# TABLE OF CONTENTS

## Preface

- Temperature Effects on Grinding Residual Stress .................................................. 2
  - Omar Fergani, Yamin Shao, Ismail Lazoglu, Steven Y. Liang
- Semi-analytical Force Model for Grinding Operations ........................................ 7
  - Deniz Asian, Erhan Budak
- Study on Hydrodynamic Pressure in Grinding Contact Zone Considering Grinding Parameters and Grinding Wheel Specifications .................................................. 13
  - Alireza Vesali, Taghi Towakoli
- Improved Process Control and Model of Axial Forces of One-way Abrasive Flow Machining .......................................................... 19
  - Martin Swat, Horst Brünnet, Nataliya Lyubenova, Joachim Schmitt, Stefan Diedels, Dirk Bähr
- Investigation of Material Removal and Surface Topography Formation in Vibratory Finishing .................................................. 25
  - Eckart Uhlmann, Arne Debels, Alexander Eulitz
- Structuring of CBN Grinding Tools by Ultrashort Pulse Laser Ablation .................. 31
  - Christian Walter, Tim Komischke, Eduardo Weingärtner, Konrad Wegener
- Effect of Dressing on Internal Cylindrical Grinding .......................................... 37
  - A. Daneshi, N. Jandaghi, T. Towakoli
- The Effect of Pad-asperity Curvature on Material Removal Rate in Chemical-mechanical Polishing .................................................. 42
  - Sanha Kim, Nannaji Saka, Jun-Hoon Chun
- Surface Finishing of Needles for High-performance Biopsy .................................. 48
  - Valens Nteiyaremye, Yancheng Wang, Wei Si Li, Albert Shih, Hitomi Yamaguchi

## CUTTING

- High Performance Machining of Profiled Slots in Nickel-Based-Superalloys .......... 54
  - Patrik Vogtel, Fritz Klocke, Dieter Lung
- Hard Broaching of Case Hardened SAE 5120 ....................................................... 60
  - Harald Meier, Kevin Ninomiya, David Dornfeld, Volker Schulze
- Observations of Surface Acoustic Wave Strain and Resistive Strain Measurements on Broaching Tools for Process Monitoring ........................................ 66
- A Review of New Strategies for Gear Production ................................................. 72
  - Gregory Hyatt, Markis Piber, Nitin Chaphalkar, Orrin Kleinheinz, Masahiko Mori
- Fast Production of Gear Prototypes – A Comparison of Technologies .................. 77
  - Jan Bouquet, Lars Hensgen, Andreas Klink, Tom Jacobs, Fritz Klocke, Bert Lauwers
- Machinability of Powder Metallurgy Steels Using PcbN Inserts .......................... 83
  - Rachid M'Saoubi, Tobias Cotscher, Olof Andersson, Daniel Meyer
- Machinability Characteristics of Wrought and EBM CoCrMo Alloys ..................... 89
  - A. Bordin, A. Ghiotti, S. Braschi, L. Facchini, F. Bucciotti
- Machinability Enhancement of Lead-free Brass Alloys ....................................... 95
  - Christoph Nobel, Fritz Klocke, Dieter Lung, Sebastian Wolf
- Deformation Induced Surface Hardening when Turning Metastable Austenitic Steel AISI 347 with Different Cryogenic Cooling Strategies .............................. 101
  - Patrick Mayer, Robert Skorupski, Marek Smaga, Dietmar Eißler, Jan C. Aurič
- Dissolution of Iron-chromium Carbides during White Layer Formation Induced by Hard Turning of AISI 52100 Steel .................................................. 107
  - S. B. Hasseini, R. Dahlgren, K. Ryttberg, U. Klement
- Cutting Forces and Vibrations During Ball End Milling of Inclined Surfaces ........ 113
  - Szymon Wojcickiowski, Paweł Twardowski, Marcin Pelc
- Prediction of Process Forces and Stability of End Mills with Complex Geometries .................. 119
  - R. Grabowski, B. Denkena, J. Köhler
Force Prediction in Cutting Operations with Self-propelled Rotary Tools Considering Bearing Friction
Norikazu Suzuki, Toru Suzuki, Ran An, Kota Ukai, Eiji Shimota, Yu Hasegawa, Nobukazu Horiike

Microstructural Analysis of Nanostructured Aluminum Alloy Strips Created from Machining Based Deformation Process
Ravinder Singh Joshi, Siddharth Srivastava, Harpreet Singh

Microstructuring of Surfaces by Two-stage Vibration-assisted Turning
R. Zhang, P. Steinert, A. Schubert

Tool Wear Analyses in Low Frequency Vibration Assisted Drilling of CFRP/Ti6Al4V Stack Material
Oliver Pecat, Eckard Brinksmeier

Latest Machining Technologies of Hard-to-cut Materials by Ultrasonic Machine Tool
Florian Feucht, Jens Ketelaer, Alexander Wolff, Masahiko Mori, Makoto Fujishima

Time Domain Prediction of Side and Plunge Milling Stability Considering Edge Radius Effect
Jeong Hoon Ko

Spindle Rotational Speed Effect on Milling Process at Low Cutting Speed
Masakazu Soshi, Nicholas Raymond, Shinji Ishii

Frequency Domain Study of Vibrations above and under Stability Lobes in Machining Systems
Mahdi Eynian

Chatter Stability Prediction in Milling Using Speed-varying Cutting Force Coefficients
N. Grossi, L. Sallese, A. Scippa, G. Campatelli

Investigating Eccentricity Effects in Turn-milling Operations
Enre Uysal, Umit Karaguzel, Erhan Budak, Mustafa Bakkal

A New Identification Method of Specific Cutting Coefficients for Ball End Milling
S. Ehson Layegh K., Ismail Lazoglu

Evaluating the Roughness According to the Tool Path Strategy When Milling Free Form Surfaces for Mold Application
Adriano FagH De Souza, Adriano Machado, Sueli Fischer Beckert, Anselmo Eduardo Diniz

Optimization of Machining Parameters in WEDM of AISI D3 Steel Using Taguchi Technique
Brajesh Kumar Lodhi, Sanjay Agarwal

Characterization and Performance Evaluation of Mono-grain and Bi-modal PCD Grade in Machining of MMC
M. Ibrahim Sadik, E. Jalilian

Constant Depth Scoring of Fibre Reinforced Plastic Structures to Prevent Delamination
Tobias Greis, Christian Klingelhoeller, Wolfgang Hinze

Finite Element Modeling of Carbon Fiber Composite Orthogonal Cutting and Drilling
Shuji Usui, Jon Wadell, Troy Marsich

Chip Root Analysis after Machining Carbon Fiber Reinforced Plastics (CFRP) at Different Fiber Orientations
Robert Vogl, Marcel Henrichs, Friedrich Kuster, Konrad Wegener

Machining of Hypereutectic Aluminum Silicon Alloys
Eckart Uhmann, Karsten Flieg, Fiona Sammler, Iris Rueck, Arne Dehliefs

Conventional and Laser Assisted Machining of Composite A359/20SiCp
Daman Przestacki

A Study of Processing Al 6061 with Electrochemical Magnetic Abrasive Finishing
G. Y. Liu, Z. N. Guo, Z. S. Jiang, N. S. Qiu, Y. B. Li

Nano-scale Multilayered Composite Coatings for Cutting Tools Operating under Heavy Cutting Conditions

Development and Analysis of Microstructures for the Transplantation of Thermally Sprayed Coatings

Rapid Tooling Injection Molded Prototypes: A Case Study in Artificial Photosynthesis Technology
Joanna Noble, Karl Walczak, David Dorndorf

SIMULATION

Workpiece Setup Simulation based on Machinable Space of Five-axis Machining Centers
Mohammad Mt’Radj Ismaili, Ryuta Sato, Keiichi Shirase

Improving CNC Machine Tool Geometric Precision Using Manufacturing Process Analysis Techniques
Adam Hansel, Kazuo Yamazaki, Kyle Konishi
Influence of Motion Error of Translational and Rotary Axes onto Machined Surface Generated by Simultaneous Five-axis Motion

Ryula Sato, Kentaro Nishio, Keiichi Shirase, Gianni Campatelli, Antonio Scippa

Alloy Selection and Die Design for Stamped Proton Exchange Membrane Fuel Cell (PEMFC) Bipolar Plates

Travis Lee Smith, Anthony D. Santamaria, Jae Wan Park, Kazuo Yamazaki

Finite Element Simulation and Experimental Validation of Residual Stresses in High Speed Dry Milling of Biodegradable Mg-Ca Alloys

M. Salahshoor, Y. B. Guo

FEM based Cutting Velocity Selection for Thin Walled Part Machining

Antonio Scippa, Niccolò Grossi, Gianni Campatelli

CFD based Investigation on Internal Cooling of Twist Drills

F. Fallenstein, J. C. Aurich

Multiphysics Modeling and Simulation of Selective Laser Sintering Manufacturing Processes

Rishi Ganeriwala, Tarek I. Zohdi

METROLOGY

Axis Location Errors and Error Motions Calibration for a Five-axis Machine Tool Using the SAMBA Method

N. Alami McHichi, J. R. R. Mayer

Evaluation of Linear Axis Motion Error of Machine Tools Using an R-test Device

Yamaji Masashi, Naoki Hamabata, Yukitoshi Ihara

Investigation of a Multi-Cone Variant of the Standard Cone Frustum Test for 5-Axis Machine Tools

Shane Keaveney, Pat Connelly, Eamonn Ahearne, Gerald Byrne

A Machining Test to Evaluate Geometric Errors of Five-axis Machine Tools with its Application to Thermal Deformation Test

Soichi Ibaraki, Yasuke Ota

Evaluation of Polishing Pad Property by Rubber Hardness Test estimating Edge Surface Flatness of Workpiece

Urara Satake, Toshiyuki Enomoto

MICROMACHINING

Integrated Desktop Machine Tool for Manufacturing and Application of Ultra-small Micro Pencil Grinding Tools

M. Walk, J. C. Aurich

Highly Integrated High Precision Fluidic Feed Axis

Joerg Bauer, Daniel Mack, Juergen Fleischer

Development of Electrode Insulation Layer by Using Oxygen Plasma Surface Treatment for Electrochemical Microdrilling

Jung-Chou Hung, Hsien-Kuang Liu, Yu-Shu Chang, Kuo-En Hung, Shu-Juan Liu, Hung-Yi Chen, Po-Yuan Chen

Cutting Edge Preparation of Micro Milling Tools

E. Uhlmann, D. Oberschmidt, Y. Kuche, A. Löwenstein

A Study on PCD Tool Surface Reconditioning Technique for SiC Micromachining

Shogo Takesue, Kazutoshi Katahira, Jun Komotori

Comparing the Performance of Diamond Coated and Uncoated Micro End Mills Using Robustness Testing

Brodan Richter, Justin D. Morrow, Blair Martin, Patrick J. Heaney, Justin Segersten, Frank E. Pfefferkorn

Improving the Cutting Conditions in the Five-axis Micromilling of Hardened High-speed Steel by Applying a Suitable Tool Inclination

E. Krebs, P. Kersting

Micromilling of Sintered ZrO2 Ceramic via eBN and Diamond Coated Tools

Helen Romanos, Eleonora Ferraris, Jan Bouquet, Dominick Reynaerts, Bert Lamers

Experimental Investigations on Micro Milling of Stavax Stainless Steel

S. N. B. Oliaei, Y. Karpat

Estimation of Cutting Conditions in Precision Micromachining of CuNi Alloys of Varying Composition

Tom Childs, Chris Tyler, Chris Evans, Tony Schmitz, Ed Paul, Eric Browy
High-precision and High-efficiency Micromachining of Chemically Strengthened Glass Using Ultrasonic Vibration
Kazuki Noma, Yu Takeda, Tojiro Aoyama, Yasuhiro Kakinuma, Seiji Hamada

MACHINE TOOLS

Cutting Fluid Influence on Thermal Behavior of 5-axis Machine Tools
Josef Mayr, Michael Gebhardt, Benjamin B. Massow, Sascha Wielhert, Konrad Wegener

Next Generation High Performance Cutting by Use of Carbon Dioxide as Cryogenics
Sasanne Cordes, Fabian Hübner, Thomas Schaarschmidt

Regenerative Instability of Impact-cutting Material Removal in the Grinding Process Performed by a Flexible Robot Arm
Farzad Rafieian, Bruce Hazel, Zhaoheng Liu

Characterization of an Eigenfrequency Adaptable Machine Tool Carriage
Simon-F. Koch, Joerg Bauer, Henning Wagner, Johannes Horsch, Stefan Brecht, Juergen Fleischer

NONTRADITIONAL MACHINING

Video based Process Observations of the Pulse Electrochemical Machining Process at High Current Densities and Small Gaps
Andreas Rebschläger, Rouven Kollmannsperger, Dirk Bähre

Condition Monitoring in Concurrent Micro-hole Electrical Discharge Machining with Electrode Feeding Devices Employing AZARASHI (Seal) Mechanism
Katsuaki Furutani, Daisuke Hiraoka

Evaluation of Advanced Wire-EDM Capabilities for the Manufacture of Wire Tree Slots in Inconel 718
F. Klocke, D. Welling, A. Klink, D. Veselovac, T. Nöthe, R. Perez

Fundamental Analysis of High Frequent Electrical Process Signals for Advanced Technology Developments in W-EDM
Max Schwade

Process Analysis of Water Abrasive Fine Jet Structuring of Ceramic Surfaces via Design of Experiment
M. Ditrich, M. Dix, M. Kuhl, B. Palumbo, F. Tagliaferri

PROCESS MONITORING AND CONTROL

FPGA based Monitoring Platform for Condition Monitoring in Cylindrical Grinding
Ivor Humphreys, Gerrit Eisenblätter, Garrett E. O'Donnell

In-situ CMP Endpoint Detection Using Acoustic Emission
Monor Hela, Jushua Chien, David Dornfeld

Innovative Sensor Concept for Chip Transport Monitoring of Gun Drilling Processes
F. Klocke, G. Keitzel, D. Veselovac

Power Measurement for Sustainable High-performance Manufacturing Processes
Sean Humphrey, Helen Papadopoulos, Barbara Linke, Sindic Maiyya, Athulan Vijayaraghavan, Robert Schmitt

Compensation of Disturbances on Force Signals for Five-axis Milling Processes
F. Klocke, M. Blattner, O. Adams, M. Brockmann, D. Veselovac

Tool Collision Detection in High-speed Feeding based on Disturbance Observer
Ryo Koike, Yasuhiro Kakinuma, Tojiro Aoyama, Kouhei Ohnishi

Non-contact Measurement of Dynamic Stiffness of Rotating Spindle
Atsushi Matsubara, Ryota Sawamura, Kohei Asano, Toshiyuki Muraki

Real-time Monitoring of High-speed Spindle Operations Using Infrared Data Transmission
K. Dräder, H.-W. Hoffmeister, M. Luig, T. Toennis, T. Blume

Modeling Errors Influencing Active Structural Methods for Chatter Mitigation in Milling Process
Jérémie Monnin, Fredy Kuster, Konrad Wegener

High Performance of Machining Processes by Applying Adaptronic Systems
W.-G. Drusel, A. Bucht, C. Hochmuth, A. Schubert, A. Stoll, J. Schneider, R. Schneider

Sliding Mode Contouring Control for Bi axial Feed Drive Systems with a Nonlinear Sliding Surface
A. El Khalick M., Naoki Uchiyama, Shigenori Sano

An Approach to Building Specialized CNC Systems for Non-traditional Processes
Georgi M. Martinov, Aleksandr I. Obuhov, Lilija I. Martinova, Anton S. Grigoriev
### SUSTAINABLE MACHINING

<table>
<thead>
<tr>
<th>Title</th>
<th>Page</th>
</tr>
</thead>
<tbody>
<tr>
<td>Research and Development of a Cross-platform CNC Kernel for Multi-axis Machine Tool</td>
<td>517</td>
</tr>
<tr>
<td>Sergei N. Grigoriev, Georgi M. Martinov</td>
<td></td>
</tr>
<tr>
<td>Minimum Quantity Lubrication (MQL) in Automotive Powertrain Machining</td>
<td>523</td>
</tr>
<tr>
<td>Bruce L. Tai, David A. Stephenson, Richard J. Furness, Albert J. Shih</td>
<td></td>
</tr>
<tr>
<td>An Experimental Investigation on Cryogenic Milling of Inconel 718 and its Sustainability Assessment</td>
<td>529</td>
</tr>
<tr>
<td>Amparla Aramcharoen, Sowkah Chian</td>
<td></td>
</tr>
<tr>
<td>Finite Element Model to Calculate the Thermal Expansions of the Tool and the Workpiece in Dry Turning</td>
<td>535</td>
</tr>
<tr>
<td>S. Schindler, M. Zimmermann, J. C. Ausrich, P. Steinmann</td>
<td></td>
</tr>
<tr>
<td>Effect of Cutting Speed and Tool Coating on Machined Surface Integrity of Ni-based Super Alloy</td>
<td>541</td>
</tr>
<tr>
<td>A. Thakur, S. Gangopadhyay, K. P. Malty</td>
<td></td>
</tr>
<tr>
<td>Effect Tool Wear During End Milling on the Surface Integrity and Fatigue Life of Inconel 718</td>
<td>546</td>
</tr>
<tr>
<td>W. Li, Y. B. Guo, M. E. Barkey, J. B. Jordon</td>
<td></td>
</tr>
<tr>
<td>Comparative LCA of a Linear Motor and Hybrid Feed Drive under High Cutting Loads</td>
<td>N/A</td>
</tr>
<tr>
<td>Siddharth Kale, Nattasit Dancholvichit, Chinedum Okwudire</td>
<td></td>
</tr>
<tr>
<td>Empirical Study of the Power Efficiency of Various Machining Processes</td>
<td>558</td>
</tr>
<tr>
<td>Hae-Sung Yoon, Jang-Yeob Lee, Min-Soo Kim, Eun-Seob Kim, Sung-Hoon Ahn</td>
<td></td>
</tr>
<tr>
<td>Sustainability Indicators for Finishing Operations based on Process Performance and Part Quality</td>
<td>564</td>
</tr>
<tr>
<td>Barbara Linke, Jayanti Das, Myron Lam, Cuong Ly</td>
<td></td>
</tr>
<tr>
<td>Sustainability Analysis of Grinding with Power Tools</td>
<td>570</td>
</tr>
<tr>
<td>Kyle Odum, Maria Celeste Castillo, Jayanti Das, Barbara Linke</td>
<td></td>
</tr>
<tr>
<td>Workpiece Orientation and Tooling Selection to Reduce the Environmental Impact of Milling Operations</td>
<td>575</td>
</tr>
<tr>
<td>G. Campatelli, A. Scippa, L. Lorenzini</td>
<td></td>
</tr>
<tr>
<td>A Comparative Study of CNC Part Programming Addressing Energy Consumption and Productivity</td>
<td>581</td>
</tr>
<tr>
<td>G. Minquiz, V. Borja, M. Lopez-Parra, A. Ramirez-Reivich, M. Dominguez, A. Alcaide</td>
<td></td>
</tr>
<tr>
<td>The Influence of Tool Wear on the Vibrations During Ball End Milling of Hardened Steel</td>
<td>587</td>
</tr>
<tr>
<td>S. Wojciechowski, P. Twardowski</td>
<td></td>
</tr>
<tr>
<td>The Effects of Tool Degradation on Hole Straighteners in Deep Hole Gundrilling of Inconel-718</td>
<td>593</td>
</tr>
<tr>
<td>K. Woon, A. Chaudhari, A. Kumar, M. Rahman</td>
<td></td>
</tr>
<tr>
<td>Experimental Study and Modelling of Plastic Deformation of Cemented Carbide Tools in Turning</td>
<td>599</td>
</tr>
<tr>
<td>A. Nordgren, B. Samani, R. Saoubi</td>
<td></td>
</tr>
<tr>
<td>Survival Life Analysis of the Cutting Tools During Turning Titanium Metal Matrix Composites (Ti-MMCs)</td>
<td>605</td>
</tr>
<tr>
<td>M. Aramesh, Y. Shaban, M. Balazinski, H. Akita, H. Kishawy, S. Yacout</td>
<td></td>
</tr>
<tr>
<td>Turning of High-Performance Materials with Rotating Indexable Inserts</td>
<td>610</td>
</tr>
<tr>
<td>E. Uhlmann, F. Kaufersch, M. Roeder</td>
<td></td>
</tr>
<tr>
<td>Development of a Chip Pulling System for Efficient Turning</td>
<td>616</td>
</tr>
<tr>
<td>B. Sencer, T. Aoki, E. Shamoh, T. Hasegawa, T. Koide</td>
<td></td>
</tr>
<tr>
<td>Author Index</td>
<td></td>
</tr>
</tbody>
</table>