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Sheikh Idrees Ali
Sher E Kashmir University of Agriculture Science and Technology Shalimar, SKUAST-K, Jammu and Kashmir, India

Monica Reshi
Division of Food Science and Technology Sher-E-Kashmir University of Agricultural Sciences and Technology-Srinagar, Faculty of Agriculture, Kashmir, Jammu and Kashmir, India

Correspondence
Sheikh Idrees Ali
Sher E Kashmir University of Agriculture Science and Technology Shalimar, SKUAST-K, Jammu and Kashmir, India

Progress and improve tool life with AlCrN coated inlays in high-speed dry and wet steel

Sheikh Idrees Ali and Monica Reshi

Abstract

In this document, the tool lifetime improvement by coating with aluminum chromium nitride (AlCrN) coated PVD (called Alcrona) for sintered carbide the inserts are examined. Progress in the wear of microstructures, such as wear mechanisms of abrasive tools from AlCrN coated sintered carbide tools in dry and wet machining at very high cutting speeds, are fully analyzed based on experimental tests. Maximum cutting speed achieved at revolutions of 410 m / min. various progressive stages of abrasive wear are observed in experimental results. These results of wear on AlCrN-coated carbide inserts are compared with other life tool data reported in the literature. It was found that 260 m / min, Alcrona achieves 95% better tool wear than the TiAlN carbide tool under the same machining conditions. Comparison the performance of Alcrona coated spray coatings coated with TiN can reach about 33% of the cutting depth and achieve higher cutting speed due to better thermal resistance of coated liners. This finding verifies the speculation that the Alcrona coating improves the coating ability to cut metal and improve tool life even under rough cutting conditions. Types of microstructure wear phenomena captured during During the experimental study are micrographs, micro fracture fractures, microtubule, micro terminal cracks, micro traumas, and micro-abrasion. Experimental cutting observations with basic tool inserts indicate that wear progresses over time and passes through Different phases, namely wear, steady wear and tear of the tool. Evidence is also that the use of the coolant emulsion increases tool life relatively to cutting speeds and significantly reduces wear. SEM and optical microscope imaging tools the wear took place in different phases to submerge into the morphology of tool inserts.

Keywords: Aluminum chromium nitride, alcrona coating, TiAlN carbide tool and PVD

1. Introduction

The aim of this research is to understand microwave wear Unlabeled mechanisms and Alcrona coated liners for high-speed machining in dry and wet conditions. Work focuses on investigating uncontrolled and carbide inserts coated with a surface under hard cutting conditions. This study gives a better idea of understanding the features available coatings on the market, helping with machining professionals choose appropriate machining coatings processes. Coatings are classified as hard coatings and soft coatings based on the difference in hardness between the substrate and the coating. Hard coatings are proven and used more than soft coatings because of their better properties [1]. For high-speed machining we require cement plating carbide tools with a certain type of coating that they can lower loss of material, prolonging the life of tools and parts of machines, and most importantly, reduce wear and tear [2]. Several scientists have that hard coatings placed on tool and machine Parts by different physical methods of steam decomposition can dramatically change the performance of parts. These coatings Materials not only help reduce wear and increase tooling but also improve strength and chemical inertia, reduce friction and increase stability at high temperatures [3]. The use of surface coatings is beneficial in that the substrate the material can be designed for strength and toughness while the coating is responsible for wear resistance, thermal load and corrosion [1]. In recent years, TiN-based coatings have been widely used industry for the protection of cutting tools. Between different alloyingTiN-based coatings applied to tool inserts, TiAlN and TiAlCrNare most often discussed by many researchers. Some recent relevant research results in the area can be found in [4-9, 18-21]. In particular, Luo *et al.* [7] examined tribological behavior of TiAlN/CrN and TiAlCrN coatings different storage methods. They reported that the wear rate forall of these coatings were at least ten times lower than uncoated Tool Insert. Recently, Luo *et al.* [8] further studied the wear mechanism low-friction TiAlN/VN coatings. Based on their observation TEM it was found that multilayered TiAlN/HN coatings resulted in tribofilm formation the worn surface cause's tribooxidation other than traditional isothermal oxidation, better for tool protection. Along the same line, Kovalev *et al*. [9] examined the impact AL and Cr alloying of TiN-based coatings for final cutting performance. They reported that adding Al to TiNof coatings, the chemical reactivity of the coating decreases on the other hand, controls the intensity of crater wear during rotation. Moreover, in [9] it was concluded that adding Cr to TiN coatings improved plasticity of the coating. Authors proved that the simultaneous addition of Al and Cr in the complex TiN-based nitride weakens long-range bonds improve the plasticity of the compound and prolong cutting tool life under severe wear conditions. In addition, Koalas et al. that the TiAlN/CrN wear rate was stable TiAlCrN was sensitive to the change in cutting speed. Their conclusion that nitride coatings increase wear tool steel resistance up to 10 times. Recently, physical vapor decomposition (PVD) has been used extensively compared to other coating processes. It includes atomization or evaporation of material from a solid source a depositing this material on the substrate to form a coating. The advantage of this process is the ability to save alloy compounds, multilayer structure compositions, and the ability to continuously change coating properties functionally graded coating [1]. Just as this process involves temperatures up to 500 °C, overcomes the problem storing a brittle layer. In addition, the PVD process creates a very smooth surface coated product, which leads to a good shifting of the chips through the inserts. Contact zone temperature which further reduces the tendency to heat cracking [4]. The paper is organized as follows. Coolant properties cutting fluid selected for basic machining operations are listed in the following section. The inscription follows experimental details of research work. Then the results experimental testing and related analytical discussion are presented. Finally, some final remarks are made in the last part of the thesis.

2. Tool wear mechanisms

Morphology of wear at high speeds machining is described in this section. Morphology was

Investigated and reported for basic Alcron cutting insert the material. The intention is to provide a valuable insight understanding, optimizing machining operations and gaining sufficient knowledge to improve coatings and coatings techniques related to unconventional high-speed machining operations. Che Haron *et al.* studied the phenomenon of wear-coated and uncoated carbides in a turning tool for dry steel cutting and wet. Work piece material was selected as ISO 95MnCrW1 with 23HRC hardness. Tools with hard metal coating were tested at four different speeds, 200, 250, 300 and 350 m/min, respectively. The results showed that performance covered (TiCN) carbide tools during wet cutting was significantly better than for dry cutting for all selected cutting speeds. The measured tool life was 52, 31, 16 and 14 minutes for wet cutting for cutting speeds of 200, 250, 300 and 350 m/min. The life of the dry cutting tool at the above speeds was measured as 49, 22, 12 and 7 min. Jindal *et al*. [11] studied the performance of PVD used TiN, TiCN and TiAlN coated sintered carbide tools in turning. The experiment was performed at two different speeds, 305 a 396 m/min. For the wear criterion of 0.4 mm, the life of the for Ti tool, TiCN and TiAlN were measured at 40, 50 and 60 minutes, for 305 m/min and 10, 15 and 28 minutes for 396 m/min, respectively. D'Errico *et al*. [12] studied the effect of PVD coatings Cemented tool life for continuous and intermittent rotation. Monolayers thin TiN and TiCN layers were coated onto the cement tool. It was stated that when it comes to coated liners for life better than uncovered inserts.

3. Coolant properties

The refrigerant emulsion quickly influences the temperature of the chips and sometimes can favorably affect chip breaking, in particular when large cross-sections are formed [13, 23, 24].In general, most machining and other machining applications are used water-based coolant emulsion. These contain a microscopic dispersion concentrate in water. Microscopic oil balls are homogeneously dispersed in the cooling medium. Basic the components of these emulsions are water, oil and wetting agents [15].

There are currently many types of cutting liquids market. Cutting fluid used in basic research was a water based emulsion. In concentration, mix with water from 10%. Its properties are shown in Tables 1 and 2.

Table 1: The properties of cutting fluid

Appearance concentration	liquid
Appearance	Opaque-white
Odour	bland
pH (5%)	9.4
Lbs/g	7.6
Flash point	222
Specific gravity	0.96

Table 2: Concentration and refractometer reading for the coolant %

concentration	Refracto meter reading
4%	4.6
5%	5.7
6%	6.8
7%	8.0
8%	9.1
9%	10.3
10%	11.4

4. Preparation of experimental testing

4.1 Selection of tool inserts

There are thousands of paint available on the market. Selection depends on work piece material and speed Machining. BALINIT Alcronawas was selected for this experimental study on the basis of its extraordinary characteristics. Alcrona is AlCrN monolayer by structure. Its high hot hardness results excellent abrasion resistance even at high cutting speeds [16]. The hardness of Alcona is compared to commonly used of the titanium-based coatings of FIG

4.2 Work piece material

This study was conducted in accordance with ISO 3685 [17]. Work piece material was SAE 4140 steel. Part specification are given in Table 3. Chemical composition the work piece is listed in Table 3. The work piece has been replaced when the length/diameter ratio reached 10 in accordance with the ISO standard3685 [17].

Table 3: Workpiece chemical compositions in %

Carbon	**0.4**
Manganese	0.91
Phosphorous	0.017
Sulphur	0.02
Silicon	0.24
Chromium	1.01
Tin	0.008
Aluminium	0.030
vanadium	0.002
Calcium	0.0064
molly	0.2
copper	0.12

4.3. Cutting inserts and tool holder geometry

Inert carbide inserts with 6% cobalt were used in turning tests. The tool holder used in the test is ISOmarkedVBMT 160408. The grinding pad assembled geometry is listed in Table 5.table 6 lists the two types of inserts used in the experiment. The coating properties of both inserts are listed in Table 4. The inserts were firmly attached to the tool holder ISO Design SVJBR 2525 M16.

Table 4: Worpiece Tool geometry

Nose radius (mm)	0.8
Back rake angle	0
End relief angle	0.0873
End cutting edge angle	0.9076
Side cutting edge angle	0.0524
Side rake angle	0
Side relief angle	0.087

4.4. Cutting conditions

Continuous tests of turning SAE 4140 steel rod heat treated were performed on variable spindle speeds (Clausing 1300) lathe with a maximum power of 7.5 HP. Speed The work piece was measured before each cut with (HT-5300) a manual digital tachometer for securing the work piece exactly running at the specified cut speed. Cutting speeds and parameters are given in Tables 8 and 9. An optical microscope with 200x magnification was used to measure wear on the side surface. Scanning electron microscope (SEM) was used to obtain images initiation and micro-treatment mechanisms at different stages tool life. During the test, five high cutting speeds were used in the range of 210 m/min to a maximum speed of 410 m/min, before premature insertion failure. Cutting depth and feed rate during the test period were constant at 1 mm, and 0.14 mm/rev.

Table 5: AlCrN specification

structure	**AlCrN monolayer**
Hardness HV 0.05	3200
Residual compressive stress [GPa]	-3.0
Max operating temperature [c]	1095
Coefficient of friction [AlCrN against steel	0.32

Table 6: cutting speeds in turning

Cutting inserts	**Cutting speed (m/min)**				
Uncoated carbide	60	90	120	150	180
Alcrona coated inserts	210	260	310	360	410

Table 7: feed/depth of cut

Feed rate (mm/rev)	0.14
Depth of cut (mm)	1.0

5. Results of experimental testing and discussion

In this section experimental observations of microwave wear mechanisms are summarized and discussed. Scanning electron microscope images (SEM) and optical microscope images to increase the appearance of wear and microstructure and better understand the phenomenon that is behind this problem result. Several wear mechanism occurs simultaneously during machining processes, these include oxidation, diffuse wear and tear fatigue wear [25]. In the various stages of wear from the beginning to the failure of the tool several degrees of wear have been noted, including welding tip, nose break, micro abrasion, tip failure, nose failure, damage to chips, etc., which are observable and explained in. This section with SEM images taken and an optical microscope through a study.

5.1 Uninflated inserts

The most commonly used carbide inserts were most often un used cutting tool in the manufacturing industry. Material of these carbide inserts is produced by powder metallurgy the technology of sintering fine carbide particles in metal binder. The advantage of the carbide insert over the earlier used high-speed steel tool is its chemical stability at a higher level speed leading to higher temperatures [25]. Chemical composition cemented carbide usually includes tungsten carbide, titanium carbide and cobalt tantalum carbide as a binder.

5.1.1 Experimental Findings for Unpainted Inserts in Wearing mechanisms

In an experiment for machining steel stocks, uncoated carbide inserts with a cutting speed of from 60 to 180 m/min were used for both wet and dry machining. It was found that an adhesion of metal has taken place on the uncoated carbide surface of the crater insert at a very early stage of rotation, as shown Fig. 1. As the cutting speed increases, the temperature increases and the hardness of the insert decreases. Loss of circuit breaker the mechanism results in the longest chips and the accumulation of chips around the cutting tool. This cluster of chips along with the new one the created surfaces shake the tool insert and catalyze growth wear on the side. Slowly with rising friction and temperature the tip starts to roll. Typical sliding wear on the side edge the cutting insert begins to grow parallel to the direction of contact. The adhesive metal layer is torn off the side surface due to the continuous friction between the flank and the flank newly created metal surface [27]. Therefore, micro-abrasion there is a wear mechanism that involves buckling from the substrate material. As a result, micro-holes appear on the surface exhibiting the characteristic property of microatrilation wear as shown in FIG. 1 at 120 m/min under wet cutting. If the pin is lost, the chips are not being removed from the surface of the newly created work piece and the chip the flow velocity across the surface of the cutting tool decreases. It brings it formed edges of the formation on the surface as the chip that flows above the surface of the crater surface will move at the chip rate the top sheet and the back sheet are attached to the craft of the cutting too land will not exceed. These cutter wear effects are displayed in Fig. 2 at a speed of 120 m/min in a dry cut. Overall the performance of the cutting insert during wet machining improves due to the average cutting edge temperature of the cutting too land shear zones [26, 27]. In the event of a tool failure, ie when the wear reaches the limit value 0.6 mm scanning electron microscope (SEM, 500m) the images shown in Figure 1 clearly showed the combination of the tip fracture, nose rupture, crater wear, and massive metal adhesion on the side of the cutting insert and the edge of the tool the break is shown in Figure 1. This mechanical failure is caused subsequent compression and tension on the cutting edge leads to mechanical fatigue and thus prevents any more effective removing material from the surface of the work piece.

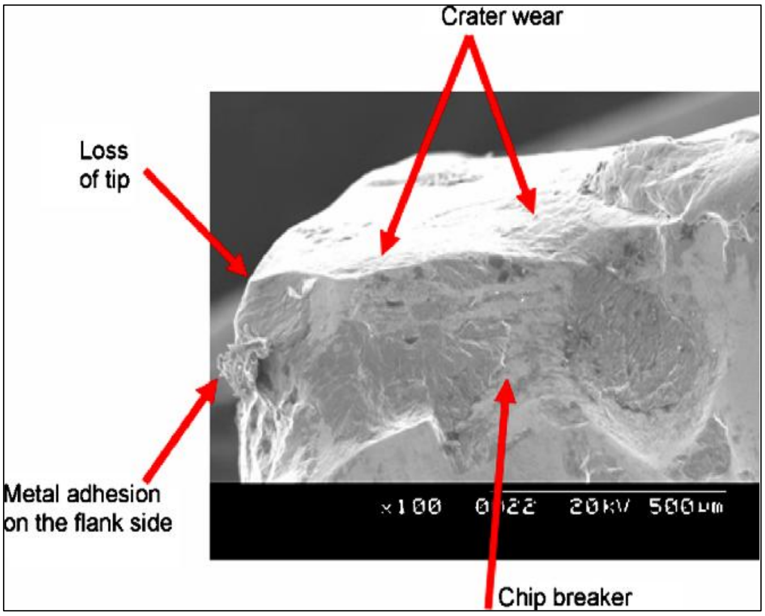

Fig 1: SEM image of Nose part of tool

5.2 Inserted inserts

Coating increases lubricity and reduces affinity to workpiece material. This makes it possible to perform coated inserts much better than unpainted inserts, especially when cutting higher speed. The coating provides a better thermal barrier, so the temperature is reduced [22]. In this current experimental study
Alcron-coated inserts are examined for the first time. This that it is a cover for the next generation thereby achieving longer tool life compared to other titanium coatings easy to use today in the manufacturing industry. The experimental results are extremely important for the coating industry, as well as practitioners of machining to provide a reality sheet for newly tested paint, Alcona, the most suitable for high-speed cutting tools, amongst other hundreds coatings readily available at present (Figure 2).

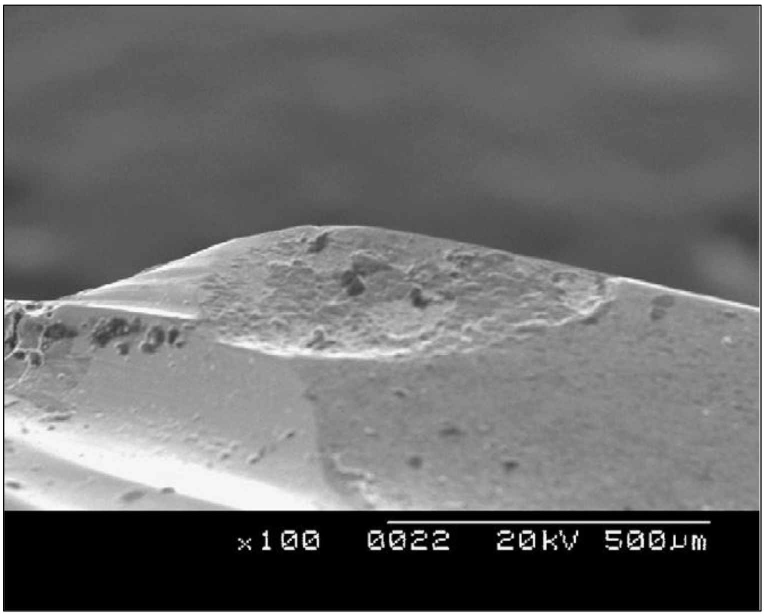

Fig 2: SEM image showing tool’s edge fracture

5.2.1 Experimental finds for Alcrona-coated inserts

Both abrasion wear and stress concentration remain uneven border configuration on microscope after machining begins. Tensile bending is less mild when wet machining compared to dry machining. This is a contribution cooling when lowering the cutting temperature is very strong at higher speeds approaching 410 m/min. However, when using coated dry machining inserts at higher speeds, a high level of microfibers is recorded as shown in FIG. 3.It is also difficult to achieve a uniform droplet size inconsistent droplet size, resulting in increased stress resulting in destructive wear of the paint [15]. Figure 3 shows a tip rupture, crater wear and metal adhesion to the coated liner below Wet cutting at 410 m/min. The coating is damaged and destruction of coatings accelerates the growth of crater wear on surface and leads to a rapid tool failure from the top the cutting insert remains uncovered in this situation. Figure 3 also showed that some of the stuck metal would be torn from tungsten carbide residues and binders insert material. Therefore, thermal drilling, micro adhesion and low level of microencapsulation.

In addition, it is a loss of surface coating and micro-shakes that catalyze the growth of crater wear on the surface of the tool insert, as can be seen in the SEM (50m) of Figure 3. Strong binder distortion itself arises as a result of activation of micro trauma and microabrasionwear during cutting speed conditionsand the introduction of a cooling medium as illustrated in Figure 3. Thus, the micro fatigue,microbrashes and microhard drive wear mechanism are activated in a wet state while high levels of microfibers can be observed in the dry state in which it participates Fig. 11 [15].

In a recent study by Khrais and Lin [14, 22], high speed machining tool wear was investigated for TiAlNand a TiN-TiCN-TiN coated cement liner. For the wear criterion0.4 mm the tool life was measured as 70, 66, 34, 30 and18 min for the TiN-TiCN-TiN tool with dry machining cutting speeds 210, 260, 310, 360 and 410 m/min. The lifetime of the TiAlN tool has been measured for the abovementioned wear. Criteria and Cutting Speed 50, 21, 10, 9 and 7 minfor dry machining. For wet-cutting, tool life has beenReported increase to TiN-TiCNTiN to 85, 70, 50, 45 and 22 min coated tool. It has also been shown that in the case of TiAlN wet machining has had a negative impact and tool life has fallen to 42, 19, 9, 8 and 6 min. For the abovementioned wear criterion and a combination of cutting speed.

For the current experimental study with Alcrona coating for the wear criteria of 0.4 mm measured the life of the cutting tool 54, 40, 15, 7 and 6 min for wet cutting for cutting speeds at 210, 260, 310, 360 and 410 m/min. Anyway wear and cutting speeds for dry machining, cutting the service life was reduced to 51, 32, 11, 5 and 4 min, respectively. Change of wear criteria to 0.6 mm and maintenance cutting speed range, as described above, tool life has been reached 65, 47, 19, 10 and 7 min for wet machining and 57, 38,15, 7 and 6 minutes for dry machining. The tool wear criterion is 0.4 mm and the cutting speed is at 260 m/min, tool life was reported [14] for 19 min Alcron's spraying tool life is 40 minutes, which means is about a 95% increase in tool life. Jindal *et al*. [11] that the tool operates at a 0.75 mm cut-off depth for TiN and TiCN coated liners are 10 and 15 minutes at a speed of 396 m/min. However, our current study at 410 m/min gave the tool life approximately 7 min. Due to the depth of cut ratio, Alcronou standing thanks to the expected lifetime of the Alcrona toolwill be approximately 10-15 minutes at a lower cut depth and reduced cutting speeds. He Haron *et al*. [10] reported the lifetime of the coating tool (TiCn, Al2O3, TiN) as 16 and 12 minutes for wet and dry machining at a speed of 300 m/min. Alcron values were found19 and 15 min. This is about a 20% increase tool life. Experimental work verifies the tool's life span for Alcron, as expected earlier, due to its higher oxidation resistance that gives it chemical stability and ability to withstand temperatures up to 1100 ◦C. It also gives its monolayer structure higher hardness and results in excellent abrasion resistance. Fig. 3 and 4 summarize all experimental graphs measuring tool life on Alcron inserts for cutting AISI 4140 steel at high speeds in dry and wet turning, respectively. It should be noted that the use of coolant has positive effects both non-adhesive carbide inserts and BALINIT-coated inserts Alcrona. The life spans covered by Alcrona show drastic improvement in both quality and machining times reduction. Inked inserts are not only made for a longer period of time, but also survived at speeds of up to 410 m/min. Also the instrument lives for dry and wet cutting are compared based on the extreme results shown in Figures 3 and 4. These comparisons life of the tool against failure with a wear criterion of 0.6 mm are shown in the bar graph in Figure 7. Extending tool life wet dry cutting in percentage at each height the cutting speed is shown in FIG. 6. It will be seen that in FIG the range of cutting speeds (210-410 m/min) used in our machines rotation of experiments, extension of tool life thanks to coolant emulsion increased cutting speed. This finding means that faster machining speed, the better thanks use of cutting fluids.

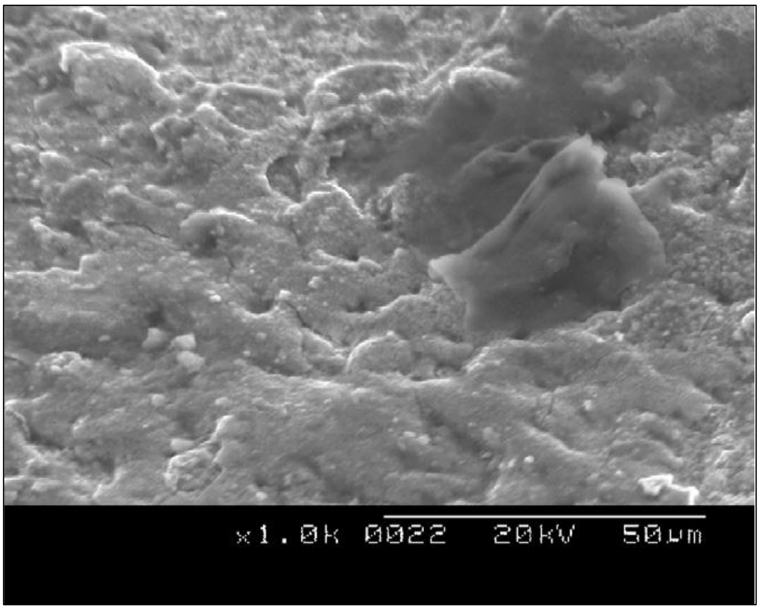

Fig 3: SEM image showing numerous micro holes indicating micro wear and the loss of coating

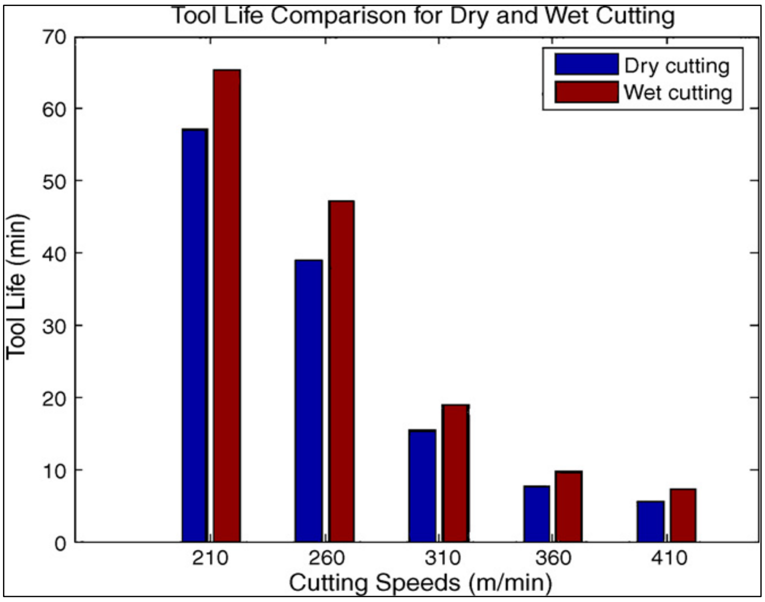

Fig 4: Tool life comparison of high speed dry and wet turning with 0.6mm wear criterion.

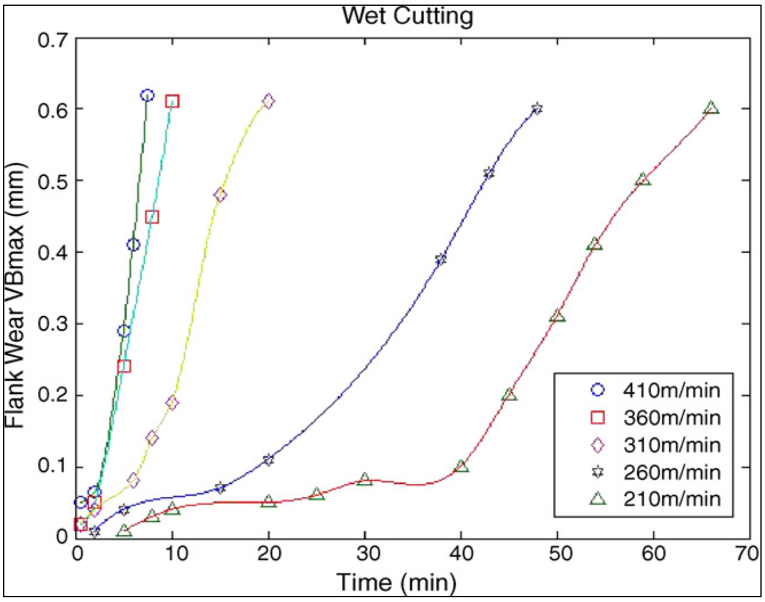

Fig 5: Tool wear vs. cutting time under wet turning.

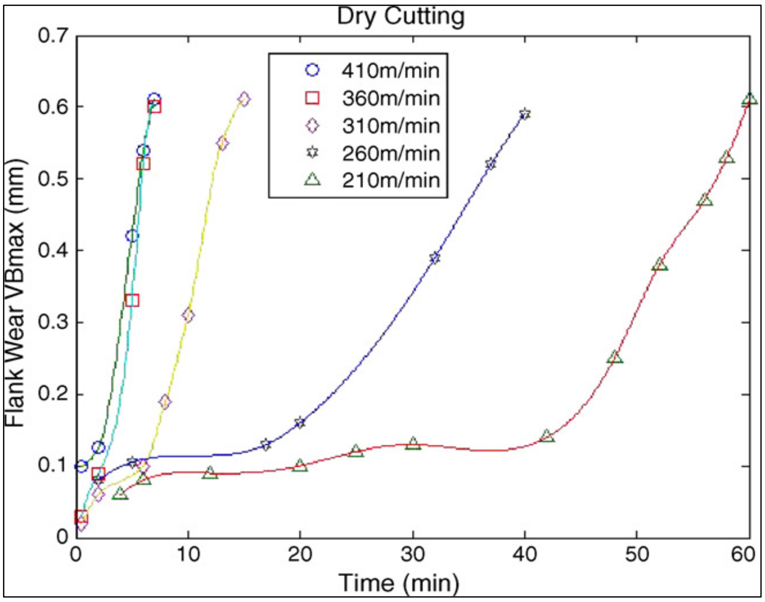

Fig 6: Tool wear vs. cutting time under dry turning

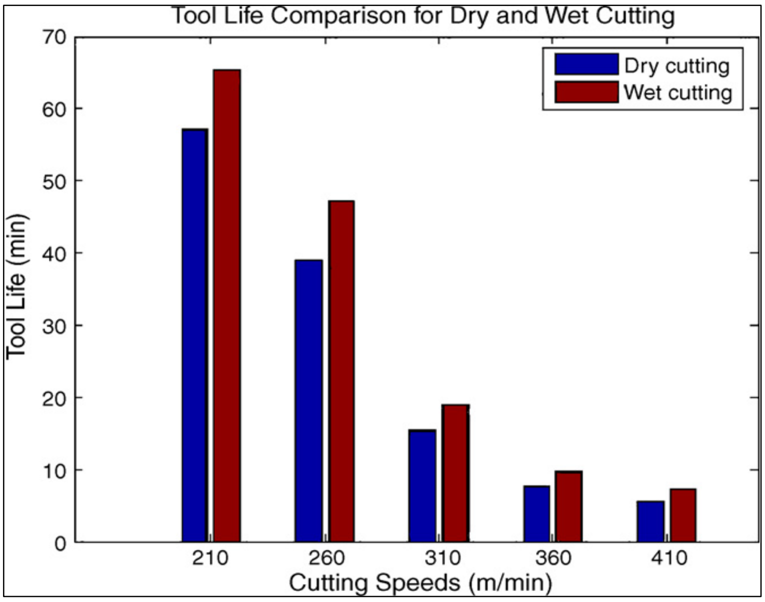

Fig 7: Tool life comparison of high speed dry and wet turning with 0.6mm wear criterion

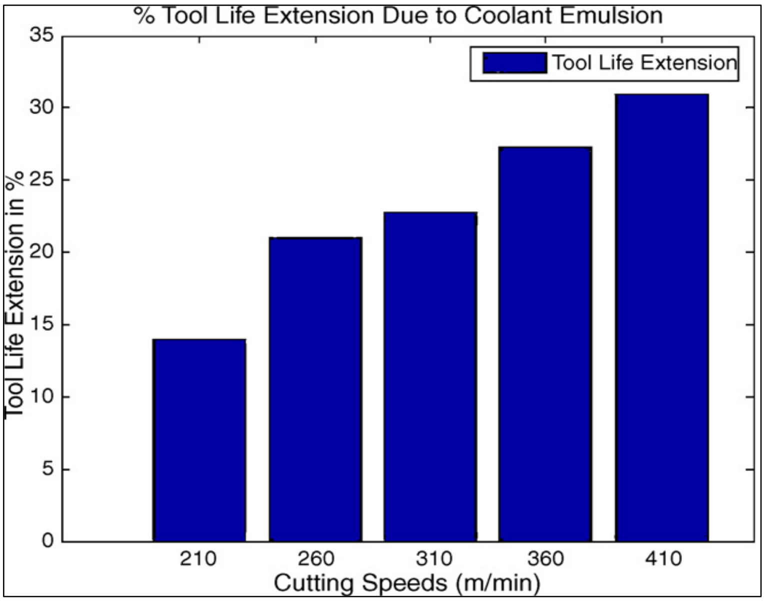

Fig 8: Tool life extension due to coolant emulsion for high speed cutting

6. Conclusions

The useful life of the tool plays a decisive role in estimating expected productivity for specific cutting conditions in 2007 manufacturing. It becomes extremely important both economically and for the good quality that should be chosen tool pad in such a way that it is progressing gradually than to be unpredictable due to its uncertainty working. The current experimental study providesa new dimension when monitoring the performance of the coated material and uncoated carbide inserts for cutting metals with the desired speed. The findings of this research contribute directly

Machining community to determine optimal machining cost and policy of instrument exchange associated with a specific working.

The experimental study began with ISO standards3685 1993 [16]. Five different cutting speeds were selected using both coated and uncoated inserts. Machining was done dry and wet. Cutting speeds have been tested from 60 to 180 m/min for uncoated tools and from 210up to 410 m/min for coated tools. Scanning electron microscope and optical microscope imaging of progressive instrument tool inserts wearing were adopted to better interrogate the health tool in machining at different wear levels. The findings showed that the performance of the liner is drastically increased by applying a coating to the carbide liner. The speed achieved after the coating was twice as fast as the speed uncoated insert. Improvements achieved as a result coating extends tool life, achieves higher cutting speeds, and lower production costs. It was also noted that machining Performance has been improved for both Alcron and Coated Coatings uncoated carbide inserts with the application of a coolant emulsion. Hip wear was measured using an optical microscope on different stages of the machining process and the results were presented graphically. In the light of experimental results it can be summarized that at elevated temperatures, newly tested Alcron coating works much better than others used coatings for tool inserts. Use of coolant emulsion brings a positive impact on the life of the Alcron tool, as noted in most other relevant literature. Performing an experiment on a CNC lathe with an efficient coolant pump at higher speeds will be a proposal for future research in this area. In addition, future research along the line can sink into precise wear modeling new inserts of tools with a coating to reduce the lifetime of tool uncertainties for a similar researching [24-27].

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