

Coating Performance on Carbide Inserts

M. Narasimha, S. Ramesh

Abstract— For machining various materials for the multiple operations in order to produce components different types of cutting tools are in use. The manufacturers of these components desired to improve their productivity, quality of the components and longer life of the cutting tools. Similarly the customers also expect the quality and durability of the product at competitive price. The tool manufacturers also aims at producing quality tools to with stand for higher cutting forces, thermal resistivity with more wear resistance and to give longer life of the tool, to produce better surface finish product and maintain desired dimensional accuracies of the product. For the past several years the materials of the cutting tools are the same, but due to continuous improvements in enhancing the life of the cutting tools, different methods/process are in progress for producing the quality tools. The cutting tool manufacturers with their rich R&D experience and continuous innovations, carrying on their production activity to meet the challenges of the market demand. In this paper the analysis is made for the performance of various coated carbide inserts in machining the steel AISI 1018. In this review, the machining performance of coated tungsten based cemented carbide inserts, were investigated during finish turning of AISI 1018 steel under dry conditions. The coatings are of TiN, Al₂O₃TiN/Al₂O₃, TiC/Al₂O₃/TiN and nano composite coating respectively. For comparison, uncoated cemented tungsten carbides are also tested under the same cutting conditions. The performance of coated carbide inserts found to be better while compared to that of uncoated carbide inserts. The coated tools exhibited superior wear resistance over the uncoated tool. The TiC/Al₂O₃/TiN coated tool had the lowest flank wear. The Al₂O₃ coated tool showed superior wear-resistance over the TiN/Al₂O₃ coated tool. The TiN coated tool showed the least wear resistance with respect to the other coated tools. The coated tools produced lower surface roughness compared to the uncoated tool. The TiC/Al₂O₃/TiN coated tool produced the lowest surface roughness of all the tools tested.

Index Terms— Coated carbide insert, coating Materials and Steel AISI 1018.

I. INTRODUCTION

The manufacturing industry specially machine building and automobile sector is constantly striving to decrease its operation costs and increase the quality of the machined parts as the demand for high tolerance manufactured goods is rapidly increasing. The increasing need to boost productivity, to machine more difficult materials and to improve better quality in high volume by the manufacturing industry has been the driving force behind the development of cutting tool materials [1]. Cemented carbides are the most popular and most common high production tool materials available today

Manuscript received August 24, 2014.

M. Narasimha, PhD Scholar of Sri Venkateshwara University Meerut,
S. Ramesh, Department of Mechanical Engineering,
VeltechHightechDr RR Dr SR Engineering College, Avadi, Chennai -
600062.

[3]. The productivity enhancement of manufacturing processes is the acceleration of improved cutting tools with respect to the achievement of a superior tribological attainment and wear-resistance [4]. This resulted in developing hard coating for cutting tools; these hard coatings are thin films of one layer to hundreds of layers. These hard coatings have been proven to increase the tool life by as much as 10 folds through slowing down the wear phenomenon of the cutting tools. This increase in tool life allows for less frequent tool changes, therefore increasing the batch sizes that could be manufactured and in turn, not only reducing manufacturing cost, but also reducing the setup time as well as the setup cost. In addition to increasing the tool life, hard coating deposited on cutting tools allows for improved and more consistent surface roughness of the machined work piece. The majority of carbide cutting tools in use today employ chemical vapour deposition (CVD) or physical vapour deposition (PVD) hard coatings. The high hardness, wear resistance and chemical stability of these coatings offer proven benefits in terms of tool life and machining performance [5-6]. The first technique of CVD deposits thin films on the cutting tools through various chemical reactions and coatings were traditionally deposited using the CVD technique. Another technique is PVD. This method deposits thin films on the cutting tools through physical techniques, mainly sputtering and evaporation. Dry machining is desirable to avoid the extra costs and environmental problems associated to cutting fluids. High speed machining of hardened steel has the potential of giving sufficiently high quality of the machined surface to make finishing operations such as grinding and polishing unnecessary [10].

II. LITERATURE REVIEW

The literature included information on carbide cutting tools used in turning, coating materials for cutting tools, wear observed during turning operations and surface finish of the machined work piece. This information served as a guideline in the course of this study. The boost in wear resistance gave room for a significant increase in cutting speed and thereby improved productivity at the machine shop floor. And today, 70% of the cemented carbide tools used in the industry is coated [11]. Application of coatings on tools and machine elements is, therefore, a very efficient way of improving their friction and wear resistance properties [12]. The combined substrate-coating properties ultimately determine the important properties such as wear, abrasion resistance and adhesion strength of a coating. A hard wear resistant coating cannot perform well unless complimented by a hard and tough substrate. Thus, a hard coating deposited on a soft substrate leads to poor properties [9].

2.1. Wear

Wear is one of the most essential problems emerging in the design of cutting operations [13]. A useful definition for a worn out tool is: "A tool is considered to be worn out when the

replacement cost is less than the cost for not replacing the tool” [14]. Tool failure is said to occur when the tool no longer performs the desired function whereas total failure (ultimate failure) is defined as the complete removal of the cutting edge, a condition obtaining when catastrophic failure occurs [15]. Therefore, in machining operations, tools are considered to be worn out and are changed long before total failures to avoid incurring high costs associated with such catastrophic failures.

Some of the tool life rejection criteria presented in ISO 3685 is listed below [16]:

1. Average flank wear = 0.4 mm
2. Maximum flank wear = 0.6 mm
3. Notching = 1.0 mm
4. Nose wear = 0.5 mm
5. Surface roughness (Ra) = 6.0 μm .

Flank wear is observed on the flank or clearance face of a metal cutting insert and is caused mainly by abrasion of the flank face by the hard constituents of the work piece [17]. This failure mechanism is commonly observed during machining of cast irons and steels where the abrasive particles are mainly Fe₃C and non-metallic inclusions [9]. Crater wear is observed on the rake face of cutting tools and is caused by chemical interactions between the rake face of a metal cutting insert and the hot metal chip flowing over the tool. Depth of cut notching is attributed to the oxidation of the tool material. Nose wear or tool tip blunting results from insufficient deformation resistance of the tool material [9].

Machining of metals is a complex process. The cutting tool environment features high-localized temperatures (~1000 °C) and high stress (~700 MPa). The tool may experience repeated impact loads during interrupted cuts, and the work piece chips may chemically interact with the tool materials. The useful life of a cutting tool may be limited by a variety of wear processes such as crater wear, flank wear or abrasive wear, built up edge, depth of cut notching and nose wear [9]. The wear zones are characterized by the type of wear that occurs on the tip of the tool and around the cutting edge. The main types of wear on a carbide-cutting tool are shown in Figure 2-1.

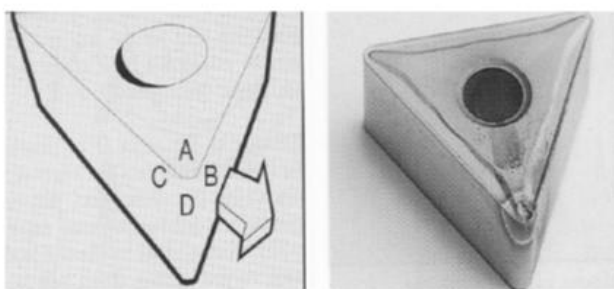


Fig. 2-1. Wear zones on the cutting tool caused by chip formation

Cemented carbide tools worn off by dissolution/diffusion exhibit smoothly worn through carbide grains [18, 19, 23]. In many previous studies, a very smooth surface at the worn flank face possessing voids between carbide grain boundaries was observed on a carbide insert. This smoothly worn surface topography is a characteristic of dissolution/diffusion wear. Inter-diffusion between cobalt in the tool and iron in the steel and decarburization of the tool has been reported as the major diffusion reactions that occur [24, 25]. According to Jiang and Xu [26], the tool wear process can be divided into five stages: initial stage of wear, regular stage of wear, micro breakage

stage, and fast wear stage and tool breakage. Other studies have divided the tool wear process into three stages in which rapid flank wear occurred at the beginning of machining at cutting speeds of 200-250 m/min, followed by a gradual and steady wear growth, and finally by an accelerated wear towards the point of tool rejection [27].

2.2. Coating

The machining of hard and chemically reactive materials at higher speeds is improved by depositing single and multi-layer coatings on conventional tool materials to combine the beneficial properties of ceramics and traditional tool materials [21]. Schintlmeister et al. [28] had summarized the effect of coatings in the following statements:

1. Reduction in friction, in generation heat, and in cutting forces
2. Reduction in the diffusion between the chip and the surface of the tool, especially at higher speeds (the coating acts as a diffusion barrier)
3. Prevention of galling, especially at lower cutting speeds.

2.3. Coating Materials

At present various metal cutting operations are being performed using cemented carbide tools coated with a material consisting of nitrides (TiN, CrN, etc.), carbides (TiC, CrC, W₂C, WC/C, etc.), oxides (e.g. alumina) or combinations of these [10,21] and nano composite materials(ZTA). Coating cemented carbide with TiC, TiN and Al₂O₃ dramatically reduces the rate of flank wear [19] High hardness is beneficial in resisting the abrasive wear. Retention of hardness even at higher temperatures is very important since the tool bit experiences a temperature in the range of 300-1000°C depending on the machining parameters and the materials to be machined [9]. Micro hardness values of different coatings measured at different temperatures are shown in Figure 2.3 They all exhibit a decrease with an increase of temperature, and the decrease of hardness was much more pronounced in the case of TiC. Interestingly, the micro hardness of Al₂O₃ was significantly lower than TiC at room temperature but retained almost 40 % of its room temperature hardness at 1000 °C

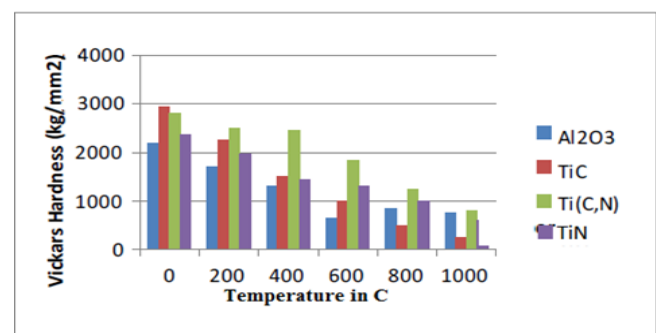


Figure 2.3 Temperature dependence of micro hardness [17, 29].

Coating with three layers of TiC-Al₂O₃-TiN as seen from the substrate are widely used for machining of many types of steels [10]. This type of coating improves the wear resistance of the tool by combining the properties of the three materials. The ranking of the solubility products and limits of TiC, TiN and Al₂O₃ in iron, compared to the carbide substrate, is in the order TiC>TiN> Al₂O₃ [19]. Therefore there is less driving force for significant dissolution-diffusion wear of Al₂O₃ to take place. Thus, having a coating layer of

Al₂O₃ over an under layer of TiC help decrease the dissolution/diffusion wear at the TiC coating layer. This enhances the performance of the cutting tool, by including the TiC layer with a low wear rate and protecting it with a layer of Al₂O₃ to decrease the effect of diffusion/dissolution wear. The softer TiN outer layer helps in reducing the propagation of cracks into the inner coating layers, in addition to decreasing the welding of the chips to the cutting tool. Another reason for having the TiN as an outer layer, as opposed to inner layer, is that at higher temperatures of oxidation, the growth of TiO₂ (rutile) under layer may affect the performance of the protective alumina over layer of the oxide [9].

2.4. Surface Finish

Surface roughness and tolerance are among the most critical quality measures in many mechanical products. As competition grows closer, customers now have increasingly high demands on quality, making surface roughness become one of the most competitive dimensions in today's manufacturing industry [29].

There are several measurements that describe the roughness of a machined surface. One of the most common is the arithmetic average (AA) value usually known as Ra. [32]. The AA value is obtained by measuring the height and depth of the valleys on a surface with respect to an average centerline. The higher the AA value is, the rougher the machined surface. Figure 2.4 shows a magnified cross section of a typical machined surface.

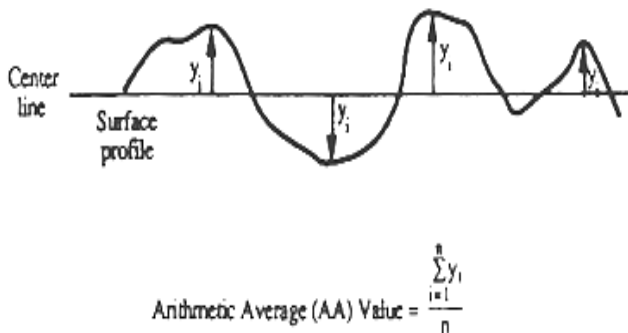


Figure 2.4 Illustration of surface roughness [30]

Factors influence the formation of surface roughness in the turning process. These factors include chip deformation and side flow, vibration of the machine-tool fixture work piece system, geometrical contribution of the feed and tool nose radius. Classical surface roughness related equations calculate geometrical contribution:

$$h \approx f^2 / 8R, \quad h_{CLA} \approx f^2 / 18\sqrt{3}R$$

Where h is the peak to valley height, h_{CLA} the centre line average roughness, f the feed and R the nose radius. This show that surface roughness is primarily dependent on feed rate and tool nose radius. However, the above equations give ideal surface finish values under satisfactory cutting conditions [32].

The tool wear influences the surface roughness of the work piece and the value of surface roughness is one of the main parameters used to establish the moment to change the tool in finish turning [20]. Carbide tool wear may occur by the mechanical detachment of relatively large fragments of tool material (attrition wear). This causes the surface roughness to increase significantly and promote the formation of ridges [19, 23].

The geometry of tool wear also causes a change in surface roughness as machining time elapses. Flank wear is along with groove wear are the types of wear that most influence this change in surface roughness [33]. Some studies have claimed that the change in surface roughness is primarily caused by cutting-tool flank wear [31].

2.5. Work-piece Material

The cutting performance tests were performed on AISI 1018 cold rolled steel. The work piece material used was 1.5 inch in diameter and 20 feet long. However, in order to meet the requirement of the ISO 3685 [17] that the length/diameter ratio of the work piece material to be used should be less than 10 during testing.

III. RESULTS AND ANALYSIS

Results for the performance of the five different coated cutting tools in turning and the uncoated cutting tool in turning AISI 1018 steel. The results for the flank wear of the uncoated tool and the surface roughness of the machined work-piece are first presented. The results of the other coated tools are then shown and are compared to those obtained using the uncoated tool in order to obtain the effectiveness of the different coatings on the flank wear and the surface roughness. The flank-wear and the obtained surface roughness results for each of the coated tools are then compared in order to confirm the machining performance rankings of the different coatings considered.

3.1. Wear of TiN Coated vs. Uncoated Tool

To compare the performance of the TiN coating, the flank wear of the TiN coated tool was compared with the flank wear of the uncoated tool. Table .1 shows the SAS output for the regression of flank-wear on the number of cuts for both TiN coated and the uncoated tools. A null hypothesis (H₀) that the TiN coating has no effect on the flank wear and an alternative hypothesis (H_a) that the TiN coating has an effect on flank-wear were used. Again using a α -value of 0.05, the null hypothesis is rejected in favor of the alternative hypothesis since the P value for this regression is <0.0001. And so it can be concluded that the TiN coating has a significant effect on tool flank wear for the TiN coated tool.

Table.1 Regression of flank wear on the type of coating for TiN and uncoated.

The SAS system					
The REG procedure					
Dependant variable: wear					
Analysis of variance					
Source	DF	Sum of square	Mean Square	F value	Pr>F
Model	2	0.21497	0.10749	128.58	<0.0001
Error	37	0.03093	0.00083597		
Corrected total	39	0.24591			
Root MSE	0.02891				
Dependant t mean	0.33069	Root square	0.8742		
Coeff. Variant	8.74340	Adj. R. Sq.	0.8674		

The uncoated tool exhibited the largest wear within the 60 cuts machined in the test. All the coated tools were observed to have better wear resistance than the uncoated tool as expected. The TiN coated tool showed a slight improvement compared to the uncoated tool. The TiN/Al₂O₃ had the third highest flank wear. The improvement of the wear resistance compared to the TiN coating was due to the addition of the Al₂O₃ layer. This layer protected the TiN coating. However, the Al₂O₃ coating had the second highest flank wear resistance and showed an improvement in wear resistance as compared to TiN/Al₂O₃. Hence, using one layer of Al₂O₃ appears to have better wear resistance to flank wear as compared to using 2 layers of coating with TiN interlayer and Al₂O₃ outer layer. The TiC/Al₂O₃/TiN coated tool appeared to have the best wear resistance under the testing conditions used. This was as expected since the combination of TiC with high abrasive resistance, chemically stable Al₂O₃ with low thermal conductivity and the added wear resistance of the TiN coating improved the overall wear resistance of the cutting tool. The photographs of the flank face for each of the machined tools are shown in Figure 4. The flank-wear on the uncoated and TiN coated tool can be easily seen. The lower flank-wear on the TiN/Al₂O₃, Al₂O₃ and TiC/Al₂O₃/TiN coated tools displays their higher wear resistance performance.

The machined part surface roughness appeared to decrease with the addition of a coating layer for all cases except the TiN/Al₂O₃, in which the addition of this coating tended to increase the value of the surface roughness compared to that obtained using the uncoated tool.

The flank wear for the five different types of cutting tools tested are shown in Figure 2-4. The uncoated tool exhibited the largest wear within the 60 cuts machined in the test. All the coated tools were observed to have better wear resistance than the uncoated tool as expected.

The TiN coated tool showed a slight improvement compared to the uncoated tool. The TiN/Al₂O₃ had the third highest flank wear. The improvement of the wear resistance compared to the TiN coating was due to the addition of the Al₂O₃ layer. This layer protected the TiN coating.

However, the Al₂O₃ coating had the second highest flank wear resistance and showed an improvement in wear resistance as compared to TiN/Al₂O₃. Hence, using one layer of Al₂O₃ appears to have better wear resistance to flank wear as compared to using 2 layers of coating with TiN interlayer and Al₂O₃ outer layer. The TiC/Al₂O₃/TiN coated tool appeared to have the best wear resistance under the testing conditions used. This was as expected since the combination of TiC with high abrasive resistance, chemically stable Al₂O₃ with low thermal conductivity and the added wear resistance of the TiN coating improved the overall wear resistance of the cutting tool.

The photographs of the flank face for each of the machined tools are shown in Figure 3-1. The flank-wear on the uncoated and TiN coated tool can be easily seen. The lower flank-wear on the TiN/Al₂O₃, Al₂O₃ and TiC/Al₂O₃/TiN coated tools displays their higher wear resistance performance.

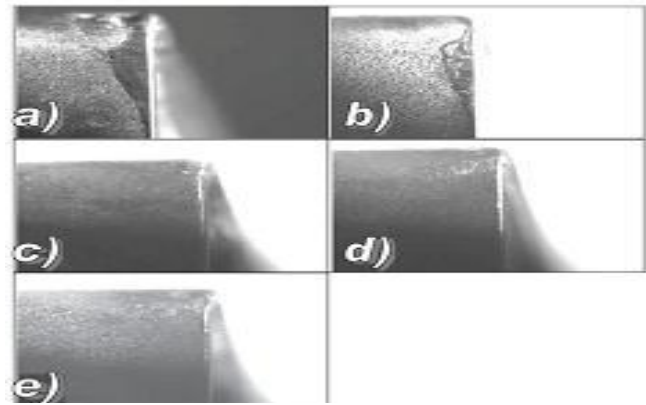


Figure 3-1 Photographs of the final flank wear for a) uncoated tool, b) TiN coated tool, c) TiN/Al₂O₃ coated tool, d) Al₂O₃ coated tool and e) TiC/Al₂O₃/TiN coated tool

IV. CONCLUSIONS

The machining performance of five cutting tool inserts in turning AISI 1018 steel, Uncoated, TiN coated, TiN/Al₂O₃ coated, Al₂O₃ coated and TiC/Al₂O₃/TiN coated tools were examined and their flank wear and the resultant machined work piece surface finish were analysed. The tool coatings were found to improve upon the wear resistance of the cutting tool. This was shown by the decrease in wear on the flank face of the coated tools compared to that of the uncoated tool. The wear of the TiN coated tool was around 12% lower than the wear observed on the uncoated tool. TiN/Al₂O₃ coated tool showed a decrease of around 65% compared to the uncoated tool. The Al₂O₃ coated tool showed a decrease of around 92% compared to the uncoated tool. The TiC/Al₂O₃/TiN coated tool appeared to have the lowest wear of all the tools tested, and showed a decrease of around 96% in wear compared to the uncoated tool. In the case of the machined surface roughness, all the coated tools produced lower surface roughness than that produced by the uncoated tool except for the TiN/Al₂O₃ coated tool. This was believed to be due to factors other than the coating material and mainly the different chip breaker geometry on the tool which produced longer chips that got in contact with the work piece material and increased its surface roughness. The TiC/Al₂O₃/TiN coated tool produced the lowest average surface roughness during the 60 cuts with a decrease of around 38% compared to the uncoated tool. The Al₂O₃ coated tool produced the second lowest average surface roughness with a decrease of around 23% compared to the uncoated.

The TiN coated tool produced the third lowest average surface roughness with a decrease of around 7%. While on the other hand, the TiN/Al₂O₃ coated tool produced the highest average surface roughness with an increase of around 21%. (TiAlCrYN) nano composite material coated turning tool insert exhibits higher hardness, superior wear resistance and higher fracture toughness when compared with the uncoated and TiN coated insert. (36). This research may be extended to study the effects of multi-layer coatings on cutting tool performance. Multi layers are composed of alternating layers of two different materials that can vary in number from few up to tens of thousands. Multi layers are believed to offer very high strength, hardness, heat resistance, and many new properties that could greatly enhance the performance of the cutting tools..

REFERENCES

- [1] Wallbank, J., Development in tool materials, Proceedings of the Second International Conference on Behaviour of Materials in Machining, York, UK, November 14-15, 1991.
- [2] Smith, G. T., Advanced Machining: The Handbook of Cutting Technology, IFSPublications, 1989.
- [3] Metals Handbook, Machining, Vol. 7, 9th Edition, ASM, USA, 1980, pp. 773-783.
- [4] Bouzakis, K. D., Michailidis, N., Vidakis, N., Eftathiou, K., Kompogiannis, S., Erkens, G., Interpretation of PVD Coated Inserts Wear Phenomena in Turning, Annals of the CIRP 49 (2000) 65-68.
- [5] Lux, B., Columbiere, C., Atena, H., Stemberg, K., Preparation of Alumina Coatings by Chemical Vapor Deposition, Thin Solid Films 138 (1986) 49-64.
- [6] Prengel, H. G., Pfouts, W. R., Santhanam, A. T., State of the art in hard coatings for carbide cutting tools, Surface &
- [7] Coatings Technology 102 (1998) 183-190.
- [8] Haron, C. H., Ginting, A., Goh, J. H., Wear of coated and uncoated carbides in turning tool steel, Journal of materials processing technology 116 (2001) 49-54.
- [9] Wright, P. K., Bagchi, A., Horne, J. G., Identification of the dominant wear mechanism in specific tool-work systems, Proceedings of the International Conference on Cutting Tool Materials, Ohio, 1980 pp. 7-23.
- [10] PalDey, S., Deevi, S. C., Single layer and multilayer wear resistant coatings of (Ti,Al)N: A review, Materials Science and Engineering 342 (2003) 58-79.
- [11] Armarego, E. J. A., Verezub, S., Samaranyake, P., The effect of coatings on the cutting process, friction, forces and predictive cutting models in machining operations, Proceedings of the Institution of Mechanical Engineers, Part B: Journal of Engineering Manufacture 216 (2002) 347-356.
- [12] Abdullah, A., Machining of aluminium based metal matrix composite (MMC), Ph.D. Thesis, University of Warwick, Warwick, UK, 1996.
- [13] Hogmark, S., Jacobson, S., Larsson, M., Design and evaluation of tribological coatings, Wear 246 (2000) 20-33.
- [14] Holmberg, K., Matthews, A., Ronkainen, H., Coatings tribology - contact mechanisms and surface design, Tribology International 31 (1998) 107-120.
- [15] Carlsson, T. E., Strand, F., Lindstrom, B., Statistical model for prediction of tool life as a basis for economical optimization of the cutting process, CIRP Annals 41 (1992) 79-82.
- [16] Armarego, E. J. A., Brown, R. H., The machining of metals, Prentice-Hall Inc., 1965.
- [17] ISO, ISO 3685 - Tool life testing with single point turning tools, 2nd Edition (1993).
- [18] Santhanam, A. T., Quinto, D. T., ASM Handbook, Surface Engineering, vol. 5, ASM International, Materials Park, OH, 1994, pp. 900-908.
- [19] Chubb, J. P., Billingham, J., Coated cutting tools - a study of wear mechanism in high speed machining, Wear 61 (1980) 283-293.
- [20] Dearnley, P. A., Rake and flank wear mechanisms of coated and uncoated cemented carbides, Journal of Engineering Materials and Technology, 107 (1985) 68-82.
- [21] Bonifacio, M. E. R., Diniz, A. E., Correlating tool wear tool life, surface roughness and tool vibration in finish turning with coated carbide tools, Wear 173 (1994) 137-144.
- [22] Cho, S. S., Komvopoulos, K., Wear Mechanisms of Multi-Layer Coated Cemented Carbide Cutting Tools, Journal of Tribology 119 (1997) 8-17.
- [23] Dearnley, P. A., Trent, E. M., Wear mechanisms of coated carbide tools, Metals Technology 9 (1982) 60-75.
- [24] Trent, E. M., Cutting steel and iron with cemented carbide tools, Journal of the Iron and Steel Institute 201 (1963) 847-855.
- [25] Naerheim, Y., Trent, E. M., Diffusion wear of cemented carbide tools when cutting steel at high speeds, Metals Technology 4 (1977) 548-556.
- [26] Narutaki, N., Yamane, Y., Wear mechanism of carbide tool based on the reaction between tool and work material, Bulletin of the Japan Society of Precision Engineering 10 (1976) 95-100.
- [27] Jiang, Y. C., Xu, J. H., In-process monitoring of tool wear stage by the frequency band energy method, CIRP Annals 36 (1987) 45-48.
- [28] Ezugwu, E. O., Olajire, K. A., Jawaid, A., Wear Performance of multiplayer coated carbide tools, Machining Science and Technology 5(1) (2001) 115-129.
- [29] Schintlmeister, W., Wallgram, W., Kanz, J., Gigl, K., Cutting tool materials coated by chemical vapor deposition, Wear 100 (1989) 153-169.
- [30] Jindal, P. C., Santhanam, A. T., Schleincofer, U., Shuster, A. F., Performance of PVD TiN, TiC, and TiAlN coated cemented carbide tools in turning, International Journal of Refractory Metals & Hard Materials 17 (1999) 163-170.
- [31] Feng, C. X., An experimental study of the impact of turning parameters on surface roughness, Proceedings of the 2001 Industrial Engineering Research Conference, Paper No. 2036.
- [32] Yang, K., Jeang, A., Statistical surface roughness checking procedure based on a cutting tool wear model, Journal of Manufacturing Systems 13 (1994) 1-8.
- [33] DeGarmo, E. P., Black, J. T., Kohser, R. A., Materials and Processes in Manufacturing, Macmillan Publishing Co., New York, 1988.
- [34] Noordin, M. Y., Venkatesh, V. C., Chan, C. L., Abdullah, A., Performance Evaluation of Cemented Carbide Tools in Turning AISI 1010 steel, Journal of Materials Processing Technology 116 (2001) 16-21.
- [35] Luk, W. K., Scrutton, R. F., The origin of groove wear in the turning operation, International Journal of Production Research 6(1968) 197-206.
- [36] Sundaram, R. M., Lambert, B. K., Surface roughness variability of AISI 4140 steel in fine turning using carbide tools, International Journal of Production Research 17 (1979) 249-258.

Authors Biography



M. Narasimha, Received his B.Tech. Degree in Mechanical Engineering from JNTU, HYDERABAD. He received M.E. Degree from VMU, TAMILNADU. Currently PhD Scholar of Sri Venkateshwara University Meerut.



S. Ramesh, Department of Mechanical Engineering, Veltech Hightech Dr RR Dr SR Engineering College, Avadi, Chennai - 600062