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Review TMET

A Technical Review on Investigation of Cutting Conditions on Tool Life and Material Removal Rate in Turning of T51620 Using Cermet and Tungsten Carbide Insert

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Abstract

The turning is a basic material removal operation performed on lathe machine or CNC machine to get the finished product. To perform turning operation it required different operating parameter and its like cutting speed, feed, and depth of cut. The high carbon steel such as die steel, mould steel is generally used in the manufacturing of die, mould, machine tools etc. the turning operation of high carbon steel is a challenging task for the researcher and the industries. It is also important to perform turning operation very efficiently. The performance of turning operation is depend upon the tool life and Material Removal Rate (MRR) of the tool material. In current study the T51620 material is studied and is employed in making of dies in different industry. the different inserts are used to perform the operation such as Tungsten carbide, cemented carbide, ceramic, cermet etc. the most suitable insert material used for turning of T51620 is tungsten carbide and cermet inserts. but now a day's industries need higher productivity and higher tool life and higher MRR with same parameters so one should compare the tool material with the advance insert material i.e. cermet. It is the combination of ceramic and metal material. It fulfills the both the requirement of tool life and MRR so the current investigation is to review different insert used for the turning of T51620 material and it will give an idea about the selection of appropriate insert material. So, any researched and industry people can take this work as a reference for their operations.

Keywords : T51620 material, Turning, tool life, Material Removal rate(MRR), High carbon steel

INTRODUCTION

One of the crucial and frequently employed manufacturing techniques in the engineering sectors is metal cutting. Studies on metal cutting concentrate on tool characteristics and work material composition. Mechanical characteristics, and most importantly the machine parameter Parameters that affect the effectiveness of the process and the result quality (or responses) A considerably improved procedure Efficiency can be attained by optimising process parameters that Identifies and establishes the critical process control areas The causes of desired results or appropriate reactions Modifications that guarantee cheaper manufacturing costs with optimizing the process parameters for MRR and tool life.

MATERIAL

A T51620 steel contains 2.0 wt% of chromium. 1.5% Mn, 0.3% Si, and 1.1% Ni (wt%) are the

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additional components. The maximum working temperature for this steel is 500 qC. As a result, T51620 steel is a potential engineering material for use in geothermal power applications such as heat exchange, boiler pipes, and steam pipelines Coal-fired steam power stations and plants.The chemical properties are tabulated in Table 1.

Table 1. Chemical properties of the material.

Element	**Content**
Carbon	0.28-0.40
Manganese	0.60-1.00
Silicon	0.20-0.80
Chromium	1.40-2.00
Molybdenum	0.30-0.55
Copper	0.25
Phophorus	0.03
Sulfur	0.03

The mechanical properties are tabulated in Table 2.

Table 2. Mechanical properties of the material.

Hardness Brinell	Hardness Rockwell	Tensile Strengh Ultimate
300	30	965 - 1030 MPa
Tensile Strength Yield	Elongation	Elastic Modulus
827 - 862 MPa	20%	190 - 210 GPa

Turning Process

The cutting tool removes the material from external diameter of the work piece while the work piece is rotating is known as turning process. The slicing device is Linearly fed in a direction that is perpendicular to the axis of rotationThe power to turn is provided by a lathe that performs the turning. Feeding the work piece at a specific rotating speed andA cutting instrument operating at a preset rate and cut depth. As a result, threeCutting settings, including depth of cut, feed, and speed of cutMust be decided upon throughout a turning procedure. The shiftingA cutting tool is used to complete activities; the highDuring machining, pressures and temperature produce a harsh[5].

LITERATUREREVIEW

Anil Gupta, Hari Singh, Aman Aggarwal et.al [5] This paper affords the utility of Taguchi technique with logical fuzzy reasoning for more than one output optimization of excessive velocity CNC turning of AISI P-20 device metal the usage of TiN lined tungsten carbide coatings. The machining parameters (slicing velocity, feed rate, intensity of reduce, nostril radius and slicing environment) are optimized with concerns of the more than one overall performance measures (floor roughness, device life, slicing pressure and electricity consumption). Taguchi's ideas of orthogonal arrays, sign to noise (S/N) ratio, ANOVA were fuzzified to optimize the excessive velocity CNC turning method parameters via a unmarried complete output measure (COM). The end result evaluation indicates that slicing velocity of a hundred and sixty m/min, nostril radius of 0.eight mm, feed of 0.1 mm/rev, intensity of reduce of 0.2 mm and the cryogenic environment are the maximum favorable slicing parameters for excessive velocity CNC turning of AISI P-20 device metal

Vishnu Vardhan Mukkoti , Chinmaya Prasad Mohanty , SankaraiahGandla , Pallab Sarkar , Srinivasa Rao P & Dhanraj B et. al.[6]. Proposes an intensive experimental and microstructural evaluation to take a look at the outcomes of deep cryogenic remedy (DCT) soaking period on tungsten carbide stop mill cutter at the machinability of P20 mould steel. A Box-Behnken layout of reaction floor methodology (RSM) is applied to acquire information for the take a look at. Cutting speed, feed rate, intensity of reduce and milling cutters subjected to diverse soaking intervals are taken as critical system variable which vicinity feature of overall performance measures viz. Device put on rate (TWR), Material elimination rate (MRR) And floor roughness(R).It is found that slicing speed, feed, intensity of reduce and cryogenic remedy showcase a full-size impact on overall performance measures. In the existing take a look at, NSGA-II multi-goal optimization approach Is used to achieve the most excellent system parameters of stop milling system to beautify the productiveness of the system.

J. Rathod, N.J. Rathod, U.S. Vidhate, U.V. Saindane et. al. [7] the machining parameter research is done on SS304.Using the Grey–Based Taguchi approach, this studies seems at multi-goal Turning manner optimization for you to discover first-rate parametric in conjunction for a minimal manufacturing time and most device life. Feed rate, Cutting velocity in addition to intensity of reduce are all known as turning parameters. In order to conquer the multi-reaction optimization problem, general 9 take a look at runs primarily based totally on Taguchi's L9 OA had been performed, Grey relational evaluation follows. The Grey relational grade fee turned into used to decide gold standard parameter levels. The use of evaluation of variance (ANOVA) might be vital withinside the reputation of the maximum big parameters amongst velocity, feed, and reduce intensity.

Raman Kumar, Paramjit Singh Bilga, Sehijpal Singh et. al.[8]The studies specializes in simultaneous optimization of top electricity consumption responses, floor roughness and fabric elimination charge for sustainable machining operations. The experiments had been carried out on difficult turning of EN 353 alloy metal with multi-layer lined tungsten carbide insert. The impact of enter parameters: nostril radius, reducing speed, feed charge and intensity of reduce at the side of their interactions had been studied at the reaction parameters viz. Strength issue (PF), lively strength fed on via way of means of the machine (APCM), lively electricity fed on via way of means of the machine (AECM), electricity efficiency (EE), floor roughness (Ra) and fabric elimination charge (MRR). The Taguchi's L 27 orthogonal array have been used for layout of experiments via way of means of the use of sixteen software. The weights of significance to the responses had been assigned via way of means of Equal, Analytical Hierarchy Process (AHP) and Entropy weights approach. The multi overall performance composite index (MPCI) become received via way of means of Technique for Order Preference via way of means of Similarity to Ideal Solution (TOPSIS) approach and become optimized with Taguchi approach. The consequences confirmed that the MPCI with those 3 one of a kind weight standards had one of a kind choicest manipulate issue levels. At choicest turning parameters of MPCI the use of AHP weights, Equal weights and Entropy weights, there has been an development in MPCI of 319.72%, 45.38% and 9.02% respectively in comparison to turning parameters in not unusual place use. The intensity of reduce become located to be a important parameter for MPCI with AHP weights and nostril radius for MPCI with Equal and Entropy weights. Hence the selection of approach of assigning weights of significance to the responses or even the optimization approach performs vital position in choice making in multi objective optimization

K.Jagatheesan,K.Babu,D.Madhesh et. al. [9]. This study examines how minimum quantity lubrication (MQL) affects the turning of AISI 4320 alloy steel. Recently, the benefits and importance of the MQL focused have distinctly demonstrated greater advances in the machining process. Only a few studies have been done on the input process parameters, such as cutting speed, depth of cut, and feed. The current investigation's goal is to deal with a variety of output factors, including temperature, surface roughness, and machining force. Comparisons are made between the various output parameter values obtained under various cooling conditions, such as dry, wet, and MQL.

Selim Gürgen, Mehmet. al. per Sofuoglu et. al. [10]. A type of intelligent material known as shear thickening fluid (STF) exhibits rising viscosity when loaded. This distinctive behavior has advantages in a number of applications, however the use of STF in machining tools has not been studied in the literature. In this work, an unique tool for turning operations was created by incorporating STF with traditional cutting tools. The shear thickening fluid mainly contributes to vibration dampening characteristics of cutting tool. Because of this, STF integrated cutting tools offer improved operation stability, which enhances the workpieces' surface quality.

R.K.Bharilya, Ritesh Malgaya, Lakhan Patidar et. al. [11]. From this experimental study different machining parameter is optimized in turning operation. The material is used for this experimental study is mild steel, aluminum and brass. all this material were machined on CNC machine and the cutting force is measured in dynamometer. which are particularly efficient tools for measuring cutting force, is used to cut metal. By employing a force dynamometer to optimize the process parameter and find a superior surface finish for the given work piece material during a turning operation, our study aims to reduce cutting forces and boost cutting speed in this research we used different spindle speed, feed rate and depth of cut. According to our research, improved surface quality, or surface finish & uniformity, is discovered. We can reduce the cost by using advanced CNC machine.

Bárbara Cristina Mendanha Reis, Anderson Júnior dos Santos et. al. [12]. The single and multilayer coated carbide tools is used for the examination of wear patterns and AISI4340 steel is used for the experiment using different chip breaker geometries. Next, tool wear, wear mechanisms, and the quality of the machined surface were studied at this speed using only the MP chip breaker. The coated cermet gives the highest values for flank wear and cemented carbide gives more flank and crater wear. Both tools' rake and flank faces showed signs of adhesive and abrasive wear, respectively. On the coated carbide tool, chipping and notch wear were also seen. Finally, although both tools' roughness increased with cutting length, the coated carbide tool produced superior machined surfaces

Prashant Kumar Tiwari, Ramanuj Kumar Ashok Kumar Sahoo, Amlana Panda, et. al. [13]. Cermet is made up of a metallic binder that holds a ceramic matrix together. The inclusion of metal coating layers improves the ceramic's thermal resistance and hardness. the multilayer coated(TIN/TICN) cermet insert is used in hard turning for examination. The capacity to machine a tougher workpiece in terms of surface roughness (Ra), material removal rate (MRR), and chip reduction coefficient is, nonetheless, highly intriguing (CC).Ra was discovered to be within 1.6 mm (standard criteria) for the full set of L trials, which supports the use of coated cermet tools in hard turning applications to provide high-quality finishes. The influence of input words on machining characteristics is investigated using main effect plots, contour plots, surface plots, and ANOVA. Depth of cut has the highest impact on MRR and CC

S.S. Sarjana, I. Bencheikh, M. Nouari [14]. The rationale for this study is to find an alternate tool material to support the use of coated cemented carbide for boosting productivity when turning hardened steel. The mechanical characteristics of hard metals and the benefits of contemporary Cermet cutting tools led to the recommendation of this tool for use in turning hardened steel. To work material is having hardness of 50HRC and the cutting tool is used coated (TICN/TIN).The findings of the investigation indicate that both Cermet tools can be suggested to assist Coated Cemented carbide's job. Especially for the hardened steel's final turning.

JunboLiu,ji Xiong [15]. The tools made of cemented carbides and cermets have CVD coatings applied to them. For the machining of hardened AISI H13 steel, tools made of uncoated cermets, coated cermets, and cemented carbides were employed. The face-centered cubic structure of the cermets is due to the TiN coatings' direct development. On the ceramics, TiN and TiCN exhibit a preferential (2 0 0) orientation. The cemented carbides' hexagonally close-packed structure causes the TiN coatings to initially form, then expand. The desired orientation of TiN and TiCN on the cemented carbides is (1 1 1). The coated cermets are most durable when the cutting speed approaches and surpasses 700 r/min. The coated cermets' strong diffusion and adhesion wear resistance at high temperatures produce a better workpiece surface quality.

H. Lopez-Galvez , X. Soldaniet el.[16]. Finish turning operations involve precisely sizing and cutting a very thin chip portion from the workpiece in three dimensions. The finish turning operation on Inconel® 718 is modelled numerically in this research for the first time. The goal of the work is to identify the best numerical parameters (such as the mesh size and deletion element criterion) for the simulation of the chip-removing process: for the prediction of cutting forces the feed direction is required. Calibration of the shear element affects the temperature distribution in machining.

Qinqiang Wang, ZhujiJin, Yong Zhao [17]. turning of tungsten alloy it effect more to tool wear and short tool life.In this study, we examined how well typical cutting tool materials cut when turning WHAs in an oil-lubricated environment. To investigate the tool lifetimes and wear behaviours of three different cutting tools, namely the TiAlN-coated carbide cutting tool, the uncoated carbide cutting tool, and the Ti (C, N)-coated cermet cutting tool, experiments were carried out. Under various cutting parameters, tool life, wear progression, and cutting force were studied. The processes and wear patterns were investigated in the meantime. The three chosen cutting tools' primary wear pattern was discovered to be flank wear. Adhesion and oxidation were the primary wear processes identified in all of the chosen cutting tools. The uncoated carbide cutting tool showed signs of chipping, notch wear, and diffusion wear when compared to the other cutting tools. According to the testing findings, the TiAlN-coated carbide cutting tool outperformed the Ti (C, N)-coated cermet cutting tool and the uncoated carbide cutting tool in terms of cutting performance, with a tool life that approaches 15 km when utilizing optimal parameters.

S.P. Leo Kumar et. al.[18]. The work material is C360 copper alloy and tool material is tungsten carbide insert. For optimization of cutting parameters like spindle speed, feed rate, depth of cut for average surface roughness and material removal rate. Taguchi Lp Orthogonal Array base Experiments were included, and a micromachining tool was used to create an 800 mm micro pin. With Type-'A uncertainty analysis, the accuracy of the measured values was confirmed, and a standard deviation of 0.007 mm was noted. It has been noted that combining process variables with a lower range (within the specified range) results in a fine surface finish whereas combining variables with a higher range results in a maximum MRR but a subpar surface finish. It was also discovered that a higher "f" influences surface finish by creating markings. The optimal Ra and MRR values were determined to be 0.031 mm and 0.0768 mm/s, respectively. The process parameters for these values are n = 1686 rev/min, f = 10.6242 mm/rev, and a = 99.45 mm. Finally, confirmation experiments were used to verify the veracity of the GA results

Soni Kumari, Anshuman Kumar, Rajiv Kumar Yadav et el. [19]. The goal of this study is to determine how various turning factors, such as spindle speed (N), feed rate (f), and depth of cut (d), affect various output performance characteristics when AISI D2 Steel is turned dry using a PVD coated carbide tool. In an experiment using the L9 orthogonal array, surface roughness and material removal rate (MRR), two turning performance criteria, were measured (Ra). Through the use of grey relational analysis, an effort was made to reduce the several responses to an equivalent single response, or the overall grey connection grade. In this case, an upgraded version of the most recent evolutionary algorithm called harmony search (HS) has been used to assess the ideal machining condition. The effectiveness of the aforementioned approach is confirmed by comparing the findings to a genetic algorithm

Sarmad Ali Khan, Saqib Anwar, Kashif Ishfaq, Muhammad Zubair Afzal et. al. [20]. Each type of tooling has its limitations, and manufacturers are constantly working to reduce the downsides of the tool geometries. Recently, the advantages of diverse tools have been combined to create a modified tool shape known as the Xcel insert. The work material is hardened D2 steel with two xcel insert. The output parameters is tool life, wear process, power consumption, surface roughness ,micro hardness. With xcel insert one step technique of sustainable machining is possible. Meaning that with fewer resources, including a shorter cycle time, comparable or superior outcomes could be obtained. A1 inserts are also advised above A2 inserts due to their lower energy usage, reduced tool wear, and improved surface integrity

Alexey Vereschaka, Jury Bublik,MarinaVolosova, Catherine Sotova et. al. [21]. The article explores the relationship between coating and tool cutting characteristics in the turning of 1045 steel and the thickness of nanolayers in a wear-resistant layer of a multilayered composite coating of Ti-TiN-(Ti,Cr,Al)N. Investigated were coatings with nanolayer thicknesses between 10 and 302 nm. According to the studies, cutting tool life rose as the thickness of the nanolayers decreased. The experiments determined that 16 nm was the ideal nanolayer thickness for the specified cutting conditions in terms of tool life. The tool life decreased when the nanolayer thickness was progressively decreased to 10 nm

Xiao Chen, Jianfeng Xu [22]. When turning a hardened steel, the cutting performance and wear parameters of cermet based on Ti(C,N) were examined (61–62 HRC). For this comparison study, a cemented carbide tool coated with a multilayer of TiN/Al 2 O/Ti(C,N) was chosen. At shallower cuts, the cermet tool outlasted the coated tool in terms of tool life, but at deeper cuts, the chipping brought on by increased cutting force resulted in a shorter tool life. The ceramic grains were eventually lost due to a lack of structural support when the soft binder phase in the flank face of the ceramic tool was predominantly removed by abrasion and adhesion wear mechanisms. The crater wear resistance of the cermet tool seems to be enhanced by high thermal conductivity and light cutting force. But because of wear phenomena called adhesion and diffusion, the coated tool experienced extremely bad crater wear. Although both tools' average roughness rose exponentially with cutting time, the cermet tool's surface quality was marginally worse than the coated tool's. The chips were made to curl by thermal stress that was produced at them during the cutting process. Due to the low cutting temperature, the chips from the cermet tool seemed less severely curled and sticky

M Vishnu Vardhan, Chinmay P Mohanty, B Dhanraj, et. al. [23] Due to its tight tolerances and ability to produce flawless surface finishes by removing waste material, milling is the most popular type of machining process utilized in the manufacture of moulds and dies. Pre-hardened steel (P-20) is frequently utilized in the manufacture of moulds and dies due to its lower wear resistance and application to big components. Manufacturing demands trustworthy models and methodologies for the prediction of output performance of machining processes due to the industry's widespread usage of highly automated machine tools. The main goal of the current work is experimental examination of end milling parameters for surface roughness while taking into account input parameters such cutting speed, feed rate, depth of cut, and time of cryogenic soaking

T. Mikolajczyk, K. Nowicki, A. Bustillo, D. Yu Pimenov et. al. [24]. For the automatic prediction of tool life in turning operations, a two-step solution is provided. First, under the same constant processing circumstances, experimental data are gathered for three cutting edges. In these trials, the tool wear parameter V is estimated using Neural Wear, a specially created software programme that blends flank wear picture recognition and Artificial Neural Networks, as opposed to being assessed using standard methods (ANNs). The data gathered from the first two cutting edges are used to train an ANN model of tool life, and the resulting model is assessed on two different subsets for the third cutting edge: the second subset is derived from the Neural Wear programme, which calculates tool wear based on edge images, whereas the first subset is derived from the actual measurement of tool wear. Despite having a little higher inaccuracy than the direct measurements, the fully automated solution—which combines Neural Wear software for tool wear recognition with an ANN model for tool life prediction—can nevertheless satisfy all industrial criteria. These findings support the possibility of developing an industrial tool for low-cost tool life estimate in turning operations using image recognition software and ANN modeling

C. J. Rao, D.Sreeamulu, Arun Tom Mathew et. al. [25]. The characteristics of the process efficiency and output quality will be influenced by the tool features, input work materials, and machine parameter settings in any metal cutting operation. Reduction of production cost can be improve the process efficiency. the output parameters are tool life and cutting forces

Sara Moghadaszadeh Bazaz, Mika Lohtander, Juha Varis et. al. [26]. In manufacturing sector various resources conservation issues are developing. The handling of production circumstances may occasionally be challenging due to the multiple items being processed simultaneously in the facility. Changing tools in the middle of an operation could disrupt the process and increase production time. One of the most important aspects to avoid wasting resources and producing unneeded unfinished components is the estimation of a tool's life during the turning process. The overall goal of research is to create a machine learning system that can forecast tool life for every workpiece or material used in a tool during a turning operation. In today's small lot production, when components and materials are continually changing, the method under discussion is crucial. This particular paper's goal is to identify a viable machine learning algorithm, or possibly a few ways, to assess tool life under various turning settings and circumstances. This study's premise is that using machine learning and mathematical modelling together is an appropriate way to predict tool life in small-lot production at an acceptable cost and operating time

Shivani Katiyar,MuskanJaiswal,Ratneshwar Pratap Narain,Sarthak Singh, et. al. [27]. Tool chatter is a big stumbling block in machining operations which includes; turning, milling, and drilling. A lot of work is reported in this area. It is very important to report work together. For the comfort of the readers and for better understanding. So anyone can identify the best suitable technique among them.

E. Mohan, L. MamundiAzaath, U. Natarajan et. al. [28]. In general, machine tool vibration that happens during any machining or metal-cutting activity. These vibrations also raise the cutting tool's temperature, which ultimately shortens the cutting tool's lifespan. In this investigation, copper and brass were employed as dampening materials to reduce the vibration and temperature of the cutting tool tip. In order to give additional dampening effects during the metal cutting operation, the structural modification was made to the standard cutting tool holder. These components were fitted to create a new damped turning tool holder, which increases the stability of the cutting tool holder. For the purpose of conducting experiments, the standard and advised levels of input parameters, such as cutting speed, feed rate, depth of cut, and tool overhang length, were chosen. For various cutting conditions, the impact of input parameters was examined. As a result, the damped turning tool holder allowed for the best conditions and the desired outcome. It also significantly reduced vibration during turning operations.

Kourosh Tatar, Soren Sjoberg, Niklas Andersson et. al. [29]. Generally speaking, all metal cutting operations, including milling titanium, place a high value on tool life prediction. This study used a full factorial design to conduct tool life testing. The cutting breadth and speed were 10 and 70 percent of the tool diameter and 100 and 120 m/min, respectively. Using milling inserts with Physical Vapor Deposition (PVD) coated surfaces, all cutting tests were carried out in wet Ti6Al4V. The 0.2 mm wear limit was chosen. One method is used for analyze the data least squares method. which gives mathematical tool life model. The adequacy of the model is checked.

Jian Chen, Wei Liu, Xin Deng, Shanghua Wu et. al. [30] In this work, a thorough HT250 grey cast iron machining test was conducted using an unique cemented carbide of WC-5TiC-0.5VC-8Co (WTVC8). Due to much increased hardness and red hardness compared to the baseline plain WC-8Co(WC8) carbides, WTVC8 exhibits significantly higher tool life under the same cutting conditions.. According to the worn flank face observation, oxidation and adhesion wear are the primary wear mechanisms for both WTVC8 and WC8, and there is no obvious chipping, breaking, or abrasion wear. Cutting speed has the highest impact on tool life. The tool life models can provide quantitative direction

N.F. Husein, N.H. Razak et. al. [31]. Machining of challenging materials, including 316 stainless steel, has become a crucial concern in the manufacturing sector. This is because of its mechanical characteristics, which include great hardness and a high propensity for cutting tool failure. Therefore, in order to increase the machining of 316 Stainless Steel, it is essential to comprehend the detailed progression of cutting tool deterioration. In order to track and comprehend the tool degradation of coated tungsten carbide inserts during dry down-milling of 316 Stainless Steel, a number of recorded experiments had been carried out. But flank wear was shown to be the most common kind of tool degeneration (tool wear). Cutting tool wear increased with time as a result of blunting and rubbing on the surface of machined workpieces

D. Palanisamy, A. Devaraju, N. Manikandan . et. al. [32]This article describes how deep cryogenically treated tungsten carbide cutting tool inserts performed when they were used to machine precipitation-hardened stainless steel (PHSS). The cutting tool is cryo-treated tungsten carbide insert the output parameters are cutting force surface roughness and flank wear. According to the experimental research, inserts that had received cryogenic treatment had smaller cutting pressures, longer tool life, and greater wear resistance at higher cutting speeds. Surface finish was also seen to be superior when using cryo-treated inserts during machining, as opposed to cutting force

K.C. Ee, P.X. Li, A.K. Balaji et. al. [33]When assessing the effectiveness of a machining process, tool wear and life are crucial factors that are frequently taken into account. It is now more important than ever to understand how new grooved tools with intricate chip-groove geometry affect tool wear and life. The research being conducted at the University of Kentucky on modifications to the traditional tool wear and tool life methodologies when using grooved tool inserts is summarized in this paper. These modifications were made in response to the observation of more complex wear features and the application of more subtle failure criteria. Using tools with varying tool coatings and chip-groove geometries, cutting conditions such as cutting speed, feed, and depth of cut were experimentally investigated for their effects on tool life. To take into account the effects of these parameters, an empirical tool-life equation was put forward. According to the described method, each tool insert has to undergo 11 tests for tool wear and life.

CONCLUSION

We can conclude that the cermet insert don’t require cutting fluid due to ceramic material for the cutting operation in T51620 tool steel material but as compared to cermet insert tungsten carbide insert require cutting fluid for the cutting operation in T51620 tool steel material with the help of different range of cutting speed, feed and depth of cut we can get the optimum material removal rate and tool life of cermet and tungsten carbide inserts in T51620 tool steel material and the we can do comparison of tool life and material removal rate in both insert.

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