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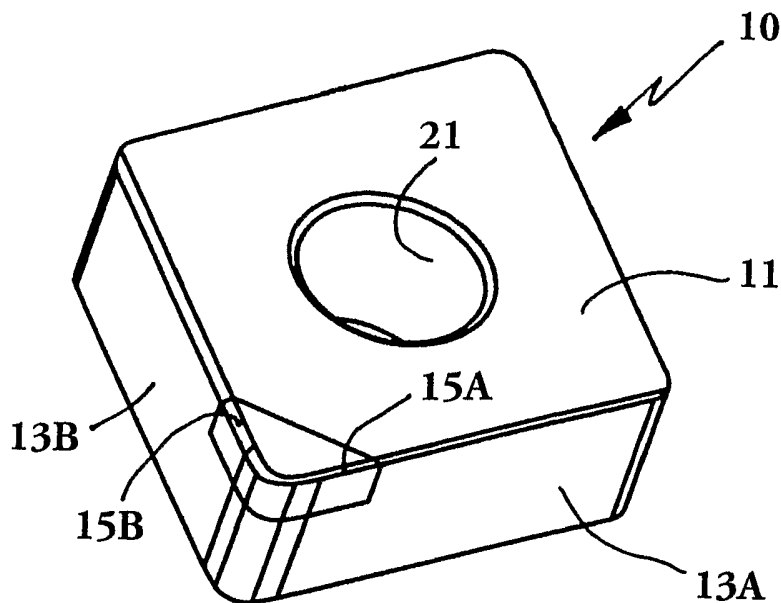
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(54) Title: A CUTTING INSERT WITH A SMALL CHAMFER ANGLE AT THE NOSE CUTTING EDGE



(57) Abstract: The present invention relates to a metal cutting insert (10) that is primarily intended for turning operations. The cutting insert comprises an upper surface (11), a lower surface (12) substantially parallel with said upper surface, and at least three side surfaces (13A,13B) extending between said upper and lower surfaces. A transition between two adjacent side surfaces (13A,13B) forming a rounded nose radius surface (14A) at a cutting insert corner (14). The cutting insert comprises a peripheral land (15,15A,15B) bridging the upper and side surfaces at least at the corner portion (14) at a chamfer angle ($\beta_A-\beta_E$). An intersection of the land (15,15A,15B) and the nose radius surface (14A) forms a nose cutting edge (16;16'). The nose cutting edge (16;16') is defined by at least one

radius (R1). The cutting corner comprises at least one curved wiper edge (17,18;17',18'). The chamfer angle (β_c) in a cross-section at the nose cutting edge (16; 16') is smaller than the chamfer angle in a cross-section a distance away from the nose cutting edge (16; 16'). The chamfer angle (β_c) has a minimum at a bisector (B) of the corner portion (14)

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A cutting insert with a small chamfer angle at the nose cutting edge.

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Background of the invention

The present invention relates to a metal cutting insert that is primarily intended for turning operations.

10 For all sorts of turning operations, there is a certain interplay between the feed rate and the corner radius, the corner radius being the connection between the main cutting edge and the secondary cutting edge. The surface fineness produced on the workpiece is specifically influenced by the interplay between the corner radius and the feed rate. The approach angle is defined as the angle between the main cutting edge and the direction of feed. This angle has a
15 considerable influence on the interrelation between the different cutting force components, and thereby also on the surface fineness and dimension accuracy. Surface fineness and dimension accuracy are very sensitive to changes of the approach angle. One problem for all turning operations is to obtain the desired surface fineness. Another problem is short tool life due to for example crater
20 wear.

Objects of the invention

One object of the present invention is to provide a cutting insert that improves the fineness of the machined surface.

25 Another object of the present invention is to provide a cutting insert that significantly improves tool life.

Still another object of the present invention is to provide a cutting insert that improves surface finish over the total tool life.

30 Still another object of the present invention is to provide a cutting insert that increases compressive residual stresses in the work piece subsurface.

Still another object of the present invention is to provide a cutting insert that increases hardness in the workpiece rim zone.

Still another object of the present invention is to provide a cutting insert that reduces the sensitivity of a turning cutting insert relative to the positioned approach angle.

5 Still another object of the present invention is to provide a versatile cutting insert.

These and further objects have been attained by a cutting insert as defined in the appended claims.

Brief description of the drawings

10 The objects and advantages of the invention will become apparent from the following detailed description of preferred embodiments thereof in connection with the accompanying drawing in which like numerals designate like elements, and in which:

15 FIG. 1 shows a plan view of a turning cutting insert according to the invention.

FIG. 2 shows the cutting insert in a perspective view.

FIG. 3A shows a cross-section according to the line E in Fig. 1.

FIG. 3B shows a cross-section according to the line F in Fig. 1.

FIG. 3C shows a cross-section according to the line G in Fig. 1.

20 FIG. 3D shows a cross-section according to the line H in Fig. 1.

FIG. 3E shows a cross-section according to the line J in Fig. 1.

FIG. 4 shows a plan view of a corner portion of the cutting insert in magnification.

FIG. 5 shows the corner portion in a side view.

25 FIG. 6A shows a graph of chamfer angle range at the different cross-sections according to lines E-J in Fig. 1.

FIG. 6B shows a graph of chamfer height at the different cross-sections according to lines E-J in Fig. 1.

30 FIG. 7A shows the cutting insert during turning of a work piece and Fig. 7B shows portions of the cutting insert and the workpiece.

Fig. 8 shows an alternative embodiment of a cutting insert according to the present invention in a view similar to Fig. 5.

Detailed description of preferred embodiments of the invention

In the figures 1 to 5 a turning cutting insert 10 according to the present invention is shown. The cutting insert may be either single- or double-sided. The cutting insert is rhombic, the corner portion shown in FIG. 1 having a nose angle of about 60 to 80°. However, it may also be square, rectangular, triangular or hexagonal. When it is hexagonal, it may also be in the form of a so-called trigonal insert. The insert in this embodiment is made of cemented carbide having a cubic boron nitride (CBN) corner portion, but may also be made completely of any of those materials or of any other suitable material. The cutting insert 10 comprises an upper surface 11, a lower surface 12 substantially parallel with said upper surface, and at least three side surfaces 13A, 13B extending between said upper and lower surfaces. The upper surface 11 is planar in this embodiment and extends perpendicularly relative to said at least three side surfaces. A transition between two adjacent side surfaces 13A, 13B forms a rounded nose radius surface 14A at a cutting insert corner 14. The cutting insert 10 comprises a peripheral land 15, constituted by at least two peripheral lands 15A and 15B, bridging the upper and side surfaces at least at the corner portion 14. The peripheral lands 15A and 15B in this embodiment may extend along the entire cutting insert periphery. The peripheral lands 15A and 15B in this embodiment are of different configuration. The peripheral lands 15A and 15B slope at chamfer angles β_A - β_E (as illustrated by Figs. 3A-3E) relative to a plane P containing the upper surface 11. The peripheral land is adapted to strengthen the cutting edges of the cutting insert. In this embodiment the upper surface 11 is planar and connects directly to the peripheral land 15 to allow a strong configuration. An intersection of the peripheral land and the nose radius surface 14A forms a nose cutting edge 16. The nose cutting edge 16 is defined by at least one radius R1. Each operative cutting corner 14 comprises at least one convex wiper edge 17, 18 connected to the nose cutting edge 16. In this embodiment there is provided a first 17 and a second 18 wiper edge separated by the nose cutting edge 16. The nose radius surface 14A may be symmetrical with respect to the corner bisector B (as shown in Fig. 8). The

cutting insert 10 in this embodiment has a through-going hole 21 extending perpendicularly to the surfaces 11 and 12. Referring especially to Figs. 3C and for example 3E, the chamfer angle β_C in a cross-section at the nose cutting edge 16 is smaller than the chamfer angle β_E in a cross-section a distance
5 away from the nose cutting edge 16. The chamfer angle β_C in the cross-section at the nose cutting edge 16 is smaller than the chamfer angle in a cross-section at said second 18 wiper edge but greater than the chamfer angle β_A in a cross-section at said first wiper edge 17. Each peripheral land 15A and 15B follows a substantially straight line in a cross-section through the cutting insert 10, such
10 as shown in Figs. 3A-3E. The peripheral land 15 has a continuously varying chamfer angle β at the corner portion 14. The chamfer angle β_C , in a cross-section as illustrated by Fig. 3C at the nose cutting edge 16, is smaller than the chamfer angle β_E in a cross-section at the second wiper edge 18. The peripheral land 15 in a plan view has a substantially constant width W_A - W_E , as
15 illustrated by Figs. 3A-3E. The land width W_E is however slightly larger than the widths W_A - W_D . Alternatively, the land widths may vary similar to the variations of the chamfer angle.

The first wiper edge 17 is defined by at least one first wiper radius R2 and the second wiper edge 18 is defined by at least one second wiper radius R3,
20 said radii R1-R3 have different points of origin. The radii R2 and R3 can be equally large. The peripheral land 15 at each first and second wiper edge 17, 18 has a continuously varying chamfer angle β .

Referring to Figs. 3A-3E and Fig. 6A and 6B, the angle β can be chosen in the following order $\beta_A < \beta_B < \beta_C < \beta_D < \beta_E$, that is for a right hand version of the
25 cutting insert 10. The angle β_A is chosen within the range of 5 to 15°; the angle β_B is chosen within the range of 6.1 to 18.2°; the angle β_C is chosen within the range of 12.5 to 37.5°; the angle β_D is chosen within the range of 18.9 to 56.8°, and the angle β_E is chosen within the range of 20 to 60°. Furthermore, the projected height Z of the chamfer when viewed perpendicular to the side
30 surface 13A, 13B or nose radius surface 14A may vary in the ranges disclosed in Fig. 6B or as follows (in mm):

A	B	C	D	E
0.00	0.01	0.01	0.02	0.02
0.13	0.16	0.38	0.77	0.87

Referring now to Figs. 7A and 7B that show the cutting insert during right-hand turning of a work piece 19 and an enlarged portion of the cutting insert and the workpiece during a hard turning process, respectively. Usually the depth of cut Y is equal to or less than the nose cutting edge radius R1, such that the uncut material for example does not reach the bisector B. The insert is positioned with a clearance angle σ beyond the wiper edge 17. The size of the chip 20 to be removed is determined by the depth of cut Y and the feed per revolution X. The thickness of the chip transfers into zero at the convex wiper edge 17. The peripheral land 15 has a chamfer that has the highest sharpness at the bisector of the corner portion 14, i.e. lowest values of chamfer angle. The wiper edge 17 that cuts the thin part of the chip is the most blunt chamfer. The bluntness of the wiper edge 17 can be correlated with the degree of plastic deformation (fineness of the surface) and in turn the generated residual stress due to mechanical effect.

Fig. 8 shows an alternative embodiment of a cutting insert 10' according to the present invention in a view similar to Fig. 5. The major difference between this cutting insert 10' in relation to the above-captioned cutting insert 10 is that the peripheral lands 15A' and 15B' are identical. The peripheral lands 15A' and 15B' slope at chamfer angles β_C - β_E (as illustrated by Figs. 3C-3E) relative to a plane containing the upper surface 11'. The smallest chamfer angle β_C is provided at a bisector B of the corner portion, i.e. it has a minimum at the bisector B. An intersection of the peripheral lands and the nose radius surface 14A' forms the nose cutting edge 16'. The nose cutting edge 16' is defined by at least one radius. Each operative cutting corner comprises at least one convex wiper edge connected to the nose cutting edge 16'. In this embodiment there is provided a first 17' and a second wiper edge 18' separated by the nose cutting edge 16'. The nose radius surface 14A' is symmetrical with respect to the corner bisector B. This results in the advantage that the cutting insert becomes

symmetrical, thereby enabling both left-hand and right-hand turning with the same insert, i.e., both left-hand and right-hand holders may be used.

In the described embodiments the active corner of the cutting insert is a section of CBN and thus the cutting edges 16, 17 and 18 are comprised of
5 CBN. Alternatively any other suitable cutting material can be used all due the machining application.

The result of the hard turning process is a function of the development of cutting insert wear, e.g. increasing surface roughness, decreasing compressive stresses and increasing tensile stresses in the workpiece rim zone (or
10 subsurface) and increasing workpiece (micro)hardness. The results in short summary compared to normal standard wiper inserts are significant increase of tool life, better surface finish over the total tool life with increase in tool life, increase of achievable compressive residual stresses in the surface (compression in the work piece surface) and increase of micro hardness in the
15 surface. Furthermore, tests have proven that crater wear at the corner portion at a cutting insert according to the present invention grows distant from the nose cutting edge thereby keeping the cutting edge intact for a long period of time in relation to prior art inserts. Thus, a cutting insert for turning is proposed that improves the fineness of the machined surface and significantly improves tool
20 life. The cutting insert improves versatility, equal performance running left or right hand operations and still differentiating the effective chamfer angle as much as possible.

The disclosures in Swedish patent application Nos. 0500413-0 and
0500699-4, from which this application claims priority are incorporated herein by
25 reference.

Claims

1. A cutting insert for turning comprising an upper surface (11;11'), a lower
5 surface (12;12') substantially parallel with said upper surface, and at least three
side surfaces (13A,13B;13A',13B') extending between said upper and lower
surfaces, a transition between two adjacent side surfaces (13A,13B;13A',13B')
forming a rounded nose radius surface (14A;14A') at a cutting insert corner
(14), said cutting insert comprising a peripheral land (15,15A,15B;15A',15B')
10 bridging the upper surface and side surfaces at least at the corner portion (14)
at a chamfer angle (β_A - β_E), and an intersection of said land
(15,15A,15B;15A',15B') and said nose radius surface (14A;14A') forming a nose
cutting edge (16;16'), said nose cutting edge (16;16') being defined by at least
one radius (R1), said cutting corner comprising at least one curved wiper edge
15 (17,18;17',18'), characterized in that the chamfer angle (β_C) in a cross-
section at the nose cutting edge (16;16') is smaller than the chamfer angle in a
cross-section a distance away from the nose cutting edge (16;16') and in that
the chamfer angle (β_C) has a minimum at a bisector (B) of the corner portion
(14).

20

2. The cutting insert according to claim 1, characterized in that
the chamfer angle (β_C) in the cross-section at the nose cutting edge (16;16') is
smaller than the chamfer angle in a cross-section at said wiper edge.

25

3. The cutting insert according to claim 1 or 2, characterized in
that the peripheral land (15,15A,15B;15A',15B') follows a substantially straight
line in a cross-section through the cutting insert.

30

4. The cutting insert according to anyone of the preceding claims,
characterized in that the peripheral land (15,15A,15B;15A',15B') has a
continuously varying chamfer angle (β) at the corner portion (14).

5. The cutting insert according to claim 4, characterized in that the chamfer angle (β_C) in a cross-section at the nose cutting edge (16;16') is smaller than the chamfer angle (β_E) in a cross-section at a first wiper edge (17;17').

5

6. The cutting insert according to anyone of the preceding claims, characterized in that the peripheral land (15,15A,15B;15A',15B') in a plan view has a substantially constant width (W_A-W_E).

10

7. The cutting insert according to anyone of the preceding claims, characterized in that the cutting corner (14) comprises a first wiper edge (17;17') being defined by at least one radius (R2) and a second wiper edge (18;18') being defined by at least one radius (R3), said radii (R1-R3) have different points of origin.

15

8. The cutting insert according to claim 7, characterized in that each first and second wiper edge (17,18;17',18') has a continuously varying chamfer angle (β).

20

9. The cutting insert according to anyone of the preceding claims, characterized in that the cutting insert (10) partly or completely is comprised of cubic boron nitride.

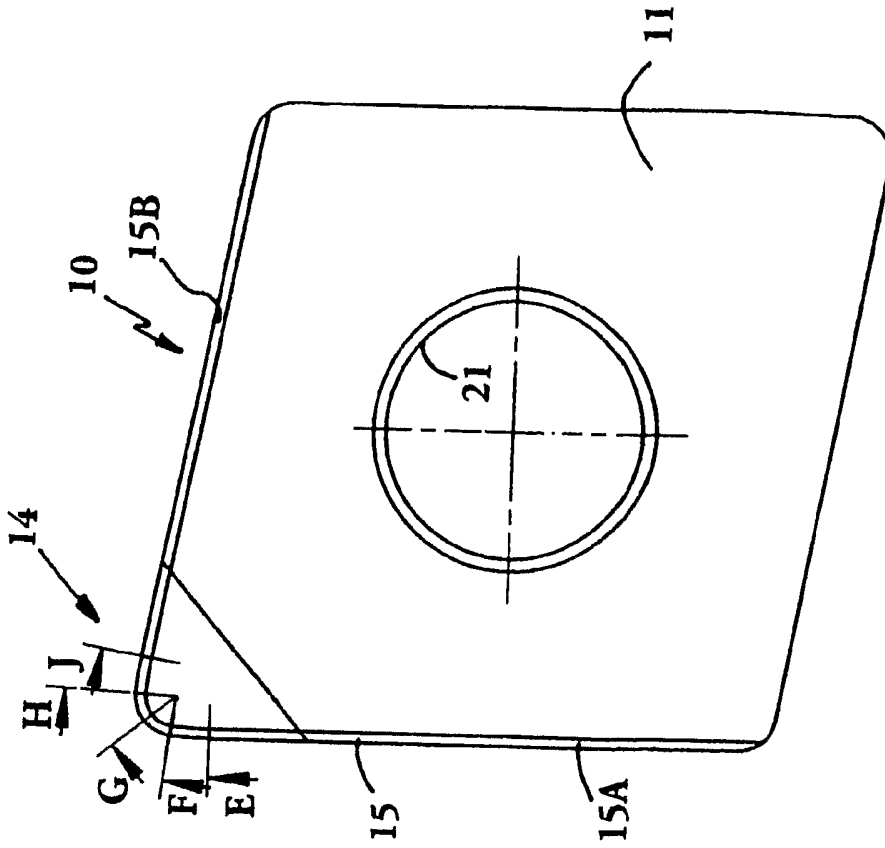


FIG. 1

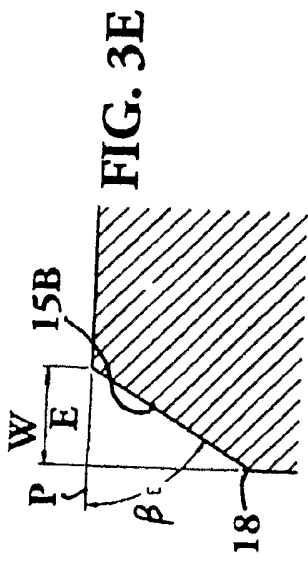


FIG. 3E

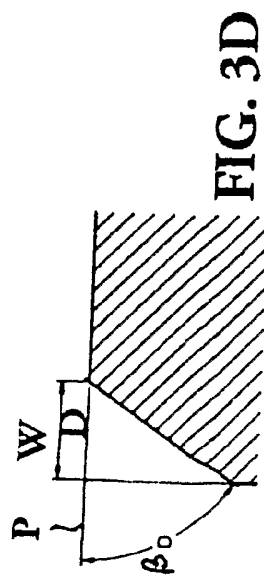


FIG. 3D

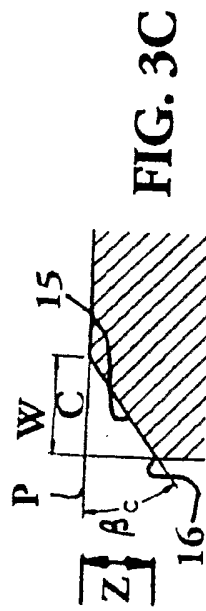


FIG. 3C

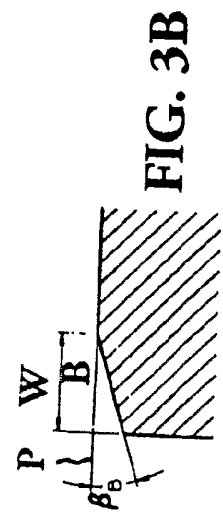


FIG. 3B

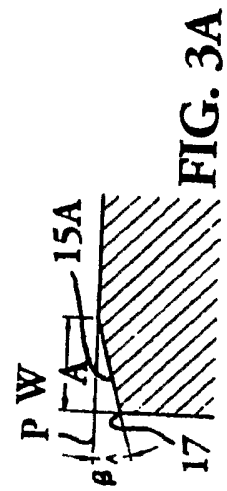


FIG. 3A

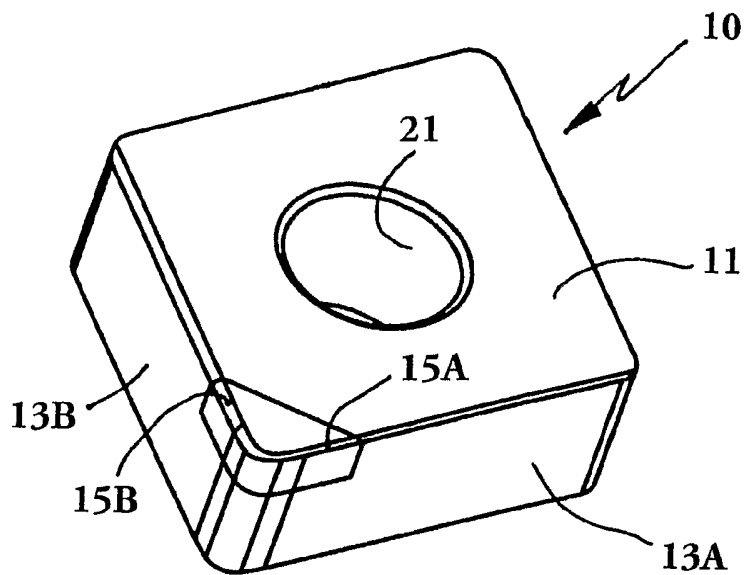


FIG. 2

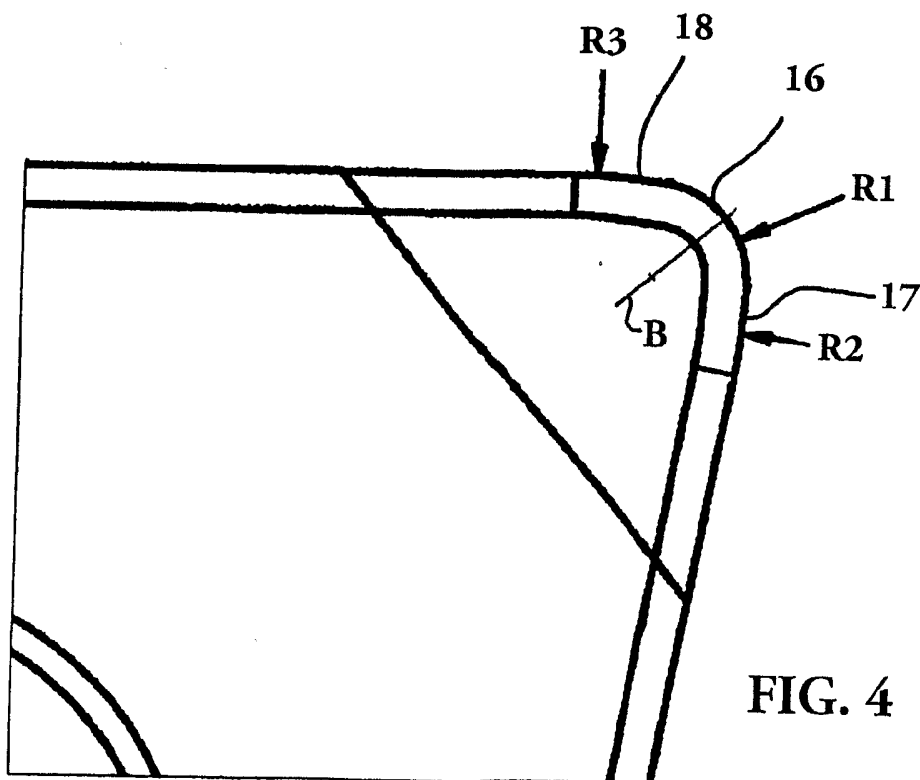


FIG. 4

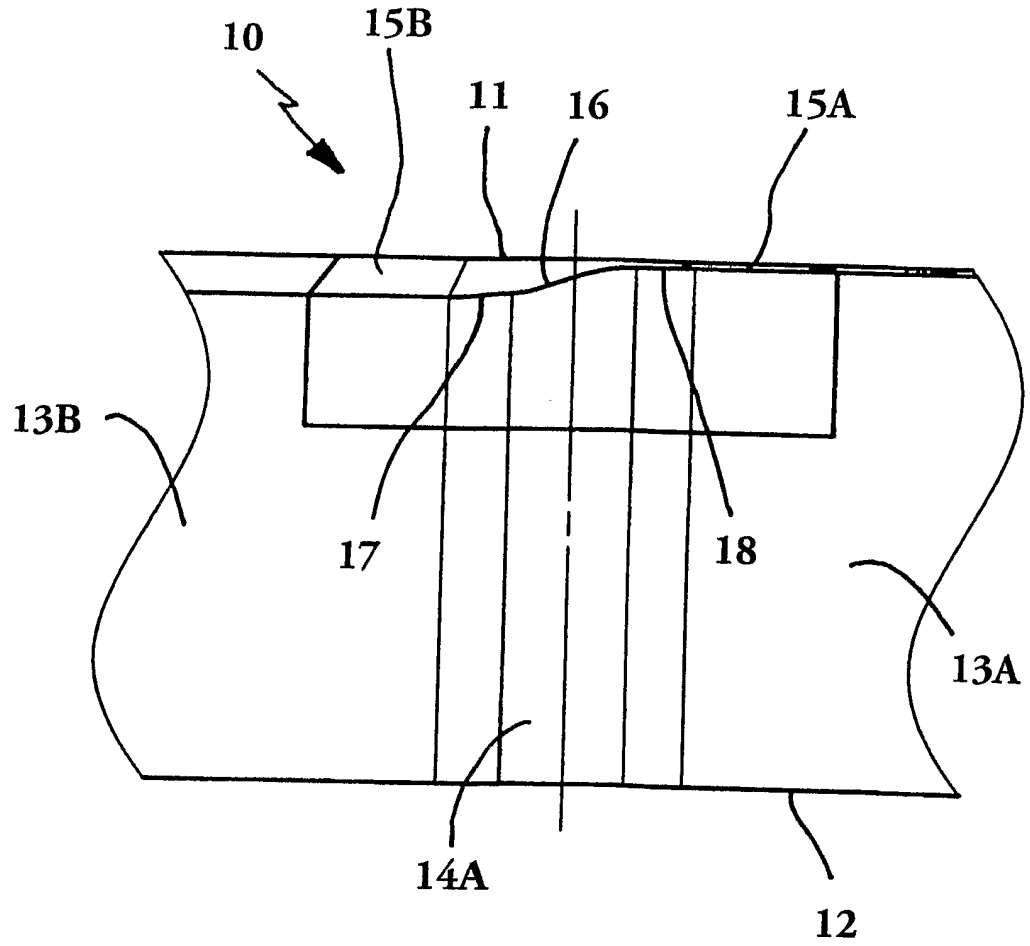


FIG. 5

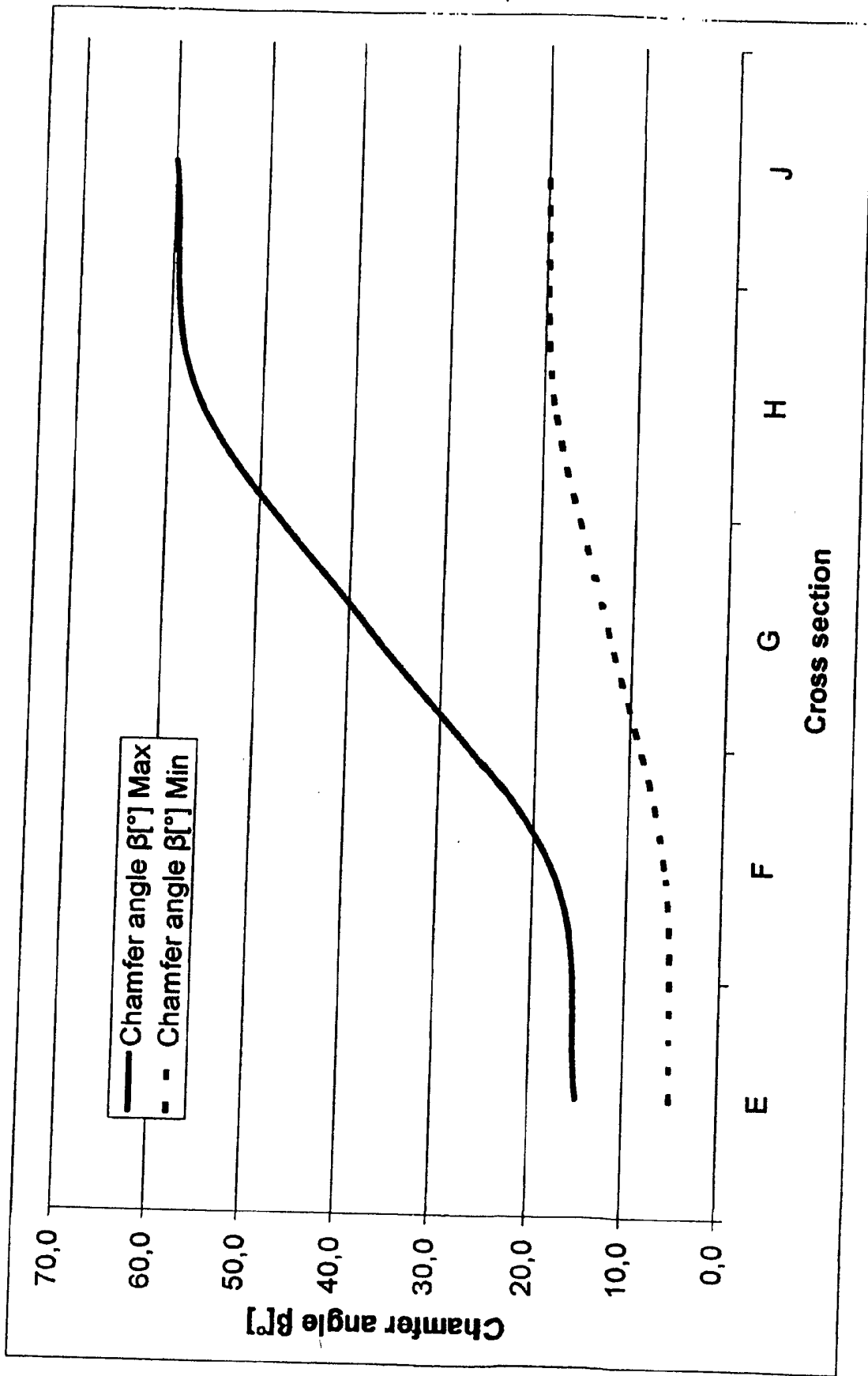


FIG. 6A

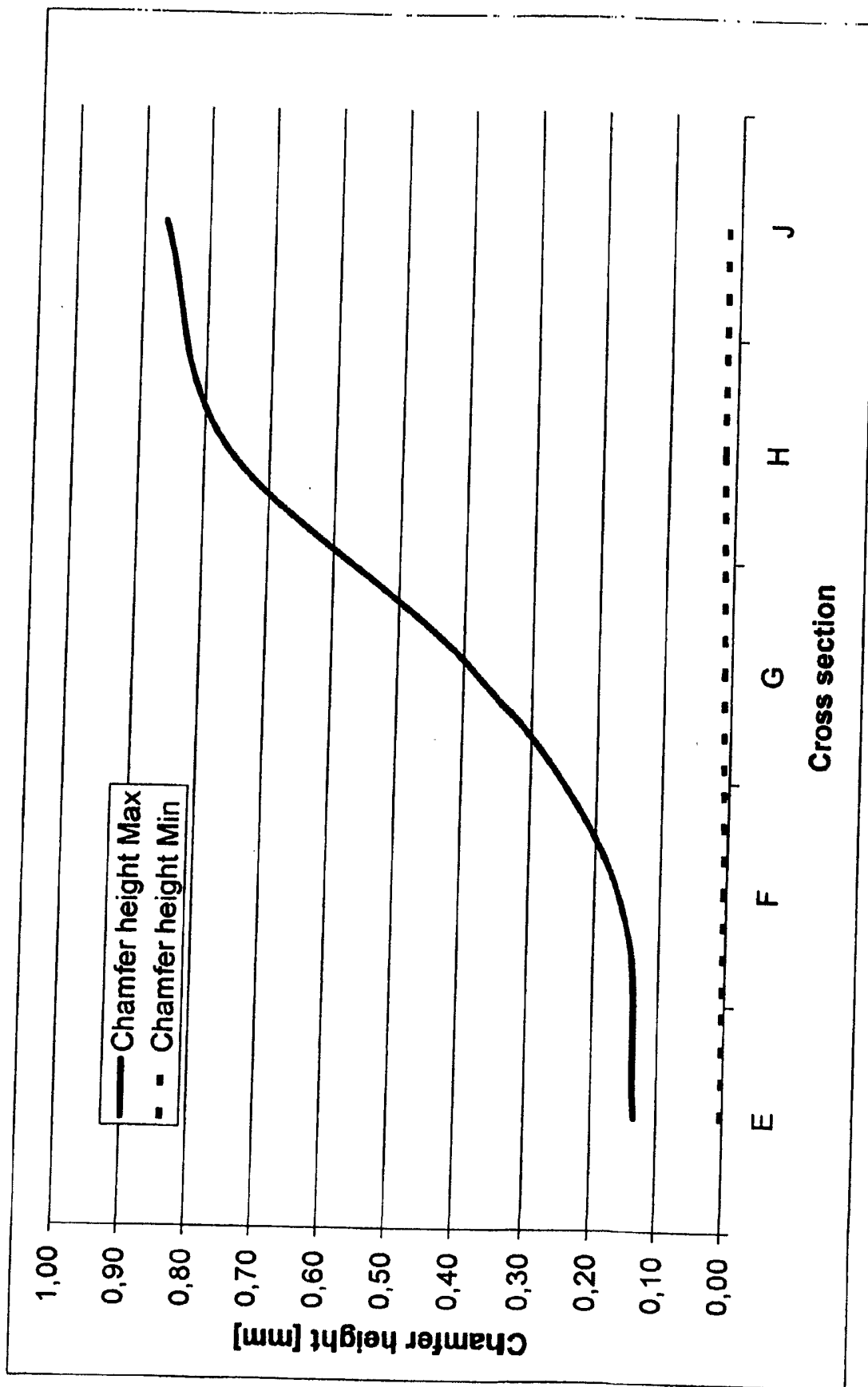


FIG.6B

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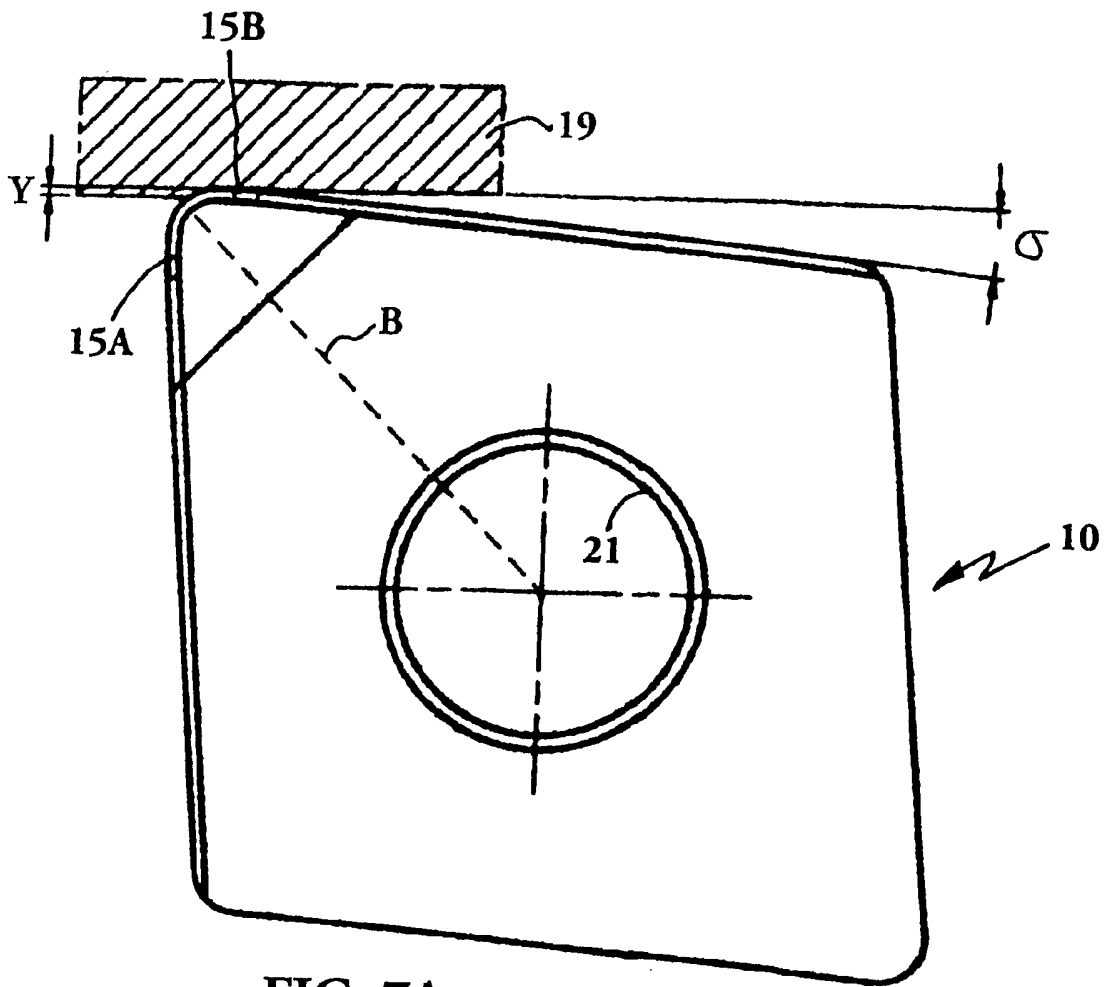


FIG. 7A

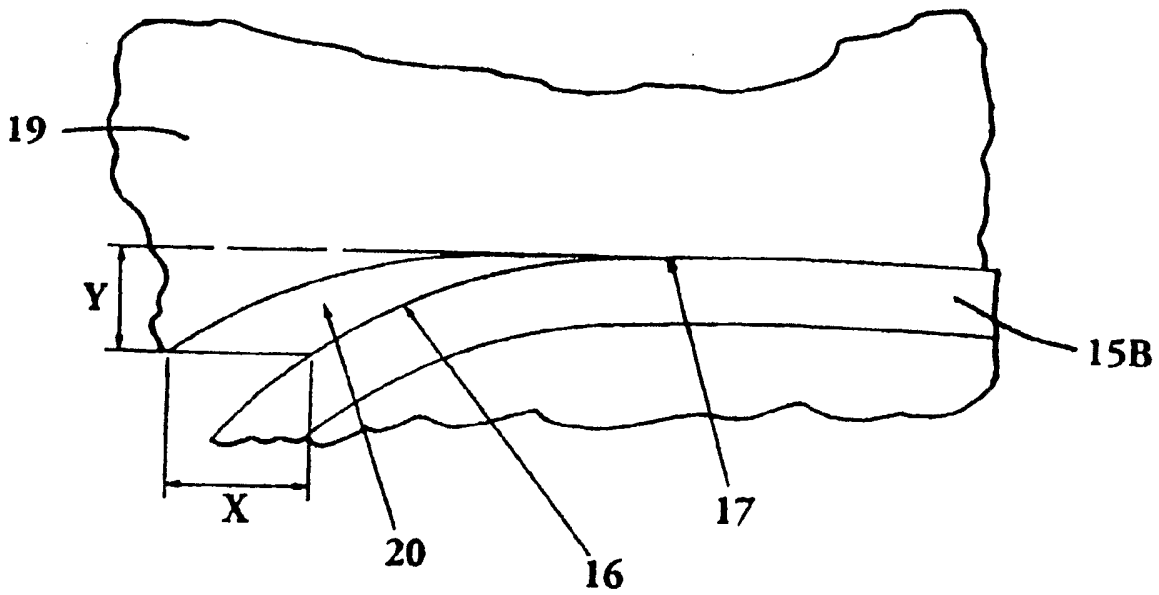


FIG. 7B

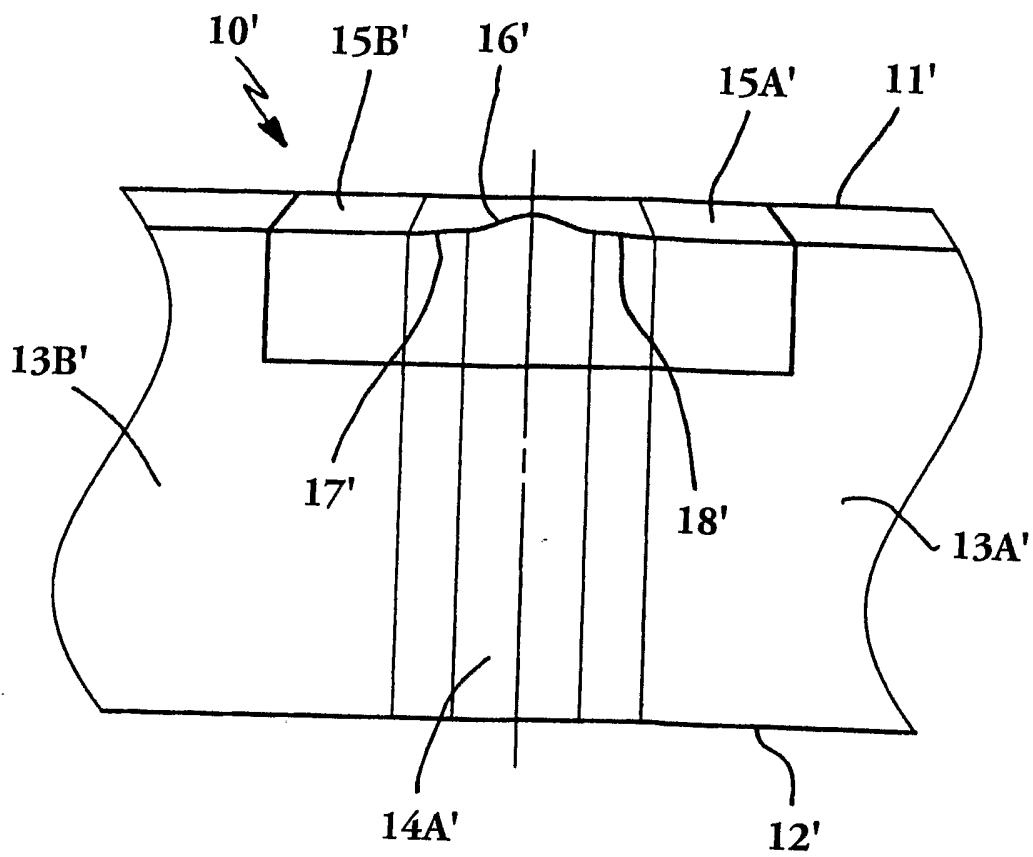


FIG. 8

INTERNATIONAL SEARCH REPORT

International application No.

PCT/SE2006/000214

A. CLASSIFICATION OF SUBJECT MATTER

IPC: see extra sheet

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC: B23B

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

SE,DK,FI,NO classes as above

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

EPO-INTERNAL, WPI DATA, PAJ

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
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A	US 5904450 A (A. SATRAN ET AL), 18 May 1999 (18.05.1999), figures 2A,3-9, abstract --	1-9
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A	US 5006020 A (E. ROOS), 9 April 1991 (09.04.1991), figures 2-5B, abstract --	1-9

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Date of the actual completion of the international search

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INTERNATIONAL SEARCH REPORT

International application No.

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C (Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	EP 1066903 A2 (MITSUBISHI MATERIALS CORPORATION), 10 January 2001 (10.01.2001), figures 2-3, abstract ----- -----	1-9

International patent classification (IPC)**B23B 27/14** (2006.01)**B23B 27/00** (2006.01)**Download your patent documents at www.prv.se**

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Cited literature, if any, will be enclosed in paper form.

INTERNATIONAL SEARCH REPORT

Information on patent family members

04/03/2006

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