

Introduction to Manufacturing, AGE-1320
Ahmed M. El-Sherbeeney, PhD
Fall-2025

Manufacturing Engineering Technology in SI Units, 6th Edition

Chapter 24: Machining Processes: Milling
(Milling, Broaching, Sawing, Filing and Gear
Manufacturing)

Chapter Outline

2

1. **Introduction**
2. **Peripheral milling**
3. **Face milling**
4. **End milling**
5. **Other milling operations**
6. **Milling machines**

1. Introduction

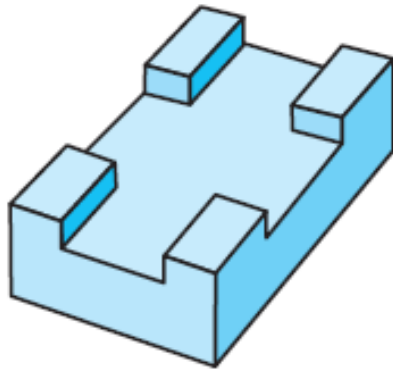


Introduction

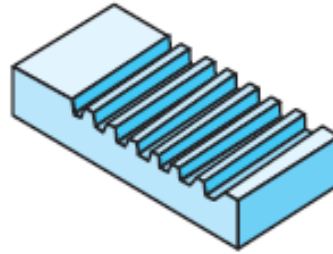


4

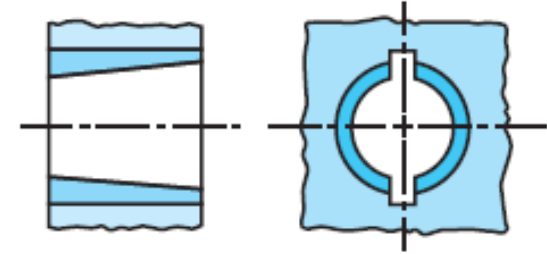
- Last chapter: processes that produce round shapes
- Milling:
 - ▣ One of most common, versatile, economical machining processes
 - ▣ Rotating cutter removes material, traveling along various axes w.r.t. workpiece:
 - ▣ Milling cutter – multitooth tool: produces num. of chips / 1 rev
 - ▣ Takes place in a variety of configurations
 - ▣ Produces parts w/ complex external and internal features
- Similar processes (not discussed here):
 - ▣ Planing, shaping, broaching, sawing, filing, gear manufacturing
 - ▣ Either tool or workpiece travel along straight path
 - ▣ Produce flat or various shaped surfaces



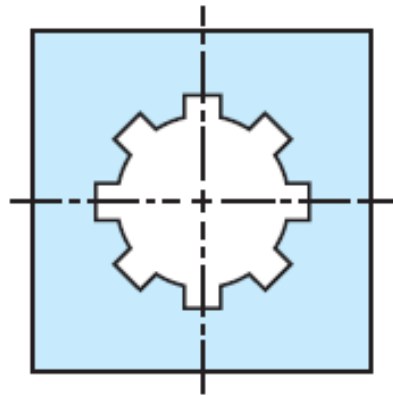
(a)



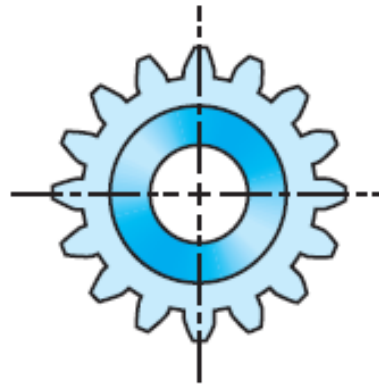
(b)



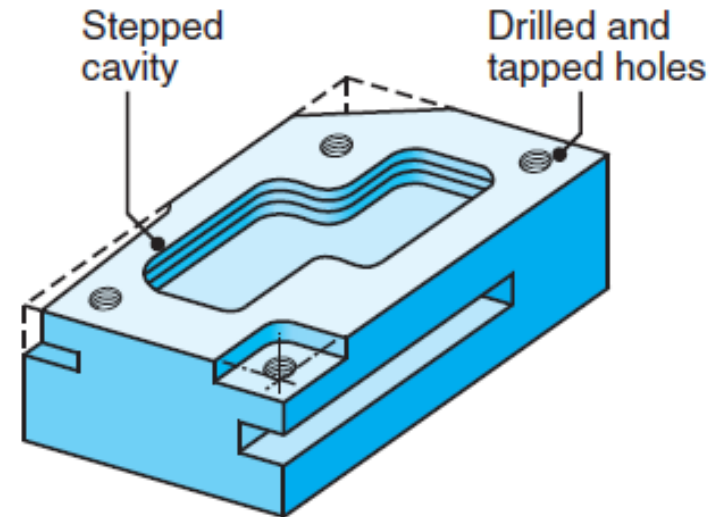
(c)



(d)



(e)



(f)

Typical parts and shapes that can be produced with machining processes described in this chapter. Can you guess how a) – f) are produced?

Introduction



6

Some basic types of milling cutters and milling operations:

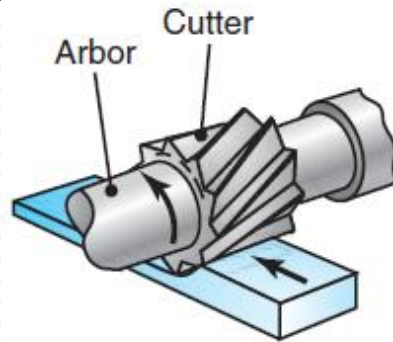
a) Peripheral (aka plain milling)

b) Face milling

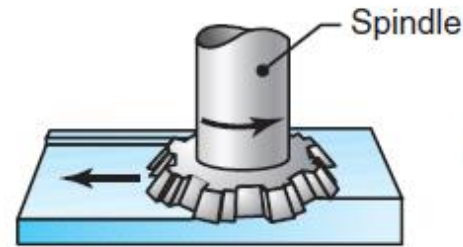
c) End milling

d) Ball-end mill (with indexable coated-carbide inserts)

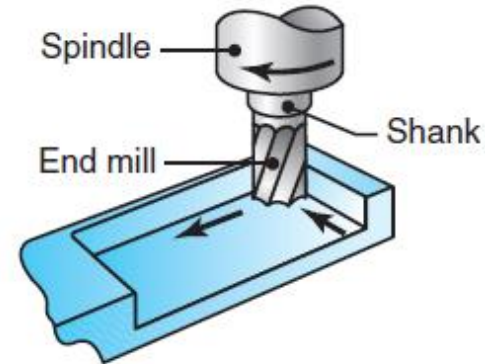
e) End mill using [5-axis](#) NC machine



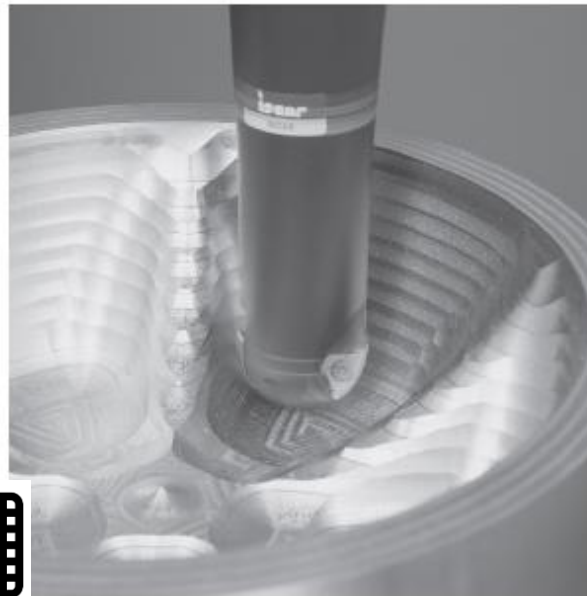
(a) Peripheral milling



(b) Face milling



(c) End milling



(d)



(e)

4-Flute Ball
Nose End Mill



2. Peripheral Milling

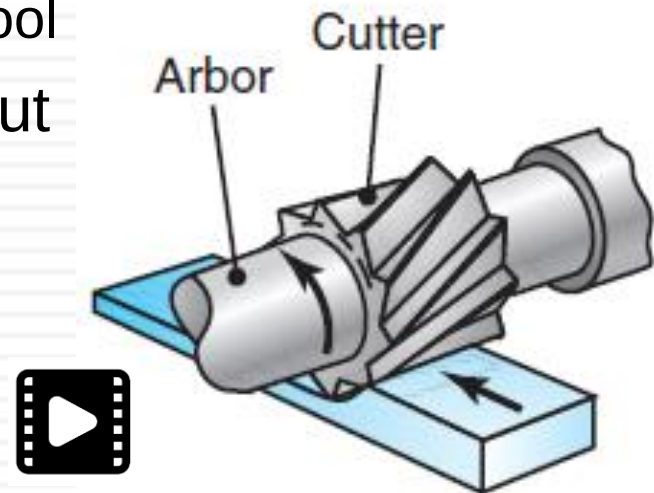
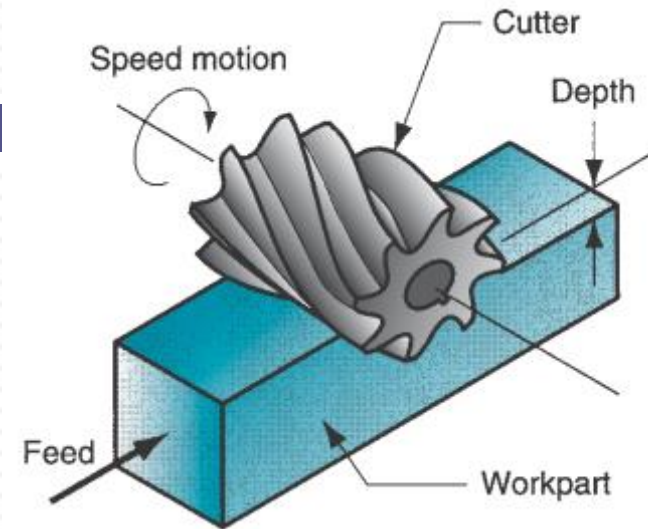


Milling and Milling Machines:

Peripheral Milling

8

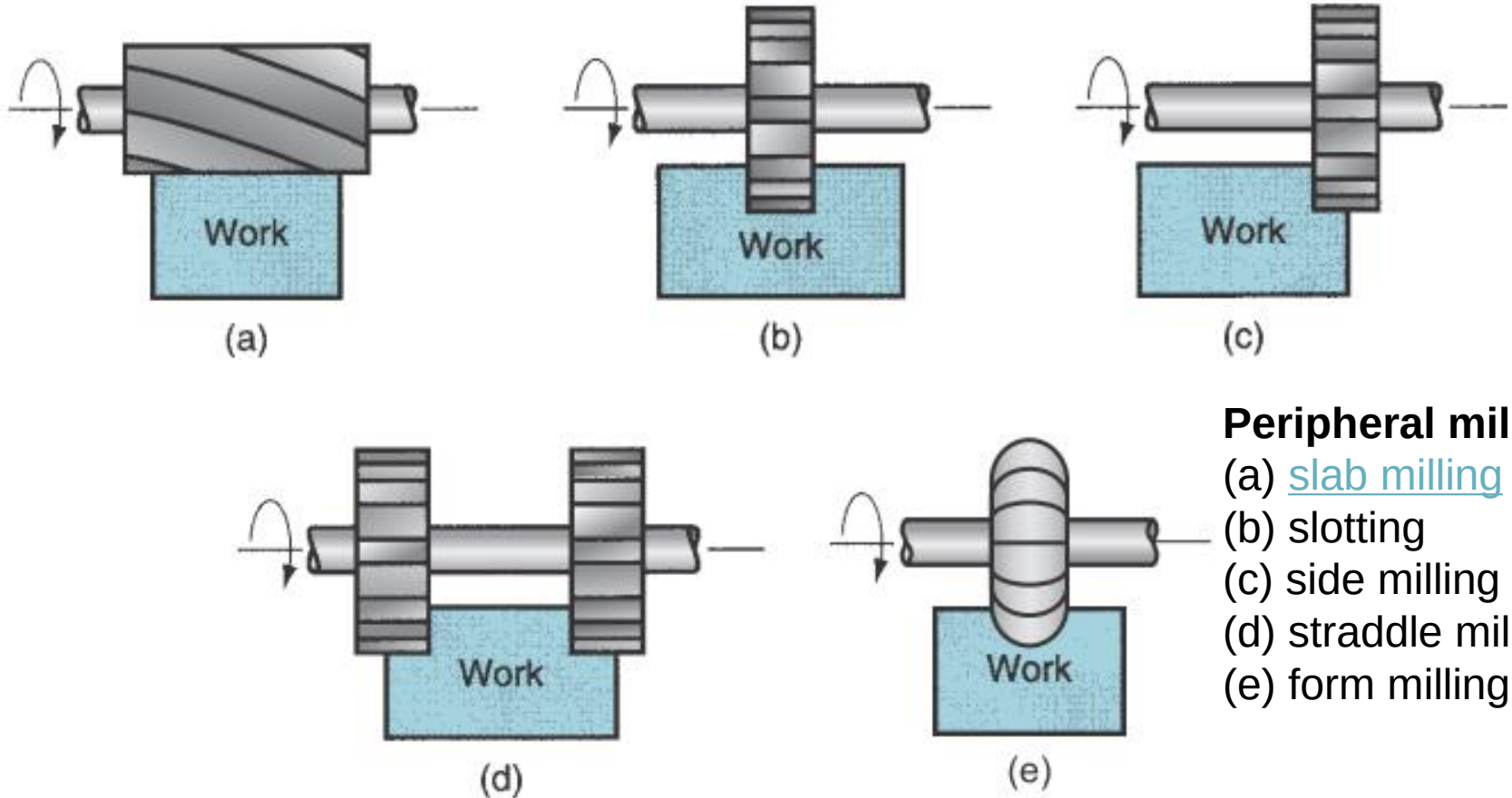
- Axis of cutter rotation: parallel to workpiece surface
- Cutter body:
 - ▣ Generally made of high-speed steel
 - ▣ Has # of teeth along its circumference
 - ▣ Each tooth acts like a single-cutting tool
- When cutter: longer than width of cut
 - ▣ $\Rightarrow$ process is called *slab milling*
- Other types of peripheral milling are shown on the [next slide](#)



Milling and Milling Machines:

Peripheral Milling

9



Peripheral milling:

(a) [slab milling](#)

(b) slotting

(c) side milling

(d) straddle milling

(e) form milling

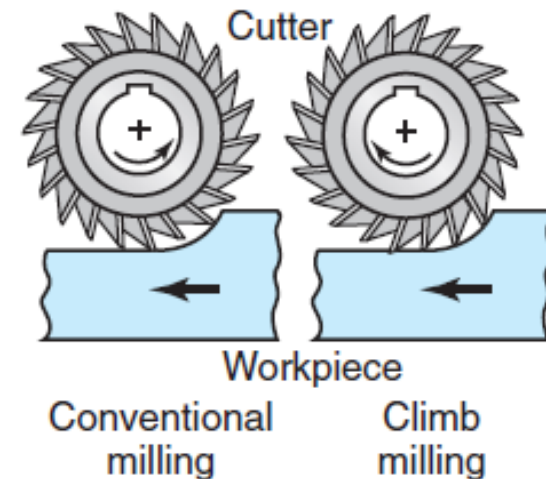
Milling and Milling Machines:

Peripheral Milling

10

Conventional Milling and Climb Milling

- Cutter rotation:
 - ▣ Conventional (aka up) milling,
 - ▣ Climb (aka down) milling
 - ▣ This is significant in operation



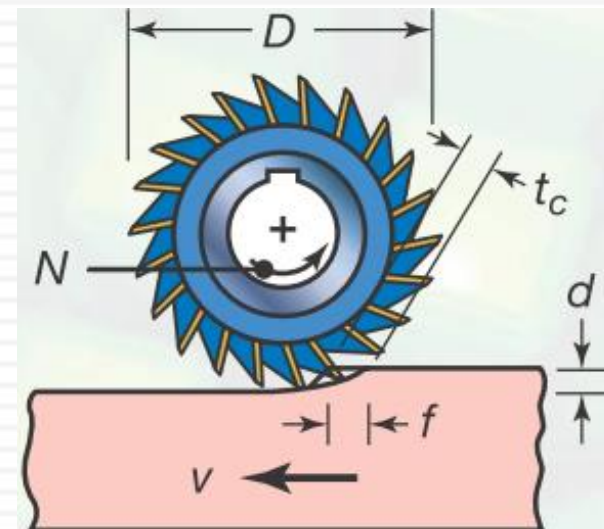
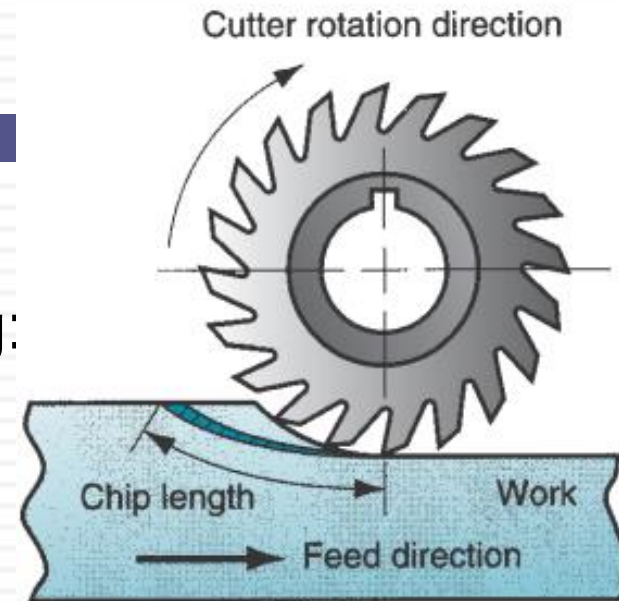
Milling and Milling Machines:

Peripheral Milling

11

Cont. Conventional / Climb Milling

- Conventional (more common) milling:
 - ▣ max. t_c is at end of cut
 - ▣ i.e. as tooth leaves workpiece (→)
- Advantage:
 - ▣ Tooth engagement: not function of workpiece surface characteristics
- Disadvantages:
 - ▣ If cutter teeth not sharp $\Rightarrow$ tooth rubs on surface before cutting
 - ▣ Also: tool may chatter; workpiece may be pulled upward



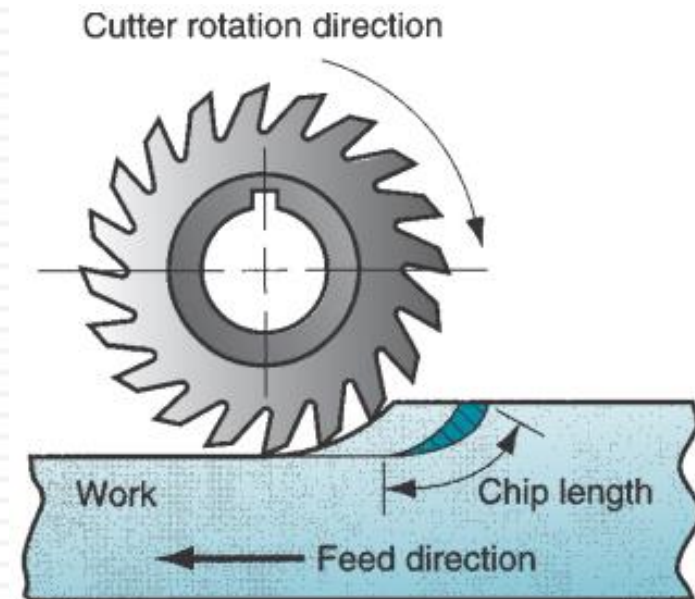
Milling and Milling Machines:

Peripheral Milling

12

Cont. Conventional / Climb Milling

- Climb milling:
 - ▣ Cutting starts at surface of workpiece where chip is thickest →
- Advantage:
 - ▣ Downward component of F_c holds workpiece in place (esp. thin parts)
- Disadvantages:
 - ▣ Requires rigid work-holding setup
 - ▣ Not suitable for workpieces with scale (e.g. hot-worked metals)
 - ▣ Note, scale $\Rightarrow$ more wear $\Rightarrow$ lower T (tool life)



Milling and Milling Machines:

Peripheral Milling

13

Slab milling operation showing:

d : depth of cut

f : feed per tooth

w : width of cut (not shown)

t_c : chip depth of cut

v : workpiece speed (feed rate)

D : cutter diameter

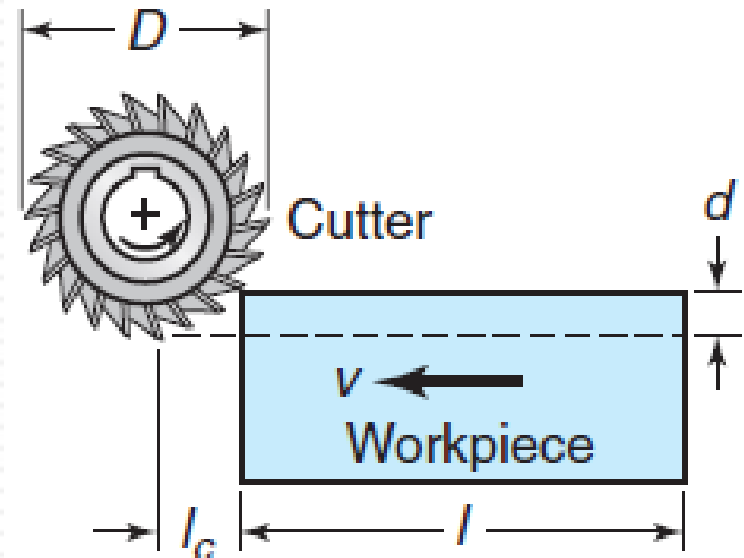
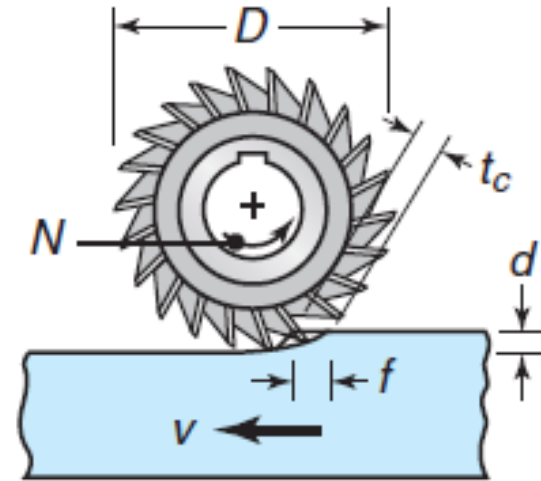
N : cutter rotational speed

n : number of teeth on cutter periphery

Schematic illustration of:

l_c : cutter travel distance (horizontal) to reach full depth of cut

l : length of workpiece



Milling and Milling Machines:

Peripheral Milling

14

Milling Parameters

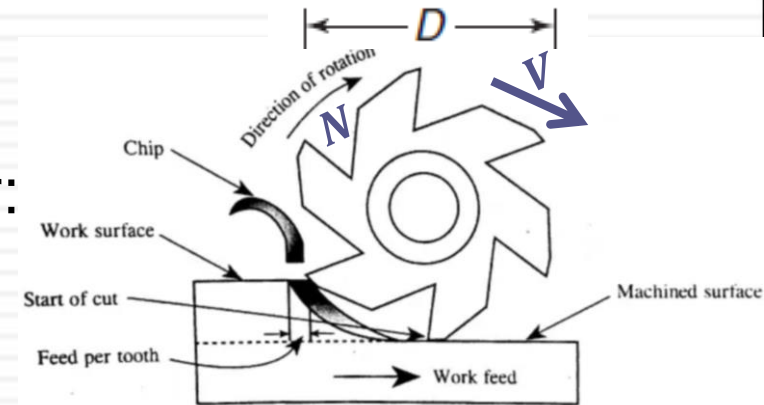
- Cutting speed in peripheral milling is surface speed of cutter:

$$V = \pi DN$$

- t_c in slab milling:

- ▣ Varies along its length (due to relative longitudinal motion between cutter and workpiece)
- ▣ As $t_c \uparrow \Rightarrow F_c \uparrow$
- ▣ For straight-tooth cutter, approx. t_c :

$$t_c = 2f \sqrt{\frac{d}{D}}$$



Milling and Milling Machines:

Peripheral Milling

15

Milling Parameters (cont.)

- f : distance workpiece travels per tooth of cutter:

$$f = \frac{v}{Nn}$$

- Note, dimensional accuracy can be checked:

$$[mm/tooth] = [mm/min] / [rev/min] [num. of teeth/rev]$$

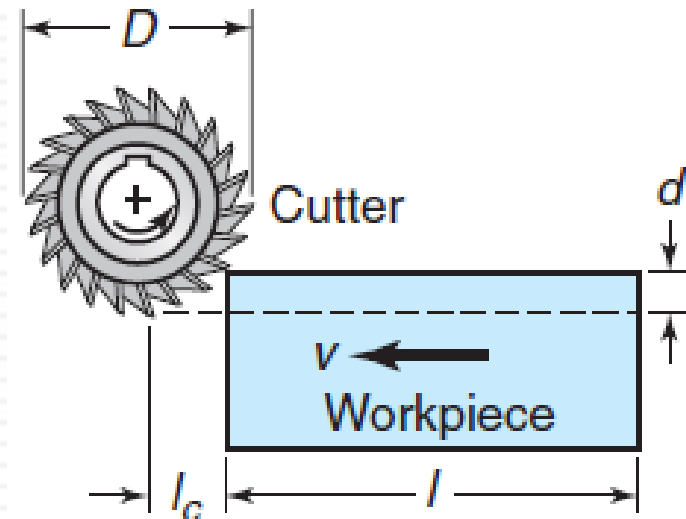
- Cutting time is given by:

$$t = \frac{l + l_c}{v}$$

- Note, l_c : horizontal extent of cutter's first contact with workpiece

- l_c can be approximated using:

$$l_c = \sqrt{d(D - d)}$$



Milling and Milling Machines:

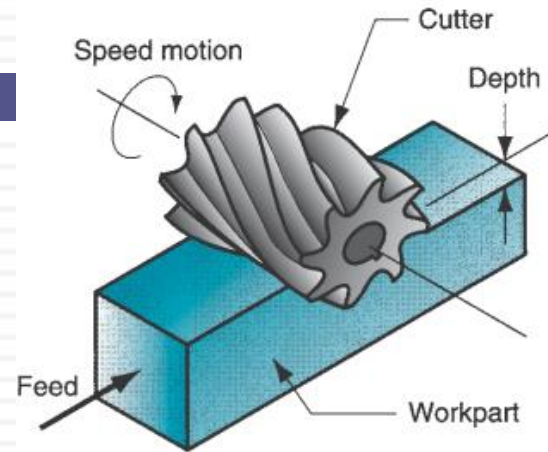
Peripheral Milling

16

Milling Parameters (cont.)

- Assuming $l_c \ll l \Rightarrow$ MRR is given by:

$$MRR = \frac{lwd}{t} = wdv$$



- Note, in slab milling: w is same as w of workpiece
- Also, as with turning, non-cutting time should be minimized
- Power requirement on spindle:
 - Calculated similar to technique used in drilling
 - Note, forces on cutter (tangential, radial, axial):
 - Difficult to calculate (since many variables are involved)
 - Many variables related to cutting-tool geometry

Milling and Milling Machines:

Peripheral Milling

17

Summary of Peripheral Milling Parameters and Formulas

N = Rotational speed of the cutter, rpm

F = Feed, *mm/rev*

D = Cutter diameter, mm

n = Number of teeth on cutter

v = Linear speed of the workpiece or feed rate, mm/min

V = Surface speed of cutter m/min

$$= \pi DN$$

f = Feed per tooth, mm/tooth

$$= v/Nn$$

$$t_c = 2f \sqrt{\frac{d}{D}}$$

l = Length of cut, mm

t = Cutting time, s or min

$$= (l + l_c)/v, \text{ where } l_c = \text{extent of the cutter's first contact with the workpiece}$$

$$l_c = \sqrt{d(D - d)}$$

MRR = mm³/min

$$= wdv, \text{ where } w \text{ is the width of cut}$$

Torque = N · m

$$= F_c D/2$$

Power = kW

$$= (\text{Torque})(\omega), \text{ where } \omega = 2\pi N \text{ radians/min}$$

(advanced)

Milling and Milling Machines:

Peripheral Milling

18

EXAMPLE 24.1

Material-removal Rate and Cutting Time in Slab Milling

A slab-milling operation is being carried out on a 300-mm-long, 100-mm-wide annealed mild-steel block at a feed f 0.25 mm/tooth and a depth of cut d 3.0 mm. The cutter is $D=50$ mm in diameter, has 20 straight teeth, rotates at 100 rpm and, by definition, is wider than the block to be machined. Calculate the material-removal rate and calculate the cutting time.

Milling and Milling Machines:

Peripheral Milling

19

Solution

Material-removal Rate, Power, Torque, and Cutting Time in Slab Milling

The linear speed of the workpiece is

$$v = fNn = (0.25)(100)(20) = 500 \text{ mm/min}$$

The material-removal rate is

$$MMR = (100)(3)(500) = 150,000 \text{ mm}^3 / \text{min}$$

The cutting time is

$$t = \frac{300 + \sqrt{Dd}}{500} = \frac{300 + \sqrt{(50)(3)}}{500} = 0.62 \text{ min} = 37.2 \text{ s}$$

3. Face Milling



Milling and Milling Machines:

Face Milling

21

□ Face milling cutter:

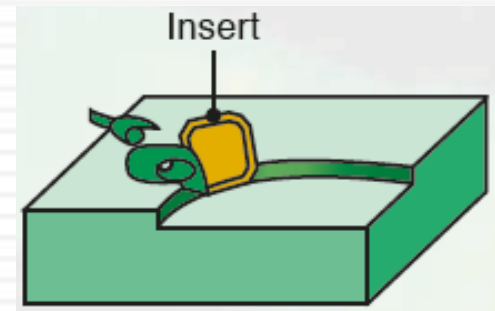
- ▣ Mounted on a spindle
- ▣ Axis of rotation: $\perp$ to workpiece surface
- ▣ Removes material in manner shown ($\rightarrow$)
- ▣ Cutting teeth:
 - Example: carbide inserts
 - Mounted on the cutter body



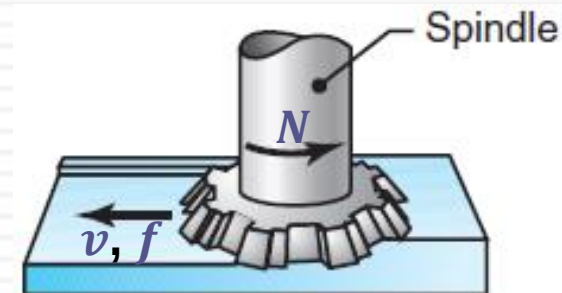
Indexable
Face Mill
(FAST)



Precision
Face Milling



- ▣ Cutter: rotates at rotational speed, N
- ▣ Workpiece: moves along straight path at linear speed, v
- ▣ Rotates as:
climb or conventional milling ([next slide](#))

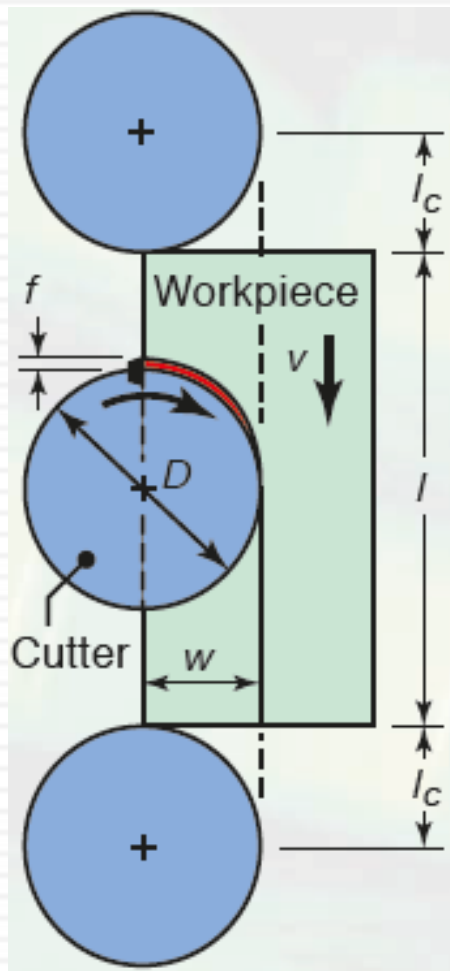


(b) Face milling

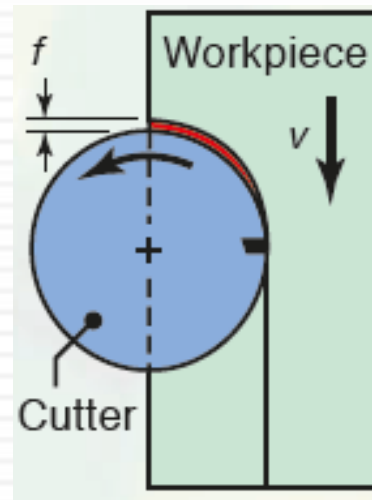
Milling and Milling Machines:

Face Milling

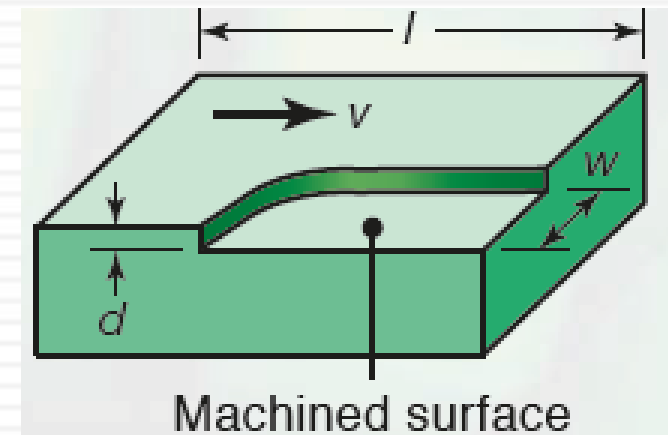
22



Climb milling



Conventional milling



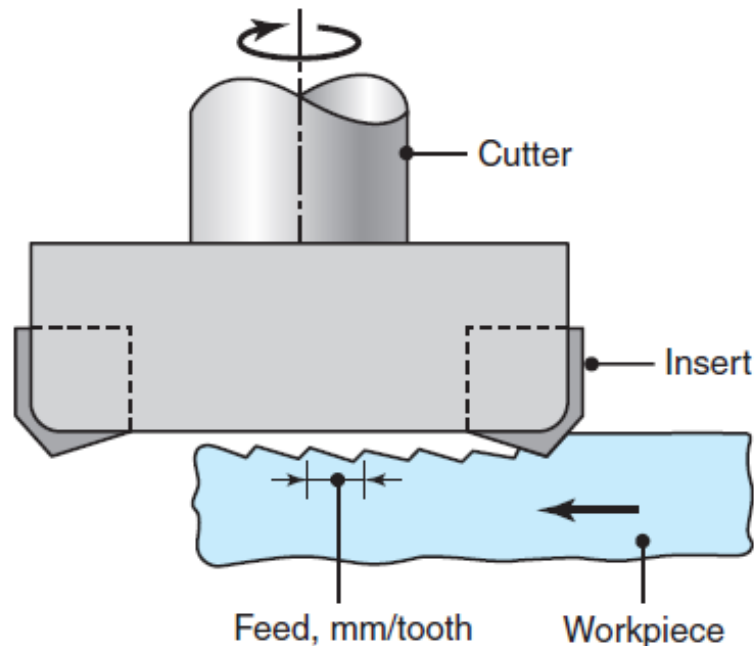
Dimensions in face milling

Milling and Milling Machines:

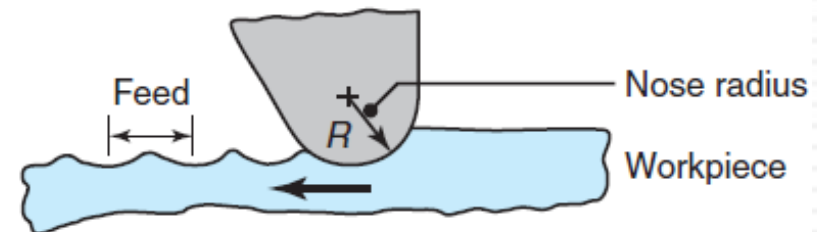
Face Milling

23

- Relative motion between cutter teeth and workpiece $\Rightarrow$ **feed marks** on machined surface ($\downarrow$)
 - ▣ Note, these marks are similar to those left by turning
 - ▣ Roughness of workpiece depends on: corner geometry and f



Feed marks due to various insert shapes

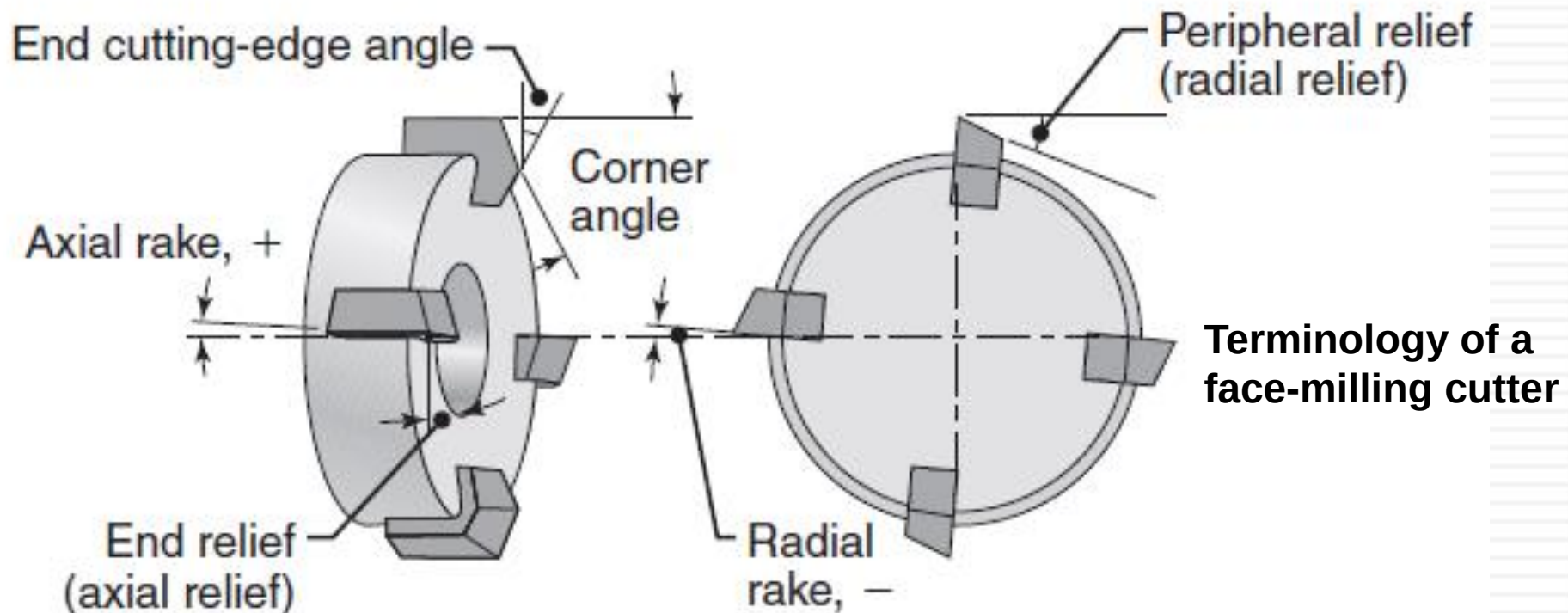


Milling and Milling Machines:

Face Milling

24

- Face-milling cutter: terminology and various angles:
 - ▣ 2 cutting angles
 - ▣ 2 rake angles
 - ▣ 2 relief angles



4. End Milling

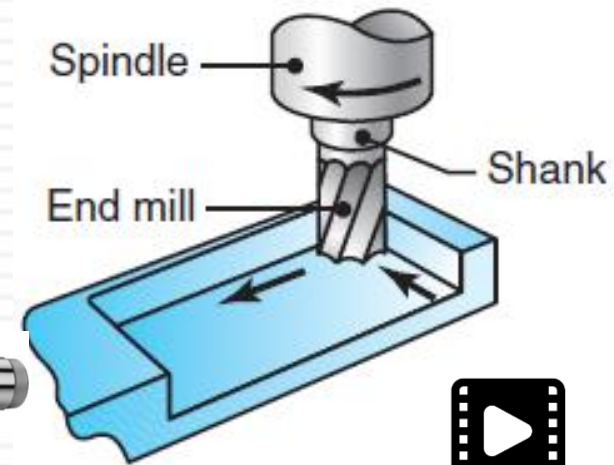


Milling and Milling Machines:

End Milling

26

- End milling:
 - ▣ Important and common machining process
 - ▣ Versatile: produces various profiles, curved surfaces
- Cutter (aka **end mill**):
 - ▣ Has straight shank, or
 - ▣ Tapered shank (for larger sizes)
 - ▣ Mounted into spindle of milling machine
 - ▣ Made of HSS or carbide inserts (like face milling)
 - ▣ Usually rotates on axis $\perp$ to workpiece surface
 - ▣ Can be tilted to conform to curved surfaces



End Milling
(CNC)

Milling and Milling Machines:

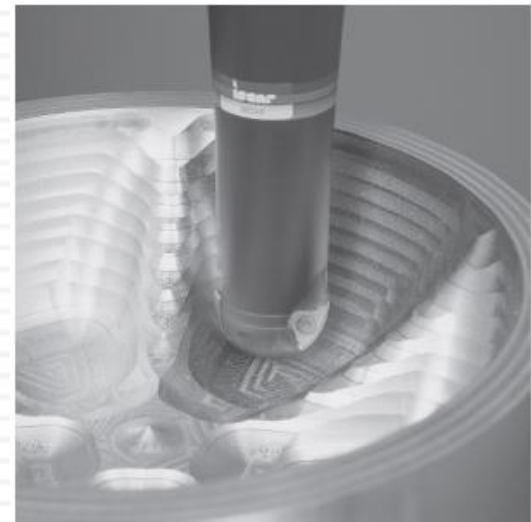
End Milling

27

- Cont. end mills:
 - ▣ Available with hemispherical ends (aka ball nose mills →)
 - ▣ Can produce variety of surfaces, at any depth
 - ▣ Used in machining dies and molds
 - ▣ Examples:
curved, stepped, pocketed surfaces (→)
 - ▣ Can remove material on both end and cylindrical cutting edges



Ball Nose End Mill



5. Other Milling Operations



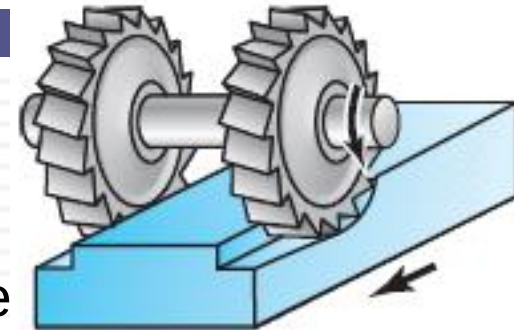
Milling and Milling Machines:

Other Milling Operations and Milling Cutters

29

□ Straddle milling:

- ▣ Two or more cutters: mounted on an arbor
- ▣ Used to machine 2 // surfaces on workpiece



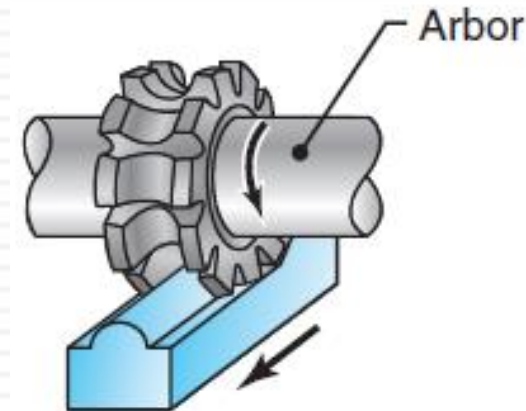
(a) Straddle milling

□ Form milling:

- ▣ Produces curved profiles
- ▣ Uses cutters with specially shaped teeth
- ▣ Also used for cutting gear teeth



Profile
Milling



(b) Form milling

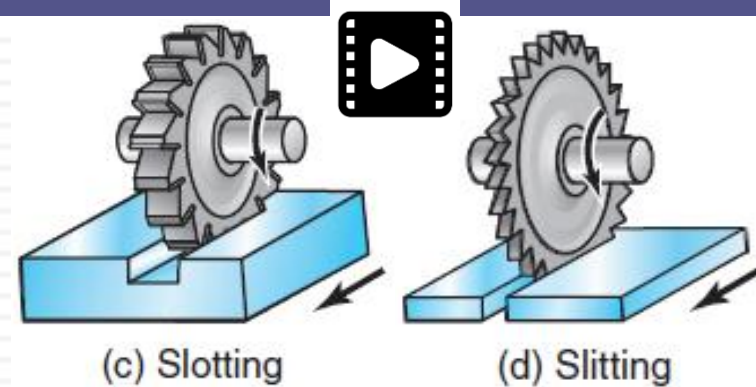
Milling and Milling Machines:

Other Milling Operations and Milling Cutters

30

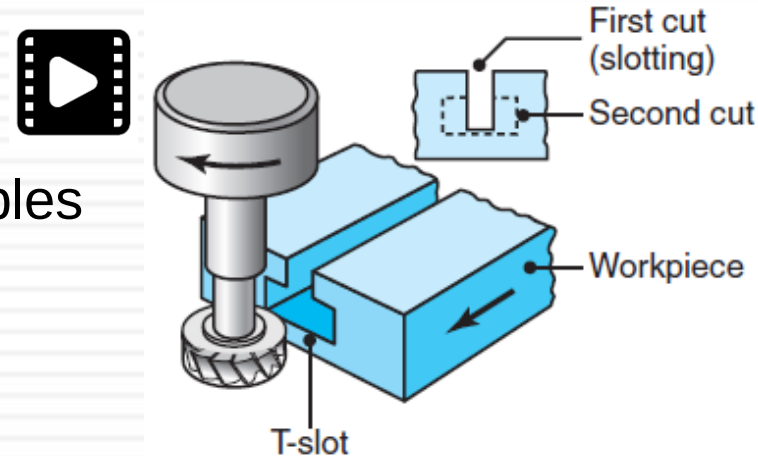
□ **Slotting & Slitting** operations:

- Performed with circular cutters
- Slitting saws: thin (usu. $< 5\text{ mm}$)



□ **T-slot cutters:**

- Used to mill T-slots
- Application: machine-tool worktables for [clamping workpieces](#)
- Step 1: slot is milled with end mill
- Step 2: cutter machines profile of T-slot in one pass



Milling and Milling Machines:

Milling Process Capabilities

31

- [Table 24.2](#) shows (for milling), conventional ranges of:
 - ▣ Speeds (vary widely: 30 – 3000 *m/min*)
 - ▣ Feed per tooth (typically: 0.1 – 0.5 *mm*)
 - ▣ Depths of cut (usually: 1 – 8 *mm*)
- Note, large range of values shown is due to variance in:
 - ▣ Workpiece material
 - ▣ Workpiece condition
 - ▣ Cutting-tool material
 - ▣ Process parameters
- Note, cutting fluid recommendations:
 - ▣ Same as those used with turning/hole making operations

General Recommendations for Milling Operations

32

		General-purpose starting conditions		Range of conditions	
		Feed mm/tooth	Speed m/min	Feed mm/tooth	Speed m/min
Material	Cutting tool				
Low-carbon and free-machining steels	Uncoated carbide, coated carbide, cermets	0.13–0.20	120–180	0.085–0.38	90–425
Alloy steels					
Soft	Uncoated, coated, cermets	0.10–0.18	90–170	0.08–0.30	60–370
Hard	Cermets, PcBN	0.10–0.15	180–210	0.08–0.25	75–460
Cast iron, gray	Uncoated, coated, cermets, SiN	0.10–0.20	120–760	0.08–0.38	90–1370
Soft					
Hard	Cermets, SiN, PcBN	0.10–0.20	120–210	0.08–0.38	90–460
Stainless steel, Austenitic	Uncoated, coated, cermets	0.13–0.18	120–370	0.08–0.38	90–500
High-temperature alloys	Uncoated, coated, cermets, SiN, PcBN	0.10–0.18	30–370	0.08–0.38	30–550
Nickel based					
Titanium alloys	Uncoated, coated, cermets	0.13–0.15	50–60	0.08–0.38	40–140
Aluminum alloys					
Free machining	Uncoated, coated, PCD	0.13–0.23	610–900	0.08–0.46	300–3000
High silicon	PCD	0.13	610	0.08–0.38	370–910
Copper alloys	Uncoated, coated, PCD	0.13–0.23	300–760	0.08–0.46	90–1070
Plastics	Uncoated, coated, PCD	0.13–0.23	270–460	0.08–0.46	90–1370

Source: Based on data from Kennametal Inc.

Note: Depths of cut, d , usually are in the range of 1 to 8 mm. PcBN: polycrystalline cubic-boron nitride. PCD: polycrystalline diamond. See also Table 23.4 for range of cutting speeds within tool material groups.

6. Milling Machines



Milling and Milling Machines:

Milling Machines

34

- Milling machines:
 - ▣ Among most versatile/useful machine tools
 - ▣ First milling machines: 1820
 - ▣ Machines today have many features
 - ▣ Standard milling machines now being replaced with computer controls (CNC) and machining centers
 - ▣ Manually controlled machines: inexpensive, still used today for small production
 - ▣ Typical machines are described in upcoming slides

Milling and Milling Machines:

Milling Machines

35

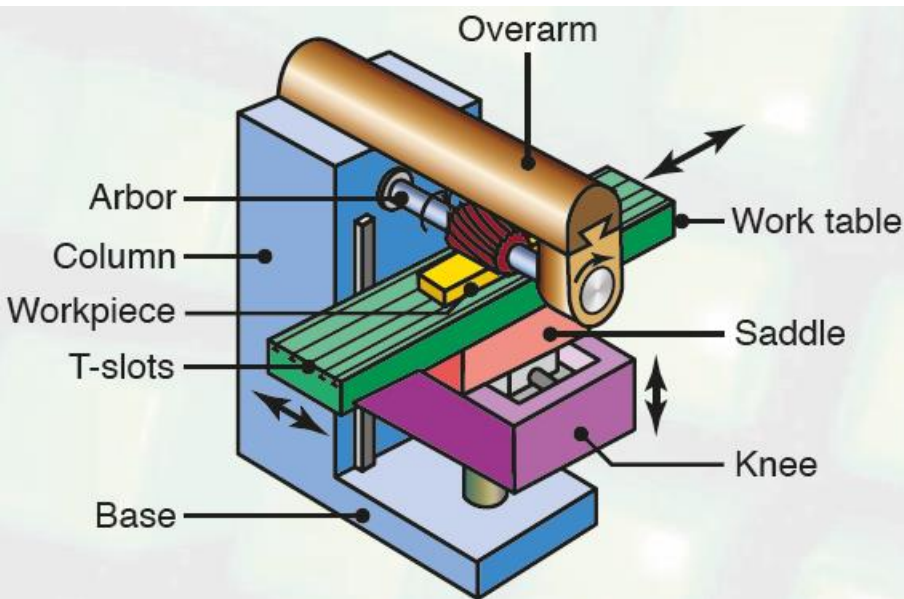
Column-and-knee-type Machines

- Used for general-purpose milling operations
- Most common milling machines
- Spindle on which cutter is mounted may be either ([next](#)):
 - ▣ Horizontal (for peripheral milling)
 - ▣ Vertical (for face and end milling, boring, drilling)
- Usually have 3 axes of movement
 - ▣ aka plain milling machines
 - ▣ Motion takes place manually or powered

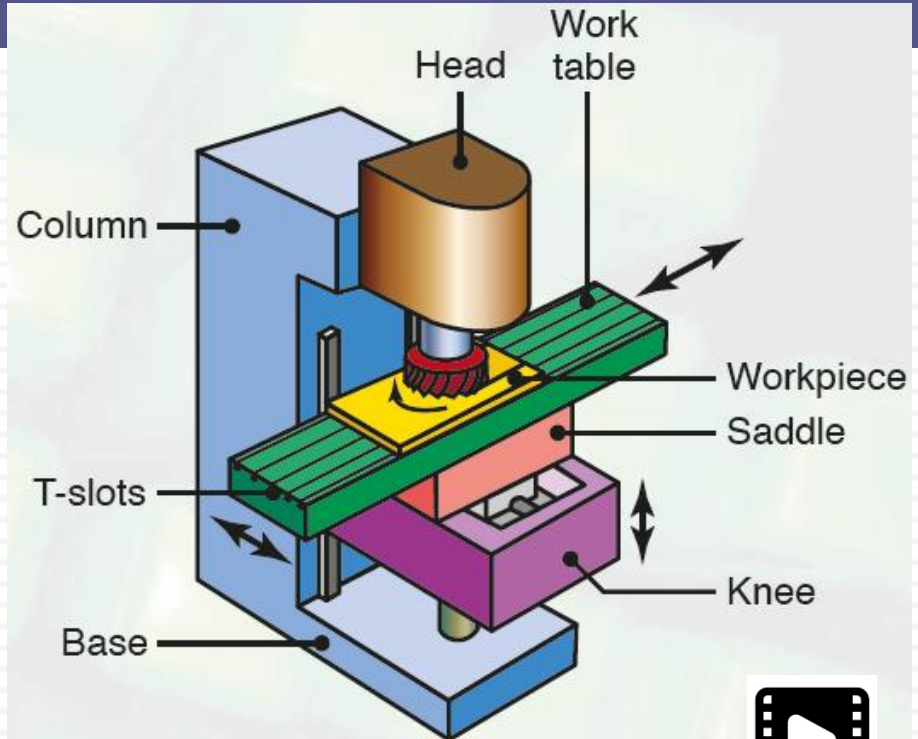
Milling and Milling Machines:

Milling Machines

36



(a)



(b)

Horizontal or
Vertical?

Fig. 24.15 (a) Schematic illustration of a horizontal-spindle column-and-knee-type milling machine. (b) Schematic illustration of a vertical-spindle column-and-knee-type milling machine. *Source:* After G. Boothroyd.

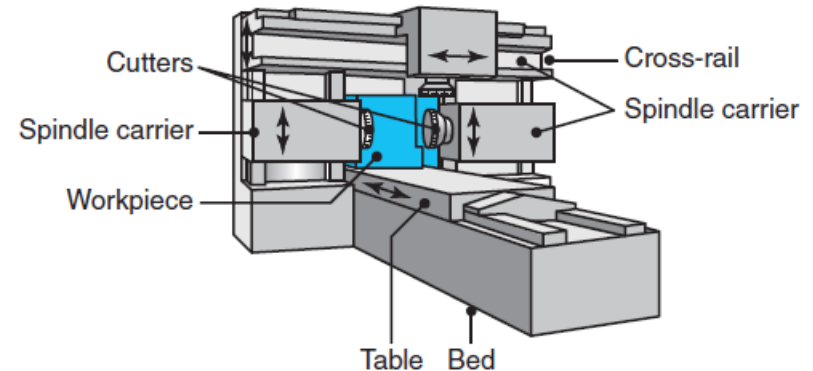
Milling and Milling Machines:

Milling Machines

37

Bed-type Milling Machines

- Worktable replaces knee
- Can move only longitudinally



Other Types of Milling Machines



□ Planer-type milling machines:

Planer machine

- Have several heads and cutters to mill different surfaces

□ Computer numerical-control (CNC) machines (→):

- Used for high production quantities
- Capable of: milling, drilling, boring, tapping

