

Cutting insert for chip forming machining of work pieces

DESCRIPTION

The present invention relates to a cutting insert for chip forming machining of metallic work pieces, having at least one cutting edge limited by a rake face and a clearance face, the rake face being provided with a rake face section adjoining the cutting edge which has a positive rake angle relative to the cutting insert plane, and with a plurality of dome-shaped recesses which are arranged parallel to the cutting edge at a distance from each other, moulded into the rake face section, limited by their upper edge with respect to the rake face section and partially penetrating the cutting edge.

It is known that chip breaking and chip removal during cutting can be facilitated by the provision of recesses in the rake face (DE-C-28 40 610). The chip obtains there during the cutting operation a wave-like structure and thereby a greater stiffness which is necessary for easy breaking. Especially for drilling, small, short broken chips are important for undisturbed stress relief. For this purpose suitable deformation of the stiffened chip, which leads to reliable chip breaking, is additionally required.

Starting with this, the present invention has the object to improve the known cutting insert of the kind described above in such a way that during machining the formation of small, short broken chips is facilitated.

In order to attain this object, the combinations of features of patent claims 1 and 3 are proposed. Advantageous embodiments and further developments result from the dependent claims.

The present invention is mainly based on the consideration to subject the chip, which was provided with a wave structure during machining, to a suitable deformation in a most confined space, by which it is broken into small pieces. In order to achieve this, the present invention provides for a chip forming step on the side of the dome-shaped recesses which is opposite the cutting edge, which step projects beyond the rake face section containing the recesses in the direction of chip breaking, and for the rake face being provided in the region of the rake face section with a positive rake angle and in the region of the recesses with a neutral or negative rake angle with respect to the cutting insert plane. An especially advantageous cutting and chip breaking behaviour is achieved when the rake angle of the concave rake face section is 15 to 25°, while in the region of the recesses, at the cutting edge, it is 0 to -10°.

During machining, the chip, which was provided with a transverse wave structure, is pushed in the chip travel direction against the chip forming step and is sharply deflected. The deflection leads to chip breaking, so that small, short broken chips are created. The chip breaking step can run at its limiting line at the side of the cutting edge tangentially into the rake face section, while, at the side of the limiting line away from the cutting edge, it can change sharp-edged into a central rake face plateau which is positioned above the cutting edge with respect to the cutting edge plane.

In a preferred embodiment the invention provides for the chip forming step to run linearly or wave-shaped, substantially parallel to the cutting edge and either touching the dome-shaped recesses with its limiting line at the side of the cutting edge, or being arranged at a distance therefrom.

If the chip forming step is curved at its limiting line at the side of the cutting edge in a wave- or zig-zag shape,

that it does not extend into the dome-shaped recesses, additional wedge effects are created in the region between the recesses, which stimulate the chip breaking. In this respect a further improvement can be achieved in that the chip forming step with its limiting line at side of the cutting edge extends with the wedge tip which points to the cutting edge, wedge-shaped into the dome-shaped recesses and forms there their upper edge. In both cases the chip forming step may run wave-shaped and/or zig-zag-shaped with its limiting line away from the cutting edge substantially in phase or in antiphase parallel to the limiting line at the side of the cutting edge.

A further advantageous embodiment of the invention provides that the dome-shaped recesses form a conical dome-shaped concave surface which converges towards the cutting edge and penetrates the cutting edge, while they change into a spherical dome-shaped concave surface towards the side of the chip forming step. With this arrangement there is obtained an extended distance with greater rake angle extending from the cutting edge in the chip travel direction, which results in improved heat dissipation by the chips and thereby in lesser heating of the tool.

A further preferred embodiment of the invention provides that the rake face section between the cutting edge and the chip forming step is bent concavely in the chip travel direction, wherein the chip forming step touches the concavely bent rake face section tangentially and may also be bent concavely.

The recesses penetrating the cutting edge achieve that the corrugated-sheet-shaped chip only impacts at one point on the chip forming step, so that only a very low cutting resistance and a low heat transfer from the chip to the cutting insert take place. It was found to be of special advantage, when the recesses are formed as cylindrical domes penetrating the cutting edge with their cylinder axis being substantially

perpendicular to the clearance face. Basically it is also possible to form the recesses as conical domes penetrating the cutting edge with a substantially perpendicular lowest surface line with respect to the clearance face, or as ellipsoid or paraboloid domes penetrating the cutting edge with their lowest surface line being substantially perpendicular to the clearance face.

In order to achieve an especially low cutting resistance and low heat transfer from the chips to the cutting insert, it is of advantage when the distance between the cutting edge and the limiting edge of the recesses at the side of the plateau is less than 50%, preferably 20% to 30% of the distance between the cutting edge and the plateau edge at the side of the cutting edge.

The cutting insert can be provided with a plurality of cutting edges which delimit a polygon and are penetrated by dome-shaped recesses, while the possibly wave-shaped and/or zig-zag-shaped curved limiting lines of the chip forming steps may form a correspondingly contoured circumferential polygon at a distance from the cutting edges.

In order to avoid breaking of the insert, especially the inner insert of a solid drill, there is provided in accordance with an advantageous or alternative embodiment of the invention that the cutting edges are partially chamfered in the region between the recesses which are adjacent via the corners of the cutting insert. In order to allow use of the cutting inserts as inner or outer inserts of a solid drill, it is of advantage when the cutting edges are chamfered asymmetrically in the region of the corner area between the corner and only one of the adjacent recesses. For this purpose, the cutting edges can be chamfered, if necessary, also in the region between the recess adjacent a corner and the next, possibly also the following recess in continuation of the corner chamfers extending from a corner.

The invention will now be illustrated with the help of a number of embodiments shown in the drawings, in which

- Fig. 1 shows a top view of a trigonal cutting insert;
Figs. 2a to 2i show an enlarged part from Fig. 1 with nine different embodiments of the chip forming steps;
Fig. 3a shows a section along line A-A of Fig. 2e;
Fig. 3b shows a section along line B-B of Fig. 2e;
Fig. 4a shows another embodiment of a trigonal cutting insert in a diagrammatical view;
Fig. 4b shows a plan view of the cutting insert according to Fig. 4a;
Fig. 4c shows a section along line C-C of Fig. 4b;
Figs. 4d and e show a view in direction D and B of Fig. 4b in an enlarged sectional view; and
Fig. 5 shows a trigonal cutting insert with asymmetrical chamfering in a view corresponding to Fig. 4a.

The cutting inserts shown in Figs. 1 and 4a are formed in the outline of hexagonal indexable cutting inserts, the cutting edges 10 of which are connected at corners 12 and 14 alternating by an acute corner angle δ and an obtuse corner angle ϵ . Such cutting inserts are used, for example, in solid drills, in which two cutting edges 10 separated from each other by the obtuse corner angles are effective in pairs up to the adjacent corners 12. The cutting edges 10 are formed by the transition between the rake face 16 and the adjacent clearance face 18. The rake face 16 is divided into a substantially plane planar portion 20 close to the cutting edge, and a plateau 22, situated higher and away from the cutting edge, connected to each other in chip travel direction by a chip forming step 24. The chip forming step 24 verges at its limiting line 26 at the side of the cutting

edge tangentially into the planar portion 20, while it verges at the limiting line 28 away from the cutting edge sharp-edged into the plateau 22 (Figs. 3a, b and 4c). In the center of the plateau region 22 there is situated an opening 23 for the passage of a fastening screw (not shown).

The planar portions 20 and the chip forming steps 24 which belong to each cutting edge are connected to each other via corners 12, 14 and form a continuous coherent plane or step. Dome-shaped recesses 30, which extend up to the cutting edge 10 and penetrate this in an edge section 32, are arranged in the rake face in the region of the planar portions 20 along the cutting edge 10 next to each other and at a distance from each other. According to the embodiments of Figs. 1 to 3, the recess 30 is formed in the region 34 adjacent the cutting edge converging towards the cutting edge conically dome-shaped, while it is spherically dome-shaped in the region 36 away from the cutting edge. In the region of the acute corners 12, there is provided in addition a through-shaped recess 38 in the planar portion 20, at a distance from each cutting edge 10 and the corner 12, the depth of which is less than that of the dome-shaped recesses 30.

The embodiments shown in Figs. 2a to 2i differ from each other mainly in the form of the chip forming step 24. The chip forming step 24 may touch at its inner limiting line 26 either linearly parallel to the cutting edge 10 the recesses 30, 38 (Fig. 2a), or may run at a small distance therefrom (Fig. 2b). The chip forming step 24 may also be formed at its limiting line 26 at the side of the cutting edge wave-shaped and/or zig-zag-shaped, but in such a way that it either touches the dome-shaped recesses 30 (Figs. 2c, 2d, 2g, 2h), is at a distance therefrom (Fig. 2c), or may partially extend into this (Fig. 2f and i). This results in an additional break-promoting chip deformation by wedge formation in the region of the chip forming step in the region between the recesses 30 (Figs. 2c, 2d, 2e and 2g) on the one hand, and in

the dome-shaped recesses 30 (Figs. 21 2h and 2i) on the other hand.

The limiting line 28 of the chip forming step 24 on the side of the plateau may be either straight (Figs. 2a, 2b, 2c, 2d, 2f) or wave-shaped (Figs. 2g, 2h, 2i), wherein in the latter case the -shaped either in the same direction (Figs. 2g, 2h) or in the opposite direction (Fig. 2i).

In the embodiments shown in Figs. 4a to 4e and 5, the planar portion 20 and the chip forming step 24 adjacent thereto in the chip travel direction are formed concavely, verging gradually tangentially into each other. The rake angle α with respect to the insert plane 40 is positive at the cutting edge 10 and is approximately 15 to 20° (Fig. 4e). The recesses 30 are formed as short cylindrical domes penetrating the cutting edge 10 and having a cylinder axis which is approximately perpendicular to the clearance face 18. The cutting angle β with respect to the insert plane 40 is negative and is approximately -5° (Fig. 4e). The distance between the cutting edge 10 and the limiting edge of the recesses 30 on the side of the plateau is relatively small and comprises only about 20 to 30% of the distance between the cutting edge 10 and the plateau limiting line 28 at the side of the cutting edge.

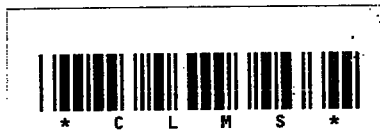
In order to avoid breakage in the region of the insert corners 12, especially when the cutting insert is employed as an inner insert in a solid drill, the cutting edges 10 are provided in the region of the recesses 30 which are adjacent via the corner 12, with a chamfer 42 having a chamfer angle γ of about 20° with respect to the insert plane 40 (Figs. 4a and 4d).

In the embodiment shown in Fig. 5 the corner chamfers 42 are disposed between the insert corner 12 and only one of the adjacent recesses 30, while the cutting edge 10 is formed in

a sharp-edged manner between the corner 12 and the other recess 30. In solid drills fitted with cutting inserts which are staggered radially with respect to each other, the cutting inserts point radially to the drill center with their chamfered corner and to the outside with their sharp-edged corner. This allows the use of the same cutting inserts as inner inserts or outer inserts of a solid drill, without loss of cutting quality despite the corner chamfers.

In principle it is possible to provide also the cutting edge regions touching the recess adjacent corner 12 with a chamfer up to the next or subsequent recess 30. This chamfer should, however, not be continued beyond each adjacent blunt cutting edge corner 14.

In summary, the following can be stated: The invention relates to a cutting insert for chip forming machining of preferably metallic workpieces. The cutting insert has at least one cutting edge 10 in the transition region between a rake face 16 and a clearance face 18, wherein the rake face 16 has a plane rake face section 20 extending essentially parallel with respect to the cutting edge 10 and a plurality of dome-shaped recesses which are spaced with respect to each other and parallel to the cutting edge 10, which are moulded into the rake face section 20, and which partially penetrate the cutting edge 10. In order to facilitate an undisturbed stress relief while forming short broken chips, it is proposed according to the invention to provide a chip forming step 24 on the side of the dome-shaped recesses which is opposite the cutting edge 10, which step projects beyond the rake face section, and which is delimited by a lower limiting line 26 on the side of the cutting edge and by an upper limiting line 28 away from the side of the cutting edge, which limiting lines 26, 28 may be straight or wave-shaped.



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CLAIMS:

1. A cutting insert for chip forming machining of metallic work pieces, having at least one cutting edge (10) limited by a rake face (16) and a clearance face (18), wherein the rake face (16) has a rake face section (20) adjoining the cutting edge (10) which has a positive rake angle (α) relative to the cutting insert plane and a plurality of dome-shaped recesses (30) which are arranged parallel to the cutting edge (10) at a distance from each other, moulded into the rake face section, limited by their upper edge with respect to the rake face section (20) and partially penetrating the cutting edge, characterized in that there is provided a chip forming step (24) on the side of the recesses (30) opposite the cutting edge (10) which projects beyond the rake face section (20), which step is limited by a lower limiting line on the side of the cutting edge and an upper limiting line away from the cutting edge, and that the rake face in the region of the dome-shaped recesses (30) has a neutral or negative rake angle (β) with respect to the cutting insert plane (40).
2. Cutting insert according to claim 1, having several cutting edges (10) delimiting a polygon and being penetrated by dome-shaped recesses (30), characterized in that the cutting edges (10) are partially chamfered in the region between the recesses (30) which are adjacent to each other via the corners of the cutting insert.
3. Cutting insert for chip forming machining of metallic work pieces, having at least one cutting edge (10) limited by a rake face (16) and a clearance face (18), the rake face (16) being provided with a rake face section (20) adjoining the cutting edge (10) which has





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a positive rake angle (α) relative to the cutting insert plane and with a plurality of dome-shaped recesses (30) arranged parallel to the cutting edge (10) at a distance from each other, moulded into the rake face section, limited by their upper edge with respect to the rake face section (20) and partly penetrating the cutting edge, and wherein there are provided several cutting edges (10) delimiting a polygon and being penetrated by dome-shaped recesses (30), characterized in that there is provided a chip forming step (24) on the side of the recesses opposite the cutting edge (10) which projects beyond the rake face section (20), which step is limited by a lower limiting line on the side of the cutting edge and an upper limiting line away from the cutting edge, and that the cutting edges (10) are partially chamfered in the region between the recesses (30) which are adjacent to each other via the corners of the cutting insert.

4. Cutting insert according to claim 2 or 3, characterized in that the cutting edges (10) are chamfered asymmetrically in the region of the corner area between the corner (12) and only one of the adjacent recesses (30).
5. Cutting insert according to claim 4, characterized in that the cutting edges (10) are chamfered in the region between the recess adjacent the corner (12) and the next one, and possibly also the following recess (30), in continuation of the chamfer extending from the corner (12).
6. Cutting insert according to any one of claims 1 to 5, characterized in that the chip forming step (24) verges tangentially into the rake face section (30) at its limiting line (26) at the side of the cutting edge.

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7. Cutting insert according to any one of claims 1 to 6, characterized in that the chip forming step (24) verges preferably sharp-edged into a central face plateau (22) arranged above the cutting edge at its upper limiting line (28) away from the cutting edge.
8. Cutting insert according to any one of claims 1 to 7, characterized in that the chip forming step (20) runs linearly or wave-shaped, substantially parallel to the cutting edge (10) and either touching the dome-shaped recesses (30) with its limiting line (26) at the side of the cutting edge, or being arranged at a distance therefrom.
9. Cutting insert according to any one of claims 1 to 8, characterized in that the chip forming step (24) extends in a wave- and/or zig-zag-shaped manner with its limiting line (10) at the side of the cutting edge and preferably exhibits a wavelength corresponding to the center distance of the recesses.
10. Cutting insert according to any one of claims 1 to 9, characterized in that the chip forming step (24) with its limiting line (26) at the side of the cutting edge extends wedge-shaped into the regions between the recesses with the wedge tip which points to the cutting edge.
11. Cutting insert according to any one of claims 1 to 10, characterized in that the chip forming step (24) with its limiting line (26) at side of the cutting edge extends wedge-shaped into the dome-shaped recesses with the wedge tip which points to the cutting edge, and forms there the upper edge of the recess.
12. Cutting insert according to any one of claims 1 to 11, characterized in that the chip forming step (24)

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extends wave-shaped and/or zig-zag-shaped with its limiting line (28) away from the cutting edge substantially in phase or in antiphase parallel to the limiting line (26) at the side of the cutting edge.

13. Cutting insert according to any one of claims 1 to 12, characterized in that the dome-shaped recesses (30) form a conical dome-shaped concave surface (34) which converges towards the cutting edge (10) and penetrates the cutting edge.
14. Cutting insert according to any one of claims 1 to 12, characterized in that the dome-shaped recesses (30) at the side of the chip forming step (24) form a spherical dome-shaped concave surface (36).
15. Cutting insert according to any one of claims 1 to 14, characterized in that the rake face section (20) between the cutting edge (10) and the chip forming step (24) is bent concavely in the chip travel direction.
16. Cutting insert according to claim 15, characterized in that the chip forming step (24) between the rake face section (20) and the rake face plateau (22) is bent concavely in the chip travel direction and joins the rake face section (20) tangentially.
17. Cutting insert according to any one of claims 1 to 16, characterized in that the recesses (30) are formed as cylindrical domes penetrating the cutting edge (10) with their cylinder axis being substantially perpendicular to the clearance face.
18. Cutting insert according to any one of claims 1 to 16, characterized in that the recesses (30) are formed as conical domes penetrating the cutting edge (10) with

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their lowest surface line being substantially perpendicular to the clearance face (18).

19. Cutting insert according to any one of claims 1 to 16, characterized in that the recesses are formed as ellipsoid or parabolic domes penetrating the cutting edge with their lowest surface line being substantially perpendicular to the clearance face (18).
20. Cutting insert according to any one of claims 1 to 19, characterized in that the distance between the cutting edge (10) and the limiting edge of the recesses (30) at the side of the plateau is less than 50%, preferably 20% to 30% of the distance between the cutting edge (10) and the plateau edge (28) at the side of the cutting edge.
21. Cutting insert according to any one of claims 1 to 20, characterized in that the rake angle (β) in the region of the dome shaped recesses (30) is 0 to -10° at the cutting edge.
22. Cutting insert according to any one of claims 1 to 21, characterized in that the rake angle (α) of the concave rake face section (20) is positive at the cutting edge and is preferably 10 to 25° .
23. Cutting insert according to any one of claims 1 to 22, having several cutting edges (10) delimiting a polygon and being penetrated by dome-shaped recesses (30), characterized in that the linear or wave-shaped limiting lines (26,28) of the chip forming steps (24) form at a distance from the cutting edges (10) a similarly contoured polygon.

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CLAIMS:

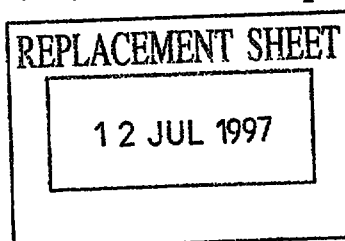
1. A cutting insert for chip forming machining of metallic work pieces, having at least one cutting edge (10) limited by a rake face (16) and a clearance face (18), wherein the rake face (16) has a rake face section (20) adjoining the cutting edge (10) which has a positive rake angle (α) relative to the cutting insert plane and a plurality of dome-shaped recesses (30) which are arranged parallel to the cutting edge (10) at a distance from each other, moulded into the rake face section, limited by their upper edge with respect to the rake face section (20) and partially penetrating the cutting edge, wherein there is provided a chip forming step (24) on the side of the recesses (30) opposite the cutting edge (10) which projects beyond the rake face section (20), which step is limited by a lower limiting line on the side of the cutting edge and an upper limiting line away from the cutting edge, and wherein the rake face in the region of the dome-shaped recesses (30) has a neutral or negative rake angle (β) with respect to the cutting insert plane (40), characterized in that the recesses (30) are formed as conical, cylindrical, ellipsoid or parabolic domes penetrating the cutting edge (10) with their lowest surface line being substantially perpendicular to the clearance face (18).
2. Cutting insert according to claim 1, wherein the rake face section (20) is bent concavely between the cutting edge (10) and the chip forming step (24) in the chip traveling direction and wherein the chip forming step (24) verges in a sharp-edged manner into a central rake face plateau at its upper limiting line (28) away from the cutting edge, characterized in that the chip forming step (24) is bent concavely between the rake face section (20) and the rake face plateau (22) in the





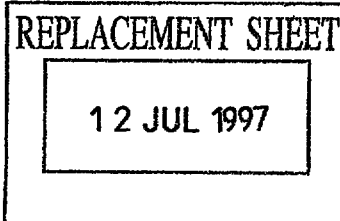
chip traveling direction and joins the rake face section tangentially and that the rake face plateau is disposed above the cutting edge.

3. Cutting insert according to claim 1 or 2, having several cutting edges (10) delimiting a polygon and being penetrated by the dome-shaped recesses (30), characterized in that the cutting edges (10) are partially chamfered in the region between the recesses (30) which are adjacent to each other via the corners of the cutting insert.
4. Cutting insert according to claim 3, characterized in that the cutting edges (10) are chamfered asymmetrically in the region of the corner area between the corner (12) and only one of the adjacent recesses (30), wherein the cutting edges (10) are chamfered in continuation of the chamfer extending from the corner (12) in the region between the recess adjacent the corner (12) and the next recess and possibly also the following recess (30).
5. Cutting insert according to any one of claims 1 to 3, characterized in that the chip forming step (20) runs linearly or wave shaped, substantially parallel to the cutting edge (10) and either touching the dome-shaped recesses (30) with its limiting line (26) at the side of the cutting edge, or being arranged at a distance therefrom.
6. Cutting insert according claim 5, having several cutting edges (10) delimiting a polygon and being penetrated by dome-shaped recesses (30), characterized in that the linear or wave-shaped limiting lines (26,28) of the chip forming steps (24) form at a distance from the cutting edges (10) a similarly contoured polygon.





7. Cutting insert according to any one of claims 1 to 6, characterized in that the distance between the cutting edge (10) and the limiting edge of the recesses (30) at the side of the plateau is less than 50%, preferably 20% to 30% of the distance between the cutting edge (10) and the plateau edge (28) at the side of the cutting edge.
8. Cutting insert according to any one of claims 1 to 7, characterized in that the rake angle (β) in the region of the dome-shaped recesses (30) is 0° to -10° at the cutting edge.
9. Cutting insert according to any one of claims 1 to 8, characterized in that the rake angle (α) of the concave rake face section (20) is positive at the cutting edge and is preferably 10° to 25° .
10. Cutting insert according to any one of claims 1 to 9, characterized in that the chip forming step (24) with its limiting line (26) at the side of the cutting edge runs in a wave- and/or zig-zag-shaped manner and preferably exhibits a wavelength corresponding to the center distance of the recesses (30).
11. Cutting insert according to claim 10, characterized in that the chip forming step (24) with its limiting line (26) at the side of the cutting edge extends wedge-shaped into the regions between the recesses (30) with the wedge tip which points to the cutting edge (10).
12. Cutting insert according to claim 10 or 11, characterized in that the chip forming step (24) with its limiting line (26) at side of the cutting edge extends wedge-shaped into the recesses with the wedge





tip which points to the cutting edge, and forms there the upper edge of the recess.

13. Cutting insert according to any one of claims 10 to 12, characterized in that the chip forming step (24) extends with its limiting line (28) away from the cutting edge wave-shaped and/or zig-zag-shaped substantially in phase or in antiphase parallel to the limiting line (26) at the side of the cutting edge.

