
Contents

Preface	ix
Introduction	xi
Chapter 1. Cutting Forces in Milling Processes	1
1.1. Formulations of cutting forces	1
1.1.1. Mechanics of orthogonal cutting	1
1.1.2. Cutting force model for a general milling cutter	4
1.2. Milling process geometry	8
1.2.1. Calculations of uncut chip thickness	8
1.2.2. Determination of entry and exit angles	12
1.3. Identification of the cutting force coefficients	24
1.3.1. Calibration method for general end mills	24
1.3.2. Calibration method in the frequency domain	33
1.3.3. Calibration method involving four cutter runout parameters	39
1.3.4. Identification of shear stress, shear angle and friction angle using milling tests	48
1.4. Ternary cutting force model including bottom edge cutting effect	55
1.4.1. Calculations of $\mathbf{F}_B(\varphi)$	57
1.4.2. Calculations of $\mathbf{F}_B(\varphi)$	57
1.4.3. Calibration of K_{qc} ($q = T, R$)	58
1.4.4. Calibrations of $K_{q,B}$ ($q = T, R$)	59
1.4.5. Experimental work	61

1.5. Cutting force prediction in peripheral milling of a curved surface	61
1.5.1. Calculations of instantaneous uncut chip thickness	65
1.5.2. Calculations of entry and exit angles	67
Chapter 2. Surface Accuracy in Milling Processes	71
2.1. Predictions of surface form errors	71
2.1.1. Calculation of cutting forces and process geometries	73
2.1.2. Iterative algorithms of surface form errors	81
2.2. Control strategy of surface form error	89
2.2.1. Development of control strategy	89
2.2.2. Verification of control strategy	93
2.3. Surface topography in milling processes	95
2.3.1. Prediction method for flat-end milling	97
2.3.2. Prediction method for multi-axis ball end milling	101
Chapter 3. Dynamics of Milling Processes	115
3.1. Governing equation of the milling process	115
3.2. Method for obtaining the frequency response function	120
3.2.1. Derivation of calculation formulations	121
3.2.2. Identification of model parameters	134
3.3. Prediction of stability lobe	139
3.3.1. Improved semi-discretization method	139
3.3.2. Lowest envelope method	144
3.3.3. Time-domain simulation method	155
Chapter 4. Mathematical Modeling of the Workpiece-Fixture System	165
4.1. Criteria of locating scheme correctness	165
4.1.1. The DOFs constraining principle	165
4.1.2. The locating scheme	168
4.1.3. Judgment criteria of locating scheme correctness	172
4.1.4. Analysis of locating scheme incorrectness	173
4.2. Analysis of locating scheme correctness	175
4.2.1. Localization source errors	175
4.2.2. Fixture modeling	176
4.2.3. Locating scheme correctness	182
4.3. Analysis of workpiece stability	186

4.3.1. Modeling of workpiece stability	186
4.3.2. Solution techniques to the model of workpiece stability	194
4.4. Modeling of the workpiece-fixture geometric default and compliance	201
4.4.1. Source error analysis	201
4.4.2. Workpiece position error	207
4.4.3. Machining error analysis	212
4.5. Optimal design of the fixture clamping sequence	218
4.5.1. Effect of clamping sequence on high-stiffness workpiece	218
4.5.2. Effect of clamping sequence on low-stiffness workpiece	224
4.5.3. Optimization of clamping sequence	225
Bibliography	229
Index	245