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## Experimental Comparison of Micromilling Pure Titanium and Ti-6Al-4V

Fábio Oliveira Campos, Anna Carla Araujo, Shiv Gopal Kapoor

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**Abstract**

Pure titanium is the ideal metallic material to be used for producing dental implants due to its good corrosion resistance and biocompatibility. However, pure titanium does not present high mechanical resistance, which can be a limiting factor. Recently, the pure titanium is being replaced by titanium alloy with aluminum and vanadium (Ti-6Al-4V). This study deals with micromilling machinability of pure titanium and Ti-6Al-4V considering mechanical properties, the forces measured during the process, surface roughness, top burr height, and chips morphology. The cutting tests are performed for the constant depth of cut and cutting speed, and a range of feed per tooth from 0.5 to 4.0  $\mu\text{m}/\text{tooth}$ . Results show no significant differences in roughness and burr formation whereas higher forces are found for the titanium alloy compared to pure metal. Both materials produce long chips for smaller feeds.

**Keywords:** micromilling, titanium, machinability.

**1. Introduction**

Pure titanium (CP-Ti) is the ideal titanium-based material to be used in the manufacturing of implants because of its properties: good corrosion resistance, biocompatibility and reasonable mechanical resistance [1, 2]. However, due to fatigue failure the chances for a surgery for implant removal are seen to be increased [3]. The titanium alloy (Ti-6Al-4V) presents higher mechanical resistance preserving the essential properties for implants, although it can be dangerous for health after a long time use of these implants [4].

Titanium based metals are considered difficult-to-machine materials, especially due to their low thermal conductivity [4-6]. Although there are a few studies that covered some aspects of micromilling titanium alloys [7,8], there is a lack of comprehensive study on the micromilling machinability of titanium alloys. The present work compares the micromilling machinability of pure titanium grade 2 and Ti-6Al-4V that includes cutting forces, surface roughness, top burr height and chips morphology analysis.

**2. Experimental Work**

Experiments are conducted using the statistical design of experiment approach in order to characterize the influence of feed per tooth on cutting forces, surface roughness, top burr height and chips morphology and the results are compared for both titanium-based materials including pure titanium and titanium alloy (Ti-6Al-4V).

**2.1. Material and experimental apparatus**

Pure titanium (CP-Ti) grade 2 and Ti-6Al-4V workpieces were prepared from annealed bars. Microstructures of both materials were analysed under an optical microscope after a chemical attack with Kroll's reagent and are shown in Fig.1. It can be seen that pure titanium is composed by equiaxed coarse alpha grains with dimension in the order of 20-30  $\mu\text{m}$ . Titanium alloy presents equiaxed alpha grains

mixed with alpha/beta small regions in between them.

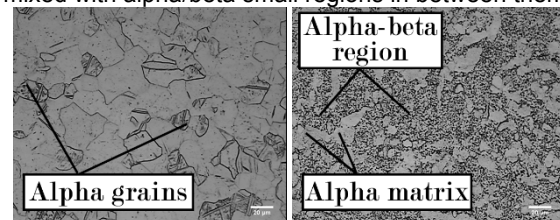


Fig. 1. Microstructure of pure titanium and Ti-6Al-4V.

Mechanical properties of CP-Ti grade 2 and Ti-6Al-4V were obtained from literature [9]. These include flexural modulus of 105 GPa and flexure strength 345 MPa, for pure titanium whereas Ti-6Al-4V has flexural modulus of 105 GPa and flexural strength of 900 MPa. Vickers hardness tests were also carried out for both materials using loads of 30 kgf for cycles of 20 s. The hardness values for pure titanium and Ti-6Al-4V were found to be 168 HV30 and 318 HV30, respectively.

The micromilling experiments were performed on a CNC Mini-mill/GX using 500  $\mu\text{m}$  carbide square-end-mills with 2 flutes. The microtools were analysed under a Zeiss scanning electron microscope, model DSM 940. The measurements yielded the cutting edge  $r_e$  radius of 2-2.5  $\mu\text{m}$ , corner radius of 10  $\mu\text{m}$  and helix angle of 26° as can be seen in Fig. 2.

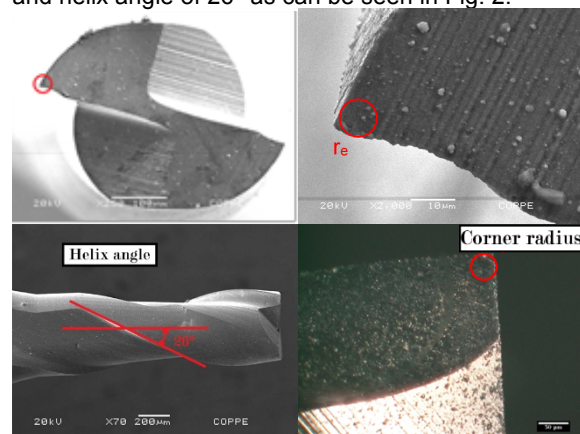


Fig. 2. Cutting edge radius, helix angle and corner radius

measurement.

For force measurements, the Kistler dynamometer MiniDyn 9256C2, the Kistler charge amplifier 5070A10100 and the data acquisition board USB 6251 from National Instruments were used. Figure 3 shows the axis configuration of force measurements in relation to the workpiece. Force results were analysed using the average of the maximum resultant force per tool revolution for 40 revolutions

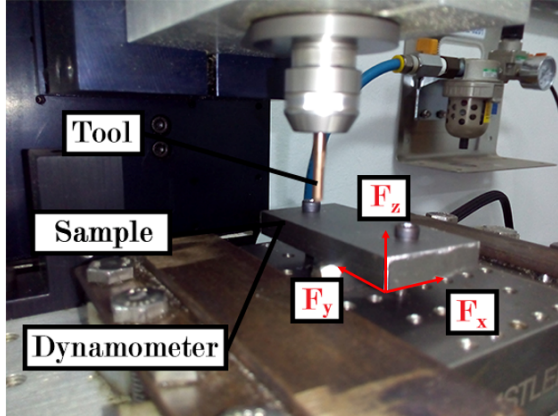


Fig. 3. Cutting force measurement directions.

For roughness and top burr height measurements, a profilometer Form Talysurf Intra120 with stylus 112/2009, and 2  $\mu\text{m}$  corner radius was used. Three roughness measurements were performed along the feed direction on the bottom surface of each machined groove as shown in Fig. 4. Cut-off filter used was 0.08, according to ISO 4288-1996.

Top burr height measurement was performed by taking the profile of each groove as showed in Fig. 5. Five measurements in different positions along the groove were made. Also, SEM images were used to visually analyse burr formation. Chips were collected in all experiments. For the chips morphology and grooves surface analysis SEM and USB AM3715TB Dino-Lite Edge handheld digital microscope images were used.

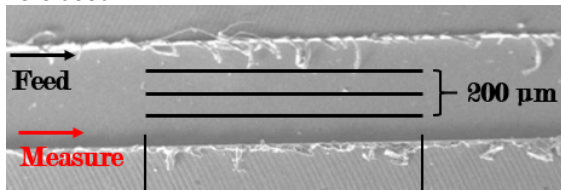


Fig. 4. Surface roughness measurement.

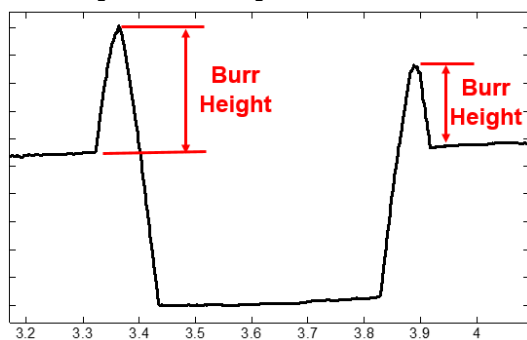


Fig. 5. Top burr height measurement procedure.

## 2.2. Experimental procedure

Before the actual experiments, the workpieces

were pre-machined to avoid axial depth of cut variation. The cutting speed of 37.7 m/min. (4000 rpm), feed of 120 m/min. (feed per tooth of 0.015 mm) and axial depth of cut of 30  $\mu\text{m}$  with a 3 mm diameter tool were employed in machining tests.

Feed per tooth range considering the cutting edge radius value ( $r_e = 2.0\text{-}2.5 \mu\text{m}$ ) was chosen in order to clearly detect both ploughing and shearing regions. The cutting speed, axial depth of cut and cutting length were kept constant during machining. The full immersion machining was chosen so that the tool would engage in both up and down milling. The cutting parameters are shown in Table 1.

In order to study the tool wear influence on the measured outputs, the tests were conducted in two batches. The tests in batch A were performed with increasing feed per tooth and the tests in batch B were done with decreasing feed per tooth, as shown in Table 2.

Table 1. Cutting data.

Parameter	Value
Tool diameter	500 $\mu\text{m}$
Spindle speed	18000 rpm
Cutting speed	28.3 m/min.
Feed per tooth	0.5 – 4.0 $\mu\text{m}$
Axial depth of cut	40 $\mu\text{m}$
Radial depth of cut	500 $\mu\text{m}$
Cutting length	4 mm
Cutting system	Dry cutting

Table 2. Design of experiments.

Exp.	Batch	Feed ( $\mu\text{m}/\text{tooth}$ )	Machined length (mm)
1 to 8	Batch A	0.5; 1.0; 1.5; 2.0; 2.5; 3.0; 3.5; 4.0	4 to each level of feed per tooth (0 to 32 mm)
9 to 16	Batch B	4.0; 3.5; 3.0; 2.5; 2.0; 1.5; 2.0; 0.5	4 to each level of feed per tooth (0 to 32 mm)

## 3. Results and Discussion

In this section, the machinability measures including cutting forces, surface roughness, top burr height and chip morphology are analysed as a function of feed per tooth in micro-milling of both pure titanium and titanium alloy. It can be seen, as expected, titanium alloy with aluminium and vanadium presented higher strength and hardness than pure titanium.

### 3.2. Cutting forces analysis

Maximum resultant force results for batches A and B for CP-Ti and Ti-6Al-4V are shown in Fig. 6. The error bars in Fig. 6 represent  $\pm 1.96\sigma$  and they correspond to a 95% confidence interval. For both materials, there was a significant difference between the batches, indicating that tool wear probably had a significant influence on force results. The influence of feed per tooth on machining forces was found to be

as expected. The higher forces are seen with increasing feed per tooth since the chip area increases with feed.

Further, due to its higher mechanical resistance and hardness, titanium alloy presented higher forces for both batches. However, it can be seen that difference between the batches was higher for the titanium alloy, indicating the tool wear had more influence for this material.

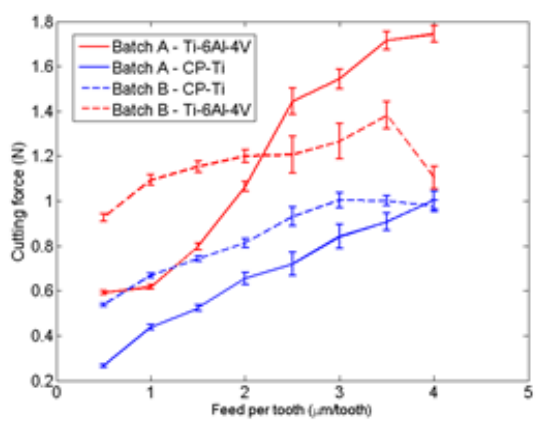


Fig. 6. Experimental cutting force results.

### 3.3. Surface roughness analysis

Figure 7 presents the influence of feed per tooth on surface roughness for pure titanium and titanium alloy, considering both batches of experiments. Three regions with different trends can be identified in the figure. In Region I, between feeds of 0.5 to 1.5  $\mu\text{m}/\text{th}$ , the roughness decreased when feed per tooth is increased. In Region II, between 1.5 and 3.5  $\mu\text{m}/\text{tooth}$ , it can be seen that the roughness initially increased and then decreased or maintained at the same level. In Region III, between 3.5 and 4.0  $\mu\text{m}/\text{tooth}$ , the roughness showed a rapid growth for higher feed values.

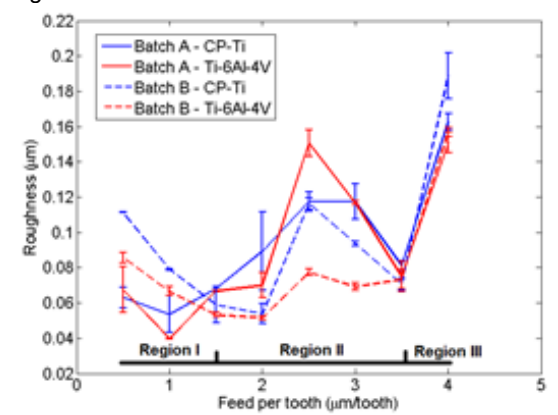


Fig. 7. Surface roughness results.

The Region I in Fig. 7 shows a decrease in roughness when feed/tooth is small, because in this region, the ploughing phenomenon occurs, where the material is plastically deformed rather than removed by shearing. The Region II presents a transition phase from ploughing to shearing and has feed values around the cutting edge radius ( $r_e = 2.0\text{-}2.5 \mu\text{m}$ ). The Region III corresponds to pure shearing and roughness presents behaviour similar to the conventional macro milling, where roughness increases for higher feed values.

Also, it can be seen in Fig. 7, a large variation in

roughness value for some feed values between batches A and B. This can be related to the fact that roughness is deeply connected to the corner radius of the tool and can vary with tool wear. Regarding the comparison of roughness values between pure titanium and Ti-6Al-4V, it can be seen that there is no significance difference in roughness results between the two materials.

### 3.4. Top burr height analysis

For the top burr height results, the average was computed between the batches for up and down milling as burr measurements are found inherently noisy. The results are presented in Fig. 8. It can be seen that, in general, up milling presented a better result in terms of lower top burr height than down milling, which is also confirmed by SEM images of machined channels (Fig. 9) for both materials. The lower burr formation in up milling can be explained by the fact that in up milling chip thickness starts with small values meaning that a small volume of material is being deformed and removed. When the tool is in the down milling region, a higher volume of material, which has already been deformed, generates the top burr.

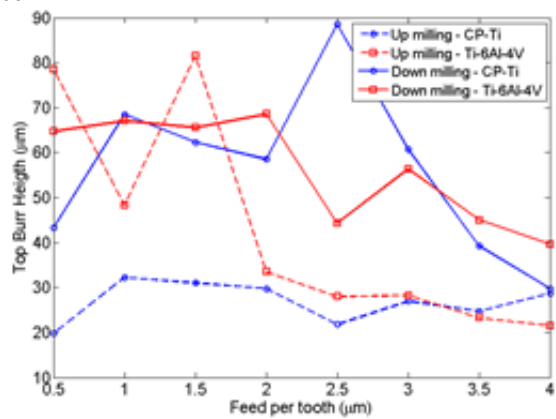
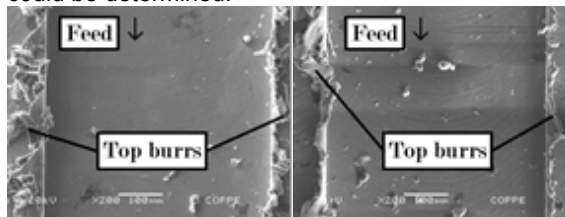


Fig. 8. Top burr height results for up and down milling.

Figure 8 indicates that top burr values are higher for small feeds per tooth, which can also be confirmed by observing the SEM images in Fig. 9. Indeed, higher feeds lead to smaller top burr heights. This happens because as feed per tooth decreases and gets closer to the cutting edge radius, shearing of the material starts to be replaced by ploughing mechanism where the material is plastically deformed more than machined through shearing. By comparing the burr height results of CP-Ti with Ti-6Al-4V, it can be seen that the results are similar with the exception of a few specific points and no significant difference could be determined.





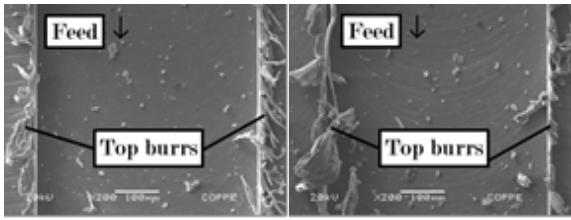


Fig. 9. Scanning electron microscope images: a) CP-Ti – 1.0  $\mu\text{m}/\text{th}$ ; b) CP-Ti – 3.5  $\mu\text{m}/\text{th}$ ; c) Ti-6Al-4V – 1.0  $\mu\text{m}/\text{th}$ ; d) Ti-6Al-4V – 3.5  $\mu\text{m}/\text{th}$ .

### 3.5. Chips morphology analysis

Microchips images for the pure titanium and titanium alloy obtained from the experiments using the feed per tooth of 0.5 and 4.0  $\mu\text{m}/\text{tooth}$ , are shown in Fig. 10. Analysing the images, it can be seen that lower feeds generated long and continuous chips. When increasing feed per tooth, microchips became very short going from a length of more than 1 mm for 0.5  $\mu\text{m}$  feed per tooth to around 200  $\mu\text{m}$  for 4  $\mu\text{m}/\text{tooth}$ . Usually, short chips are preferred in machining, as long chips can roll up the tool and have more chances to be cut again during the process, which can prejudice surface finish. Also, chips are responsible for removing heat from the cutting region. Therefore, the longer a chip takes to break away, the longer it requires to remove heat and cool the tool-material contact region. However, the chip length rapidly decreased after machining with feeds above 1.5  $\mu\text{m}/\text{tooth}$ . The long chips for the small feeds probably happened because the chip thickness is given by the feed per tooth. The thicker the chips, more difficult it is for them to curl while in contact with the rake surface of the microtool. Probably, the chips break when they start to curl during the cutting process.

For titanium alloy, the chip length decreased with increasing feed per tooth varying from a length of around 0.5 mm for 0.5  $\mu\text{m}$  feed per tooth to around 200  $\mu\text{m}$  for 4  $\mu\text{m}/\text{tooth}$ . Feeds higher than 2.0  $\mu\text{m}/\text{tooth}$  showed smaller chips. For 0.5 and 1.0  $\mu\text{m}/\text{tooth}$  feeds, despite them being longer than for other feeds, the chips are found curly in shape, which is a more desirable shape than the snarled one as they are less likely to cause damage to the tool or the machined surface.

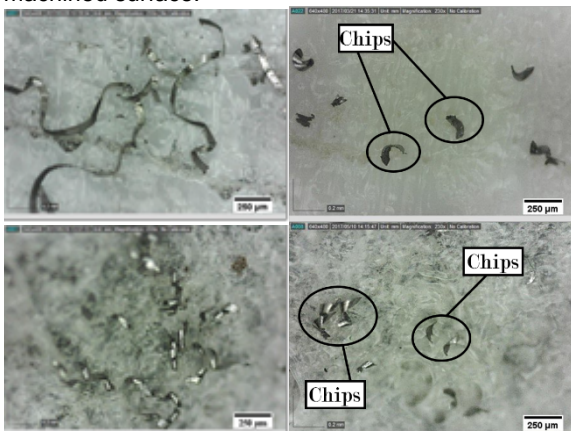


Fig. 10. Digital microscope images of chips: a) CP-Ti – 0.5  $\mu\text{m}/\text{tooth}$ ; b) CP-Ti – 4.0  $\mu\text{m}/\text{tooth}$ ; c) Ti-6Al-4V – 0.5  $\mu\text{m}/\text{tooth}$ ; d) Ti-6Al-4V – 4.0  $\mu\text{m}/\text{tooth}$ .

## 4. Conclusions

This work presented a comparison between the micromilling machinability of pure titanium and Ti-6Al-4V at different feeds per tooth (from 0.5 to 4.0  $\mu\text{m}/\text{th}$ ). The machinability measures included the cutting forces, surface roughness, top burr height and chips morphology. The following conclusions can be drawn from this study:

- Titanium alloy presented higher strength and hardness, but similar elastic modulus as pure titanium. The mechanical properties directly influenced the forces during micromilling processes. Cutting forces for titanium alloy were higher than for CP-Ti and results indicated a high influence of tool wear for machining Ti-6Al-4V;
- Surface roughness results show no significant difference between the two materials. The general behavior of the influence of feed per tooth on roughness identified the three cutting regimes: ploughing, transition from ploughing to shearing and shearing;
- Top burr height measurements indicated similar results for both pure titanium and titanium alloy. Also, up milling presented better results in terms of smaller top burr heights than down milling because in up milling a small volume of material is plastically deformed while in down milling a higher volume has the possibility of becoming burrs;
- Chips morphology results showed that for pure titanium, chips changed from a snarled long shape to short chips with increasing feed. For the titanium alloy, with higher feeds, the chips are found to be curly and short.

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