

FLANK SUPERABRASIVE MACHINING

BACKGROUND OF THE INVENTION

The present invention relates to a tool and a method for machining complex airfoil shapes in materials such as nickel or titanium alloys.

In the past, airfoil shapes have been machined using a variety of different techniques. These techniques included flank milling, electro-chemical machining (ECM), and conventional point milling. These techniques however are slow and the tools used to perform them do not have a particularly long life especially, in hardened alloyed materials such as nickel alloys. The cutting forces produced during the milling operation result in high loads on the workpiece which can result in airfoil deflection and chatter that results in poor surface finish. It is also difficult using these techniques to produce surface finishes that meet part requirements without additional processing such as hand polishing or media finishings.

Thus, there is a need for an improved tool and an improved method for machining complex airfoil shapes in less time at lower loads.

SUMMARY OF THE INVENTION

Accordingly, it is an object of the present invention to provide an improved tool for machining complex shapes in less time at lower load and with improved surface finishes.

It is a further object of the present invention to provide a tool as above which lasts longer than convention tools.

It is yet a further object of the present invention to provide an improved method for machining complex shapes.

The foregoing objects are attained by the tool and the method of the present invention.

In accordance with the present invention, a tool which may be used in superabrasive machining is disclosed. The tool broadly comprises a shaft portion, an enlarged head portion adjacent the shaft portion, and a tapered grinding portion adjacent to the enlarged head portion. The tapered grinding

portion 12 and the head portion 14 are each provided with a plurality of flat portions 22 for accommodating a wrench.

The tool 10 may be formed from any suitable tool material known in the art such as a steel material.

The grinding portion 16 has thereon a layer of grit material 24 selected from the group consisting of diamonds and cubic boron nitride. The grit material 24 may extend over the entire length of the grinding portion 16 or just a portion of the grinding portion. In a preferred embodiment of the tool, the grit material 24 extends from the tip 25 of the tapered grinding portion 16 to a point 27 which is about 70 to 75% of the length of the tapered grinding portion 16.

The grit material 24 preferably has a grit size in the range of 40 to 400, preferably 45 to 325. The grit material 24 may be electroplated or brazed onto the tapered grinding portion 16. For example, the grit material could be cubic boron nitride plated onto the tapered grinding portion 16. For finishing cuts, the tool is a vitrified cubic boron nitride or diamond tool having a layer of vitrified grit material on the grinding portion 16. It is preferred to use a vitrified grit applied to portion 16 for finishing cuts because the quill 10 can be dressed to produce less run-out and therefore result in better surface finishes. Also, when the grit wears, it can be redressed or sharpened to produce a better surface finish. A vitrified grit material has a glass type ceramic bonding material which holds the abrasive grits together and then bonded to the underlying tool substrate.

To form a complex airfoil shape in a substrate material 30, the tool 10 is inserted into a grinding spindle in a multi-axis machine tool 32. The tool 10 is then rotated about its longitudinal axis 20 by the machine 32 at a spindle speed in the range of 40,000 RPM to 90,000 RPM. The tool is cooled and lubricated by a nozzle (not shown) which distributes oil or water lubricant on the tool 10 and the workpiece or substrate material 30. The tool 10 is then moved into contact with the substrate material 30 and maneuvered to form a desired complex shapes, e.g. an airfoil shape. Movement of the tool 10 and the

machine 32 is controlled by software which generates a tool path in multiple directions. The particular software which is used varies from part to part being produced. The shapes which are formed can follow an arbitrary airfoil shape for components such as integrally bladed rotors or blisk.

The method of the present invention is advantageous because it is capable of producing very fine surface finishes, less than 10 μ in, with machining times much less than conventional flank milling, ECM or conventional point milling techniques. The method of the present invention uses lower loads and therefore has less chatter and deflection. The superabrasive machining quill tool of the present invention lasts longer than the tools used in conventional methods used to produce integrally bladed rotors.

It is apparent that there has been provided in accordance with the present invention a flank superabrasive machining tool which fully satisfies the objects, means, and advantages set forth hereinbefore. While the present invention is described in the context of specific embodiments thereof, other alternatives, modifications, and variations will become apparent to those skilled in the art having read the foregoing description. Accordingly, it is intended to embrace those alternatives, modifications, and variations as fall within the broad scope of the appended claims.

WHAT IS CLAIMED IS:

1. A tool for use in superabrasive machining comprising:

a shaft portion;

an enlarged head portion adjacent the shaft portion;

a tapered grinding portion adjacent the enlarged head portion; and

said tapered grinding portion having a layer of grit material selected from the group consisting of diamonds and cubic boron nitride.

2. A tool according to claim 1, wherein said grit material is electroplated onto said tapered portion.

3. A tool according to claim 1, wherein said grit material is brazed onto said tapered milling portion.

4. A tool according to claim 1, wherein said grit material is cubic boron nitride plated onto said tapered grinding portion.

5. A tool according to claim 1, wherein said grit material is a vitrified cubic boron nitride material.

6. A tool according to claim 1, wherein said enlarged head portion is joined to said tapered grinding portion by a fillet portion.

7. A tool according to claim 1, wherein each of said shaft portion and said enlarged head portion have a plurality of flats to accommodate a wrench.

8. A tool according to claim 1, wherein said grit material has a grit size in the range of 40 to 400.

9. A tool according to claim 1, wherein said grit material has a grit size in the range of 45 to 325.

10. A method for machining a complex shape in a substrate comprising the steps of:

providing a tool having a shaft portion, an enlarged head portion adjacent the shaft portion, a tapered grinding portion adjacent the enlarged head portion, and a layer of grit material on the tapered grinding portion;

inserting said shaft portion of said tool into a grinding spindle;

rotating said tool at a spindle speed in the range of 40,000 RPM to 90,000 RPM; and

placing said rotating tool into contact with a substrate material.

11. A method according to claim 10, further comprising spraying a lubricant onto said tool and said substrate material.

12. A method according to claim 10, wherein said tool providing step comprises providing a tool having vitrified or plated cubic boron nitride on said grinding portion.

13. A method according to claim 10, further comprising moving said rotating tool to form a plurality of airfoil shapes in said substrate material.

14. A method for forming a component having a plurality of airfoil shapes comprising the steps of:

providing a vitrified or plated cubic boron nitride quill having a tapered grinding portion with a layer of vitrified grit material thereon;

placing an end portion of the quill into a grinding spindle used on a multi-axis milling machine;

rotating said quill at a spindle speed in the range of 40,000 RPM to 90,000 RPM; and

placing the rotating quill into contact with a substrate material selected from the group consisting of nickel alloys, titanium alloys, and steels.