

LIST OF FIGURES

		Pages
Fig.1.1	Pattern of variation of contact stresses at chip /tool interface	12
Fig.1.2(a)	Shear plane model	17
Fig.1.2(b)	Velocity field	17
Fig.1.3	Lee-Shaffer model	17
Fig.1.4	Kudo's field I	17
Fig.1.5	Kudo's field II	17
Fig.1.6	Dewhurst's field	17
Fig.2.1	Physical plane showing stress system in plane plastic flow	27
Fig.2.2	A slipline field net for demonstrating Hencky's theorems	27
Fig.2.3	A slipline net	29
Fig.2.4	A slipline net for demonstrating super position principle	29
Fig.2.5	A slipline field net for series representation of radius of curvature	33
Fig.2.6	Calculation of coordinates, traction and moment	33

Fig.2.7	A slipline field net for matrix representation of slipline curves	39
Fig.2.8	Matrix operators generating singular field on the convex side of a slipline curve	39
Fig.2.9	Shifting the origin of a slipline curve	43
Fig.2.10	Field construction using smooth boundary operators	43
Fig.2.11	Sliplines adjacent to a straight rough boundary	44
Fig.2.12	Sliplines adjacent to a curved boundary	44
Fig. 3.1(a)	Slipline field	49
Fig.3.1(b)	Hodograph for slipline field in Fig.3.1(a) Solution - I	49
Fig.3.2(a)	Slipline field	50
Fig.3.2(b)	Hodograph for slipline field in fig.3.2(a) Solution - II	50
Fig.3.2(c)	Angular coordinates of slipline fields	51
Fig.3.3(a)	Range of validity of slipline field in Fig.3.1(a)	62
Fig.3.3(b)	Range of validity of slipline field in Fig.3.2(a)	62
Fig.3.4	Variation of non-dimensionalized cutting force with γ_0 and μ	64
Fig.3.5	Variation of non-dimensionalized thrust force with γ_0 and μ	65
Fig.3.6	Variation of curvature of the machined chip with γ_0 and μ	66
Fig.3.7	Variation of the cutting ratio with γ_0 and μ	67
Fig.3.8	Variation of l_t / t_0 , l_s / t_0 and l_s / l_t with γ_0 and μ	68

Fig.3.9	Variation of σ_n and τ at the chip-tool interface	70
Fig.3.10(a)	Slipline field of solution I (Fig.3.1(a))	73
Fig.3.10(b)	Hodograph for slipline field in Fig.3.10(a)	73
Fig.3.11(a)	Slipline field solution I (Fig.3.1(a))	74
Fig.3.11(b)	Hodograph for slipline field in Fig.3.11(a)	75
Fig.3.12(a)	Slipline field solution II (Fig.3.2(a))	76
Fig.3.12(b)	Hodograph for slipline field (Fig.3.12(a))	77
Fig.3.13(a)	Slipline field solution II (Fig.3.12(a))	78
Fig.3.13(b)	Hodograph for slipline field (Fig.3.13(a))	79
Fig.4.1(a)	Slipline field - I	83
Fig.4.1(b)	Hodograph Solution-I	83
Fig.4.2(a)	Slipline field - II	84
Fig.4.2(b)	Hodograph Solution-II	84
Fig.4.3	Variation of machining parameters with field angle η for solution-I (Fig.4.1).	90
Fig.4.4	Variation of machining parameters with field angle η for solution-II (Fig.4.2)	91
Fig.4.5	Variation of natural and elastic contact length with rake angle for solution-I	92

Fig.4.6	Variation of natural and elastic contact length with rake angle for solution-I	94
Fig.4.7	Variation of natural and elastic contact length with rake angl for solution-II	95
Fig.4.8	Variation of natural and elastic contact length with rake angle for solution-II	96
Fig.4.9	Variation of natural and elastic contact length with rake angle for solution-II	97
Fig.4.10	Comparison of contact length between exponential and parabolic stress distribution for solution-I	98
Fig.4.11	Comparison of contact length between solution-I and solution-II	100
Fig.4.12	Variation of natural contact with rake angle and friction factor m	101
Fig.4.13	Variation of interface contact stress (solution-I)	102
Fig.4.14	Variation of interface contact stress (solution-I)	103
Fig.4.15	Variation of interface contact stress (solution -II)	104
Fig.4.16	Variation of interface contact stress (solution - II)	105
Fig.4.17(a)	Slipline field solution I (Fig.4.1(a))	108
Fig.4.17(b)	Hodograph	108
Fig.4.18(a)	Slipline field solution I (Fig.4.1(a))	109

Fig.4.18(b)	Hodograph	109
Fig.4.19(a)	Slipline field solution II (Fig.4.2(a))	110
Fig.4.19(b)	Hodograph for slipline field in Fig.4.19(a)	111
Fig.4.20(a)	Slipline field solution II (Fig.4.2(a))	112
Fig.4.20(b)	Hodograph	113
Fig. 5.1(a)	Slipline field	117
Fig.5.1(b)	Hodograph Solution- I	117
Fig.5.2(a)	Slipline field	121
Fig.5.2(b)	Hodograph Solution- II	121
Fig.5.3(a)	Slipline field	126
Fig. 5.3(b)	Hodograph Solution III	126
Fig. 5.4	Variation of machining parameters with η for solution-I (Fig.5.1)	128
Fig.5.5	Variation of machining parameters with ψ for solution -II (Fig.5.2)	129
Fig.5.6	Variation of machining parameters with ψ for solution - II (Fig.5.2)	130
Fig.5.7	Variation of machining parameters with ψ for solution - III (Fig.5.3)	131
Fig.5.8	Variation of machining parameters with ψ for solution III (Fig.5.3)	132
Fig.5.9	Variation of contact length with tool rake angle Γ (Solution II, Fig.5.2)	133

Fig.5.10	Variation of contact length with tool rake angle (Solution -III, Fig.5.3)	135
Fig.5.11	Dependence of contact length on the nature of stress distribution in the elastic zone (Solution-III).	136
Fig.5.12	Variation of sticking ratio and plastic contact ratio with rake angle (Solution II & III)	137
Fig.5.13	Variation of interface contact stress (Solution II, Fig.5.2)	138
Fig.5.14	Variation of interface contact stress (Solution II, Fig.5.2)	139
Fig.5.15	Variation of interface contact stress (Solution III, Fig.5.3)	140
Fig.5.16	Variation of interface contact stress (Solution III, Fig.5.3)	141
Fig.5.17	Variation of interface contact stress (Solution III, Fig.5.3)	142
Fig. 5.18	Variation of Interface Contact Stress (Solution III, Fig.5.3)	143
Fig.5.19(a)	Slipline field solution - I (Fig.5.1(a))	146
Fig.5.19(b)	Hodograph for slipline field (Fig.5.19(a))	147
Fig.5.20(a)	Slipline field solution -I (Fig.5.1(a))	148
Fig.5.20(b)	Hodograph for slipline field (Fig.5.20(a))	149
Fig.5.21(a)	Slipline field solution II(Fig.5.2(a))	150

Fig.5.21(b)	Hodograph for slipline field solution II (Fig.5.21(a))	151
Fig.5.22(a)	Slipline field solution II (Fig.5.2(a))	152
Fig.5.22(b)	Hodograph for slipline field (Fig.5.22(a))	153
Fig.5.23(a)	Slipline field solution III (Fig.5.3(a))	154
Fig.5.23(b)	Hodograph for slipline field (Fig.23(a))	155
Fig.5.24(a)	Slipline field solution III (Fig.5.3(a))	156
Fig.5.24(b)	Hodograph for slipline field (Fig.5.24(a))	157
Fig.6.1(a)	Slipline field	161
Fig.6.1(b)	Hodograph - Solution I	161
Fig.6.2(a)	Slipline field	162
Fig.6.2(b)	Hodograph - Solution II	162
Fig.6.3(a)	Range of validity of solution - I (Fig.6.1)	164
Fig.6.3(b)	Range of validity of solution-II (Fig.6.2)	164
Fig.6.4	Variation of non-dimensionlized F_C with γ_0 and μ	166
Fig. 6.5	Variation of non-dimensionlized F_T with γ_0 and μ	167
Fig.6.6	Variation of the cutting ratio with γ_0 and μ	168
Fig.6.7	Variation of curvature of the machined chip with γ_0 and μ	169
Fig.6.8	Comparison of machining parameters between the solutions with and without elastic contact	170

Fig.6.9	Variation of F_{CE} / F_C with Rake angle	171
Fig.6.10	Variation of contact length with rake angle	172
Fig.6.11	Variation of interface contact stress (solution - I and solution - II)	173
Fig.6.12(a)	Variation of interface contact stress (solution II)	174
Fig.6.12(b)	Variation of interface contact stress (solution II)	174
Fig.7.1(a)	Slipline field for a cutting tool with step-type chip-breaker	179
Fig.7.1(b)	Hodograph for slipline field in Fig.7.1(a)	180
Fig.7.2	Variation of mean radius of curvature with chip-breaker position	186
Fig.7.3	Variation of the mean and the outer radius of curvature of chip with chip-thickness	188
Fig.7.4	Variation of machining parameters with chip-breaker position	189
Fig.7.5	Variation of radius of curvature of chip and chip-breaker force with chip-breaker position	190
Fig. 7.6	Variation of interface contact stress	191
Fig.8.1	Experimental setup for measuring cutting tests	199
Fig.8.2	Experimental set-up for measuring contact length	199
Fig.8.3	Cutting tools used in the experiment	200
Fig.8.4	Chip samples	200

Fig.8.5	Variation of cutting force with feed (aluminium)	201
Fig.8.6	Variation of thrust force with feed (aluminium)	201
Fig.8.7	Variation of average shear angle with feed(aluminium)	202
Fig.8.8	Variation of cutting ratio with feed (aluminium)	202
Fig.8.9	Variation of machining parameters with feed (mild steel)	203
Fig.8.10	Variation of machining parameters with feed (mild steel)	204
Fig. 8.11	Comparison between experimental and computed results of cutting force	205
Fig.8.12	Comparison between experimental and computed results of thrust force	207
Fig.8.13	Comparison between experimental and computed results of cutting ratio	208
Fig.8.14	Comparison between experimental and computed results of contact length	209
FigB1	Construction for determining radius of curvature of chip and moment arm d	227
Table1.1	Summary of some experimental data on contact stress distribution	11