DETERMINATION OF THE CUTTING-TOOL PERFORMANCE OF HIGH-ALLOYED WHITE CAST IRON (Ni-Hard 4) USING THE TAGUCHI METHOD

DOLOČANJE ZMOGLJIVOSTI REZALNIH ORODIJ NA MOČNO LEGIRANEM BELEM LITEM ŽELEZU (Ni-Hard 4) Z UPORABO TAGUCHI METODE

Durmuş Kir¹, Hasan Öktem¹, Mustafa Çöl², Funda Gül Koç², Fehmi Erzinçali³

¹University of Kocaeli, Hereke Vocational School, Kocaeli, Turkey
²University of Kocaeli, Faculty of Engineering, Metallurgy and Material Engineering, Kocaeli, Turkey
³University of Düzce, Faculty of Engineering, Mechanical Engineering, Düzce, Turkey

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High-alloyed white-cast-iron materials are commonly used in the manufacturing industry due to their high wear resistance. The aim of this research is to determine the cutting tool and the optimum cutting conditions required for the metal cutting of these materials. In this study, it is proposed to determine the tool life utilizing the Taguchi optimization method when hard turning the Ni-Hard 4 material, the alloyed cast iron, with cutting tools produced with powder metallurgy (PM) and to improve the performance of the cutting tools. A series of 18 experiments were conducted on a CNC turning machine, using the cutting process parameters such as the cutting speed, the feed and the depth of cut, based on the Taguchi L9 orthogonal design of experiments. Uncoated cutting tools were utilized to perform these experiments. PM cutting tools with WC grain sizes of 0.8 μm and 1.25 μm were selected for the hard-turning experiments. The flank wear of the cutting tools was examined with SEM. Then, the life of each cutting tool was identified based on the cutting length. The performance of the cutting tools in terms of the wear and the tool life was determined with the Taguchi method based on the obtained data. The results of this study contributed to the hard turning of the Ni-Hard 4 material that is mostly employed in the as-cast condition in the manufacturing industry due to its high hardness. The optimum cutting conditions were determined by means of the Taguchi method.

Keywords: hard turning, cutting tools, wear, Taguchi method

Močno legirano belo lito železo se uporablja v predelovalni industriji zaradi velike odpornosti proti obrahi. Namen raziskave je poskusi rezalni orodje in optimalne pogoje rezanja, potrebne za rezanje teh materialov. V študiji je predlagalo, da se določi obrabna in združljivost orodij, z uporabo Taguchi metod, optimizacija pri struženju materiala Ni-Hard 4 legiranega železa z rezalnim orodijem, izdelanimi po postopku metalurgije prahov (PM), da bi izboljšali združljivost rezalnega orodja. Serija 18-ih preizkusov, z uporabo procesnih parametrov, kot so: hitrost rezanja, podajanje in globina reza, na podlagi Taguchi L9 ortogonalne postavitve preizkusov, so bile izvršene na CNC stružnici. Za te eksperimente so bila uporabljena rezalna orodja brez prevleke. Za preizkus težkega struženja so bila izbrana PM rezalna orodja, z velikostjo zr WC med 0.8 µm in 1.25 µm. Obraba boka rezalnega orodja je bila preiskovana s SEM. Združljivost vsakega orodja je bila določena na podlagi dolžine struženja. Rezultati študije se nagibajo k težkem struženju materiala Ni-Hard 4, ki se ga večinoma uporablja v predelovalni industriji v litem stanju, zaradi velike trdoosti. Optimalni pogoji rezanja so bili določeni s pomočjo Taguchi metode.

Ključne besede: težko straženje, rezalna orodja, obraba, Taguchi metoda

1 INTRODUCTION

In today’s industry, customers expect low costs, short machining times and competitiveness, so the developments in the material science have to involve new and flexible manufacturing technologies. Especially, some mechanical parts used in cement, concrete, machine-manufacturing and ceramic industries are very difficult to machine because of their high hardness. Based on modern technologies1,2 such as hard turning, milling and drilling, it is possible to cut high-alloyed cast iron materials. High-alloyed cylindrical cast-iron materials can be machined with different methods. Hard turning is preferred for these kinds of materials due a faster, low-cost and high-quality process. The hard-turning process has advantages like short set-up times, short process steps, a better surface quality, a lower wear rate and a longer tool life. In addition, it is not necessary to use the cutting fluid for alternative metal-cutting methods.3 Several studies4–6 have been performed to investigate and develop the microstructure and mechanical properties of Ni-Hard 4, so far known as the high-alloyed white-cast iron. Its main alloying elements are 7–11 % Cr, 5–7 % Ni and 2.5–3.2 % C. Researchers have studied the wear resistance, heat treatments and the influence of the alloying elements on cast iron.5–6

The tool wear and the tool life are two important problems encountered in the hard-turning processes. There are many investigations, focused on diminishing these problems. Some of them7–9 try to determine the wear rate and the tool life of the AISI 52100, AISI D2 and AISI H11 steel materials during hard turning. Most frequently, experiments were carried out on cubic boron nitride (CBN) tools under various cutting conditions.
Some other researchers measured the wear on CBN tools and polycrystalline cubic boron nitride (PCBN) tools after the hard turning of the AISI 52100 steel materials. They examined the performances of the cutting tools with respect to the tool life using mathematical models depending on the Taylor rule. In two group studies, the tool wear was investigated with a light microscope and SEM. Lin et al. and Khrais and Lin examined the hard turning of the AISI 1040 material by employing uncoated and coated WC-Co tools under wet and dry cutting conditions. They classified the wear mechanisms and types of the WC-Co tools coated with PVD AlTiN and AlCrN with a light microscope. They also determined the effects of the coatings on the wear and tool life at five different cutting speeds and the average of the observed values from the experiments, each cutting tool was investigated for the tool wear was investigated with a light microscope. Lin et al. and Arsecularatne et al. performed experiments to identify the wear, tool life and material-removal rate when hard turning the AISI D2 steel material with CBN and ceramic tools under dry conditions. Mathematical models were developed based on the Taylor rule (the formula) to obtain the cutting conditions providing the longest tool life and the largest material-removal rate. Costes et al. investigated the machining of the Inconel 718 material, utilizing CBN cutting tools in wet conditions. According to this study, the adhesion and diffusion are the most dominant mechanisms for the wear in different cutting conditions.

Unlike the studies mentioned above, Thamizhmanii and Hasan and Yiğit et al. reported about experimental results predicting the tool wear and life during the hard turning of gray and spheroidal graphite cast iron with various cutting tools based on the Taguchi optimization method. Several researchers used the Taguchi method for different materials and cutting tools in the hard-turning process to find the optimum cutting conditions versus the minimum tool wear and to prolong the tool life. Other researchers were focused on the surface roughness, cutting forces and tool wear during the hard turning of high-alloy white cast iron in different cutting conditions, employing CBN inserts. Yücel and Güngör conducted investigations on the machinability of the high-alloy white cast-iron material, Ni-Hard 4. They studied the tool wear, tool life, surface roughness and cutting forces during the hard turning with ceramic and CBN tools based on the Taguchi optimization method.

In this study, a total of 18 hard-turning experiments based on the L9 orthogonal array design were performed on the Ni-Hard 4 material, which has a high wear resistance and which is not supposed to be machinable. The as-cast material was turned on a CNC machine without the cutting fluid. Uncoated cutting tools (WC-Co) with two different grain sizes (0.8 μm and 1.25 μm) were utilized in the hard-turning experiments. After each experiment, each cutting tool was investigated for the wear and specific cutting lengths with a light microscope and SEM. The optimum cutting conditions that provide the lowest wear rate and the longest tool life were determined with the Taguchi optimization method. Thus, the aim was to develop the cutting performance of the tools for the hard turning of a cast-iron material.

2 TAGUCHI METHOD

The Taguchi method, developed by Dr. Genichi Taguchi, is a technique to determine the optimum combinations of the process conditions widely used in engineering and manufacturing industry. This method is also a powerful tool for improving and designing high-quality systems. Therefore, industries are able to reduce the time of the product development without increasing the costs.

The Taguchi method is divided into three categories: the system design, the parameter design and the tolerance design. Among these, the parameter design is the most important and used category for improving the performance characteristics without increasing the costs. The Taguchi method solves the problems by integrating the orthogonal array design, the signal to noise (S/N) ratio and the analysis of variance (ANOVA). The orthogonal array is used to create a special design determining the whole parameter space with a small number of experiments. The S/N ratio is employed to analyze the experimental results obtained from the orthogonal array design. The S/N ratio has three performance characteristics, in Equation (1) to (3) to obtain the optimum process conditions: the smaller-the-better (S/N)sb, the larger-the-better (S/N)lb and the nominal-the-best (S/N)nb. ANOVA is applied to identify which process conditions significantly affect the performance characteristics. A confirmation test was conducted to verify the accuracy and efficiency of the desired values achieved for the optimum process conditions.

\[
S/N_{sb} = \eta = \log \left( \frac{1}{n} \sum_{i=1}^{n} y_i \right)
\]

\[
S/N_{lb} = \eta = -10 \log \left( \frac{1}{n} \sum_{i=1}^{n} \frac{1}{y_i} \right)
\]

\[
S/N_{nb} = \eta = 10 \log \left( \frac{\bar{y}}{s'\bar{y}} \right)
\]

where \(y_i\) is the observed value from the experiments, \(\bar{y}\) is the average of the observed values from the experiments, \(n\) is the number of the experiments and \(s'\bar{y}\) is the variance of \(y\). The steps required for applying the Taguchi method are illustrated in Figure 1.

3 EXPERIMENTAL PROCEDURE

3.1 Materials

Cast irons are called low-alloy cast-iron materials (36-55 HRC) if the amount of carbon is below 4 % or high-alloy cast-iron materials (47-65 HRC) if this
In this study, the Ni-Hard 4 material, a high-alloy cast iron, is used to perform the turning experiments. It is a commercial name of high-alloy white cast iron, which has a high wear resistance (58-65 HRC). Its microstructure mainly includes M7C3 type (M = Fe, Cr) carbides and a martensitic matrix. It can be used in the as-cast form or after having been hardened and tempered with heat treatments. In this study, the material was used in the as-cast condition. This material is used in the as-cast condition in the cement and machine industries as well as in the mining sector. The material was melted and alloyed in a high-frequency induction furnace with a neutral pot and poured in a sand mold with a cylindrical form and solidification dimensions of Ø 40 mm × 120 mm. The chemical composition of the cast material is given in Table 1.

Table 1: Chemical composition of Ni-Hard 4 alloy (in mass fractions, w%)  

<table>
<thead>
<tr>
<th>Elements</th>
<th>ASTM A 532</th>
<th>Ni-Hard 4 (sample)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Carbon (C)</td>
<td>2.6–3.2</td>
<td>2.89</td>
</tr>
<tr>
<td>Silicon (Si)</td>
<td>1.8–2</td>
<td>1.43</td>
</tr>
<tr>
<td>Chrome (Cr)</td>
<td>7–11</td>
<td>9.22</td>
</tr>
<tr>
<td>Nickel (Ni)</td>
<td>4.5–6.5</td>
<td>6.15</td>
</tr>
<tr>
<td>Molybdenum (Mo)</td>
<td>0–0.4</td>
<td>1.03</td>
</tr>
<tr>
<td>Manganese (Mn)</td>
<td>0.4–0.6</td>
<td>0.91</td>
</tr>
<tr>
<td>Phosphor (P)</td>
<td>max. 0.06</td>
<td>0.25</td>
</tr>
<tr>
<td>Sulfur (S)</td>
<td>max. 0.10</td>
<td>0.16</td>
</tr>
<tr>
<td>Iron (Fe)</td>
<td>Balance</td>
<td>Balance</td>
</tr>
</tbody>
</table>

The cross-section of the machined material was prepared for microstructural examinations. It was etched with the Beraha II solution for about 5 s and then examined with a Zeiss light microscope and a Jeol JSM 6060 SEM as illustrated in Figures 2a and 2b. The components of the microstructure were determined with a RigakuSA HS3 XRD diffractometer. The XRD analysis result is given in Figure 2c.

The microstructure of the Ni-Hard 4 material consists of a martensitic matrix and M7C3 primary-eutectic carbides. The primary-carbide rate in the microstructure was estimated to be about 20%. The hardness of the material was measured as 55 HRC with a Zwick/ZHR instrument.

Table 2: EDX microanalysis results for points 1 and 2, (in mass fractions, w%)

<table>
<thead>
<tr>
<th>Analysis</th>
<th>C</th>
<th>Si</th>
<th>Cr</th>
<th>Fe</th>
<th>Ni</th>
<th>Mo</th>
<th>W</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 – (M7C3)</td>
<td>4.3</td>
<td>28.7</td>
<td>66.9</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>2 – (Martensite)</td>
<td>1.6</td>
<td>1.9</td>
<td>4.0</td>
<td>82.7</td>
<td>5.6</td>
<td>1.9</td>
<td>2.1</td>
</tr>
</tbody>
</table>

3.2 Cutting conditions

A series of 18 hard-turning experiments based on the Taguchi L9 orthogonal array design were carried out on the Ni-Hard 4 material using nine different tools without the cutting fluid. Initially, cutting conditions were selected on the basis of the user experience and tool catalogues. In this study, the speed (n), the chip thickness (h) and the feed rate (Vf) were calculated with Equation (4) to (6) utilizing the cutting conditions shown in Table 3:

![Figure 1: Application of the Taguchi method](image1)

**Figure 1:** Application of the Taguchi method

**Slika 1:** Uporaba Taguchi metode

![Figure 2: Light and SEM micrographs and XRD analysis of Ni-Hard 4 material](image2)

**Figure 2:** Light and SEM micrographs and XRD analysis of Ni-Hard 4 material

**Slika 2:** Svetlobni in SEM-posnetek ter XRD analiza materiala Ni-Hard 4
\[
\begin{align*}
\text{(4)} & \quad n = \frac{1000V_c}{\pi D_c} \\
\text{(5)} & \quad h_{ex} = f_a x \sin K_r \\
\text{(6)} & \quad V_f = f_a x n
\end{align*}
\]

where;

- \( n \) = spindle speed, (rev/min)
- \( D_c \) = workpiece diameter, (mm)
- \( V_c \) = cutting speed, (m/min)
- \( f_a \) = feed rate, (mm/rev)
- \( K_r \) = entering angle, (45°)
- \( h_{ex} \) = maximum chip thickness, (mm)
- \( a_p \) = depth of cut, (mm)

Nine experiments were performed for each cutting tool (Table 3) and the wear of the cutting tools was examined with a light microscope and SEM. In addition, the performances of the cutting tools were examined in terms of the powder-grain size. In these experiments, a Johnford CNC turning machine, 3500 min\(^{-1}\), 12.5 kW, with a feed rate of 2500 mm/min was employed. Figure 3 shows four different steps applied during the hard-turning experiments.

### Table 3: Hard-turning process parameters

<table>
<thead>
<tr>
<th>Levels</th>
<th>Cutting conditions</th>
<th>( V_c ) (m/min)</th>
<th>( f_a ) (mm/rev)</th>
<th>( a_p ) (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td></td>
<td>100</td>
<td>0.05</td>
<td>0.1</td>
</tr>
<tr>
<td>2</td>
<td></td>
<td>150</td>
<td>0.075</td>
<td>0.2</td>
</tr>
<tr>
<td>3</td>
<td></td>
<td>200</td>
<td>0.1</td>
<td>0.3</td>
</tr>
</tbody>
</table>

### Table 4: Cutting tools for turning experiments

<table>
<thead>
<tr>
<th>Cutting tools (Uncoated)</th>
<th>Tool code</th>
<th>Grain size (WC)</th>
</tr>
</thead>
<tbody>
<tr>
<td>BS 710</td>
<td>BS 610</td>
<td>(0.8 μm)</td>
</tr>
<tr>
<td>BS 710</td>
<td>BS 610</td>
<td>(1.25 μm)</td>
</tr>
</tbody>
</table>

Figure 4: SEM comparison of grain sizes for cutting tools: a) BS 610, b) BS 710

The cutting tools given in Table 4 are hard-metal tools with two different WC grain sizes, sintered with cobalt (Co), (94 % WC and 6 % Co). These tools were broken to observe the grain-size distributions and bonding characteristic between WC and Co. Broken surfaces were examined at a single magnification as shown in Figures 4a and 4b. Figure 4 shows that the cutting tool with fine grains (0.8 μm) is more homogenous than the one with coarse grains (1.25 μm). In addition, the porosity rate between the WC grains in Figure 4a is higher than the one in Figure 4b. Cutting-tool manufacturers usually use a certain amount (5 % – 10 %) of coarse grains added to fine grains to improve the cutting-tool performance.\(^{13,14}\)

### 3.3 Wear measurement of the cutting tools

The wear was investigated with a light microscope and SEM after each experiment planned with the L\(_9\) orthogonal array design by stopping the CNC turning machine at (250, 500, 750 and 1000) mm. The numerical value of the wear rate was calculated using the CLEMEX program equipped with a light microscope. The wear rate was not allowed to exceed \( V_B = 0.6 \) mm in accordance with the ISO standards. Moreover, the wear rate for the largest cutting length (1000 mm) and the
shortest tool life were used to determine the optimum cutting conditions with the Taguchi optimization method. The tool wear at the edges of the BS 610 and BS 710 cutting tools for a depth of cut of (0.1–0.2–0.3) mm, at a cutting speed of 100 m/min and a cutting length of 250 mm is shown in Figures 5 and 6, respectively. The abrasive wear increases as the depth of cut increases. Also, it can be observed that some material is adhered to the cutting edge (the adhesive wear) throughout the hard-turning experiments. In addition, some partial fractures and micro-cracks occurred due to the forces affecting the cutting edge. These failures indicate that the cutting tool was forced considerably during the hard-turning process.

4 ANALYSIS OF EXPERIMENTAL RESULTS AND DISCUSSION

4.1 Wear and tool life

Figure 7 displays the flank-wear values obtained with nine experiments conducted with the BS 710 cutting tool. In Figure 7, the smallest flank wear is obtained for experiment 1 ($V_c = 100$ m/min, $f_n = 0.05$ mm/rev, $a_p = 0.1$ mm) whereas the largest flank wear is observed for experiment 3 ($V_c = 200$ m/min, $f_n = 0.05$ mm/rev, $a_p = 0.3$ mm).

Figure 8 illustrates the flank-wear values obtained with nine experiments conducted with the BS 610 cutting tool. In Figure 8, the smallest flank wear is obtained for experiment 8 ($V_c = 150$ m/min, $f_n = 0.1$ mm/rev, $a_p = 0.1$ mm) whereas the largest flank wear is observed for experiment 3 ($V_c = 200$ m/min, $f_n = 0.05$ mm/rev, $a_p = 0.3$). It can be seen that the flank wear of each type of the cutting tools generally increases with the increasing cutting length. On the other hand, for experiment 1, the...
flank wear of the BS 610 cutting tool is greater than that of the BS 710 cutting tool.

4.2 Taguchi analysis

The Taguchi method integrates orthogonal arrays, the S/N ratio and ANOVA to analyze and evaluate numerical results.29–32 The hard-turning experiments were performed according to L₉ (3³) orthogonal arrays. L₉ (3³) has 9 rows corresponding to the number of hard-turning experiments (8 degrees of freedom) with 8 columns at three levels. The hard-turning experiments based on the Taguchi orthogonal array design were conducted by means of three cutting conditions, namely, the cutting speed (Vₖ), the feed (fₚ), and the depth of cut (aₚ). The wear values obtained with the experiments and their S/N ratios calculated with Equation (1) for each of the two cutting tools (BS 710 and BS 610) are given in Table 5.

### Table 5: S/N ratios for the wear values
**Tabela 5: Razmerje S/N pri vrednosti obrane**

<table>
<thead>
<tr>
<th>Experiment number</th>
<th>Wear results (μm)</th>
<th>S/N ratios (dB)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>(BS 710)</td>
<td>(BS 610)</td>
</tr>
<tr>
<td>1</td>
<td>188.2</td>
<td>276.6</td>
</tr>
<tr>
<td>2</td>
<td>197.2</td>
<td>394.1</td>
</tr>
<tr>
<td>3</td>
<td>501.3</td>
<td>459.7</td>
</tr>
<tr>
<td>4</td>
<td>163.7</td>
<td>311.4</td>
</tr>
<tr>
<td>5</td>
<td>361.6</td>
<td>449.4</td>
</tr>
<tr>
<td>6</td>
<td>284.0</td>
<td>255.5</td>
</tr>
<tr>
<td>7</td>
<td>332.5</td>
<td>402.1</td>
</tr>
<tr>
<td>8</td>
<td>211.6</td>
<td>174.5</td>
</tr>
<tr>
<td>9</td>
<td>319.4</td>
<td>355.9</td>
</tr>
</tbody>
</table>

In order to determine the optimum turning conditions providing the smallest wear value, it is required to calculate the average-response values for the cutting conditions at different levels. For this purpose, an average-response table involving the wear values and their S/N ratios calculated with Equation (1) for each of the two cutting tools (BS 710 and BS 610) are given in Table 5. The values in the average-response table are calculated by averaging the S/N ratios for each cutting condition at different levels for experiments 1 to 9.

### Table 6: Average-response table for the wear values
**Tabela 6: Tabela povprečnega odgovora pri vrednosti obrabe**

<table>
<thead>
<tr>
<th>Cutting conditions</th>
<th>Parameter levels</th>
<th>BS 710</th>
<th>BS 610</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>I</td>
<td>II</td>
<td>III</td>
</tr>
<tr>
<td>Vₖ (m/s)</td>
<td>-46.74</td>
<td>-47.86</td>
<td>-51.05</td>
</tr>
<tr>
<td>fₚ (mm/rev)</td>
<td>-48.46</td>
<td>-48.17</td>
<td>-49.01</td>
</tr>
<tr>
<td>aₚ (mm)</td>
<td>-47.02</td>
<td>-46.76</td>
<td>-51.87</td>
</tr>
</tbody>
</table>

In this study, the ANOVA was performed using Minitab to identify which three cutting conditions significantly affect the wear.33 Table 7 shows the ANOVA results for the wear. In Table 7, the statistical significance of three cutting conditions for the wear was evaluated by the F-test. The F-value (tabulated) at the 95% confidence interval controlling the three cutting conditions is Fₚ₉,₉₉ = 4.46. The percentage contributions of the three cutting conditions to the wear for the two cutting tools are given in Table 6. As can be seen from this table, the most significant cutting condition is the depth of cut (aₚ).

### Table 7: ANOVA analysis results
**Tabela 7: ANOVA analiza rezultatov**

<table>
<thead>
<tr>
<th>Cutting conditions</th>
<th>Percentage contribution (%)</th>
</tr>
</thead>
<tbody>
<tr>
<td>BS 710</td>
<td>BS 610</td>
</tr>
<tr>
<td>Vₖ</td>
<td>35.238</td>
</tr>
<tr>
<td>fₚ</td>
<td>1.13</td>
</tr>
<tr>
<td>aₚ</td>
<td>62.8</td>
</tr>
</tbody>
</table>

The optimum cutting conditions providing the smallest wear value were determined by selecting the largest S/N ratios for each cutting condition at three levels as given in Table 6. Also, the final confirmation test for the two cutting tools was carried out in the optimum cutting conditions providing the smallest wear value. Each confirmation test was repeated at least three times. The improvement rates were calculated by comparing the results of the confirmation test and the initial values in Table 8. Thus, the optimum cutting conditions providing the best cutting-tool performance were determined with the Taguchi analyses without carrying out a high number of hard-turning experiments.

### Table 8: Confirmation tests
**Tabela 8: Preizkusi za potrditev**

<table>
<thead>
<tr>
<th>Cutting tools</th>
<th>Optimum cutting conditions</th>
<th>Initial values (dB)</th>
<th>Calculated values (dB)</th>
<th>Confirmation test (dB)</th>
<th>Improvements (%)</th>
</tr>
</thead>
<tbody>
<tr>
<td>BS 710</td>
<td>Vₖ(1), fₚ(II), aₚ(II)</td>
<td>-45.686</td>
<td>-44.565</td>
<td>-44.280</td>
<td>3.2</td>
</tr>
<tr>
<td>BS 610</td>
<td>Vₖ(II), fₚ(III), aₚ(III)</td>
<td>-50.554</td>
<td>-45.853</td>
<td>-46.510</td>
<td>8.7</td>
</tr>
</tbody>
</table>

5 CONCLUSIONS

In this study, hard-turning experiments were conducted on the Ni-Hard 4 material utilizing two different cutting tools (BS 610 and BS 710) under dry conditions. The following results were obtained:

- The optimum cutting entering angle is selected as K₉ = 45° by trying a few experiments.
- During the hard-turning experiments performed with the BS 610 and BS 710 cutting tools, the wear rate on the cutting edge increases as the cutting length, the cutting depth and the cutting speed increase.
- At a cutting speed of 200 m/min, for experiments 3, 6 and 9, the wear rate of the BS 710 cutting tool is larger than that of BS 610. This situation shows that, in the case of excessive force, WC coarse grains display a better performance than fine grains.
- At a low cutting speed (100 m/min), the BS 710 cutting tool has a better performance than BS 610. For a
longer tool life, hard turning should be performed at a low cutting speed and with fine-grain cutting tools.

- The optimum cutting conditions providing the lowest wear and the longest tool life were determined by means of the Taguchi analyses. Improvements of 3.2% and 8.7% were obtained for both cutting tools, respectively.

- According to the ANOVA analyses, the depth of cut \( (a_z) \) is the most important turning parameter for both cutting tools.

- Finally, the machinability of the material, which is very difficult to cut and whose cutting conditions are not widely known, were examined experimentally and numerically.

- In future, the cutting forces, the tool wear and the surface texture will be investigated by measuring the cutting forces and surface roughness in turning or milling processes.

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