

B-002

Regarding Procedure to Mill a V-Groove

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Rev A

Abstract: Cutting a long v-groove in a part is a frequent operation in machining. This article presents a method to mill a v-groove by locating the desired groove center on the work surface.

Given:

- An object with a planar (flat) surface mounted $\theta = 45^\circ$ to the horizontal.
- and a coordinate system drawn from some arbitrary starting location on the object's surface plane, with $+x$ axis to the left, $+y$ axis into the page, and $+z$ axis downward.
- and a right triangle with angles θ , and sides a, b of length L and a hypotenuse c .
- and a hypotenuse midpoint that coincides with the coordinate system origin.
- and a milling tool with diameter D whose bottom-left corner is at the coordinate origin.

Find:

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- The distance to the left, in the $+x$ direction, the milling tool must travel to remove a v-groove in the planar surface.
- The downward distance, $+z$ direction, the milling tool must travel to remove a v-groove in the planar surface.

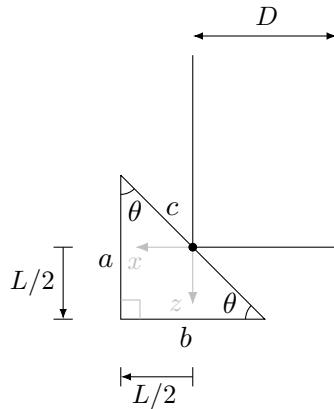


Figure 1: Initial relationship of work object and milling tool

1 Solution

As given, the right triangle shown in Figure 1 has sides $a = b = L$. Therefore $\triangle abc$ is an isosceles triangle.

Furthermore, angles θ are

$$\theta = \frac{180^\circ - 90^\circ}{2} = 45^\circ \quad (1)$$

This is expected since the mounting angle of the work relative to the cutting tool was given as $\theta = 45^\circ$.

Symmetry of the initial setup can be used to create a symmetrical v-groove in the work.

The diameter D is relatively unimportant since removal of material from the v-groove is accomplished by the travel of the cutting tool. By gradually plunging the cutting tool downward a distance $L/2$ along the z-axis, and shifting leftward a distance $L/2$ along the y-axis, the groove is formed.

Ideally the machinist should use a cutting tool where $D > L$, but this is not strictly necessary. This will avoid the need to return past the initial cutting pass.

Choosing $L \geq D$, or using a cutting tool with diameter $D \leq L$, is possible but will leave missed material before the starting cut. The machinist will need to make extra passes to remove the missed material.

Follow these steps to create a symmetrical v-groove in the work.

1.1 Method 1

This method starts cutting on the surface of the v-groove centerline. It is easy to setup. An advantage to this method is the machinist can choose to increase the value of L while machining, without disturbing the zero position of Digital Readouts or dial indicators.

1. Determine the diameter D of the cutting tool.
2. Mount the cutting tool in the milling ma-

chine.

3. Choose the desired length L for the depth of side a and width of side b .
4. Calculate $L/2$, this will determine the travel of the cutting tool.
5. Locate and scribe the place on surface of the work where the v-groove will be centered.
6. Mount the work at a $\theta = 45^\circ$ angle in a vise in the milling machine, with the scribed line parallel to the y-axis.
7. Position the milling machine table so that the scribed line touches the bottom-left corner of the cutting tool.
8. Zero out any Digital Readouts or dial indicators.
9. Turn on the milling machine, make an initial pass along the y-axis.
10. On subsequent passes, advance the cutter leftward in the x-axis until it has traveled a maximum of $L/2$ to the left.
11. Advance the depth of cutter downward along the z-axis until it has sunk a maximum of $L/2$.

1.2 Method 2

This method takes a little longer to setup, but it will be easier to machine. If $D > L$, then it will only require the machinist to advance the cut depth along the z-axis until the maximum L depth (not $L/2$) is reached.

1. Determine the diameter D of the cutting tool.
2. Mount the cutting tool in the milling ma-

3. Choose the desired length L for the depth of side a and width of side b .
4. Calculate $L/2$, this will determine the SETUP travels of the cutting tool.
5. Locate and scribe the place on surface of the work where the v-groove will be centered.
6. Mount the work at a $\theta = 45^\circ$ angle in a vise in the milling machine, with the scribed line parallel to the y-axis.
7. Position the milling machine table so that the scribed line touches the bottom-left corner of the cutting tool.
8. Zero out any Digital Readouts or dial indicators.
9. Now raise the cutting tool a distance $L/2$ along the z-axis.
10. Move the cutting tool leftward a distance $L/2$ along the x-axis.
11. Again, zero out any Digital Readouts or dial indicators.
12. Turn on the milling machine, make an initial pass along the y-axis.
13. On subsequent passes, advance the depth of cutter downward along the z-axis until it has sunk a maximum of L (not $L/2$ here)!!!

2 Example

Given:

- A piece of flat steel
- Milling cutter whose diameter $D = 0.75 \text{ inches}$

Find: Methods to mill out a v-groove where:

- $a = b = L = 0.7 \text{ inches}$
- One setup method is along desired groove centerline.
- Another setup method promotes depth-only cutting.

Basic Steps:

1. Start by labeling Figure 1 with the values of D and L .
2. Calculate the value $L/2 = 0.70/2 = 0.35 \text{ inches}$ and label the drawing with it, this will be the maximum travel of the cutting tool along the x-axis and z-axis.
3. Locate and scribe the place on surface of the work where the v-groove will be centered.
4. Mount the work at a $\theta = 45^\circ$ angle in a vise in the milling machine, with the scribed line parallel to the y-axis.
5. Position the milling machine table so that the scribed line touches the bottom-left corner of the cutting tool.
6. Zero out and Digital Readouts or dial indicators.

Method #1:

1. Turn on the milling machine, make an initial pass along the y-axis.
2. On subsequent passes, advance the cutter leftward in the x-axis until it has traveled a maximum of $L/2 = 0.70/2 = 0.35 \text{ inches}$ to the left.
3. Advance the depth of cutter downward along the z-axis until it has sunk a maximum of $L/2 = 0.70/2 = 0.35 \text{ inches}$.

Method #2:

1. Now raise the cutting tool a distance $L/2 = 0.70/2 = 0.35 \text{ inches}$ along the z-axis.
2. Move the cutting tool leftward a distance $L/2 = 0.70/2 = 0.35 \text{ inches}$ along the x-axis.
3. Again, zero out and Digital Readouts or dial indicators.
4. Turn on the milling machine, make an initial pass along the y-axis.
5. On subsequent passes, advance the depth of cutter downward along the z-axis until it has sunk a maximum of $L = 0.70 \text{ inches}$, (not $L/2 = 0.35 \text{ inches}$ here)!!!