

MILLING- INTRODUCTION:

Milling is the machine operation in which the removal of metal from the work piece takes place due to a rotating cutting tool (cutter) when the work is fed past it. The cutter has multiple cutting edges and rotates at a very fast rate. The rotating cutting tool known as the "Milling Cutter" is a multiple point tool having the shape of a solid revolution with cutting teeth arranged either on the periphery or on end or on both. The revolving cutter is held on a spindle or arbor and the work piece is clamped or bolted on the machine table or may be in a vise or a three jaw chuck or an index head held or a rotary table etc. The milling process is employed for producing flat contoured or helical surfaces, for making helical grooves, to cut teeth and toothed gears.

WORKING PRINCIPLE OF MILLING:

Below figure illustrates the working principle employed in metal removing operation on a milling machine. The job or work piece is rigidly clamped on the table of the machine or in a chuck or an index head and revolving multitooth cutter is mounted either on a spindle or an arbor. The job is fed slowly past the cutter. The work can be fed in a vertical, longitudinal or cross direction. With the movement of the work piece, the cutter teeth remove metal from the job in the form of chips to produce the desired shape.

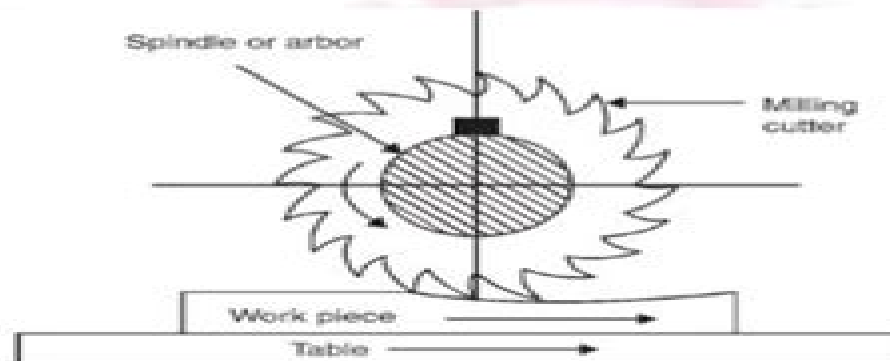


Fig.: Working Principle of Milling Machine

MILLING METHODS:

There are two distinct methods of milling classified as follows:

1. **Up-milling or conventional milling:** In the up-milling or conventional milling, the metal is removed in form of small chips by a cutter rotating against the direction of travel of the work piece.
2. **Down milling or climb milling:** Down milling is also known as climb milling. In this method, the metal is removed by a cutter rotating in the same direction of feed of the work piece.

Mechanical Engineering Practices Lab Manual

K Morrison



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Table of Contents Mechanical Engineering Practices Lab Manual

1. Understanding the eBook Mechanical Engineering Practices Lab Manual
 - The Rise of Digital Reading Mechanical Engineering Practices Lab Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Mechanical Engineering Practices Lab Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Mechanical Engineering Practices Lab Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Mechanical Engineering Practices Lab Manual

- Personalized Recommendations
 - Mechanical Engineering Practices Lab Manual User Reviews and Ratings
 - Mechanical Engineering Practices Lab Manual and Bestseller Lists
5. Accessing Mechanical Engineering Practices Lab Manual Free and Paid eBooks
 - Mechanical Engineering Practices Lab Manual Public Domain eBooks
 - Mechanical Engineering Practices Lab Manual eBook Subscription Services
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 6. Navigating Mechanical Engineering Practices Lab Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Mechanical Engineering Practices Lab Manual Compatibility with Devices
 - Mechanical Engineering Practices Lab Manual Enhanced eBook Features
 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Mechanical Engineering Practices Lab Manual
 - Highlighting and Note-Taking Mechanical Engineering Practices Lab Manual
 - Interactive Elements Mechanical Engineering Practices Lab Manual
 8. Staying Engaged with Mechanical Engineering Practices Lab Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Mechanical Engineering Practices Lab Manual
 9. Balancing eBooks and Physical Books Mechanical Engineering Practices Lab Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Mechanical Engineering Practices Lab Manual
 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
 11. Cultivating a Reading Routine Mechanical Engineering Practices Lab Manual
 - Setting Reading Goals Mechanical Engineering Practices Lab Manual
 - Carving Out Dedicated Reading Time
 12. Sourcing Reliable Information of Mechanical Engineering Practices Lab Manual

- Fact-Checking eBook Content of Mechanical Engineering Practices Lab Manual
- Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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