation between coolant pressure, cutting speed, tool life, cutting forces, and chip formation when machining Ti-6Al-4V with HPC supply. Results showed that HPC plays a role in the reduction of tool-chip temperature profiles and contact stresses, positively impacting tool flank wear, oxidation levels and chip formation, also improving chip breakability.

Keywords:

Tool wear, Titanium, High-Pressure Coolant, tribology, FEA, chip formation.

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1. Introduction

62 Ti-6Al-4V is the titanium alloy with the broadest range of applications, accounting for 45-
63 65% of the world's titanium consumption [1]. It is widely applied in the aerospace industry, mainly
64 due to its exceptional specific strength and unmatched mechanical properties [2].
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66 Due to its low thermal conductivity and high chemical reactivity, Ti-6Al-4V is classified
67 as a difficult-to-cut material [3,4]. Titanium machining leads to significantly increased
68 temperatures at the tool/chip interface, even at lower cutting speeds [5]. Furthermore, the Ti and
69 Al (it is made of) present a strong affinity to most tool materials [6], imposing an even bigger
70 challenge to the processing of this alloy. In order to mitigate such effects, a common approach
71 would be the reduction of cutting speed, which directly reduces temperatures in the cutting zone
72 [7]. This would however, adversely affect the production, as low material removal rate (MRR)
73 would increase the demand-supply gaps, making products containing Ti alloys less viable.
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79 Previous researchers have generally made use of coated cutting tools to interfere with the
80 severe interactions taking place during the titanium machining process [8,9]. However, results
81 were not satisfactory when machining Ti and its alloys, as most available coatings are composed
82 of Ti and Al, which would react with the workpiece material. An alternative to the use of tool
83 coatings is the application of cutting fluids to reduce thermal and mechanical loads, especially
84 when working at higher cutting speeds, where heat becomes the main cause for accelerated tool
85 wear [3]. However, conventional coolant supplies do not ensure targeted fluid delivery in the
86 cutting zone and thus, coolant application by traditional means does not achieve significant
87 efficiency [10]. Through careful setup, cutting fluids can be directed towards the primary,
88 secondary, and tertiary shear deformation zones. The secondary shear deformation zone, located
89 at the tool/chip interface, presents a combination of high shear and normal stresses, parallel to the
90 long tool/workpiece contact surface [7]. It consists of the most heat intensive region during the
91 cutting process, requiring substantial cooling action. On that premise, flood coolant supplies can
92 not adequately access the secondary shear deformation zone, due to the barrier imposed by the
93 severe tool/chip contact conditions, resulting in intensive heat generation. To address this issue,
94 different cooling strategies have been employed to improve machining performance of titanium
95 alloys. Cryogenic cooling was deemed a suitable alternative to conventional flood coolant supply
96 when working with low thermal conductivity alloys [11,12]. Conversely, the use of cryogenic
97 cooling significantly increases workpiece material hardness, negatively impacting mechanical
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115 loads and promoting accelerated tool wear rates in the case of Ti alloys [10]. This added to its high
116 operational costs and impact on dimensional control, makes cryogenic machining unfit for these
117 industrial applications. Experiments are reported on the use of Minimum Quantity Lubrication
118 (MQL) for the machining of titanium alloys. The application of MQL was also not proven effective
119 [11–14], since its cooling capabilities are limited when dealing with the high levels of heat imposed
120 by the cutting process.
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125 A newer alternative emerging in this direction is the use of High-Pressure Coolant (HPC),
126 which is capable of providing a relatively low cost alternative that is able to address most of the
127 aforementioned issues [10,15]. Moreover, the added benefit of using HPC for the machining of Ti
128 alloys is an improved sub-surface integrity [10]. Figure 1 illustrates some of the key benefits
129 provided by the application of HPC to the rake face of the cutting tool. That includes the reduction
130 in chip curl radius, promotion of chip breakability, and heat dissipation from the tool-chip interface
131 [7]. The shorter TCCL (Tool-Chip Contact Length) contributes to lower diffusion wear rates and
132 consequently prolongs the lifespan of the cutting tool [7].
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139 As the issue being investigated in this paper i.e. HPC assisted cutting of Ti6Al4V is topical
140 and is in infancy stages of research, many aspects such as chip formation, tool-chip contact
141 conditions and thermal phenomena when machining titanium are hitherto unexplored. Therefore,
142 this work aims to develop a better understanding of the of the wear mechanism, the chip formation,
143 contact conditions and mechanical/thermal aspects of the titanium machining process when
144 employing high pressure coolant supplies at different pressures, combined with multiple sets of
145 cutting parameters. Adding to the experimental findings, computational resources were utilised to
146 study the temperature and stress profiles. The analysis of the collected data allowed for establishing
147 a correlation between: coolant pressure, cutting speed, tool life, cutting forces, wear mechanisms
148 and chip formation.
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2. Materials and methods

2.1 Finite Element Analysis

The finite element analysis (FEA) is an essential tool for the evaluation of cutting conditions, such as temperature/stress profiles within the cutting zone. The primary difficulty in the FEA of metal cutting is capturing the severe plastic deformation of the metal, which results in extreme tribological conditions at the tool-workpiece interface [16].

Modeling of metal machining for turning requires a fundamental understanding of the deformation conditions in the relevant deformation zones, strain rates, as well as the frictional conditions at the tool-workpiece interface. The cutting temperature/stress profile is critical for understanding and controlling the machining process [17].

The numerical analyses present in this work were carried out on a commercial FEA code (Thirdwave's Advantedge CAE software). Advantedge employs a Lagrangian approach combined with adaptive remeshing capabilities [18]. This formulation is responsible for addressing the nonlinearities caused by the high levels of plastic deformation, strain rates and inherent resolution issues arising during the turning process.

The constitutive model derived from the Cuitino and Ortiz stress update method is employed for the flow stress calculations (eq. 1), where $g(\alpha)$ refers to the strain hardening, $\Theta(T)$ to the thermal softening and $\Gamma(\dot{\alpha})$, α , $\dot{\alpha}$, and T refer to rate sensitivity, equivalent plastic strain, plastic strain rate, and temperature, respectively [19].

$$\sigma(\alpha, \dot{\alpha}, T) = g(\alpha)\Theta(T)\Gamma(\dot{\alpha}) \quad (1)$$

Furthermore, the power law (eq. 2) is used to describe strain hardening and rate sensitivity, where reference values for strain and strain rates are denoted by α_0 and $\dot{\alpha}_0$, respectively.

$$g(\alpha) = \left(\sigma_0 1 + \frac{\alpha}{\alpha_0}\right)^{\frac{1}{N}}, \Gamma(\dot{\alpha}) = \left(1 + \frac{\dot{\alpha}}{\dot{\alpha}_0}\right)^{\frac{1}{M}} \quad (2)$$

A fifth order polynomial function is used to determine thermal softening (eq. 3) [19].

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227 $\theta(T) = c_0 + c_1T + \dots + c_5T^5$ (3)
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230 Adaptive remeshing capabilities enable the model to account for the element deformations
231 that are intrinsic to the Lagrangian method. Deformations were being constantly monitored,
232 anytime a certain tolerance is met, refinement/coarsening algorithms are applied in order to
233 regenerate the mesh in the best way possible [19]. The biggest advantage of this approach is the
234 ability to resolve different scaled regions for different moments in time, thus, elements present in
235 a plastic deformation intensive region will be resized to accurately reproduce such effects.
236 Likewise, inactive areas will be coarsened, so computational resources are spared and better
237 deployed [19]. For our case, the cutting tool was modeled as a rigid body and Coulomb's friction
238 was applied to the relevant zones.
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244 In modelling the pressure effect of coolant, the velocity of the jet was inputted to the
245 software. Which was calculated using the jet area based on the nozzle diameter, and the flow rate.
246 It is assumed that the flow is uniform and steady after leaving the nozzle and that the speed of the
247 jet is not appreciably reduced after hitting the chip. The pressure exerted by the jet is applied on
248 the chip surface. The heat exchange between the chip and coolant was modeled as convective
249 thermal boundary conditions. Orthogonal (2-dimensional) cutting was employed for simplification
250 matters, as experimental validation attested for the validity of the model, implying a plain strain
251 model that does not account for the load distribution applied by the coolant in the Z axis, and all
252 data input regarding simulation parameters are displayed in Table 1.
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259 2.2 Experimental methodology

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261 The cutting tests were performed on a SC-450 Nakamura-Tome CNC Lathe (Figure 2a).
262 The semi-synthetic, 6% concentrated, cutting fluid was supplied to the rake face of the
263 commercially available Kennametal CNMG 432 uncoated Tungsten Carbide (WC) grade k turning
264 insert by a ChipBLASTER J8-1000 High Pressure Coolant Supply, through Sandvik's PCLNL 16
265 4DHP (Figure 2b-c) Coolant-through tool holder.
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269 The ASTM B265 Grade 5 Ti6Al4V workpiece (Figure 2b), also known as Ti64 was used
270 for all cutting operations. The workpiece used was of a cylindrical shape measuring approximately
271 100 mm in diameter and 250 mm in length. Material properties, chemical composition, and
272 microstructure provided by the supplier are listed in Table 2.
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283 The selected cutting parameters are listed in Table 3. The main idea behind these severe
284 cutting conditions is to accelerate and intensify the wear mechanisms on the uncoated cemented
285 carbide tools. Thus, allowing for a better visualization of the phenomena taking place during the
286 cutting process, as well as the role played by the HPC supply.
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290 Cutting forces were measured by a three component Kistler 9121 tool holder dynamometer
291 (2b), transmitting to a Kistler 5010 amplifier, and recorded using LABVIEW 14.0 during the first
292 50 meters of cutting length.
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294 As shown in Figure 3, a thermocouple was positioned close to the rake face of the cutting
295 tool. The insertion was made by EDM (Electrical Discharge Machining), allowing for the
296 acquisition of peak temperature measurements [7,20]. This setup was performed exclusively for
297 modeling validation. Unaltered cutting tools were employed in the actual cutting tests.
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301 Chips were collected at the end of the first cutting step. Therefore, tool/chip contact
302 conditions would not be affected by the geometry changes imposed by tool wear. The maximum
303 flank wear criterion was set to 300 microns or 2500 meters of cutting length, whichever occurred
304 first. Flank wear measurements were taken for 100-150-meter steps, as well as optical microscopy
305 images (KEYENCE VHX-5000) of the worn inserts' rake and flank surfaces. In order to provide
306 a better understanding of the tool/chip contact behavior during the machining process, a Tescan
307 VEGA2 Scanning Electron Microscope (SEM) was employed to acquire high magnification
308 images of surface topography of chips and worn cutting inserts. Additionally, orientation maps
309 were obtained by Electron Backscattered Diffraction (EBSD) using a JEOL JSM-7000F Scanning
310 Electron Microscope. Moreover, white light interferometry was introduced by an Alicona Infinite
311 Focus optical microscope for 3D surface measurements of the worn inserts and collected chips. A
312 high resolution Nikon Eclipse LV100 optical microscope was used for the microstructural analysis
313 of the chips' cross sections. Prior to imaging, samples were cold mounted, polished and etched by
314 swabbing a cotton ball rinsed in a solution of HF + HNO₃ for 10 seconds.
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318 Vickers microhardness tests on the cross section measurements of the collected chips were
319 performed by a Matsuzawa MMT-X7A micro Vickers hardness tester with a diamond
320 quadrangular pyramid indenter at 50 gf for 10 seconds.
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3. Results and Discussion

3.1 FEA results

As shown in Figure 4, simulation results present slightly higher temperature values in comparison to the experimental data but keeping the same trend. This difference in temperature could be attributed the thermo couple being positioned few millimetres away from the tool-chip interface [7] (Figure 3). In addition, a slight decrease in peak temperature is presented when comparing both conditions at 150 m/min (Figure 4 a,b), which can be attributed to the reduced contact pressure and consequent attenuated friction conditions occasioned by the HPC jet. While overall temperature changes are not so significant, Figure 4 (d-f) reveals a considerable difference in peak temperatures on the chips. This data indicates that a higher amount of heat is being directed towards the chip, which is a highly desirable outcome when machining difficult-to-cut alloys, since the excessive heat present at the rake face of the cutting tool will facilitate the diffusion process, resulting in accelerated crater wear and a reduction in tool life. As crater wear progresses, material is being removed from the insert, thus weakening the tool's cutting edge, ultimately leading to its catastrophic failure.

As shown in Figure 4 (e,f), the additional momentum provided by the HPC jet results in some regions of concentrated strain, where chips are most susceptible to breaking. However, the same cannot be said for the flood condition presented in Figure 4-d, where the chip curls at its natural unobstructed radius, implying an undesirable continuous chip formation that might lead to poor surface finish, excessive heat accumulation and ultimately, premature tool failure.

A notable reduction in TCCL (tool-chip contact length) for the two HPC scenarios is presented in Figure 5. The changes were ~50% for the 150 m/min (Figure 5-b) and 250 m/min (Figure 5-c) HPC conditions. The stress concentration exhibits a direct correlation with the length of the contact region. Additionally, a reduction in contact pressure is visible for the two HPC scenarios, which reflects in a less intensive overall stress profile. High contact loads are some of the main facilitators of the adhesion process, once the adhesive bond's strength is proportional to the pressure being applied to it. That said, the eventual tearing apart of the welded workpiece material will cause what is known as plucking, causing damage that is similar to the diffusion process.

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395 The higher chip temperatures presented in Figure 4, combined with the lower contact
396 stresses in Figure 5, indicate an increase in the portion of heat generated by plastic deformation
397 over the heat provided by friction for the HPC conditions.
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400 3.2 Tool life

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403 Figure 6 presents a direct tool life comparison between all the tested conditions. The graph
404 shows the maximum flank wear achieved at the same cutting length (as displayed on the graph)
405 for each set of cutting parameters proposed in Table 3. The length is determined by the point of
406 failure (when flank wear exceeds the pre-established end of life criteria) for the worst performing
407 coolant pressure at a specific cutting speed.
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411 When analysing the results presented in Figure 6, a trend can be noticed in terms of
412 maximum flank wear vs. coolant pressure. Higher coolant pressures have a positive impact on
413 wear rates throughout the cutting process, which can be attributed to the reduced thermal and
414 mechanical loads acting on the tool, as seen in Figures 4 and 5. Hoier et al. [21] highlighted similar
415 behavior when machining Inconel 718 with HPC supply. This was attributed to the cobalt binder
416 present in the insert's composition being subject to thermal softening, making it easier to be
417 removed in the abrasion process. The temperature profiles shown in Figure 4 support that idea.
418 For the flood condition, heat is being dissipated into the cutting tool instead of being carried away
419 by the chips. Furthermore, it also explains the higher flank wear rates measured for the cutting
420 speeds of 200 m/min and 250 m/min.
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427 As shown in Figure 7, when cutting at the lowest speed of 150 m/min with the addition of
428 HPC, inserts were able to reach 2500 meters of cutting length without surpassing the pre-
429 established end of life criteria (300 μm flank wear). In fact, when looking at the wear curves shown
430 in Figure 7, flank wear was less than half of what was obtained for the flood benchmark condition.
431 Similar results were obtained at the highest cutting speed of 250 m/min, where the best tool life
432 results were achieved for the same pressure of 1000 psi.
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436 Cutting forces (Figure 8) are also significantly lower for the HPC when compared to the
437 benchmark. A reduction in the order of 40% at 150 m/min can be observed, which can be attributed
438 to a more efficient chip evacuation, thus requiring less power from the machine tool to advance
439 the cut. A correlation can also be established between the stress profiles seen in Figure 5 and the
440 cutting forces in Figure 8, once the compressive loads acting against the cutting movement are
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451 visibly higher for the flood condition. On that basis, cutting forces are mainly dependant on the
452 area of the shear planes [7,22]. Hence, the reduction in TCCL has a direct impact on the values
453 observed for the two HPC scenarios. These results agree to what was found by previous research
454 performed by Jagtap et al. [23]. On that premise, further analyses were narrowed down to the
455 benchmark flood condition and these two sets of parameters: 150 m/min at 1000 psi and 250 m/min
456 at 1000 psi. With the focus on pointing out the factors leading to this notable improvement in tool
457 wear and cutting forces.
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463 3.3 Tool wear modes and mechanisms 464

465 Secondary Electron SEM images were taken from the worn tools' rake and flank faces in
466 order to identify the main wear modes taking place during the cutting process. When analysing
467 Figure 9 (a-c), the dominance of adhesion and diffusion over other wear mechanisms becomes
468 evident, what leads to the formation of Built-up edge (BUE) and crater wear modes. The images
469 also show a positive influence of cutting speed on the BUE formation [7,22,24]. In Figure 9-a, the
470 extension of crater wear is about double the size of what is seen at the same cutting speed for the
471 HPC condition (Figure 9-b), supporting a shorter contact length. The presence of oxidation wear
472 is only expressive for the flood condition (Figure 9-a). Oxidation is normally found near the end
473 of the contact region, being a result of the reaction between oxygen and the tool binder [7]. On that
474 premise, the less intense sliding contact pressure, present in that area, allows for the access of
475 oxygen; thus, enabling the reaction. Furthermore, abrasion marks were noticed to be more
476 pronounced at the high-speed condition presented in Figure 9-c, resulting in lower tool life.
477 Abrasion is visible since there is not a substantial volume of material adhered to the rake face of
478 the insert.
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488 Further volumetric analysis showed that for both HPC (Figure 10) scenarios the amount of
489 adhered material, represented by V_p (Volume of peaks above reference), is in fact reduced (Figure
490 10 b,c) when compared to the flood condition. It also displays the lower adhesion at a higher
491 cutting speed (Figure 10-c). In contrast to that, V_v (Volume of valleys below reference),
492 representing the volume of removed tool material, is noticeably higher at this speed. Note that this
493 number accounts not only for crater wear, but also for the abrasion that is very pronounced at 250
494 m/min.
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507 There are three main contributors to the presented wear mechanisms: contact, load and
508 affinity. In this way, HPC promotes the separation between the chip and the rake face of the cutting
509 tool, thus reducing the contact length as well as the mechanical loads acting on that region, which
510 can be proven by the simulation results shown in Figures 4 and 5.
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512 513 514 3.4 Cutting chips analysis 515

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517 Secondary electron images of the chips undersurface and shear bands were taken to attest
518 for the influence of HPC on chip morphology. By looking at the undersurface of the studied chips
519 (Figure 11-a), some inclusions are noticed to be more frequent at the HPC scenarios, which
520 is possibly an indicator of the sticky nature of contact for those conditions. To strengthen that
521 hypothesis, as previously observed in Figure 9, a longer sliding contact region was detected for
522 the benchmark flood scenario, which means reduced contact pressure at the tool / chip interface.
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527 Images shown in Figure 11-b have revealed that segmentation is present for all three of the
528 tested conditions. In general, segmented chips are common when machining alloys with high
529 hardness and low thermal conductivity, such as titanium [25]. It is also considered, for some
530 particular situations, a desirable outcome for cutting force reduction and enhanced chip evacuation
531 [26]. Furthermore, the segmentation edges are smoother when working with the high-pressure
532 coolant supply, meaning that the shear band formation process is facilitated by its application,
533 revealing one of the possible reasons for the force reductions presented in Figure 8. Tool wear will
534 also impact the chip formation process, as stated by Dargusch et al. [25], segmentation and
535 deformation of chips will be significantly impacted as machining progresses.
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541 Based on the obtained experimental results for chip formation and tool wear mechanisms,
542 the schematic diagram presented in Figure 12 attempts to illustrate the changes occurring at the
543 tool/chip contact area when applying HPC. In Figure 12-a, the normal stress decreases
544 exponentially along the contact region and is inversely proportional to the chip's sliding velocity,
545 becoming maximum at the tool tip and minimum at the point where chip loses contact with the
546 cutting tool. The normal stress and sliding velocity profiles combined, contribute to the definition
547 of the so-called sticking and sliding regions, the first one being characterized by high levels of
548 contact pressure and significantly low chip sliding velocity, and the second one where pressure is
549 reduced, thus allowing the chip to flow at a higher speed. These contact conditions are altered once
550 HPC is introduced. As presented in Figure 12-b, once contact pressure (normal stress) is reduced
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563 to a certain level, by the application of high-pressure coolant, the chip immediately loses contact
564 with the tool's rake face, not allowing for the sliding interaction. On that basis, a direct correlation
565 can be drawn from the tools analyzed in Figure 9, where oxidation was not significant for the HPC
566 conditions; therefore, suggesting a substantially shorter low pressure contact area, and the chips
567 presented in Figure 11, where the presence of inclusions on the collected samples, characterizes a
568 process of "sticky" nature.
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573 To investigate the role of HPC as well as the cutting speeds on the shear bands, the chip
574 cross sections were analyzed using EBSD, and the acquired data is presented in Figure 13. As
575 shown, the resulting orientation maps of the regions taken from the chips in Figure 13 (a, c, e) are
576 shown in Figure 13 (b, d, f), respectively. It can be observed that the grains are more elongated at
577 higher cutting speeds (Figure 13-f) when compared to lower ones (Figure 13-d). The same can be
578 stated when comparing HPC to flood conditions, because of the severe plastic deformation caused
579 by HPC application. Here, the shear bands formed by flood coolant (Figure 13-b) have equiaxed
580 grains (~1 μm) compared to a mixture of equiaxed (~7 μm) and highly elongated grains in the case
581 of machining with HPC (Figure 13 (d, f)).
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587 Figure 14 presents the pole Figure maps of the chips obtained at different cutting
588 conditions. As shown, most of the grains in the chips obtained with flood condition, possess a Goss
589 $\{1\ 1\ 0\}$ texture (Figure 14-a) while the majority of the grains obtained with HPC possess an
590 orientation close to the Cube $\{1\ 0\ 0\}$ (001) texture as shown in Figure 14-b and 14-c. Seid Ahmed
591 et al. [27] concluded that in general, the Cube texture has higher plasticity compared to the Goss
592 texture. The main reason for this is that the Cube texture contains more slip systems, helping it to
593 deform quickly during the machining process [28]. Thus, the chips obtained with HPC (Figures
594 14-b and 14-c) show highly elongated grains compared with very equiaxed grains of the chips
595 obtained with flood condition.
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601 The micro hardness values in Table 4 are in agreement with the EBSD data presented in
602 Figures 13 and 14, attesting for the strain hardening resultant of the high deformation levels
603 imposed by the application of HPC. This becomes more evident for the areas close to the tool-chip
604 contact region, where the variation in hardness is noticeably higher. The severe plastic deformation
605 imposed by HPC causes the chips to strain harden, and once they are fragilized, their breakability
606 is improved.
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4. Conclusions

The experiments performed showed that the tool-chip contact conditions are affected significantly by the application of HPC, indicating that its influence goes beyond chip control. It also allowed for the establishment of a correlation between: coolant pressure, cutting speed, tool life, cutting forces, wear mechanisms, and chip formation. Resulting in the following contributions:

1. Modeling and experiments show a tool temperature reduction for the HPC process, whereas for these same conditions, peak chip temperatures are increased. This data combined with the less severe tool-chip interactions demonstrated in the stress profiles, indicates an increase in the portion of heat generated by plastic deformation over the heat provided by friction for the HPC conditions. In addition, it also results in reduced diffusion and adhesion rates.
2. Coolant pressure and maximum flank wear are inversely proportional to each other, indicating an influence of the heat directed towards the flank face of the cutting tool on the abrasion process. This fact could be explained by the thermal softening of the cobalt binder present in the insert's composition.
3. Oxidation wear is noticeably less extensive when employing HPC supplies, which suggests an interruption of tool-chip contact right after the end of the sticking zone.
4. Chip formation is facilitated by HPC. Improved chip evacuation allied to the lower compressive loads at the rake face of the cutting insert, caused a reduction in cutting forces as well as the formation of smoother shear bands, indicating a more stable process.
5. The strain hardening of the chips collected for the HPC process have a positive impact on their breakability. This fact is supported by the EBSD results, which attested for the presence of highly deformed grain textures.

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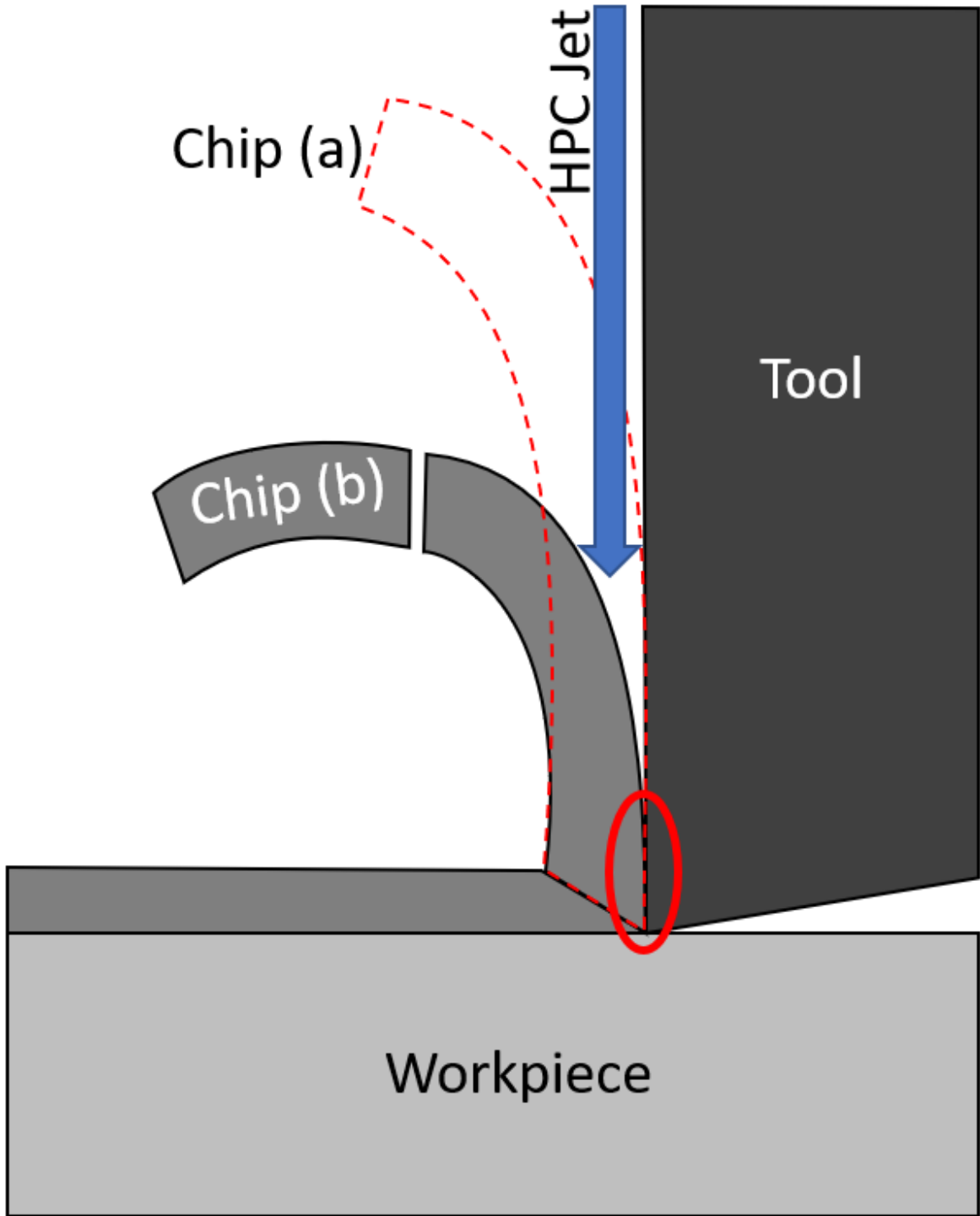
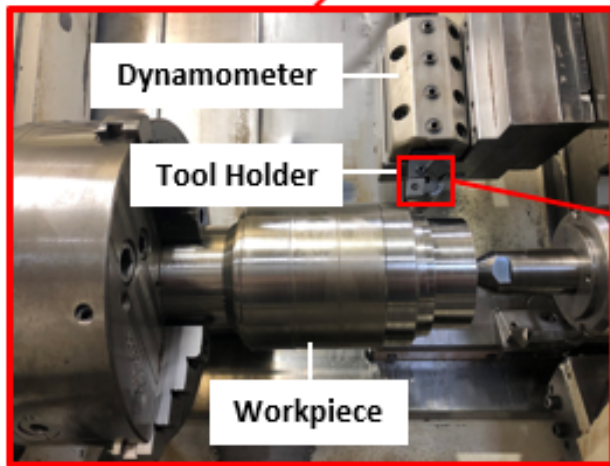


Fig. 1. – Graphic representation highlighting the changes in chip formation and contact length between (a) flood/dry and (b) HPC conditions.

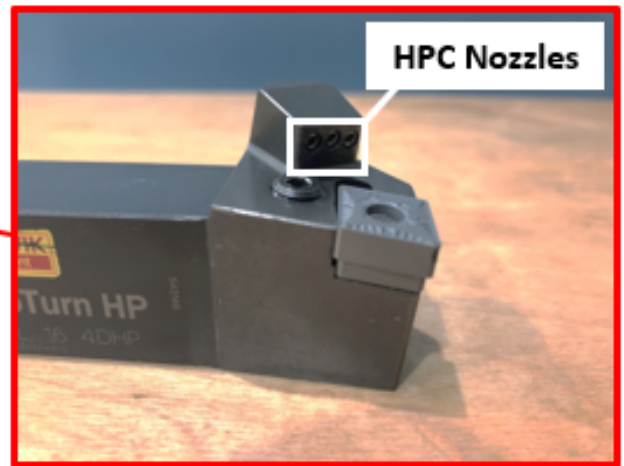
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(a)



(b)



(c)

Fig. 2. – (a) Machine tool, (b) workpiece, dynamometer, tool holder setup and (c) detailed view of tool and coolant-through tool holder.

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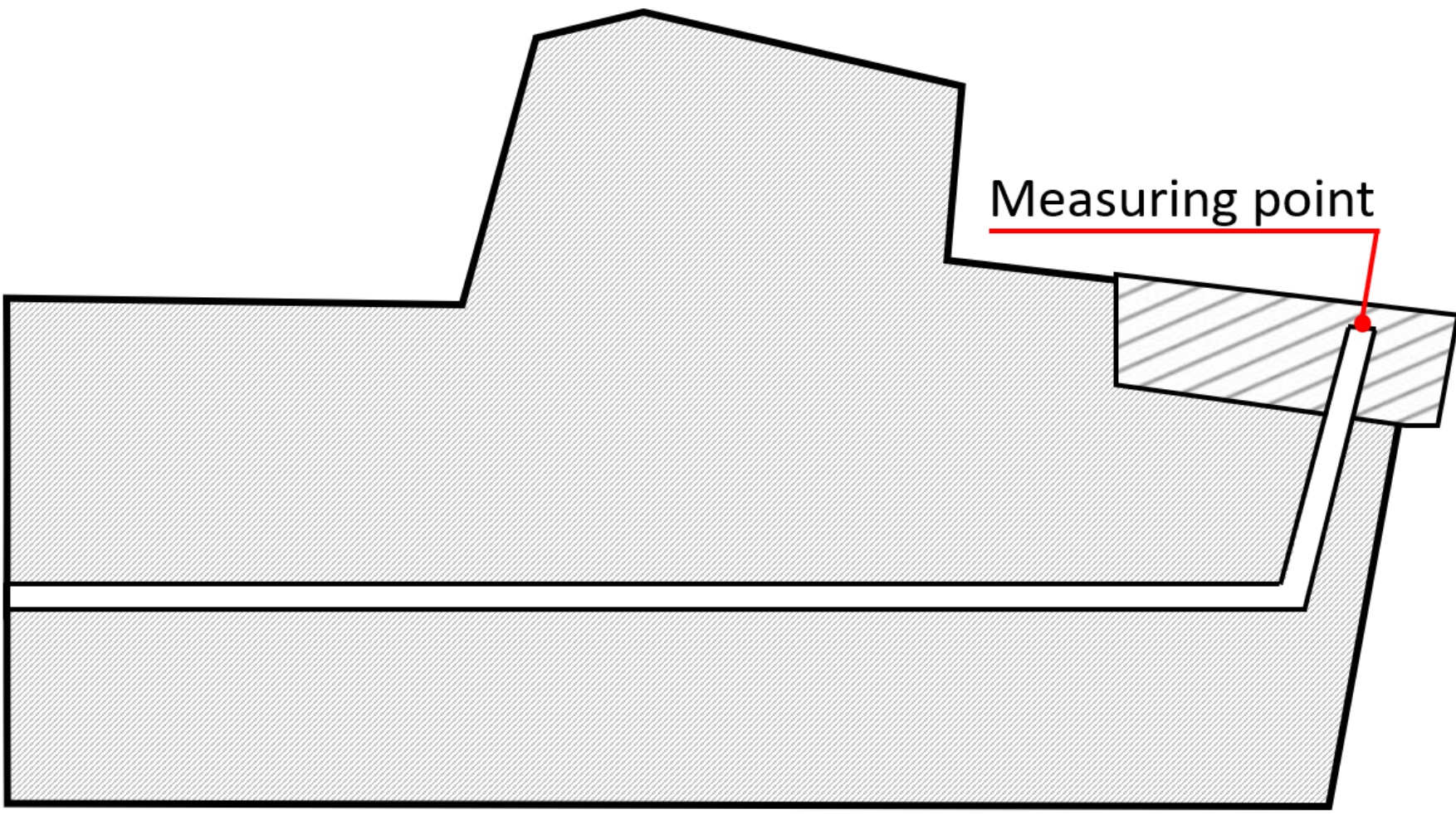


Fig. 3. – Experimental temperature measurement point.

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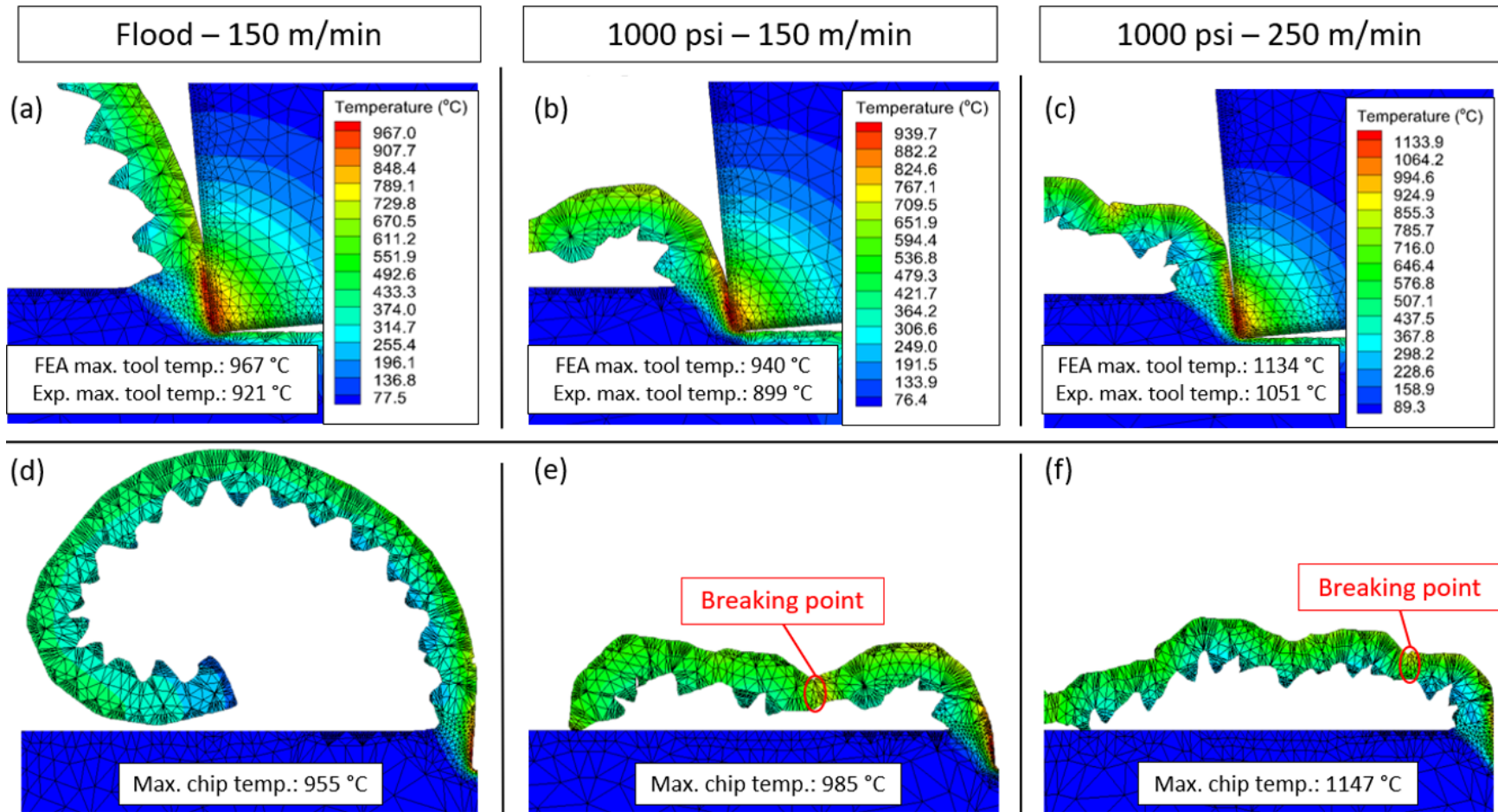


Fig. 4. – Temperature measurements for both simulation and experimental conditions, combined with FEA results for chip formation at (a,d) flood – 150 m/min, (b,e) 1000 psi – 150 m/min and (c,f) 1000 psi – 250 m/min.

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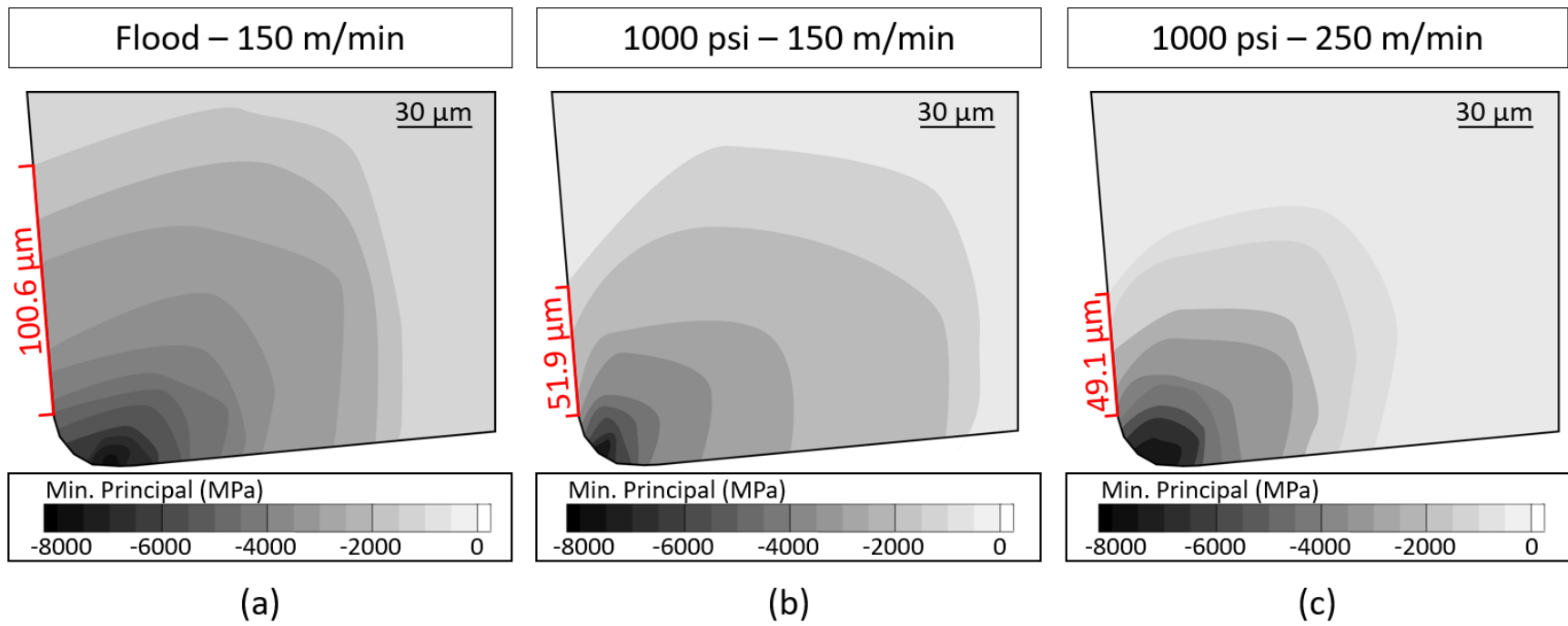


Fig. 5. – Tool stress profiles and TCCL for (a) flood – 150 m/min, (b) 1000 psi – 150 m/min and (c) 1000 psi – 250 m/min.

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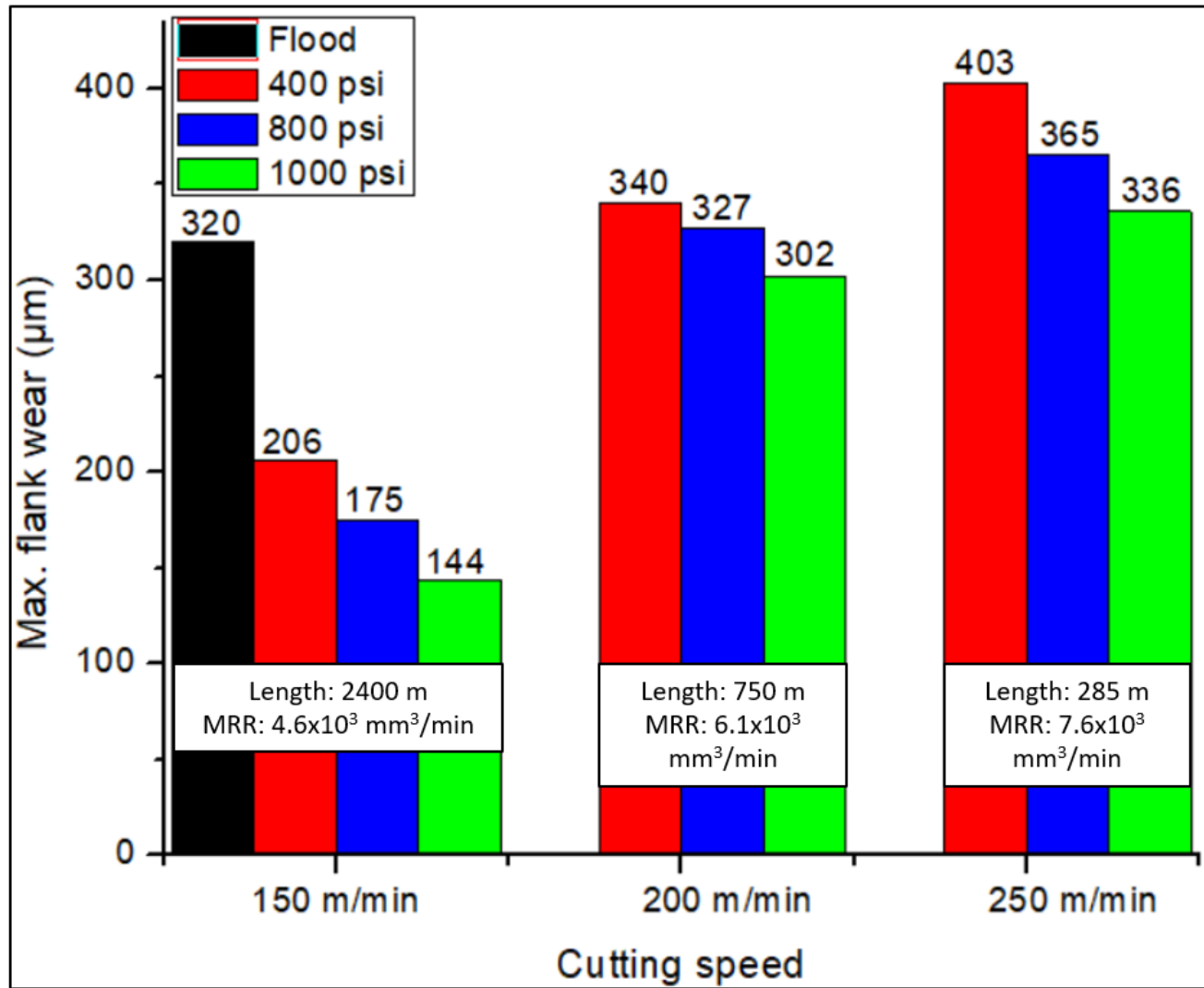


Fig. 6. – Flank wear comparison chart + MRR (Material Removal Rates) for all conditions.

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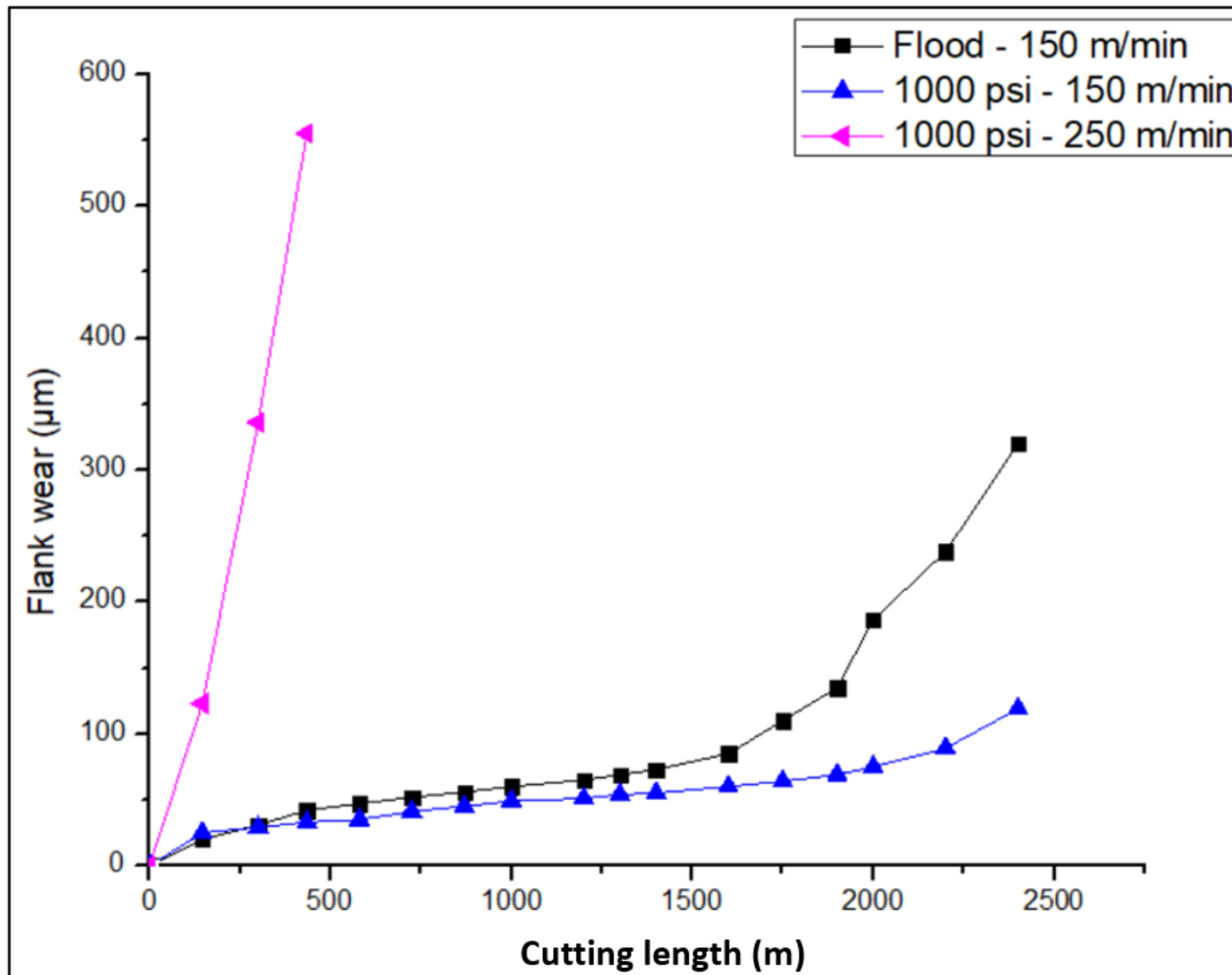


Fig. 7. – Tool wear progression curves for flood – 150 m/min, 1000 psi – 150 m/min and 1000 psi – 250 m/min.

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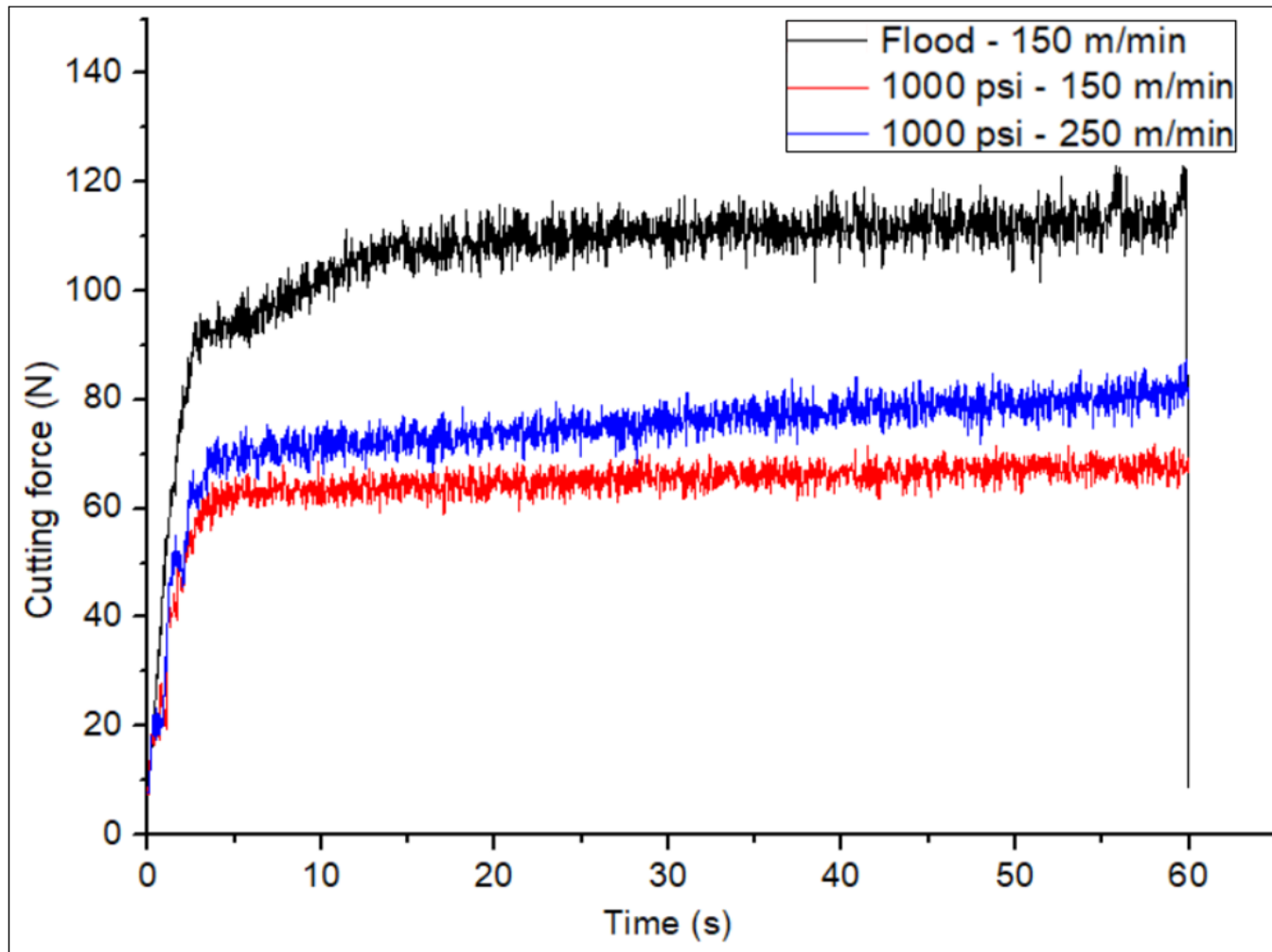


Fig. 8. – Cutting forces for flood – 150 m/min, 1000 psi – 150 m/min and 1000 psi – 250 m/min.

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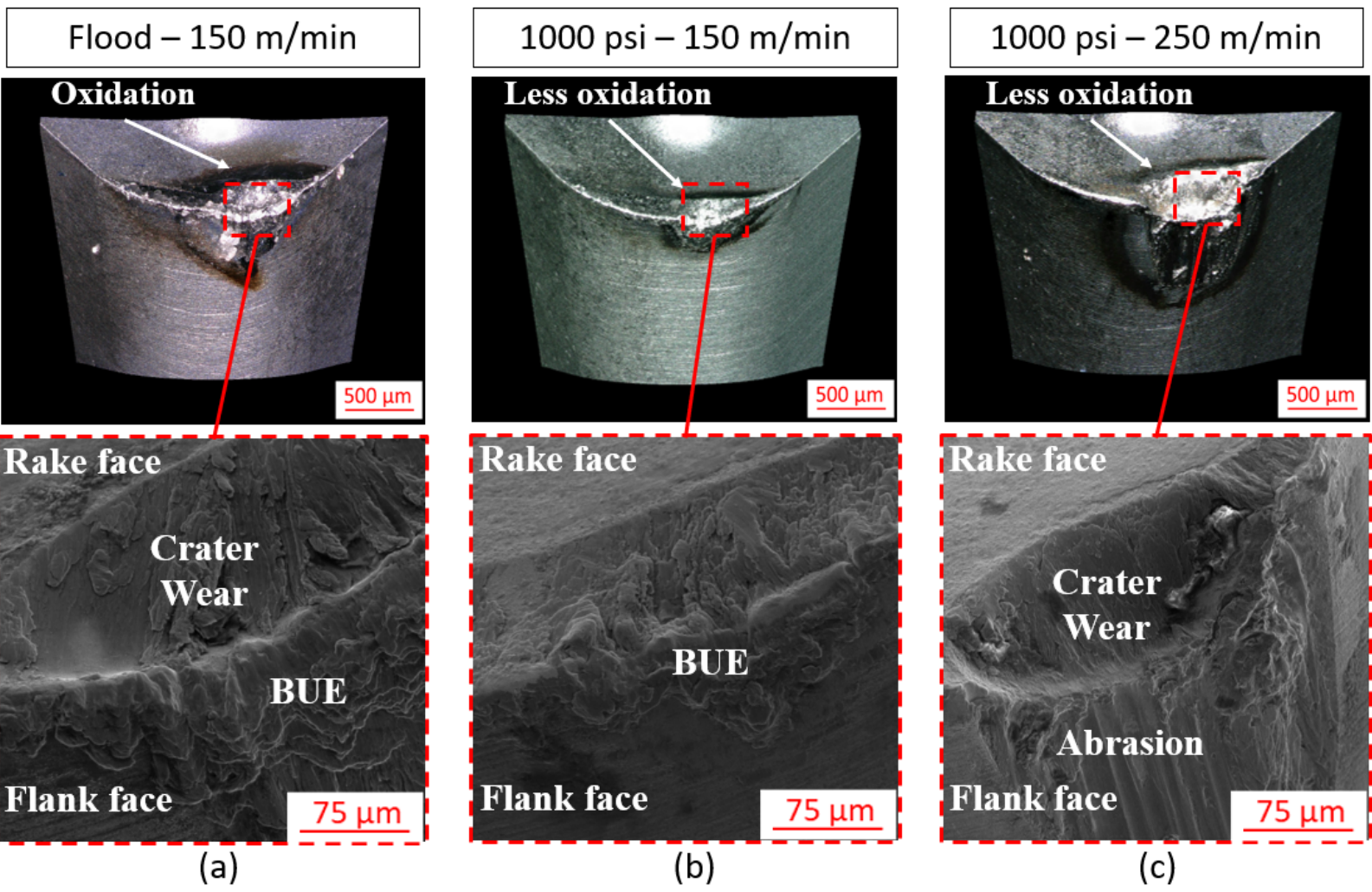


Fig. 9. – SEM of worn inserts for (a) flood – 150 m/min, (b) 1000 psi – 150 m/min and (c) 1000 psi – 250 m/min, indicating the presence of oxidation, crater, BUE and flank wear modes.

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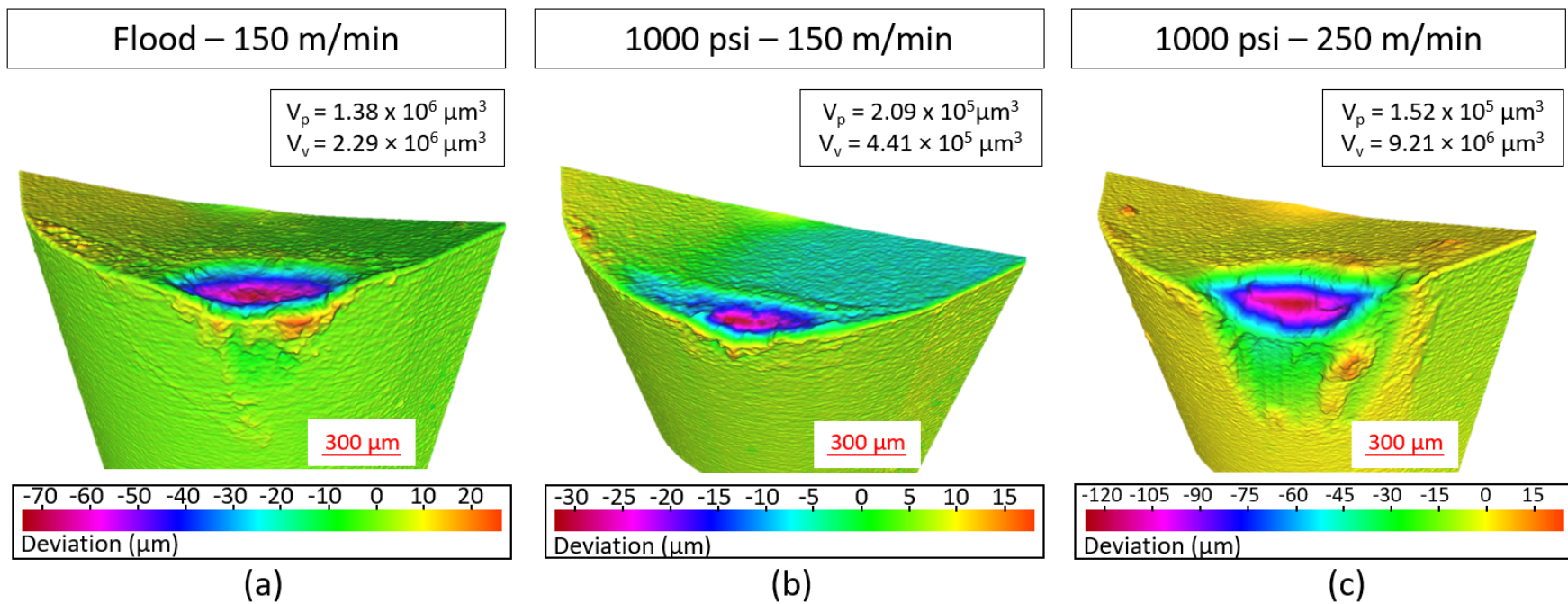


Fig. 10. – Volumetric analysis of worn tools for (a) flood – 150 m/min, (b) 1000 psi – 150 m/min and (c) 1000 psi – 250 m/min, indicating the volumes of adhered and removed material from the cutting inserts.

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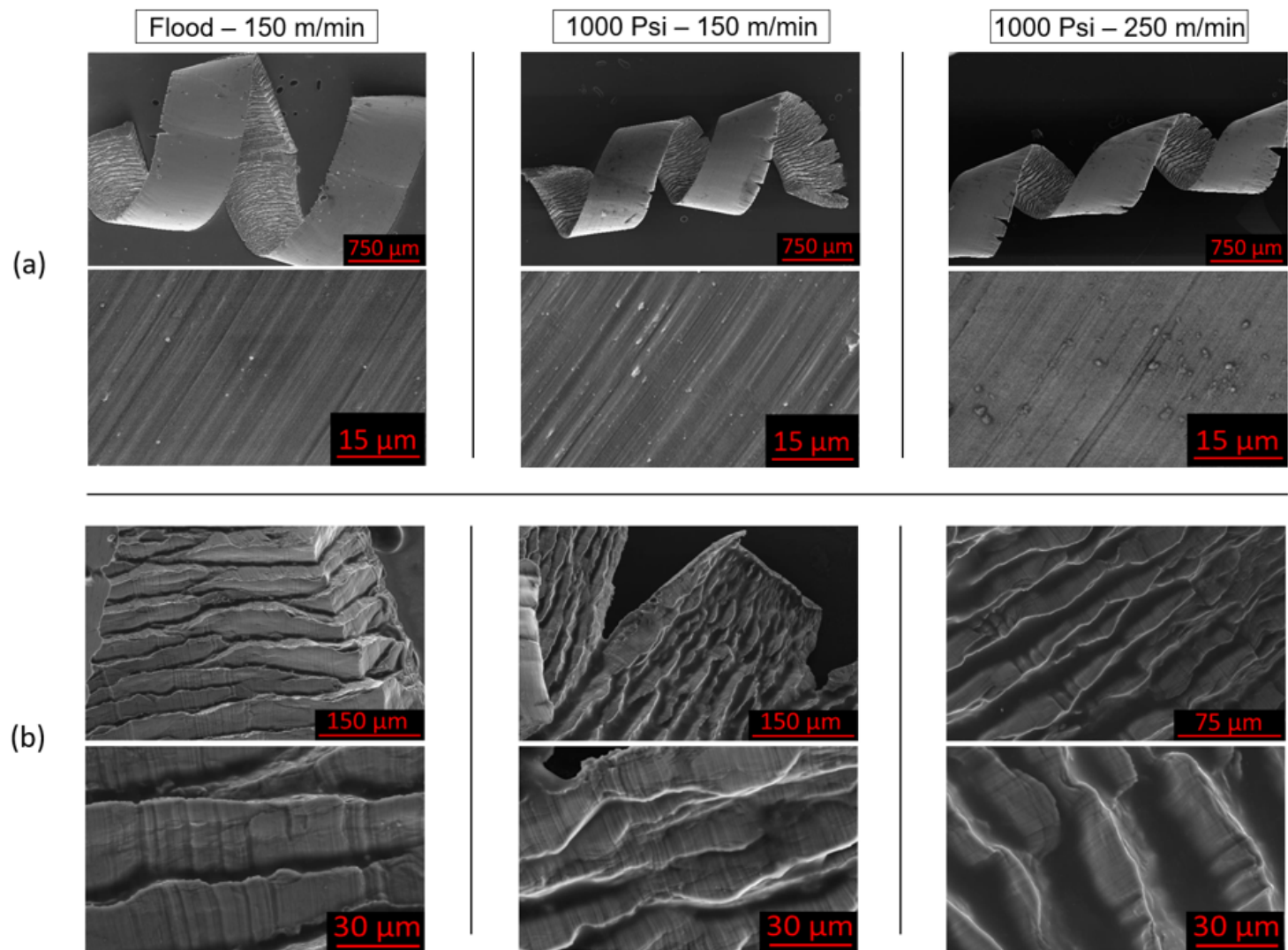


Fig. 11. – SEM of (a) chip undersurfaces and (b) shear bands.

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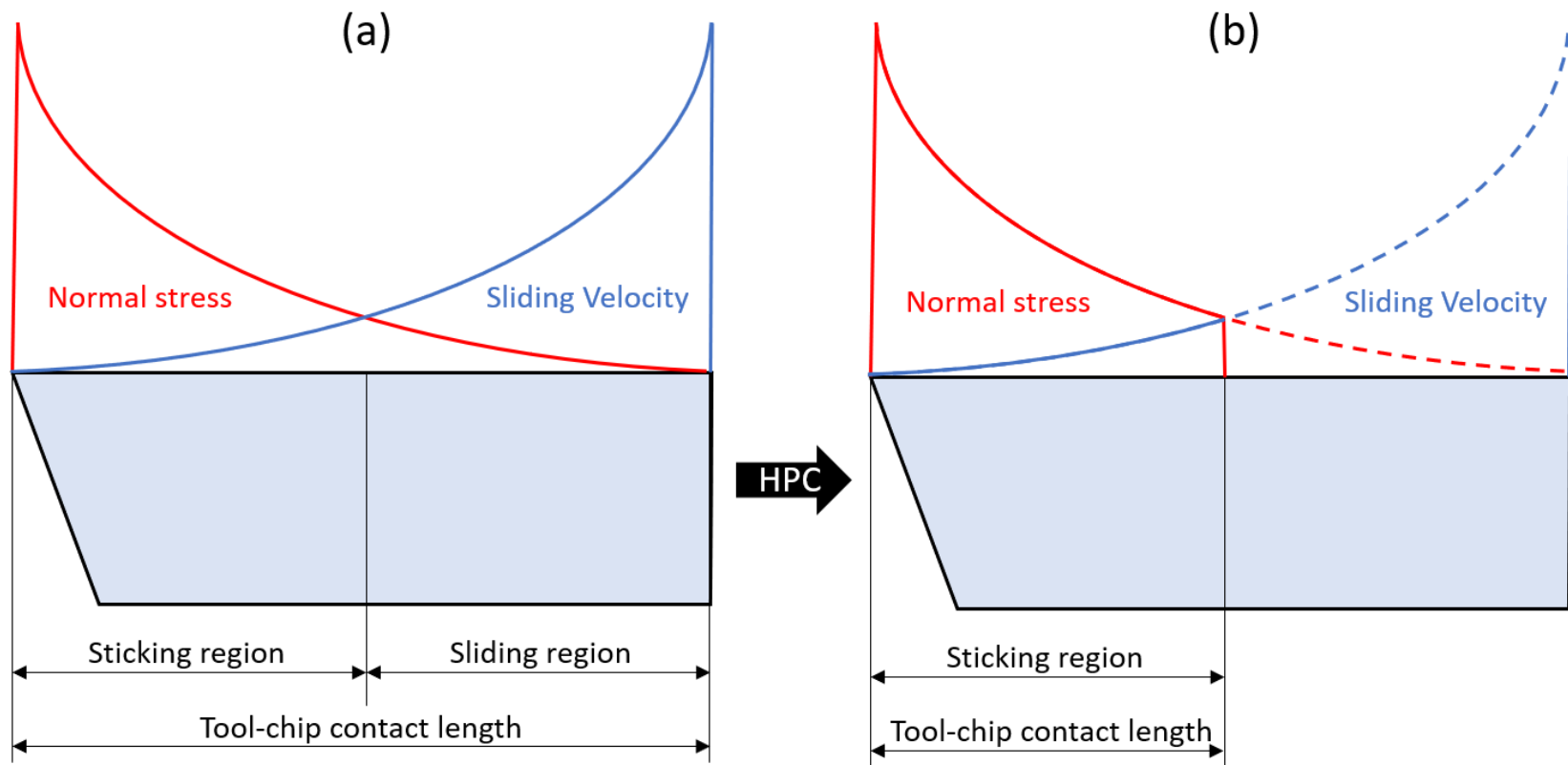


Fig. 12. – Tribological conditions along the rake face of the insert for (a) dry / flood, and (b) high-pressure coolant conditions.

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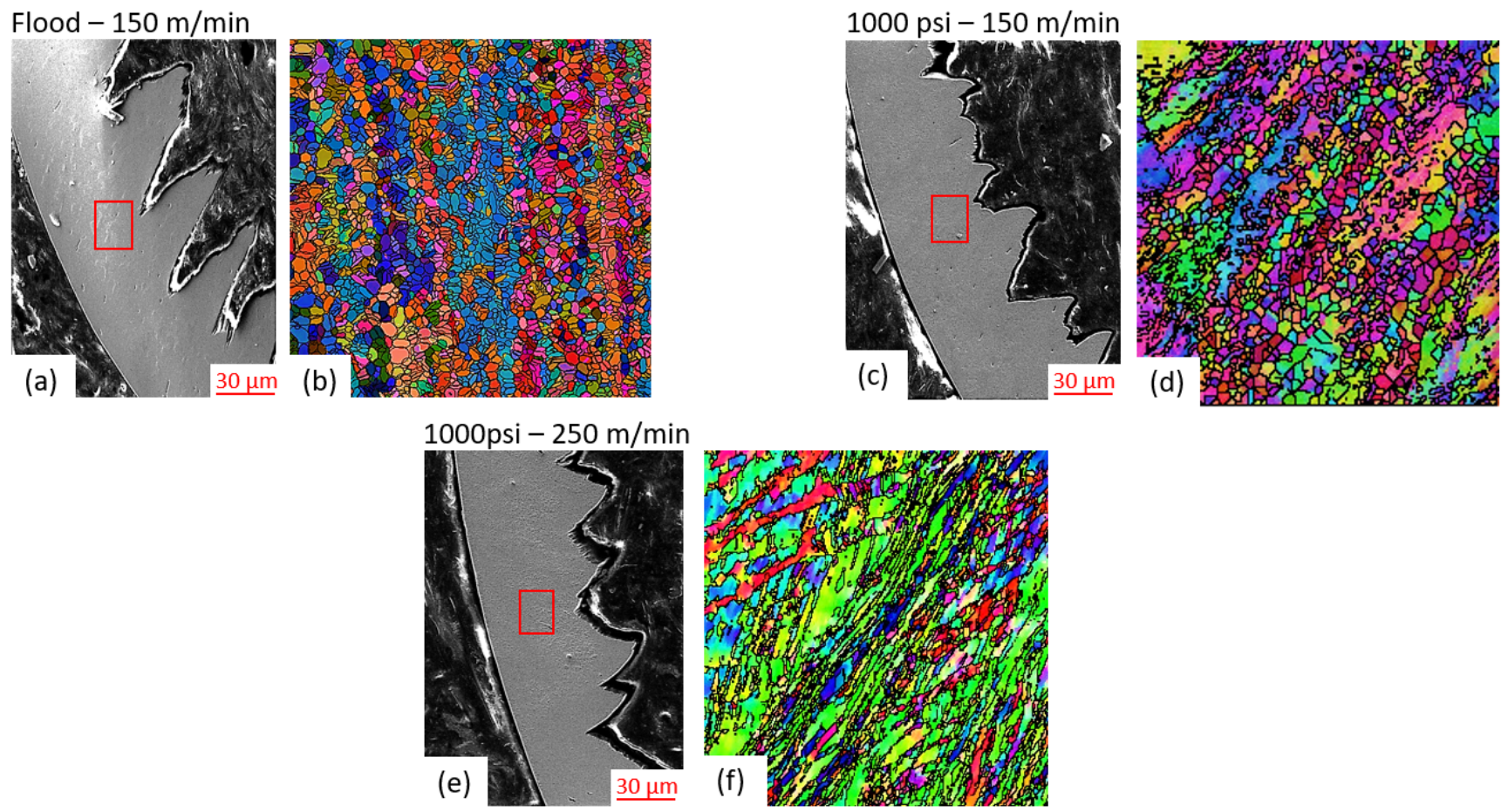


Fig. 13. – Chips cross-sections and EBSD orientation maps for (a,b) flood – 150 m/min, (c,d) 1000 psi – 150 m/min and (e,f) 1000 psi – 250 m/min.

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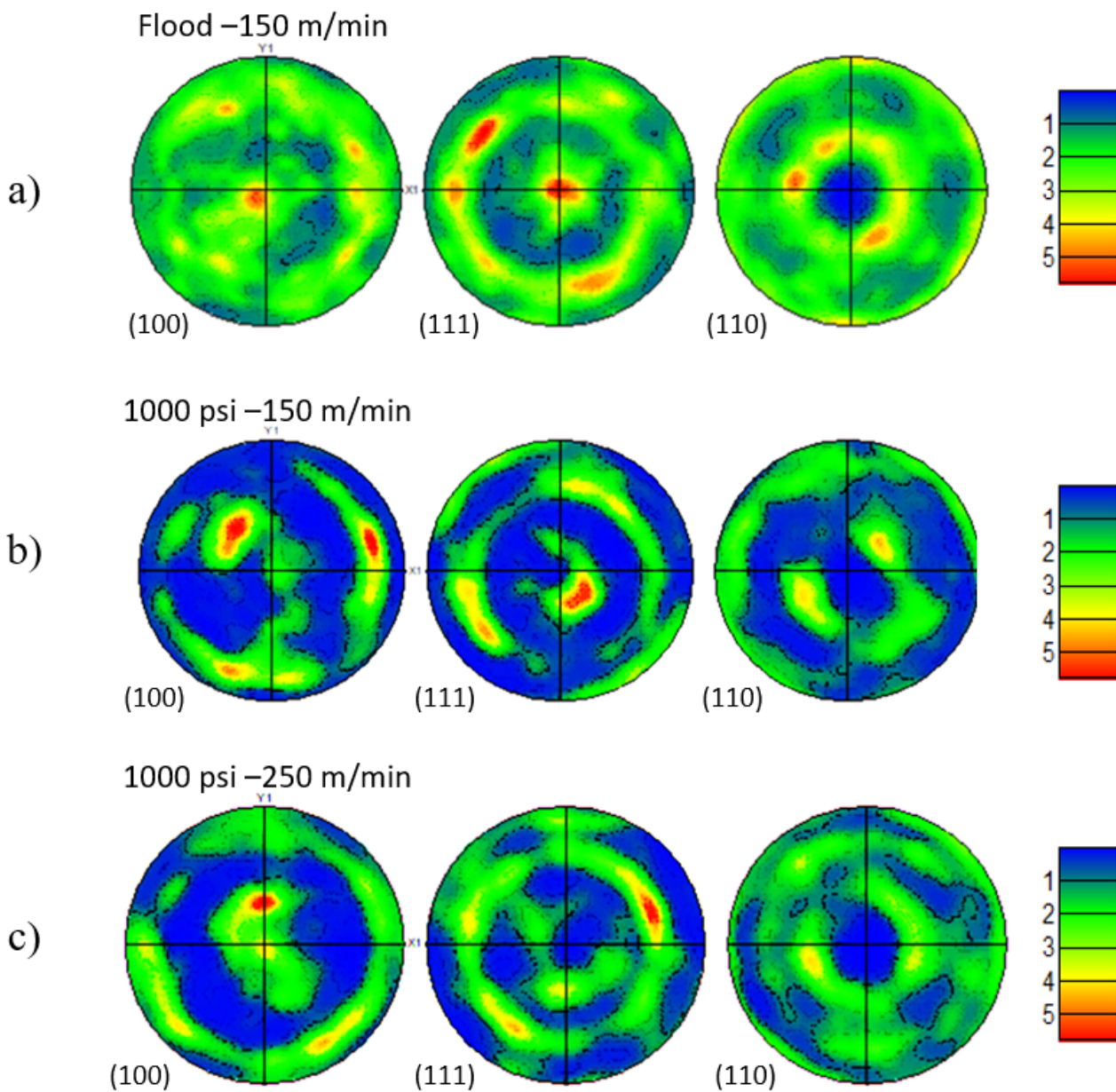



Fig. 14. – EBSD pole figures for (a) flood – 150 m/min, (b) 1000 psi – 150 m/min and (c) 1000 psi – 250 m/min.

Table 1. Simulation parameters for all the tested conditions.

Minimum element size (mm)	0.02
Maximum element size	0.1
Maximum number of nodes	24000
No. of output frames	30
Initial room temperature (°C)	20
Coolant heat transfer coefficient (W/m²K)	1x10 ⁴

Table 2. Chemical Composition, and main mechanical properties of Ti-6Al-4V at room temperature.

Element	Weight, max %	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation %	Hardness (HB)	Thermal conductivity (W/m·°C)	T_{melt} (°C)
Al	5.5 – 6.75	828	895	10	341	6.6	1630
V	3.5 – 4.5						
N	0.05						
C	0.08						
H	0.015						
Fe	0.4						
O	0.2						
Residuals, each/total	<0.1 / < 0.4						

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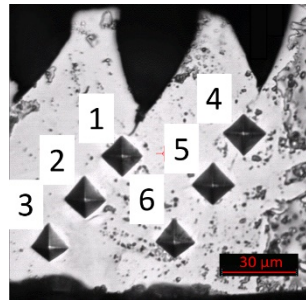
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Table 3. Machining parameters for experimental testing.

	Coolant pressure (psi)				Feed (mm/rev.)	DOC (mm)
	Flood (Benchmark)	400	800	1000		
Vc (m/min)	150				0.1225	0.25
	n/a	200				
	n/a	250				

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Table 4. Shear band chips microhardness profiles for flood – 150 m/min, 1000 psi – 150 m/min and 1000 psi – 250 m/min with values highlighted for the points located near the tool-chip interface.



	Hardness (HV)					
	1	2	3	4	5	6
Flood – 150 m/min	337	365	361	306	330	354
1000 psi – 150 m/min	354	365	392	354	396	380
1000 psi – 250 m/min	373	363	434	343	338	408

Tool-chip interface

Tool-chip interface