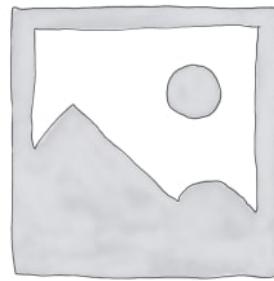


Milling machine and milling, milling cu

Milling

Regard the cutting of cutting tool as treatment with gyral cutter. Milling undertakes on milling machine or boring machine, commonly, comfortable at machining all sorts of planar, configuration faces (be like spline, gear and whorl) the special face with the mould. The feature of milling is: Each tooth participates in ? milling cutter periodically discontinuous cutting. Every tooth is in ? the cutting ply in cutting process is changed. Graph 1 it is a few kinds of familiar milling treatment patterns.



Graph the tooth back appearance of milling cutter of 6 points

Milling cutter presses the treatment means cent of tooth back, there be two kinds. Milling cutter of ? needle tine: Go up at the back of the grind give a narrow first flank in order to form hind horn, because the cutting angle is reasonable, its life is taller. The tooth back of pointed tine milling cutter has linear curve and broken line, the forms of forms (graph 6) . Linear tooth back is commonly used at finish machining milling cutter at serration. The tooth straight curve and broken line tooth back is better, can bear heavier cutting load, commonly used at thick tine milling cutter. ? shovel tine milling cutter: Cut with the shovel at the back of its (the shovel is ground) the tooth back that the method processes the corkscrewed yarn of Cheng Aji Meade, milling cutter is used at hind simply is ground again in front, can carry original tooth changeless, use at making all sorts of configuration milling cutter, such as gear milling cutter.

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