

**INFLUENCE OF DRILL GEOMETRY ON BURR
FORMATION CHARACTERIZATION**

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FORMATION CHARACTERIZATION**

Thesis submitted accordance with the requirements of the National Technical University
College of Malaysia for the Degree of Bachelor of Engineering Manufacturing
(Honours) (Manufacturing Design)

By

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May 2007



UNIVERSITI TEKNIKAL MALAYSIA MELAKA (UTeM)

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JUDUL: INFLUENCE OF DRILL GEOMETRY ON BURR FORMATION CHARACTERIZATION

SESI PENGAJIAN: 2006/2007

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DECLARATION

I hereby, declare this thesis entitled “Influence of Drill Geometry on Burr Formation Characterization” is the results of my own research except as cited in the reference.

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ABSTRACT

This report describe about “Influence of Drill Geometry on Burr Formation Characterization”. In this study the entrance and exit burr will be investigate by using a different of drill bit with coated TiN and TiAlN. The selection of cutting tool is coated to investigate the burr formation, tool wear and surface roughness. The selected point angles of drill bit are 120° to compare of burr formation characterization, surfaces roughness, and tool wear and the effect of speed and feed rate to the work piece will be discuss. In this study the burr will be measure by using of Horizontal Optical Comparator, the tool wear was measure by Tool Maker Microscope and surface roughness was measure by Portable Surface Roughness SJ-301. The diameter of cap burr formation will be measured at the exit burr. The appropriate material that used in this study is stainless steel 300 series. The burr formation will be investigated on this material. The experiment was run by using CNC Milling Machine. This experiment called hard drilling because coolant not use for this experiment and used high speed and feed rate for drilling operation.

ABSTRAK

Laporan ini membincangkan tentang pengaruh geometri mata gerudi dalam kewujudan burr. Dalam kajian ini burr pada permukaan atas dan bawah akan dikaji dengan menggunakan mata gerudi yang berbeza dan disalut dengan TiN dan TiAlN. Pemilihan mata gerudi jenis bersalut adalah untuk mengkaji kewujudan burr, kehausan mata gerudi dan kekasaran permukaan. Sudut mata gerudi yang dipilih ialah 120° untuk membandingkan kewujudan burr, kekasaran permukaan dan kehausan mata gerudi serta membincangkan kesan kelajuan gelendong dan kadar suapan pada bendakerja. Dalam kajian ini kewujudan burr akan diukur dengan menggunakan 'Horizontal Optical Comparator' kehausan mata gerudi akan diukur dengan menggunakan 'Tool Maker Microscope' dan kekasaran permukaan akan diukur dengan menggunakan Portable Surface Roughness SJ-301. dalam kajian ini, bendakerja yang akan digunakan ialah 'Stainless Steel siri 300' dan kewujudan burr akan dikaji pada bendakerja ini. Eksperimen ini dijalankan dengan menggunakan 'CNC Milling Machine'. Eksperimen ini dipanggil menggerudi keras kerana bahan penyejik tidak digunakan dan menggunakan kelajuan gelendong dan kadar suapan yang tinggi semasa eksperimen dijalankan.

ACKNOWLEDGEMENTS

Alhamdulillah, I would like to express my thankfulness to Allah S.W.T for giving me all the strength that I need in fulfilling and completing my Final Year Project (PSM). Firstly I would like to thank my supervisor, Mr. P. S. Sivarao, for his constructive guidance, encouragement and patience in fulfilling our aspiration in completing this project and also to my entire lecture and technician for their advice and motivation in develop in this project. Last but no least, I would like to thank all my friends in Universiti Teknikal Malaysia Melaka (UTeM) for giving me support and the ideal information about the project. Special thanks also to my parents and sisters for their support throughout the course in completing my project.

DEDICATION

Specially dedicated to My beloved Father Gzali b. Ahmad, My Mother, Halimah bt. Saad My Sisters Nor Zarina Bt Gzali, and special dedicated to NurDina Bt Ramli who are very concern, understanding, patient and supporting. Thanks for everything to My supervisor Mr P. S. Sivarao for his constructive guidance, encouragement and patience in fulfilling our aspiration in completing this project. To All My Friends, I also would like to say thanks. The Work and Success will never be achieved without all of you.

TABLE OF CONTENT

Abstract.....	i
Abstrak.....	ii
Acknowledgement.....	iii
Dedication.....	iv
Table of Contents.....	v
List of Figures	ix
List of Tables	xiv
1. 0 INTRODUCTION.....	
.....1	
1.1 Introduction.....	1
1.2 Drilling Machine.....	2
1.2.1 Drill bit.....	3
1.2.2 Point Angle.....	5
1.2.3 Coated drill bit.....	6
1.2.4 Drill wear.....	7
1.3 Machining Parameter.....	8
1.3.1 Drilling Speed.....	8
1.3.2 Drilling Feed.....	9
1.3.3 Drilling Parameter.....	9
1.4 The burr formation process.....	12
1.4.1 The burr formation process.....	12
1.4.2 Burr reduction in drilling.....	13
1.4.3 Burr Hunting Overview.....	14
1.4.4 Lighting for Inspection.....	15
1.4.5 Getting the Dimensions.....	16

1.5 Material Selection.....	16
1.5.1 Stainless Steel.....	16
1.5.2 Types of Stainless Steel.....	17
1.5.3 Stainless Grade.....	18
1.6 Measuring Equipment.....	19
2.0 LITERATURE REVIEW.....	20
2.1 Introduction.....	20
2.2 Reviewed Of Burr Formation.....	21
2.3 Problem Statement.....	36
2.4 Objectives.....	37
2.5 Scope of Study.....	37
2.6 Importance of Study.....	37
2.7 Outline of Study.....	38
3.0 METHODOLOGY.....	39
3.1 Methodology flow chart.....	39
3.2 Selection of Topic Study.....	40
3.3 Literature Review.....	40
3.4 Design of Experiment (DOE)	40
3.5 Parameter selection.....	41
3.6 Experiment.....	41
3.7 Measurement	42
3.8 Data Analysis.....	42
4.0 EXPERIMENTAL METHODOLOGY.....	43
4.1 Machine Selection.....	43
4.2 Process Planning.....	45
4.3 Parameter Selection.....	46
4.4 Design Parameter.....	46

4.5 Design of Experiment (DOE) Matrix.....	47
4.6 Preparation of Work Piece.....	48
4.6.1 Hardness Testing To Selected Material.....	48
4.7 Work Piece Cut by Laser Cutting.....	51
4.8 Selection of Drill Bit.....	54
4.9 Drill Bit (Tool Marking).....	54
4.10 Work Piece Marking.....	55
4.11 Coding of CNC Machine (Drilling).....	56
4.12 Experimental For 5mm Diameter Of Drill Bit Using TiN and TiAlN Coating Tool.....	57
4.13 Experimental For 8mm Diameter Of Drill Bit Using TiN and TiAlN Coating Tool.....	60
4.14 Tool performance evaluation (wear).....	63
4.14.1 Equipment for Measure Tool Wear	64
4.15 Work Quality Evaluation of Burr and Surface Roughness (Ra).....	65
4.15.1 Burr Formation Measurement.....	65
4.15.2 Equipment for Measure Burr Formation.....	65
4.15.3 Surface Roughness (Ra) Measurement.....	66
4.15.4 Equipment for Measure Surfaces Roughness.....	66
4.16 Conclusion of Performance and Quality Evaluation of Coated Drill Tools.....	69
5.0 RESULT AND DISCUSSION.....	70
5.1 Descriptions for Result and Discussion.....	70
5.2 Comparison of Tool Wear between TiN and TiAlN Coated Drill Bit with used drill bit 5mm Diameter.....	72
5.3 Burr Formation Comparison for Work Piece Size 65mm X 55mm with used TiN and TiAlN Coated.....	74
5.3.1 Comparison of Burr Formation between TiN and TiAlN Coated Drill Bit with used drill bit 5mm Diameter at Plate 65mm x 55mm.....	76

5.4 Result and Discussion for Drill Bit Size 8mm Diameter with Coated TiN and TiAlN.....	78
5.4.1 Comparison of Tool Wear between TiN and TiAlN Coated Drill Bit with used drill bit 8mm Diameter.....	80
5.5 Burr formation for comparison for work piece size 104mm x 88mm.....	82
5.5.1 Comparison of Burr Formation between TiN and TiAlN Coated Drill Bit with used Drill Bit 8mm Diameter.....	84
5.6 Comparison Surface Roughness at Work Piece Size 104mm X 88mm.....	86
5.6.1 Comparison of Surfaces Roughness between TiN and TiAlN Coated Drill Bit with used Drill Bit 8mm Diameter.....	88
5.7 Comparison of TiN Coated for Tool Wear between Diameters 5mm and 8mm...90	
5.8 Comparison of TiAlN Coated for Tool Wear between Diameters 5mm and 8mm.....	93
5.9 Comparison of TiN Coated for Burr Formation between Diameters 5mm and 8mm.....	96
6.0 Comparison of TiAlN Coated for Tool Wear between Diameters 5mm and 8mm.....	99
6.0 CONCLUSION AND RECOMANDATION.....	102
REFERENCES.....	104
APPENDIXES.....	108
A EQUIPMENT MEASUREMENT.....	108
B TOOL BIT SELECTION.....	109
C G-CODE FOR DRILLING PROCESS.....	110

LIST OF FIGURE

1-1: Schematic illustration of (a) vertical drill press, (b) CNC turret drilling machine.....	3
1-2: Nomenclature of a twist drill shown with taper and tang drives.....	5
1-3: point angle of drill bit.....	6
1- 4: drill bit coated with TiN.....	7
1- 5: The burr formation process.....	12
2-1: Burr formation on stainless steel.....	21
2-2: Figure 2-2: Proposed Types of the Interlayer Burr in the Drilling Process of the Multi-Layered Materials (Sangkee Min, 2000).....	34
3-1: Scanning Electron Microscope (SEM).....	42
4-1: CNC Haas Milling.....	43
4-2: hardness tester.....	49
4-3: Drawing of work piece with used Catia for 8mm diameter of hole with dimension 104mm x 88mm.....	50
4-4: Drawing of work piece with used Catia for 5mm diameter of hole with dimension 65mm x 55mm.....	50
4-5: laser cutting machine.....	51
4-6: Work piece with dimension 104mm x 88mm was cut by laser cutter.....	51
4-7: Work piece with dimension 65mm x 55mm was cut by laser cutter.....	51
4-8: burr occurs after cutting process with laser cutting.....	52
4-9: Removing burr process with using chisel technique.....	52
4-10: Do the sachet process with used filed technique.....	52
4-11: equipment was used for sachet process.....	53
4-11: condition of workpiece after sachet process.....	53
4-12: work piece for do the experiment.....	53
4-13: engraver and drill bit.....	54

4-14: work piece was marking.....	55
4-15: illustration of direction when do the drilling process.....	55
4-16: Plate sizes 104mm x 88mm for define the coordinate and generate G-code.....	56
4-17: Plate sizes 65mm x 55mm for define the coordinate and generate G-code.....	57
4-18: find the datum and height of drill bit.....	58
4-19: center drill.....	58
4-20: tool wear measurement for tool 5mm diameter	60
4-21: find the datum and height of drill bit.....	61
4-22: center drill for work piece size 104mm x 88mm.....	61
4-23: tool wear measurement for tool 8mm diameter	63
4-24: Methods to measure tool wear.....	63
4-25: tool wears measurement.....	64
4-26: Tool Maker Microscope.....	64
4-27: vertical Optical Comparator.....	65
4-28: measurement diameter burr.....	66
4-29: Roughness specimen.....	66
4-30: Surface roughness tester SJ-301.....	67
4-31: Third measurement for get center point.....	69
4-32: surface measurement method.....	69
5-1: Methods to measure tool wear.....	71
5-2: measurement location for cap burr.....	71
5-3: Third measurement for get center point for averaged.....	72
5-1: comparison of tool wear for experiment 1 and 8 with same feed rate (0.20mm/rev) and speed (20m/min).....	72
5-2: comparison of tool wear for experiment 2 and 6 with same feed rate (0.20mm/rev) and speed (16m/min).....	72
5-3: comparison of tool wear for experiment 3 and 5 with same feed rate (0.12mm/rev) and speed (20m/min).....	73

5-4: comparison of tool wear for experiment 7 and 4	
with same feed rate (0.12mm/rev) and speed (16m/min).....	73
5-5: comparison of burr for experiments 1 and 8	
with same feed rate (0.20mm/rev) and speed (20m/min).....	76
5-6: comparison of burr for experiment 2 and 6	
with same feed rate (0.20mm/rev) and speed (16m/min).....	76
5-7: comparison of burr for experiment 3 and 5	
with same feed rate (0.12mm/rev) and speed (20m/min).....	77
5-8: comparison of burr for experiment 7 and 4	
with same feed rate (0.12mm/rev) and speed (16m/min).....	77
5-9: comparison of tool wear for experiment 1 and 8	
with same feed rate (0.20mm/rev) and speed (20m/min).....	80
5-10: comparison of tool wear for experiment 2 and 6	
with same feed rate (0.20mm/rev) and speed (16m/min).....	80
5-11: comparison of tool wear for experiment 3 and 5	
with same feed rate (0.12mm/rev) and speed (20m/min).....	81
5-12: comparison of tool wear for experiment 7 and 4	
with same feed rate (0.12mm/rev) and speed (16m/min).....	81
5-13: comparison of burr formation for experiment 1 and 8	
with same feed rate (0.20mm/rev) and speed (20m/min).....	84
5-14: comparison of burr formation for experiment 2 and 6	
with same feed rate (0.20mm/rev) and speed (16m/min).....	84
5-15: comparison of burr formation for experiment 3 and 5	
with same feed rate (0.12mm/rev) and speed (20m/min).....	85
5-16: comparison of burr formation for experiment 7 and 4	
with same feed rate (0.12mm/rev) and speed (16m/min).....	86
5-17: comparison of surfaces roughness for experiment 1 and 8	
with same feed rate (0.20mm/rev) and speed (20m/min).....	88
5-18: comparison of surfaces roughness for experiment 2 and 6	
with same feed rate (0.20mm/rev) and speed (16m/min).....	88

5-19: comparison of surfaces roughness for experiment 3 and 5 with same feed rate (0.12mm/rev) and speed (20m/min).....	89
5-20: comparison of surfaces roughness for experiment 7 and 4 with same feed rate (0.12mm/rev) and speed (16m/min).....	90
5-21: comparison of tool wear for TiN coated and diameter 5mm and 8mm for experiment 1 and 1 with same feed rate (0.20mm/rev) and speed (20m/min)	91
5-22: comparison of tool wear for TiN coated and diameter 5mm and 8mm for experiment 2 and 2 with same feed rate (0.20mm/rev) and speed (16m/min)	91
5-23: comparison of tool wear for TiN coated and diameter 5mm and 8mm for experiment 3 and 3 with same feed rate (0.12mm/rev) and speed (20m/min).....	92
5-24: comparison of tool wear for TiN coated and diameter 5mm and 8mm for experiment 7 and 7 with same feed rate (0.12mm/rev) and speed (16m/min)	93
5-25: comparison of tool wear for TiAlN coated and diameter 5mm and 8mm for experiment 4 and 4 with same feed rate (0.12mm/rev) and speed (16m/min).....	94
5-26: comparison of tool wear for TiN coated and diameter 5mm and 8mm for experiment 5 and 5 with same feed rate (0.12mm/rev) and speed (20m/min).....	94
5-27: comparison of tool wear for TiN coated and diameter 5mm and 8mm for experiment 6 and 6 with same feed rate (0.20mm/rev) and speed (16m/min).....	95
5-28: comparison of tool wear for TiN coated and diameter 5mm and 8mm for experiment 8 and 8 with same feed rate (0.20mm/rev) and speed (20m/min).....	96
5-29: comparison of burr formation for TiN coated and diameter 5mm and 8mm for experiment 1 and 1	

with same feed rate (0.20mm/rev) and speed (20m/min).....	97
5-30: comparison of burr formation for TiN coated and diameter 5mm and 8mm for experiment 2 and 2 with same feed rate (0.20mm/rev) and speed (16m/min).....	98
5-31: comparison of burr formation for TiN coated and diameter 5mm and 8mm for experiment 3 and 3 with same feed rate (0.12mm/rev) and speed (20m/min)	98
5-32: comparison of burr formation for TiN coated and diameter 5mm and 8mm for experiment 7 and 7 with same feed rate (0.12mm/rev) and speed (16m/min)	98
5-33: comparison of burr formation for TiAlN coated and diameter 5mm and 8mm for experiment 4 and 4 with same feed rate (0.12mm/rev) and speed (16m/min).....	99
5-34: comparison of burr formation for TiN coated and diameter 5mm and 8mm for experiment 5 and 5 with same feed rate (0.12mm/rev) and speed (20m/min).....	100
5-35: comparison of burr formation for TiN coated and diameter 5mm and 8mm for experiment 6 and 6 with same feed rate (0.20mm/rev) and speed (16m/min).....	100
5-36: comparison of burr formation for TiN coated and diameter 5mm and 8mm for experiment 8 and 8 with same feed rate (0.20mm/rev) and speed (20m/min).....	101

LIST OF TABLE

1-1: part at drill bit.....	3
1-2: General recommendations for speed and feeds in drilling (Kalpakjian 2001).....	10
1-3: General recommendations for drill geometry for high speed twist drills (Kalpakjian 2001).....	11
1-4: Type of burr formation on drilling.....	13
1-5: Gred of stainless steel.....	18
2-1: Cutting conditions (feed (mm/min)/spindle speed (rpm)).....	29
2-2: process parameter Sangkee Min, 2002,	32
4-1: Standard feature.....	43
4-2: Available Control Options for Haas Mills.....	44
4-3: recommended speed and feed rate.....	46
4-4: 10% increase for speed and feed rate.....	46
4-5: Speed and feed rate for drill bit 5mm diameter.....	47
4-6: Design of Experiment (DOE) for drill bit 5mm diameter.....	47
4-7: Speed and feed rate for drill bit 8mm diameter.....	48
4-8: Design of Experiment (DOE) for drill bit 8mm diameter.....	48
4-9: comparison hardness of stainless steel and mild steel.....	49
4-10: common material used in thin film coating.....	54
4-11: Speed and feed rate for drill bit 5mm diameter.....	59
4-12: Design of Experiment (DOE) for drill bit 5mm diameter.....	59
4-13: Speed and feed rate for drill bit 5mm diameter.....	62
4-14: Design of Experiment (DOE) for drill bit 8mm diameter.....	62
4.15: Standard Accessories.....	68
5-1: Average results for tool wear for each experiment with use drill bit size 5mm diameter.....	71

5-2: average result for burr formation for each experiment on work piece size 65mm x 55mm.....	75
5-3: Average results for tool wear for each experiment with used drill bit size 8mm diameter.....	79
5-4: Average value for cap burr formation on work piece size 104mm x 88mm.....	83
5-5: Average value for surfaces roughness on work piece size 104mm x 88mm.....	87

CHAPTER 1

1.0 INTRODUCTION

1.1 Introduction

In every machining burr are formed as a result at plastic deformation. In drilling operations usually produce burrs on both the entrance and the exit surfaces of the work piece. The entrance burr forms on the entrance surface as material near the drill undergoes plastic flow. The exit burr is a part of the material extending off the exit surface of the work piece. Most burr-related problems in drilling are caused by the exit burr because the exit burr is much larger than the entrance burr. Burrs are a source of dimensional errors, jamming and misalignment when do the assembly process. They may cause short circuits in electrical components and may reduce the fatigue life of components. Furthermore, burrs can be a safety hazard to personnel because they are usually sharp. The existence of burrs on a work piece is source of the dimensional errors. The burr may reduce the fatigue life of the parts since the hardened and brittle burr material can act as a crack initiation point. Debris of the burrs can cause serious damage on the moving parts. This is why we try to avoid the formation of a drilling burr or at least to minimize it, or sometimes, to control the type of the burr.

The formation of the drilling burr depends on many parameters such as characteristics of work pieces (material properties, geometries, surface roughness), drills (material

properties, geometries, tool wear, temperature, chip formations), and process parameters (cutting speed, feed rate, usage of coolant, rigidity of machine, temperature).

In burr formation there are many type of burr such as crown burr, crown burr with inner cap fragment attached, petal burr, uniform burr, uniform burr with a drill cap, uniform burr without cap and transient burr. All these type of burr depend on cutting parameter, speed and feed, and material. A uniform burr that has a relatively uniform burr height and thickness along the hole periphery, and triangular cross-section, is the most common type of drilling burr.

The influence of drill geometry is a one thing to make a burr perform in drilling process. So, in this study the selection of drill bit must be exactly for minimize the burr formation. The selection of point angle is important thing to minimize burr formation, so in this study the point angle of drill bit was selected is 120° to investigate the burr formation on drilling. And lastly the entrance and exit burr was measure by using Horizontal Optical Comparator. The burr will measure at diameter of cap burr formation on drilling.

1.2 Drilling Machine

One of the most important and essential tools in any metalworking shop is the drilling machine or drill press. Although the drilling machine is used primarily for drilling holes, it is often used for reaming, boring, tapping, counterboring, countersinking, and spotfacing. All drilling machines operate on the same basic principle. The spindle turns the cutting tool, which is advanced either by hand or automatically into a workpiece that is mounted on the table or held in a drill press vise. Successful operation of any drilling machine requires a good knowledge of the machine, proper set-up of the work, correct speed and feed, and proper use of cutting fluids applied to the cutting tool and work. Many types and sizes of drilling machines are used in manufacturing. They range in size from a simple bench mounted sensitive drill press to the large multiple-spindle machines able to drive many drills at the same time. Figure 1 shows a schematic diagram of a

standard vertical drill press as well as a schematic diagram of a turret-drilling machine. Described below are these and other types of drill presses such as sensitive and radial drills. Drilling is the process most commonly associated with producing machined holes. Although many other processes contribute to the production of holes, including boring, reaming, broaching, and internal grinding, and drilling accounts for the majority of holes produced in the machine shop. This is because drilling is a simple, quick, and economical method of hole production. The other methods are used principally for more accurate, smoother, larger holes. They are often used after a drill has already made the pilot hole.

Drilling is one of the most complex machining processes. The chief characteristic that distinguishes it from other machining operations is the combined cutting and extrusion of metal at the chisel edge in the center of the drill. The high thrust force caused by the feeding motion first extrudes metal under the chisel edge. Then it tends to shear under the action of a negative rake angle tool.

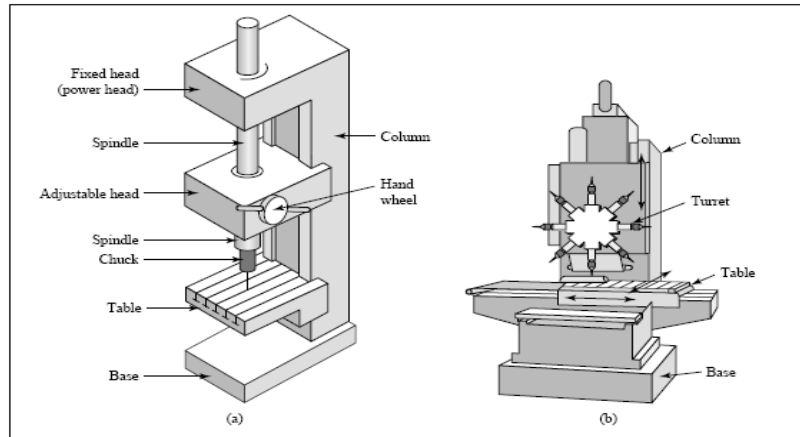


Figure 1-1: Schematic illustration of (a) vertical drill press, (b) CNC turret drilling machine.

1.2.1 Drill bit

A drill is an end-cutting tool for producing holes. It has one or more cutting edges, and flutes to allow fluids to enter and chips to be ejected. The drill is composed of a shank, body, and point.

Table 1-1: Part at drill bit

Shank	The shank is the part of the drill that is held and driven. It may be straight or tapered. Smaller diameter drills normally have straight shanks. Larger drills have shanks ground with a taper and a tang to insure accurate alignment and positive drive.
Body	The body of the drill extends from the shank to the point, and contains the flutes. During sharpening, it is the body of the drill that is partially ground away.
Point	The point is the cutting end of the drill.
Flutes	Flutes are grooves that are cut or formed in the body of the drill to allow fluids to reach the point and chips to reach the workpiece surface. Although straight flutes are used in some cases, they are normally helical.
Margin	The margin is a short portion of the land not cut away for clearance. It preserves the full drill diameter.
Chisel Edge.	The edge ground on the tool point along the web is called the chisel edge. It connects the cutting lips
Lips	The lips are the primary cutting edges of the drill. They extend from the chisel point to the periphery of the drill.
Axis	The axis of the drill is the centerline of the tool. It runs through the web and is perpendicular to the diameter.
Length	Along with its outside diameter, the axial length of a drill is listed when the drill size is given. In addition, shank length, flute length, and neck length are often used.
Body Diameter Clearance	The height of the step from the margin to the land is called the body diameter clearance.
Helix Angle.	The angle that the leading edge of the land makes with the drill axis is called the helix angle. Drills with various helix angles are available for different operational requirements
Point Angle	The included angle between the drill lips is called the point angle. It is varied for different workpiece materials.
Lip Relief Angle	Corresponding to the usual relief angles found on other tools is the lip relief angle. It is measured at the periphery.
Chisel Edge Angle	The chisel edge angle is the angle between the lip and the chisel edge, as seen from the end of the drill. It is apparent from these partial lists of terms that many different drill geometries are possible.