

CONTENTS

| | | |
|----------|---|------------|
| 1 | FUNDAMENTAL CONSIDERATIONS | 1 |
| | Chip Formation | 12 |
| | Material Deformation during Cutting | 22 |
| | Magnitude and Direction of Cutting Forces | 24 |
| | Burning Gumming, and Cracking on the Machined Surface | 27 |
| | Optimum Cutting Conditions | 31 |
| 2 | ANALYSIS OF SINGLE-EDGE CUTTING MECHANISMS | 37 |
| | Machinability of Plastics | 42 |
| 3 | SINGLE-EDGE CUTTING OF THERMOPLASTICS | 48 |
| | Polyethylene | 48 |
| | Rigid Polyvinyl Chloride | 50 |
| | Polymethyl Methacrylate (acrylic) | 57 |
| | Polystyrene | 62 |
| | Styrene Copolymers | 68 |
| | Polytetrafluoroethylene (PTFE) | 75 |
| | Polyamide (nylon) | 86 |
| | Polycarbonate | 94 |
| | Acetal Resin | 106 |
| | Polypropylene | 112 |
| 4 | SINGLE-EDGE CUTTING OF THERMOSETS | 120 |
| | Thermoset Laminates | 120 |
| | Cast Thermoset Resins | 133 |
| 5 | CUTTING-OFF OPERATIONS | 143 |
| | Cutting-off Methods for Plastics | 143 |
| | Kinds and Merits of Cutting-off Methods for Plastics | 144 |
| | Abrasive Cutting Methods | 147 |
| | Shearing Methods | 148 |
| | Thermal Cutoff Methods | 149 |
| | Tool Economics | 155 |
| | Cutting Forces | 157 |
| | Cutting-off Rate | 157 |
| | Circular Sawing | 158 |

| | |
|--|------------|
| Abrasive Cutoff Methods | 162 |
| Testing Methods of Cutting Off | 163 |
| Optimum Abrasive Cutting-off Conditions for Plastics | 165 |
| Selecting Abrasive Cutoff Wheels | 167 |
| Special Abrasive Wheel Design | 169 |
| 6 DRILLING OPERATIONS | 174 |
| Drilling Operations | 174 |
| Basic Drilling Process | 174 |
| Effects of Drilling Conditions | 180 |
| Optimum Drilling Conditions | 186 |
| 7 DRILLING OF THERMOPLASTICS | 187 |
| Polyethylene | 187 |
| Rigid Polyvinyl Chloride | 192 |
| Polymethyl Methacrylate | 195 |
| Polystyrene | 202 |
| Styrene Copolymers | 207 |
| Polytetrafluoroethylene | 211 |
| Polyamide Resins | 215 |
| Polycarbonate | 217 |
| Acetal Resins | 222 |
| Polypropylene | 223 |
| 8 DRILLING OF THERMOSETS | 228 |
| Thermoset Laminates | 228 |
| Cast Thermoset Resins | 239 |
| 9 MISCELLANEOUS FINISHING OPERATIONS | 242 |
| Finishing Methods | 242 |
| Filing | 242 |
| Grinding | 243 |
| Abrasive-belt Grinding (sanding) | 244 |
| Barrel Finishing | 245 |
| Blast Finishing | 247 |
| Buffing | 248 |
| Index | 253 |