

Influence of selected parameters of drag finishing on tool microgeometry

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The aim of the experiment described in the paper was to determine how selected parameters of drag finishing such as process time, immersion depth and rotation frequency affect microgeometry of cutting edge. Four flute cemented carbide mills with diameter of 10 mm were used in this experiment. These mills were drag finished on prototype drag finishing machine developed on Faculty of Materials Science and Technology, Slovak University of Technology. Alicona Infinte Focus SL measuring machine was used to measure microgeometry of these mills. The main parameter of microgeometry of cutting edge was the size of the radius of cutting edge. In the article we compared which parameter has the biggest influence on size of cutting edge radius and also there was statistical evaluation carried out. The most significant parameter of drag finishing was determined to be the immersion depth.

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