

# ADVANCED MACHINING TOWARDS IMPROVED MACHINABILITY OF DIFFICULT-TO-CUT MATERIALS

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Edited by:

A.K.M. Nurul Amin (Chief Editor)

Dr. Erry Yulian Triblas Adesta

Dr. Mohammad Yeakub Ali



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<b>SECTION A: HEAT ASSISTED MACHINING</b>	<b>1</b>
<b>1. CHAPTER 1: INFLUENCE OF WORKPIECE PREHEATING ON CHATTER AND MACHINABILITY OF TITANIUM LOY - TI6AL4V</b>	<b>1</b>
<b>2. CHAPTER 2: MACHINABILITY IMPROVEMENT IN END OF MILLING TITANIUM ALLOY TI-6AL-4V THROUGH PREHEATING</b>	<b>9</b>
<b>3. CHAPTER 3: SOME ASPECTS OF IMPROVED MACHINABILITY IN PREHEATED MACHINING OF TITANIUM ALLOY TI-6AL-4V</b>	<b>19</b>
<b>4. CHAPTER 4: MACHINABILITY ASPECTS IN HEAT ASSISTED MACHINING OF HARDENED STEEL AISI H13 USING COATED CARBIDE TOOL</b>	<b>27</b>
<b>5. CHAPTER 5: TOOL WEAR AND SURFACE ROUGHNESS ASPECTS IN HEAT ASSISTED END MILLING OF AISI D2 HARDENED STEEL</b>	<b>35</b>
<b>6. CHAPTER 6: MODELING IN PREHEATED MACHINING OF AISI D2 HARDENED STEEL</b>	<b>43</b>
<b>7. CHAPTER 7: RELATIVE PERFORMANCES OF PREHEATING, CRYOGENIC COOLING AND HYBRID TURNING OF STAINLESS STEEL AISI 304</b>	<b>49</b>
<b>SECTION B: CHATTER AND SELECTED METHODS OF CHATTER SUPPRESSION</b>	<b>57</b>
<b>8. CHAPTER 8: ROLE OF THE FREQUENCY OF SECONDARY SERRATED TEETH IN CHATTER FORMATION DURING TURNING OF CARBON STEEL AISI 1040 AND STAINLESS STEEL</b>	<b>57</b>
<b>9. CHAPTER 9: INFLUENCE OF THE ELASTIC SYSTEM AND CUTTING PARAMETERS ON CHATTER DURING MACHINING OF MILD STEEL</b>	<b>65</b>
<b>10. CHAPTER 10: INFLUENCE OF CHATTER ON TOOL LIFE DURING END MILLING OF ALUMINIUM AND ALUMINIUM ALLOY ON VMC</b>	<b>75</b>

11	<b>CHAPTER 11: A NEW METHOD FOR CHATTER SUPPRESSION AND IMPROVEMENT OF SURFACE ROUGHNESS IN END MILLING OF MILD STEEL</b>	<b>83</b>
12	<b>CHAPTER 12: APPLICATION OF PERMANENT ELECTROMAGNET FOR CHATTER CONTROL IN END MILLING OF MEDIUM CARBON STEEL</b>	<b>91</b>
13	<b>CHAPTER 13: APPLICATION OF PERMANENT ELECTROMAGNET FOR CHATTER CONTROL IN END MILLING OF TITANIUM ALLOY - Ti6Al4V</b>	<b>99</b>
14	<b>CHAPTER 14: CHATTER SUPPRESSION IN END MILLING OF TITANIUM ALLOY Ti6Al4V APPLYING PERMANENT MAGNET CLAMPED ADJACENT TO THE WORKPIECE</b>	<b>107</b>
	<b>SECTION C: MODELING AND OPTIMIZATION IN MACHINING</b>	<b>117</b>
15	<b>CHAPTER 15: A COUPLED ARTIFICIAL NEURAL NETWORK AND RSM MODEL FOR THE PREDICTION OF CHIP SERRATION FREQUENCY IN END MILLING OF INCONEL 718</b>	<b>117</b>
16	<b>CHAPTER 16: APPLICATION OF RESPONSE SURFACE METHODOLOGY COUPLED WITH GENETIC ALGORITHM FOR SURFACE ROUGHNESS OF INCONEL 718</b>	<b>123</b>
17	<b>CHAPTER 17: DEVELOPMENT OF A MATHEMATICAL MODEL FOR THE PREDICTION OF SURFACE ROUGHNESS IN END MILLING OF STAINLESS STEEL SS 304</b>	<b>133</b>
18	<b>CHAPTER 18: DEVELOPMENT OF AN ARTIFICIAL NEURAL NETWORK ALGORITHM FOR PREDICTING THE CUTTING FORCE IN END MILLING OF INCONEL 718 ALLOY</b>	<b>143</b>
19	<b>CHAPTER 19: DEVELOPMENT OF AN ARTIFICIAL NEURAL NETWORK ALGORITHM FOR PREDICTING THE SURFACE</b>	<b>149</b>
20	<b>CHAPTER 20: DEVELOPMENT OF TOOL LIFE PREDICTION MODEL OF TiAlN COATED TOOLS DURING PART C: HIGH SPEED HARD MILLING OF AISI H13 STEEL</b>	<b>155</b>
21	<b>CHAPTER 21: MODELING FOR SURFACE ROUGHNESS IN END-MILLING OF TITANIUM ALLOY Ti-6Al-4V USING UNCOATED WC INSERTS</b>	<b>161</b>

22	<b>CHAPTER 22: MODELING OF SURFACE ROUGHNESS DURING END MILLING OF AISI H13 HARDENED TOOL STEEL</b>	<b>167</b>
23	<b>CHAPTER 23: MODELING OF TOOL LIFE USING RESPONSE SURFACE METHODOLOGY IN HARD MILLING OF AISI D2 TOOL STEEL</b>	<b>175</b>
24	<b>CHAPTER 24: OPTIMIZATION OF SURFACE ROUGHNESS IN HIGH SPEED END MILLING OF TITANIUM ALLOY Ti-6Al-4V UNDER DRY CONDITION</b>	<b>181</b>
25	<b>CHAPTER 25: COMPARISON OF SURFACE ROUGHNESS IN END-MILLING OF TITANIUM ALLOY TI-6AL-4V USING UNCOATED WC-CO AND PCD INSERTS THROUGH GENERATION OF MODELS</b>	<b>189</b>
26	<b>CHAPTER 26: ASSESSMENT OF PERFORMANCE OF UNCOATED AND COATED CARBIDE INSERTS IN END MILLING OF TI-6AL-4V THROUGH MODELLING</b>	<b>195</b>
	<b>SECTION D: CRYOGENIC AND HIGH SPEED MACHINING OF METALS AND NON METALS</b>	<b>203</b>
27	<b>CHAPTER 27: THE EFFECT OF CRYOGENIC COOLING ON MACHINABILITY OF STAINLESS STEEL DURING TURNING</b>	<b>203</b>
28	<b>CHAPTER 28: COMPARISON OF MACHINABILITY OF CERAMIC INSERT IN ROOM TEMPERATURE AND CRYOGENIC COOLING CONDITIONS DURING END MILLING INCONEL 718</b>	<b>209</b>
29	<b>CHAPTER 29: HIGH SPEED END MILLING OF SINGLE CRYSTAL SILICON SING DIAMOND COATED TOOL</b>	<b>217</b>
30	<b>CHAPTER 30: IMPLEMENTATION OF HIGH SPEED OF SILICON USING DIAMOND COATED TOOLS WITH AIR BLOWING</b>	<b>225</b>
31	<b>CHAPTER 31: ELIMINATION OF BURR FORMATION DURING END MILLING OF POLYMETHYL METHACRYLATE (PMMA) THROUGH HIGH SPEED MACHINING</b>	<b>233</b>
32	<b>CHAPTER 32: WEAR MECHANISMS IN END MILLING OF INCONEL 718</b>	<b>239</b>

<b>33</b>	<b>CHAPTER 33: PERFORMANCE OF UNCOATED WC-CO INSERTS IN END MILLING OF ALUMINUM SILICON CARBIDE (ALSiC)</b>	<b>247</b>
<b>34</b>	<b>CHAPTER 34: APPLICATION OF PCD INSERTS IN END MILLING OF ALUMINUM SILICON CARBIDE (ALSiC)</b>	<b>253</b>
<b>35</b>	<b>CHAPTER 35: EFFECTS OF SCRIBING WHEEL DIMENSIONS ON LCD GLASS CUTTING</b>	<b>259</b>

## **High Speed End Milling of Single Crystal Silicon using Diamond Coated Tool**

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### **1.0 INTRODUCTION**

Brittle materials are hard to machine while maintaining the surface roughness desired. A brittle material will have little tendency to deform before it fractures when it is subjected to stress. Brittle material is also consider as a material which fails in tension rather than shear and has little or no evidence of plastic deformation before it fails. Thimmaiah et al. [1] specified that brittle materials, silicon by their inherent properties, are difficult to machine while maintaining the desired surface roughness but J. Yan et al. [2] reviewed that silicon is a nominally brittle material that can be deformed plastically in machining, yielding ductile chips under the influence of high hydrostatic pressure. Mariayyah [3] , stated that under certain controlled conditions, it is possible to machine brittle materials in ductile regime so that material removal is by plastic deformation, leaving a damage free surface. Rusnaldy et al. [4] research on the cutting parameters effect. They study about the effect of the depth of cut, feed rate and spindle speed. Rusnaldy et al. [5] showed that the dominant ductile cutting mode was achieved for  $F_t/F_c > 1.0$ , which indicates that the thrust force is dominant over the cutting force. Cutting to a very small uncut chip thickness can cause ploughing, resulting in a poor surface due to high friction. Siva [6] proposes a predictive model to determine the undeformed chip thickness in micro-machining of single crystal brittle materials, where the mode of chip formation transitions from the ductile to the brittle regime. The proposed model would support the determination of the cutting conditions for the micro-machining of a brittle material in ductile manner without resorting to trial and error. Furthermore, Sreejith [7] was able to obtain ductile mode of machining on silicon nitride by using Poly Crystalline Cubic Diamond (PCD) tools. His findings show that there is a maximum value of rake angle which will obtain ductile mode machining. Thimmaiah et al. [1] also did machining on silicon nitride but performed it using single point diamond turning. Their result indicates that small values of feed, small tooltip radius and at high speeds; conditions of pressure and temperature exist that facilitate ductile behaviour during machining. Negative rake angles are more likely to cause brittle to ductile transition when compared with the positive or zero degree rakes. These findings also correspond with Thimmaiah et al. [1] findings which also show that cutting force and thrust force increases as the rake angle becomes negative. The experimentation results differ with a crossover at between thrust force and cutting force at  $-45^\circ$ . Furthermore, J. Yan et al (2000) stated that there is no inherent advantage in using rake angle more negative than  $-40^\circ$ .