

How-to

## General Machining Guidelines

Brought To You by Kennametal | Dec 29, 2017

Kennametal insert technology brings chip control to your threading operations with the Top Notch™ platform. The proprietary Kennametal recessed chip groove, when used according to our recommendations, controls the chip in most applications. The Kennametal positive rake design lowers cutting pressures, which in turn lowers damaging heat generation thus providing better tool life. Long, stringy chips no longer mar the workpiece surface finish. The danger to operators when removing long chips from the workpiece and chuck is eliminated. All of these benefits combine to improve the productivity of your threading operations.

### The Last Pass

Some CNC controls require the last pass to be at a 0° infeed angle because the chip will not break on the last pass. On most carbon and alloy steels, the last pass can remain at .005" (0,127mm) depth of cut and produce an acceptable finish. For some materials, a .001" (0,025mm) to .003" (0,076mm) (spring) pass may be used to improve surface finish, however, chipbreaking action may be compromised.

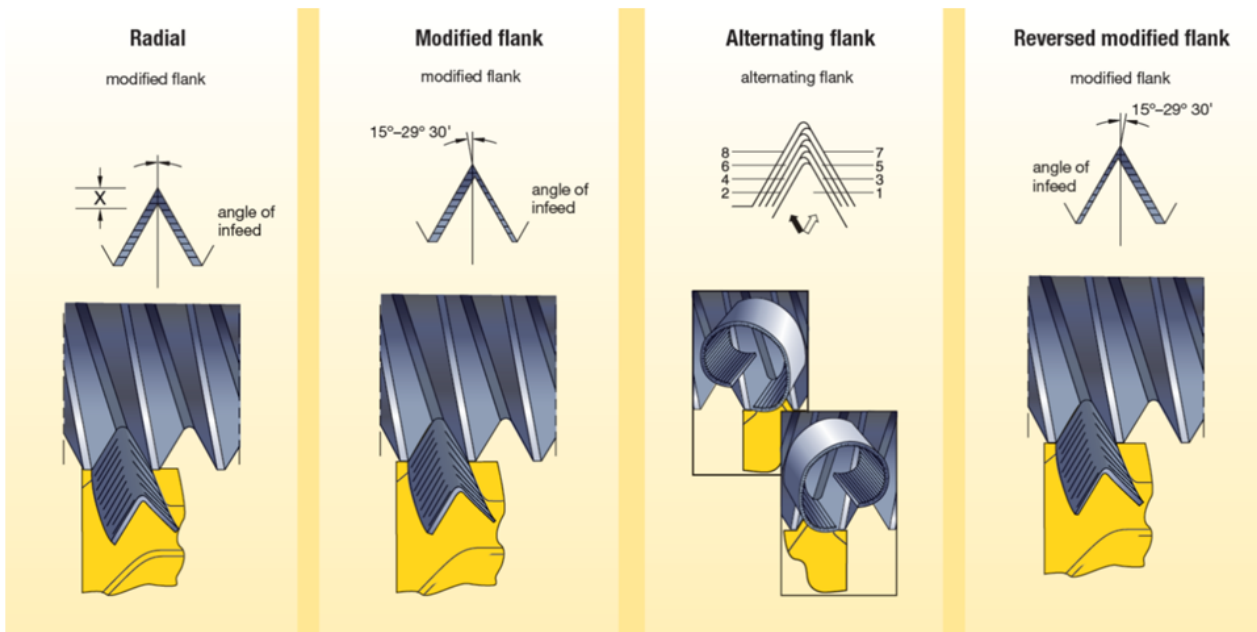
### Machine Programming

Modern CNC controls allow the programmer to easily adjust infeed angle, the number of passes, and depth of cut for each pass. The chip control threading insert performs best at an infeed angle of 29° 30', although 15° to 30° is acceptable. Also, it is important to maintain a minimum of .005" (0,127mm) depth of cut on every pass. In most applications, use of CNC canned cycles produce only marginally successful results. Custom written programs are better and are recommended.

### Infeed Angle

In order to effectively and consistently break the chip, it is important to use an infeed angle between 28° and 29° 30'. Do not apply chip control inserts at infeed angles less than 15°.

Below are the advantages and disadvantages of the different infeed angles.



Radial	Modified flank	Alternating flank	Reversed modified flank
<p><b>Advantage —</b></p> <ul style="list-style-type: none"> <li>• Cutting on both sides of the thread form places all of the cutting edge in the cut and protects edge from chipping.</li> <li>• Even wear on the insert.</li> </ul>	<p><b>Advantage —</b></p> <ul style="list-style-type: none"> <li>• Tool cuts both sides of thread form, so it is protected from chipping similar to 0° infeed. Channel-type chip develops, but uneven chip thickness helps remove the chip similar to flank infeed.</li> <li>• This is the preferred method, especially when used with a chip control insert.</li> <li>• Combined radial and/or alternating flank infeed.</li> <li>• Results in good tool life, with wear evenly distributed over both flanks.</li> </ul>	<p><b>Advantage —</b></p> <ul style="list-style-type: none"> <li>• Increased tool life because both edges are used equally.</li> </ul> <p>NOTE: Some machine tools may require special programming techniques to achieve this method of infeed.</p>	<p><b>Advantage —</b></p> <ul style="list-style-type: none"> <li>• Tool cuts both sides of thread form, so it is protected from chipping similar to 0° infeed. Channel-type chip develops, but uneven chip thickness helps remove the chip similar to flank infeed.</li> <li>• This is the preferred method, especially when used with a chip control insert.</li> <li>• Combined radial and/or alternating flank infeed.</li> <li>• Results in good tool life, with wear evenly distributed over both flanks.</li> <li>• As chip flow is the reversed feed direction, it is an excellent choice for internal threading.</li> </ul>
<p><b>Disadvantage —</b></p> <ul style="list-style-type: none"> <li>• Tool develops a channel chip that may be difficult to handle.</li> <li>• Tip chipping occurs when cutting high-tensile materials.</li> <li>• Bur condition is increased.</li> <li>• Entire cutting edge is engaged at finish of thread, causing increased tendency to chatter.</li> </ul>	<p><b>Disadvantage —</b></p> <ul style="list-style-type: none"> <li>• Similar disadvantages as with 0° infeed, although reduced somewhat in magnitude as cutting forces are better equalized and chip flow is much less of a problem.</li> </ul>	<p><b>Disadvantage —</b></p> <ul style="list-style-type: none"> <li>• Difficult to cut on conventional machinery.</li> </ul>	<p><b>Disadvantage —</b></p> <ul style="list-style-type: none"> <li>• Programming needs to be done line by line.</li> </ul>