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(71) Demandeur/Applicant:
ISCAR LTD., IL
(72) Inventeur/Inventor:
HECHT, GIL, IL
(74) Agent: DIMOCK STRATTON LLP

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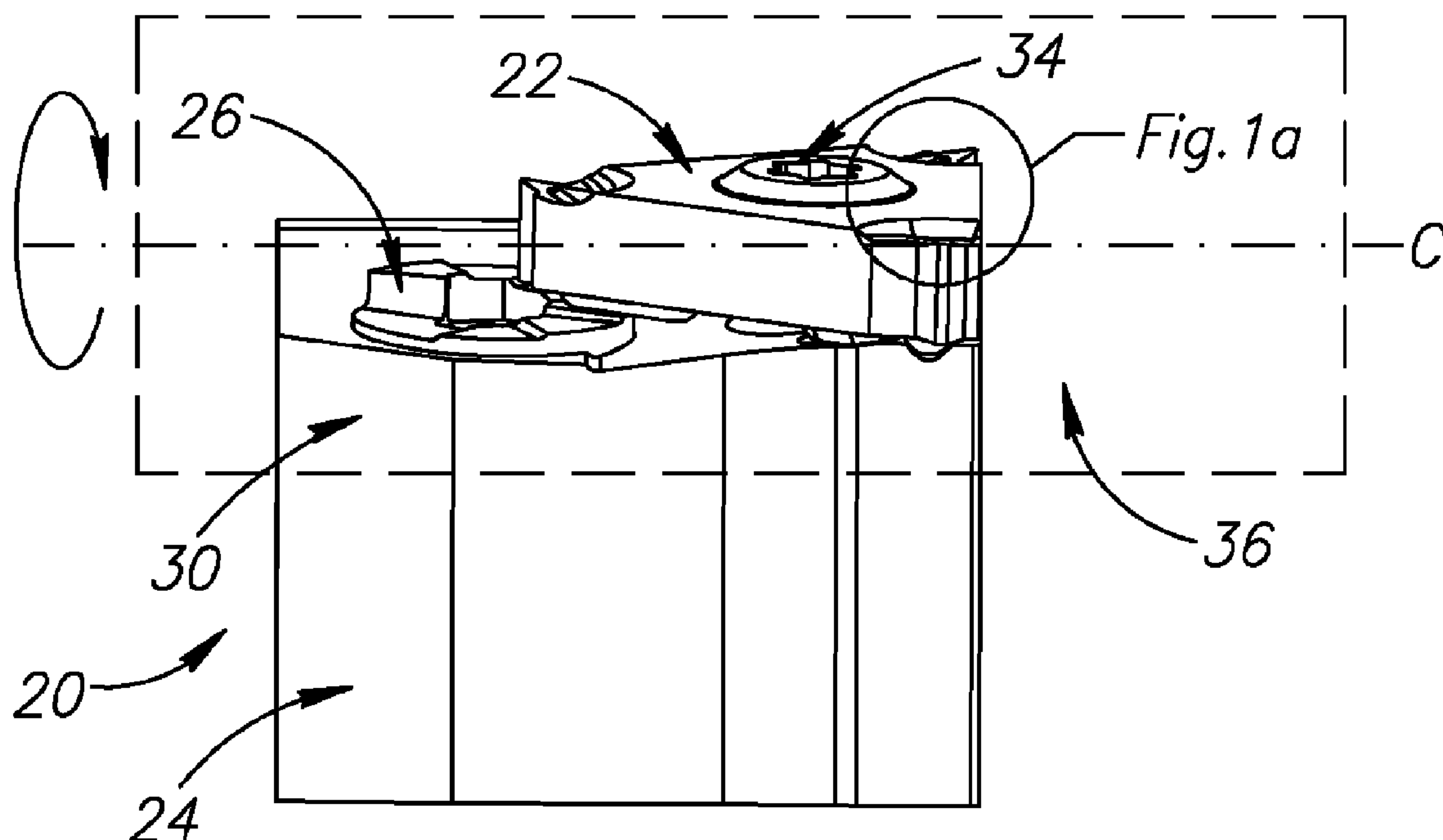


FIG.1

(57) **Abrégé/Abstract:**

A cutting tool (20) has a cutting insert (22), a tool holder (24), and an adjustment member (26). The tool holder (24) includes an insert holder portion (30) and a shank portion, the insert holder portion (30) being rigidly fixed to the shank portion. The cutting insert (22) is removably secured to the insert holder portion (30) by a fastener, at a cutting position in which the operative cutting portion (28) encounters a workpiece (36) at an insert cutting angle (a). The adjustment member (26) is non-threadingly retained on the insert holder portion (30), and operatively connected to the cutting insert (22). Actuation of the adjustment member (26) causes an increase or decrease of the insert cutting angle (a).

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- (71) **Applicant** (for all designated States except US): **ISCAR LTD.** [IL/IL]; P.O. Box 11, 24959 Tefen (IL).
- (72) **Inventor; and**
- (75) **Inventor/Applicant** (for US only): **HECHT, Gil** [IL/IL]; Ahad Ha'am Street 30/18, 22443 Nahariya (IL).
- (74) **Agent:** **ISCAR LTD., PATENT DEPARTMENT;** P.O. Box 11, 24959 Tefen (IL).

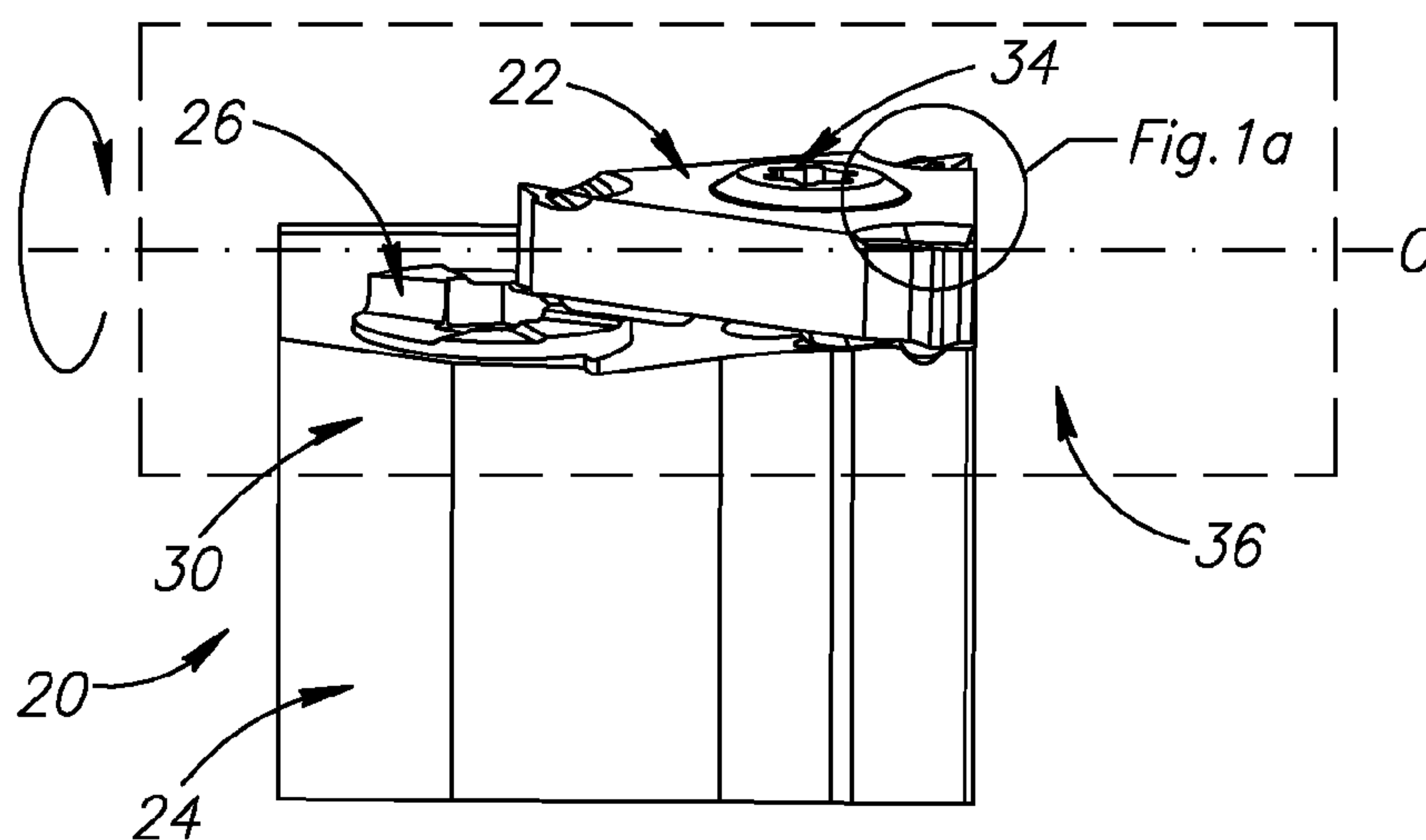
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(54) Title: ADJUSTABLE CUTTING TOOL

**FIG.1**

(57) **Abstract:** A cutting tool (20) has a cutting insert (22), a tool holder (24), and an adjustment member (26). The tool holder (24) includes an insert holder portion (30) and a shank portion, the insert holder portion (30) being rigidly fixed to the shank portion. The cutting insert (22) is removably secured to the insert holder portion (30) by a fastener, at a cutting position in which the operative cutting portion (28) encounters a workpiece (36) at an insert cutting angle (a). The adjustment member (26) is non-threadingly retained on the insert holder portion (30), and operatively connected to the cutting insert (22). Actuation of the adjustment member (26) causes an increase or decrease of the insert cutting angle (a).

ADJUSTABLE CUTTING TOOL

FIELD OF THE INVENTION

The present invention relates to an adjustable cutting tool for use in metal cutting processes in general, and for threading operations in particular.

5 BACKGROUND OF THE INVENTION

Within the field of cutting tools used in threading operations, exchangeable anvils or shims directly supporting a removably securable threading insert have long since provided a way to adjust the inclination angle of the threading insert to equal the helix angle of the thread being cut, and thus provide equal clearance for the cutting edges.

10 US 3,520,042 discloses an adjustable holder for a thread cutting insert which eliminates the need for exchangeable anvils or shims. The adjustable holder comprises a shank with a recess in the form of a partial cone, and a mating partially conical block disposed in the recess. The thread cutting insert is mounted on the conical block by means of a set screw, and the conical block is angularly adjustable within the recess so as
15 to provide alignment between the plane of symmetry of the cutting insert and the helix angle of the thread being cut. A slot in the shank is angularly aligned with a radial threaded bore in the conical block, and a bolt located in the slot engages the threaded bore to clamp the conical block in the recess at its adjusted position.

US 2008/0253847 discloses a tool holder assembly which incorporates a cutting
20 edge adjustment member that does not contact the cutting insert. The tool holder assembly also includes a tool holder and an insert holder, with the cutting insert being mounted in the insert holder by a screw and a clamp, and an outside curved surface of the insert holder configured to mate with a curved arcuate surface of an insert receiving end of the tool holder. The cutting edge adjustment member is in the form a precision ground adjustment
25 washer having an angled top surface. An adjustment bolt, having a head that rests on the

angled top surface of the adjustment washer, protrudes through a slot in the insert receiving end and engages a threaded hole in the insert holder. The angle of the top surface determines the rotational position in the slot at which the bolt engages the threaded hole and thus defines a particular cutting edge angle. The adjustment washer can be re-oriented or
5 exchanged for another adjustment washer with different angle of top surface to define a different cutting edge angle.

It is an object of the present invention to provide an improved adjustable cutting tool.

It is also an object of the present invention to provide an adjustable cutting tool
10 without exchangeable anvils or shims.

It is a further object of the present invention to provide an adjustable cutting tool without separate shank and insert holder components.

It is yet a further object of the present invention to provide an adjustable cutting tool having a readily accessible and operator friendly means of adjustment.

15

SUMMARY OF THE INVENTION

In accordance with the present invention, there is provided a cutting tool comprising:

- a cutting insert, a tool holder, and an adjustment member;
- 20 the cutting insert having at least one cutting portion,
- the tool holder having an insert holder portion and a shank portion, the insert holder portion being rigidly fixed to the shank portion,
- the adjustment member being non-threadingly retained on the insert holder portion, and operatively connected to the cutting insert, and
- 25 the cutting insert being removably secured to the insert holder portion by means of a fastener, at a cutting position in which the operative cutting portion encounters a workpiece at an insert cutting angle,

wherein actuation of the adjustment member causes an increase or decrease of the insert cutting angle.

Also in accordance with the present invention, there is provided a method of increasing or decreasing an insert cutting angle of a cutting tool relative to a workpiece, the cutting tool comprising:

- 5 a cutting insert, a tool holder, and an adjustment member;
 - the cutting insert having at least one cutting portion,
 - the tool holder having an insert holder portion and a shank portion, the insert holder portion being rigidly fixed to the shank portion,
 - the insert adjustment member being non-threadingly retained on the insert holder
 - 10 portion, and operatively connected to the cutting insert, and
 - the cutting insert being removably secured to the insert holder portion by means of a fastener,
 - the method comprising the steps of:
 - untightening the fastener,
 - 15 actuating the adjustment member without removing any components from the cutting tool, and
 - retightening the fastener.

Further in accordance with the present invention, there is provided a cutting tool

20 comprising:

- a tool holder having an insert holder portion;
- a cutting insert removably secured to the insert holder portion, the cutting insert having an operative cutting portion provided with an associated insert tilt axis and an active support zone located away from the insert tilt axis; and
- 25 an adjustment member non-threadingly retained on the insert holder portion and having a first axis and a supporting surface at least a first portion of which opposes the cutting insert at the active support zone; wherein:
 - rotation of the adjustment member about the first axis and relative to the insert holder portion results in a second portion of the supporting surface opposing the active

support zone, and changes in both the elevation of the secured cutting insert at said active support zone and the tilt of the secured cutting insert about the insert tilt axis, relative to the insert holder portion.

5 BRIEF DESCRIPTION OF THE DRAWINGS

For a better understanding, the invention will now be described, by way of example only, with reference to the accompanying drawings in which chain-dash lines represent cut-off boundaries for partial views of a member and in which:

10 **Fig. 1** is a perspective view of a cutting tool in accordance with a first embodiment of the present invention;

Fig. 1a is a detailed perspective view of the cutting tool shown in Fig. 1;

Fig. 2 is a top view of the cutting tool shown in Fig. 1;

Fig. 3 is an exploded perspective view of the cutting tool shown in Fig. 1;

15 **Fig. 4** is a top view of an adjustment member in accordance with the first embodiment of the present invention;

Fig. 5 is a front view of the adjustment member shown in Fig. 4;

Fig. 6 is a top view of a cutting insert in accordance with some embodiments of the present invention;

20 **Fig. 7** is a bottom view of the cutting insert shown in Fig. 6;

Fig. 8 is a perspective view of a cutting tool in accordance with a second embodiment of the present invention;

Fig. 9 is an exploded perspective view of the cutting tool shown in Fig. 8;

25 **Fig. 10** is a top view of an adjustment member in accordance with the second embodiment of the present invention; and

Fig. 11 is a front view of the adjustment member shown in Fig. 10.

DETAILED DESCRIPTION OF THE INVENTION

Attention is first drawn to Figs. 1 to 3, 8 and 9, showing a cutting tool **20, 120** in

accordance with some embodiments of the present invention. The cutting tool **20, 120** includes a cutting insert **22**, a tool holder **24**, and an adjustment member **26, 126**.

The cutting insert **22** has at least one cutting portion **28** and may be manufactured by form pressing and sintering a cemented carbide, such as tungsten carbide, and may be
5 coated or uncoated.

The tool holder **24**, which may be manufactured from hardened steel, has an insert holder portion **30, 130** and a shank portion **32**, the insert holder portion **30, 130** being rigidly fixed to the shank portion **32**.

The adjustment member **26, 126**, having a first axis **A1**, is non-threadingly retained
10 on the insert holder portion **30, 130** and operatively connected to the cutting insert **22**.

In some embodiments of the present invention, the adjustment member **26, 126** may be a non-threaded component.

The cutting insert **22** is removably secured to the insert holder portion **30, 130** by means of a fastener **34**, at a cutting position in which the operative cutting portion **28**
15 encounters a workpiece **36** at an insert cutting angle α .

In some embodiments of the present invention, the cutting insert **22** may be an indexable threading insert with a plurality of cutting portions **28**, each cutting portion **28** having two cutting edges **38, 40**, and the cutting tool **20, 120** may be used in threading operations.

For threading operations, as shown in Figs. 1a and 8, the insert cutting angle α is the
20 inclination angle of the two cutting edges **38, 40** of the operative cutting portion **28** relative to a central axis **C** of the rotating workpiece **36**. The inclination angle of a threading insert is a well known term used in the field of threading operations and typically adjusted to equal the helix angle of the thread being cut, in order to provide equal clearance for both cutting
25 edges.

Actuation of the adjustment member **26, 126**, causes an increase or decrease of the insert cutting angle α .

It should be understood that throughout the description and claims of the present invention, the term "actuation" describes the act of initiating movement of the adjustment member **26, 126** in a predetermined direction or along a predetermined path.

In some embodiments of the present invention, the cutting tool **20, 120** may have a
5 single adjustment member **26, 126**.

Also, in some embodiments of the present invention, actuation of the adjustment member **26, 126** may be performed without removing any components from the cutting tool **20, 120**.

To change the insert cutting angle α , one may first partially unclamp the cutting
10 insert **22**, rotate the adjustment member **26, 126**, and then clamp the cutting insert **22** once again. A method of increasing or decreasing the insert cutting angle α of the cutting tool **20, 120** comprises the steps of:

untightening the fastener **34**,
actuating the adjustment member **26, 126**, and
15 retightening the fastener **34**.

Following the untightening of the fastener **34**, actuation of the adjustment member **26, 126** may be performed by rotating the adjustment member **26, 126** about its first axis **A1**.

The insert cutting angle α may be increased by rotating the adjustment member **26, 126** in one direction about its first axis **A1** and decreased by rotating the adjustment member
20 **26, 126** in an opposite direction about its first axis **A1**.

In some embodiments of the present invention, the insert holder portion **30, 130** may have a second axis **A2**, and the first axis **A1** may be coaxial with the second axis **A2**. It can also be understood that the first and second axes **A1, A2** may be coaxial for each
25 rotational position of the adjustment member **26, 126**, and for each value of the insert cutting angle α .

In some embodiments of the present invention, the adjustment member **26, 126** may be in a fixed translational position on the insert holder portion **30, 130**, and actuation

of the adjustment member **26, 126** may be performed solely by rotating the adjustment member **26, 126** about its first axis **A1**.

As shown in Figs. 3, 5, 9 and 11, the adjustment member **26, 126** may have a planar base surface **42, 142** perpendicular to the first axis **A1**, and the planar base surface **42, 142** may be in contact with a corresponding seat surface **44, 144** on the insert holder portion **30, 130**.

In some embodiments of the present invention, the adjustment member **26, 126** may directly engage the cutting insert **22**.

As shown in Figs. 4, 5, 10 and 11, the adjustment member **26, 126** may have a top surface **46, 146** opposing the base surface **42, 142**, and a side surface **48, 148** extending therebetween, with the top or side surface **46, 148** including an adjustment supporting surface **50, 150**.

As shown in Figs. 6 and 7, the cutting insert **22** may be a lay-down threading insert having opposing upper and lower surfaces **52, 54** and a peripheral surface **56** extending therebetween, with the two cutting edges **38, 40** of each cutting portion **28** having an associated rake surface **58** on the upper or lower surface **52, 54**.

As shown in Figs. 2, 3 and 9, the fastener **34** may be in the form of a clamping screw **60**.

In some embodiments of the present invention, as shown in Figs. 3, 6, 7 and 9, the upper and lower surfaces **52, 54** may have a through bore **62** extending therebetween, and the clamping screw **60** may be located in the through bore **62** and threadingly received in a screw bore **64** in the insert holder portion **30, 130**.

In other embodiments of the present invention (not shown), the fastener **34** may be in the form of a clamping member, engaging with the through bore **62** and/or one of the upper and lower surfaces **52, 54**.

Also, in some embodiments of the present invention, the cutting insert **22** may be generally triangular in shape, having three cutting portions **28** and an equal number of support zones **66**, and the adjustment supporting surface **50, 150** may be in contact with exactly one support zone **66** distal from the operative cutting portion **28**.

The rake surface **58** of the operative cutting portion **28** may be on the upper surface **52**, and the single operative support zone **66** may be on the lower surface **54**.

In some embodiments of the present invention, as shown in Fig. 7, the cutting insert **22** may also include a plurality of V-shaped engagement ridges **68** equal to the number of cutting portions **28**, each V-shaped engagement ridge **68** located on the lower surface **54** adjacent an associated cutting portion **28**. Each V-shaped engagement ridge **68** may have two flank surfaces **70** and an insert tilt axis **A3**, with the two flank surfaces **70** parallelly extending in the direction of the insert tilt axis **A3**. Each V-shaped engagement ridge **68** may be divided into more than one separate engagement portion, and exactly one of the V-shaped engagement ridges **68** may interface with a corresponding V-shaped engagement groove **72** in the insert holder portion **30**, **130**.

Each support zone **66** may be located on a single engagement portion of each V-shaped engagement ridge **68**, on a surface separating the two flank surfaces **70**.

Also, in some embodiments of the present invention, as shown in Fig. 2, the insert holder portion **30**, **130** may have a first plane **P1**, and the insert tilt axis **A3** of the operative V-shaped engagement ridge **68** may be perpendicular to the first plane **P1** for each value of the insert cutting angle α . It can also be understood that the insert tilt axis **A3** of the operative V-shaped engagement ridge **68** may be perpendicular to the first plane **P1** for each rotational position of the adjustment member **26**, **126**.

The first plane **P1** may be parallel to the central axis **C** of the rotating workpiece **36**.

In some embodiments of the present invention, the insert cutting angle α may have an adjustment range **R** which can be attained in less than one revolution of the adjustment member **26**, **126** about its first axis **A1**. The adjustment range **R** may have a magnitude of at least 6° , and may be in the form of an inclination angle ranging from -1.5° to $+4.5^\circ$.

In a first embodiment of the present invention, as shown in Figs. 4 and 5, the adjustment supporting surface **50** may be formed on the top surface **46** of the adjustment member **26**. The adjustment supporting surface **50** may be helically step shaped, having a supporting surface axis **A4** coaxial with the first axis **A1**, and an adjustment height **H** from

the base surface **42** which increases or decreases about the supporting surface axis **A4**. The helically step shaped adjustment supporting surface **50** may comprise a plurality of step segments **74**, each step segment **74** perpendicular to the first axis **A1** and representing a distinct value of insert cutting angle α .

5 In the first embodiment of the present invention, the top surface **46** may face in generally the same direction as the rake surface **58** of the operative cutting portion **28**, and the side surface **48** may be cylindrical.

In a second embodiment of the present invention, as shown in Figs. 10 and 11, the side surface **148** of the adjustment member **126** may be non-cylindrical, and the
10 adjustment supporting surface **150** may be formed on the side surface **148**, having a radial adjustment distance **D** from the first axis **A1** which continuously increases or decreases about the first axis **A1**.

In the second embodiment of the present invention, the top surface **146** may face in a generally transverse direction to the rake surface **58** of the operative cutting portion
15 **28**.

In both embodiments, a first portion of the adjustment member supporting surface **50, 150** opposes the cutting insert **22** at the active support zone **66** located away from the insert tilt axis **A3** associated with the operative cutting portion **28**. Rotation of the adjustment member **26, 126** about the first axis **A1** and relative to the insert holder
20 portion **30, 130** presents a second portion of the supporting surface **50, 150** opposing the cutting insert **22**. This causes a change in both the elevation of the secured cutting insert **22** at the active support zone **66** and in the tilt of the secured cutting insert **22** about the insert tilt axis **A3**, relative to the insert holder portion **30, 130**.

In some embodiments of the present invention, the adjustment member **26, 126**
25 may be actuated directly by the operator, manually by means of an auxiliary tool, e.g. socket wrench (not shown).

Although, in some embodiments of the present invention, the adjustment member **26, 126** may be gradually rotated about its first axis **A1**, visual indicators or mechanical detents on the adjustment member **126** may be employed to define distinct step increases or

decreases of the insert cutting angle α , and thus aid the operator.

In the first embodiment of the present invention, as shown in Fig. 2, the cutting tool **20** may be configured to physically prevent the operator from actuating the adjustment member **26** until the cutting insert **22** has been unclamped, such as by
5 untightening the fastener **34**, and partially rotated.

In some embodiments of the present invention, the adjustment member **26**, **126** may include a non-threaded retaining portion **82** which keeps the adjustment member **26**, **126** mounted on the insert holder portion **30**, **130** whilst allowing the operator to actuate the adjustment member **26**, **126**. In addition, the non-threaded retaining portion **82** may
10 keep the base surface **42**, **142** in contact with the seat surface **44**, **144** of the insert holder portion **30**, **130**.

As shown in Figs. 3, 5, 9 and 11, the non-threaded retaining portion **82** is insertable into the insert holder portion **30**, **130** and may include a plurality of resilient legs **76** extending away from the base surface **42**, **142**, and making contact with a
15 cylindrical wall **78** of a holding cavity **80** in the seat surface **44**, **144**. The second axis **A2** may be coaxial with the cylindrical wall **78** of the holding cavity **80**.

Although the present invention has been described to a certain degree of particularity, it should be understood that various alterations and modifications could be made without departing from the spirit or scope of the invention as hereinafter claimed.

CLAIMS

What is claimed is:

1. A cutting tool (20, 120) comprising:
a cutting insert (22), a tool holder (24), and an adjustment member (26, 126);
the cutting insert (22) having at least one cutting portion (28),
the tool holder (24) having an insert holder portion (30, 130) and a shank portion (32), the insert holder portion (30, 130) being rigidly fixed to the shank portion (32),
the adjustment member (26, 126) being non-threadingly retained on the insert holder portion (30, 130), and operatively connected to the cutting insert (22), and
the cutting insert (22) being removably secured to the insert holder portion (30, 130) by means of a fastener (34), at a cutting position in which the operative cutting portion (28) encounters a workpiece (36) at an insert cutting angle (α),
wherein actuation of the adjustment member (26, 126) causes an increase or decrease of the insert cutting angle (α).
2. The cutting tool (20, 120) according to claim 1, comprising a single adjustment member (26, 126).
3. The cutting tool (20, 120) according to claim 1, wherein the adjustment member (26, 126) directly engages the cutting insert (22).
4. The cutting tool (20, 120) according to claim 1, wherein actuation of the adjustment member (26, 126) is performed without removing any components from the cutting tool (20, 120).
5. The cutting tool (20, 120) according to claim 1, wherein the adjustment member (26, 126) has a first axis (A1), and

wherein actuation of the adjustment member (26, 126) is performed by rotating the adjustment member (26, 126) about its first axis (A1).

6. The cutting tool (20, 120) according to claim 5, wherein the insert cutting angle (α) is increased by rotating the adjustment member (26, 126) in one direction about its first axis (A1) and decreased by rotating the adjustment member (26, 126) in an opposite direction about its first axis (A1).

7. The cutting tool (20, 120) according to claim 5, wherein the insert holder portion (30, 130) has a second axis (A2), and
wherein the first axis (A1) and the second axis (A2) are coaxial.

8. The cutting tool (20, 120) according to claim 5, wherein the adjustment member (26, 126) has a planar base surface (42, 142) perpendicular to the first axis (A1), and

wherein the planar base surface (42, 142) is in contact with a corresponding seat surface (44, 144) on the insert holder portion (30, 130).

9. The cutting tool (20, 120) according to claim 8, wherein the adjustment member (26, 126) has a top surface (46, 146) opposing the base surface (42, 142), and a side surface (48, 148) extending therebetween,

wherein the top or side surface (46, 148) comprises an adjustment supporting surface (50, 150),

wherein the cutting insert (22) has at least one support zone (66), and

wherein the adjustment supporting surface (50, 150) is in contact with exactly one support zone (66) distal from the operative cutting portion (28).

10. The cutting tool (20) according to claim 9, wherein the adjustment supporting surface (50) is formed on the top surface (46), and

wherein the adjustment supporting surface (50) is helically step shaped, having a supporting surface axis (A4) coaxial with the first axis (A1), and an adjustment height (H) from the base surface (42) which increases or decreases about the supporting surface axis (A4).

11. The cutting tool (20, 120) according to claim 5, wherein the insert cutting angle (α) has an adjustment range (R) which can be attained in less than one revolution of the adjustment member (26, 126) about its first axis (A1).

12. The cutting tool (20, 120) according to claim 11, wherein the adjustment range (R) has a magnitude of at least 6° .

13. The cutting tool (20, 120) according to claim 1, wherein the cutting tool (20, 120) is used in threading operations,

wherein the cutting insert (22) has a plurality of cutting portions (28), each cutting portion (28) having two cutting edges (38, 40), and

wherein the insert cutting angle (α) is the inclination angle of the two cutting edges (38, 40) of the operative cutting portion (28) relative to a central axis (C) of the rotating workpiece (36).

14. The cutting tool (20, 120) according to claim 13, wherein the cutting insert (22) is a lay-down threading insert having opposing upper and lower surfaces (52, 54) and a peripheral surface (56) extending therebetween,

wherein the two cutting edges (38, 40) of each cutting portion (28) have an associated rake surface (58) on the upper or lower surface (52, 54).

15. The cutting tool (20, 120) according to claim 14, wherein the fastener (34) is in the form of a clamping screw (60).

16. The cutting tool (20, 120) according to claim 15, wherein upper and lower surfaces (52, 54) have a through bore (62) extending therebetween, and

wherein the clamping screw (60) is located in the through bore (62) and threadingly received in a screw bore (64) in the insert holder portion (30, 130).

17. The cutting tool (20, 120) according to claim 1, wherein each of the at least one cutting portion (28) has an insert tilt axis (A3),

wherein the insert holder portion (30, 130) has a first plane (P1), and

wherein the insert tilt axis (A3) of the operative cutting portion (28) is perpendicular to the first plane (P1) for each value of the insert cutting angle (α).

18. The cutting tool (20, 120) according to claim 1, wherein the adjustment member (26, 126) is in a fixed translational position on the insert holder portion (30, 130).

19. The cutting tool (20, 120) according to claim 1, wherein the adjustment member (26, 126) has a first axis (A1), and

wherein actuation of the adjustment member (26, 126) is performed solely by rotating the adjustment member (26, 126) about its first axis (A1).

20. The cutting tool (20, 120) according to claim 1, wherein the adjustment member (26, 126) is capable of being actuated directly by an operator.

21. A method of increasing or decreasing an insert cutting angle (α) of a cutting tool (20, 120) relative to a workpiece (36), the cutting tool (20, 120) comprising:

a cutting insert (22), a tool holder (24), and an adjustment member (26, 126);

the cutting insert (22) having at least one cutting portion (28),

the tool holder (24) having a insert holder portion (30,130) and a shank portion (32), the insert holder portion (30, 130) being rigidly fixed to the shank portion (32),

the insert adjustment member (26, 126) being non-threadingly retained on the insert holder portion (30, 130), and operatively connected to the cutting insert (22), and

the cutting insert (22) being removably secured to the insert holder portion (30, 130) by means of a fastener (34),

the method comprising the steps of:

untightening the fastener (34),

actuating the adjustment member (26, 126) without removing any components from the cutting tool (20, 120), and

retightening the fastener (34).

22. The method according to claim 21, wherein the adjustment member (26, 126) is in a fixed translational position in the insert holder portion (30, 130).

23. The method according to claim 21, wherein the adjustment member (26, 126) has a first axis (A1), and

wherein actuation of the adjustment member (26, 126) is performed solely by rotating the adjustment member (26, 126) about its first axis (A1).

24. The method according to claim 21, wherein the adjustment member (26, 126) directly engages the cutting insert (22), and

wherein the adjustment member (26, 126) is capable of being actuated directly by the operator.

25. A cutting tool (20, 120) comprising:

a tool holder (24) having an insert holder portion (30, 130);

a cutting insert (22) removably secured to the insert holder portion (30, 130), the cutting insert having an operative cutting portion (28) provided with an associated insert tilt axis (A3) and an active support zone (66) located away from the insert tilt axis (A3); and

an adjustment member (26, 126) non-threadingly retained on the insert holder portion (30, 130) and having a first axis (A1) and a supporting surface (50, 150) at least a first portion of which opposes the cutting insert (22) at the active support zone (66); wherein:

rotation of the adjustment member (26, 126) about the first axis (A1) and relative to the insert holder portion (30, 130) results in a second portion of the supporting surface (50, 150) opposing the active support zone (66), and changes in both the elevation of the secured cutting insert (22) at said active support zone (66) and the tilt of the secured cutting insert (22) about the insert tilt axis (A3), relative to the insert holder portion (30, 130).

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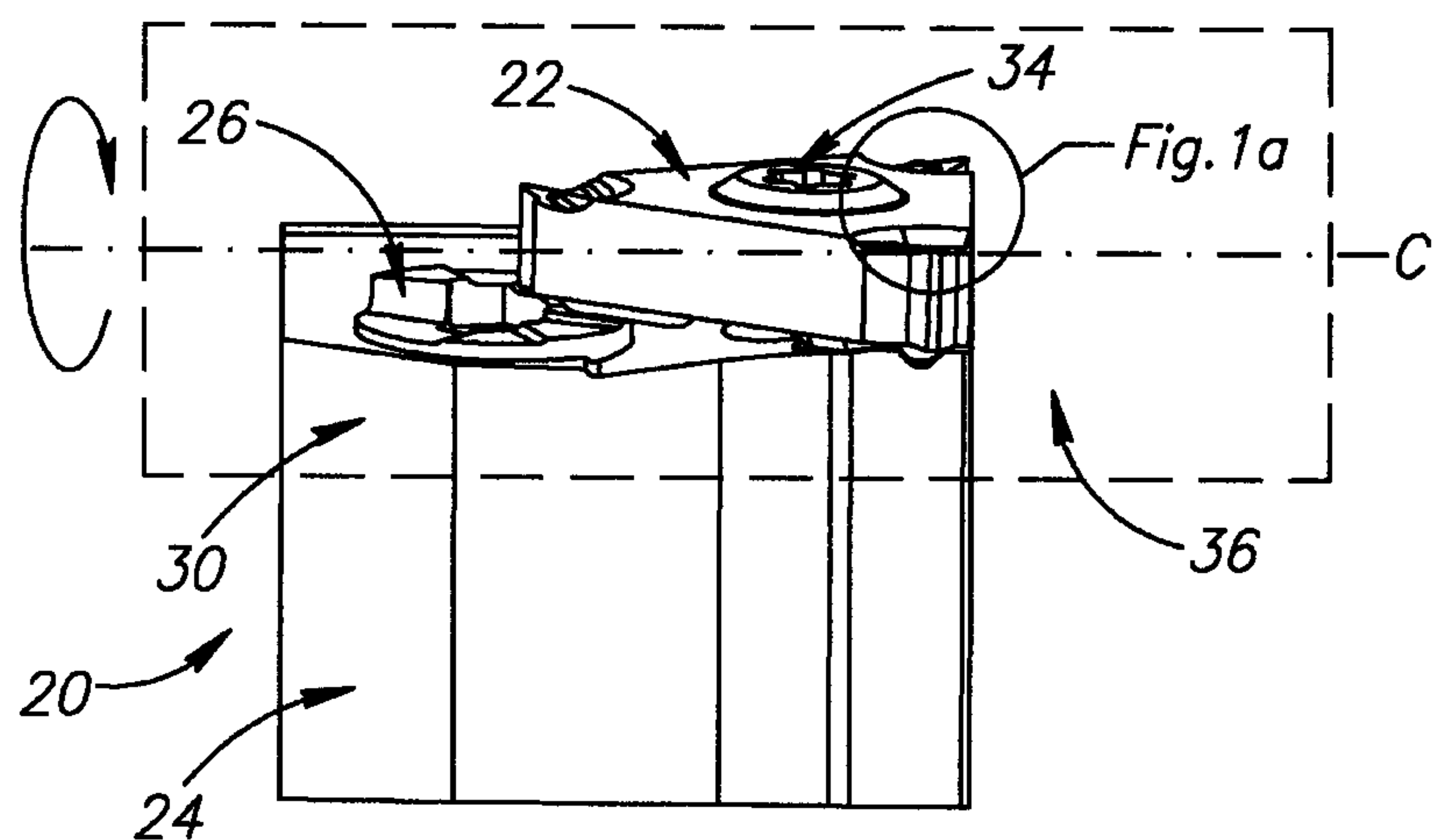
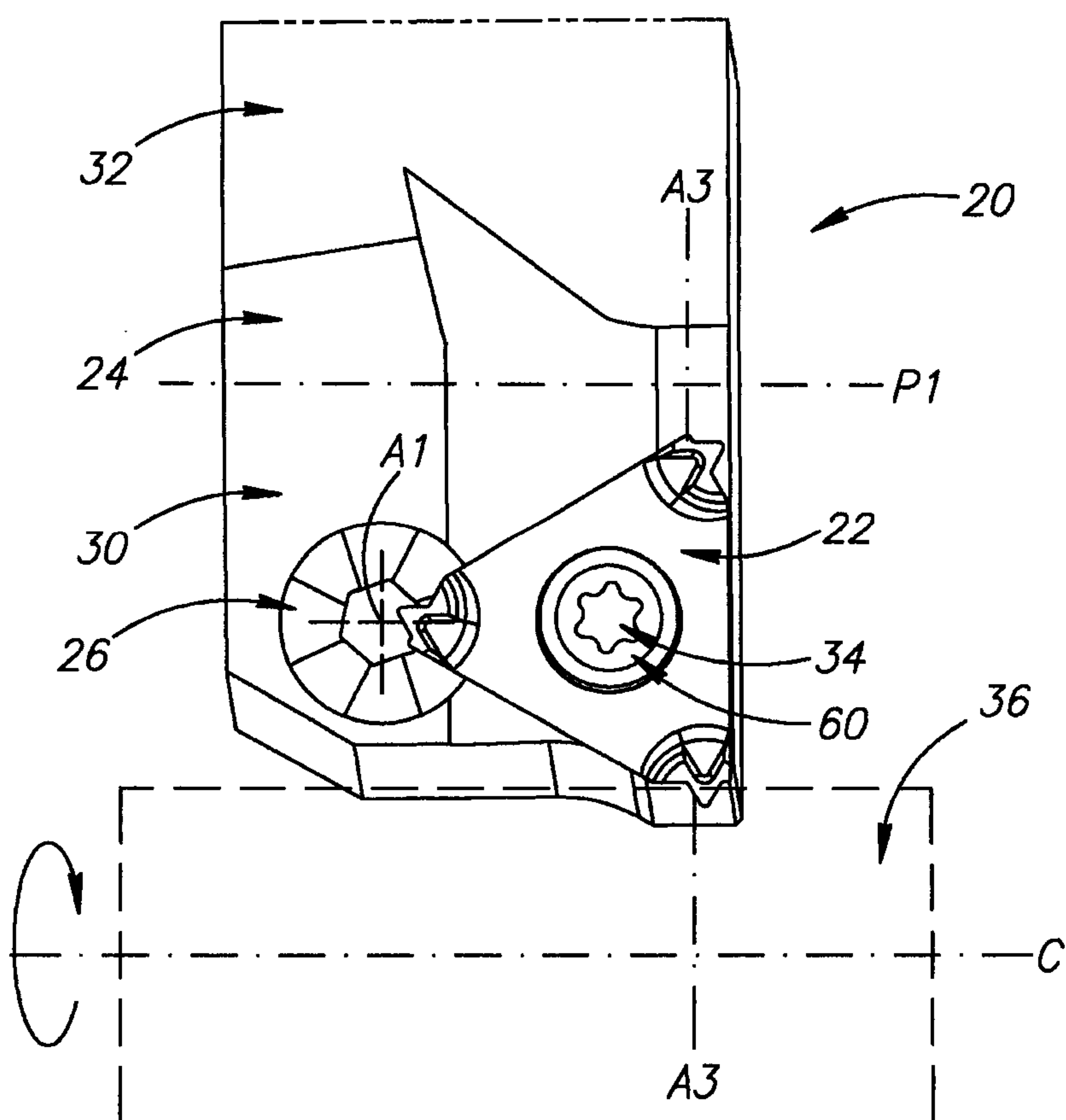


FIG.1



ETC 2

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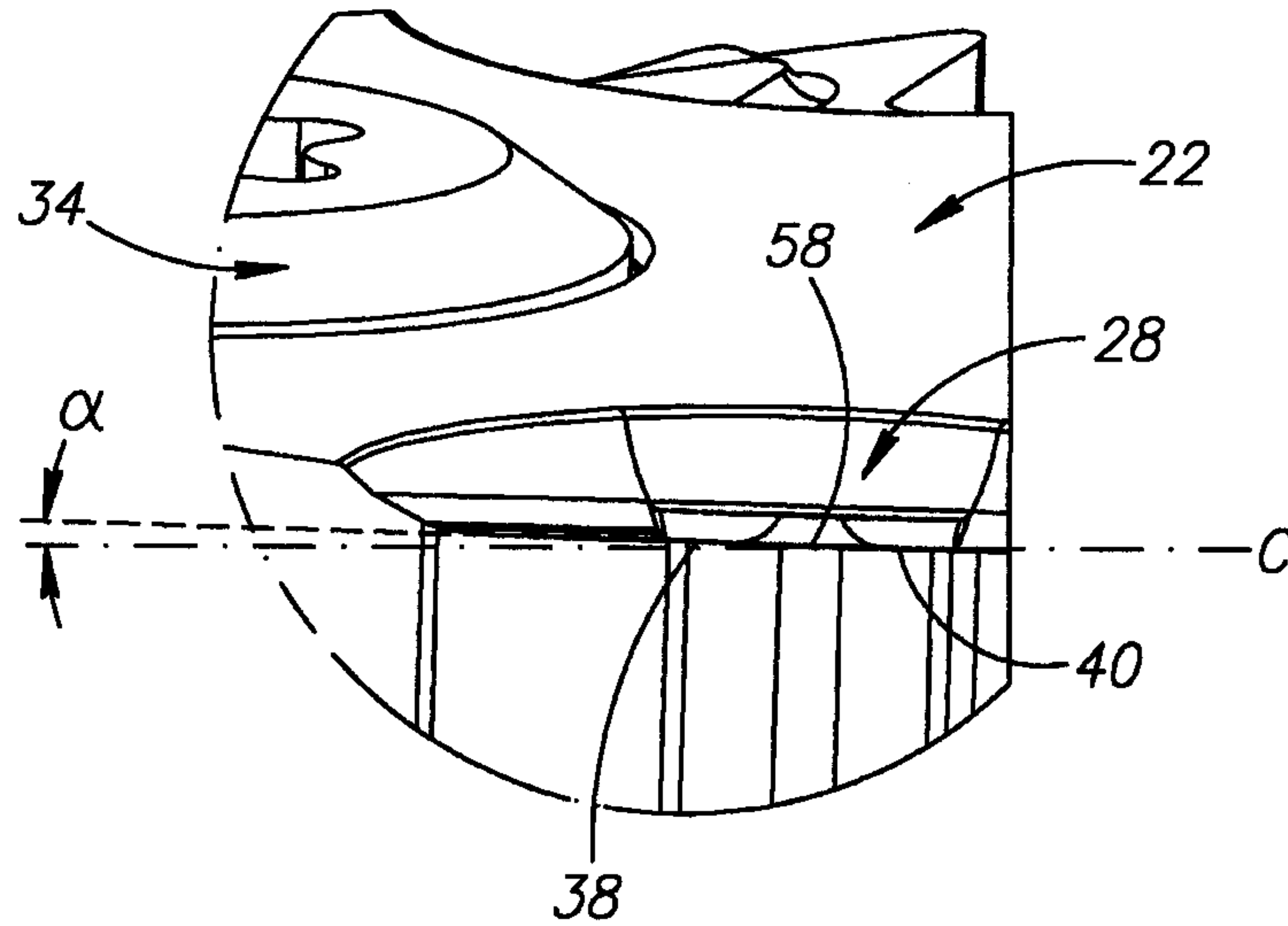


FIG. 1a

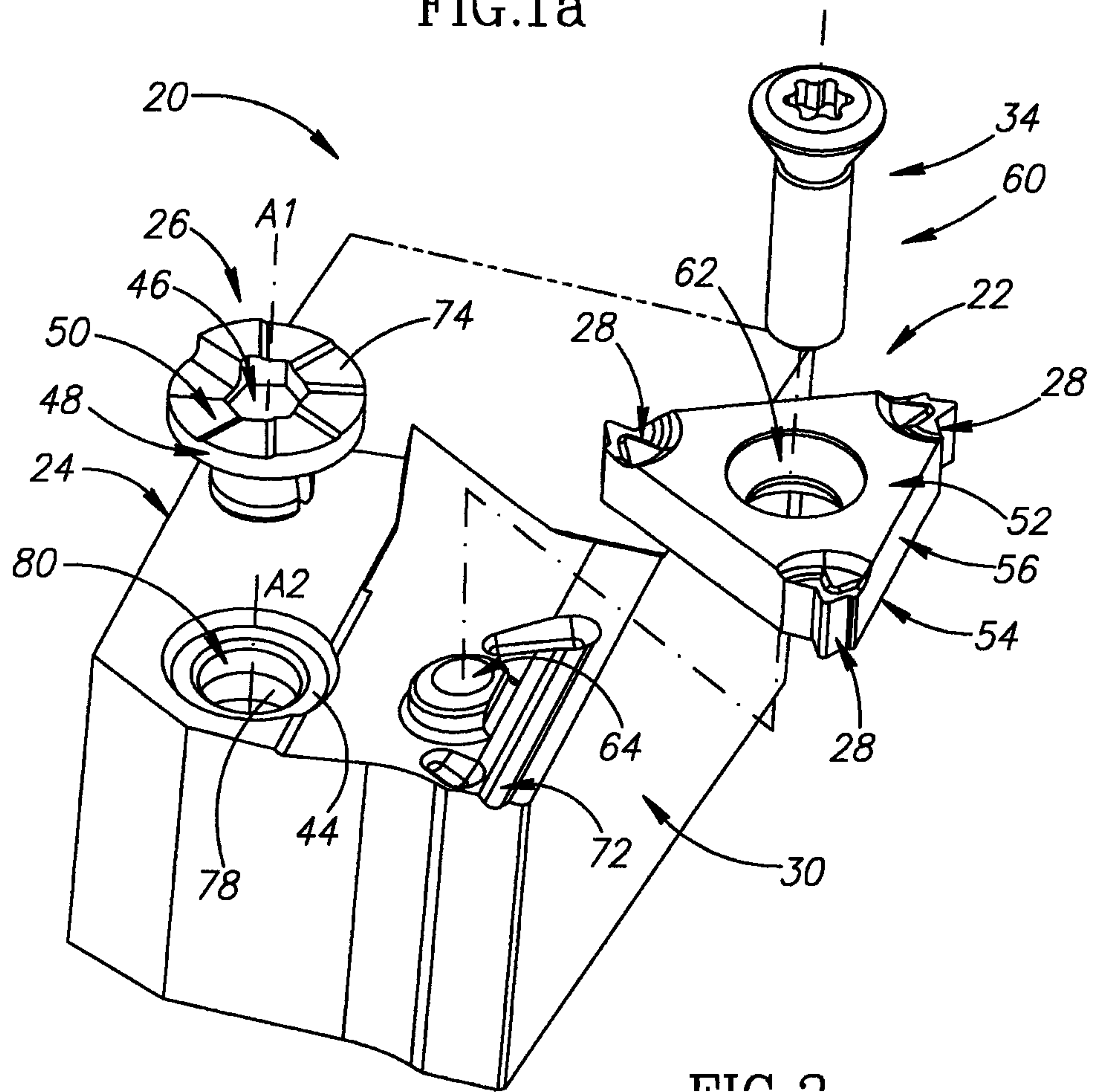


FIG. 2

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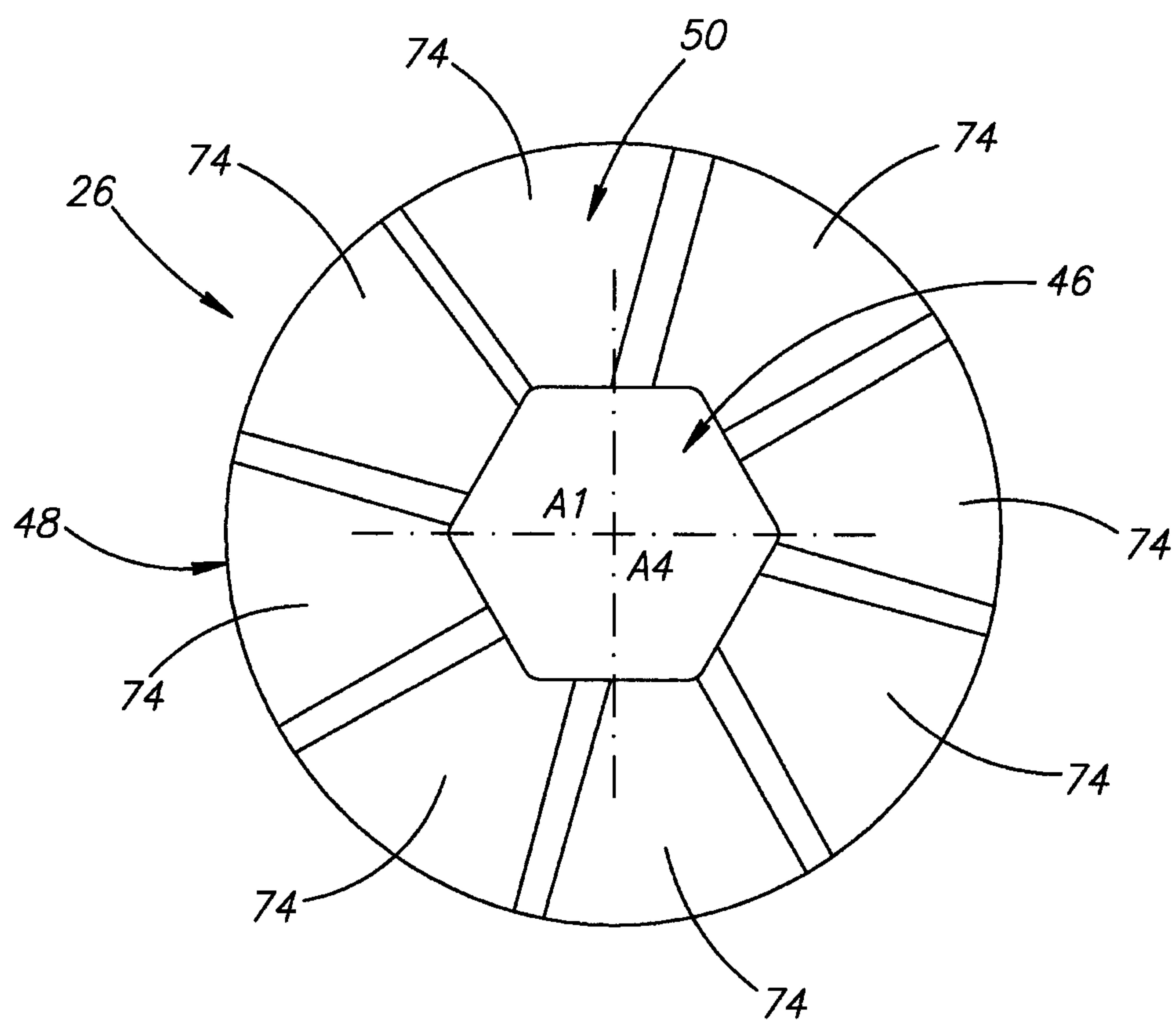


FIG. 4

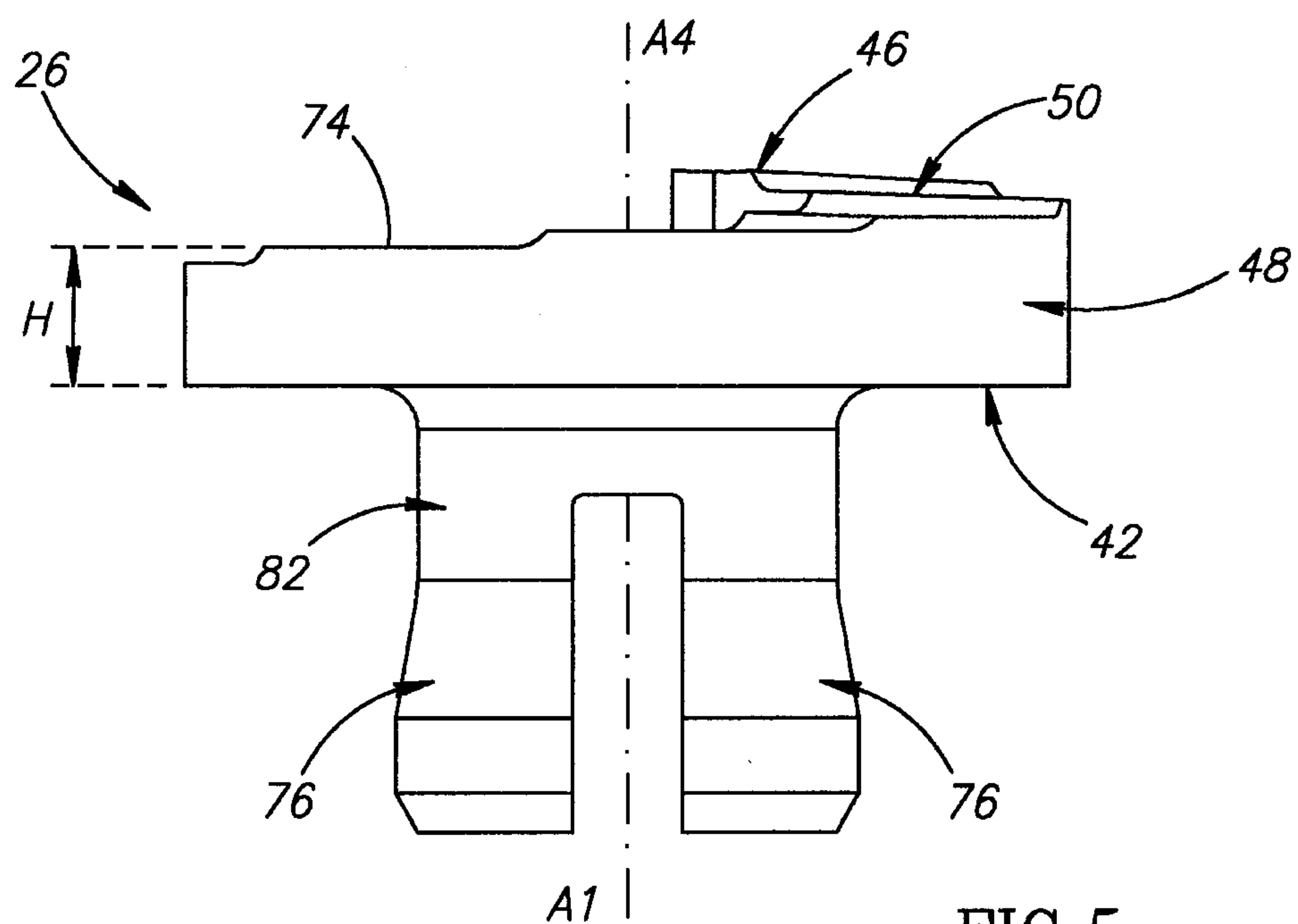
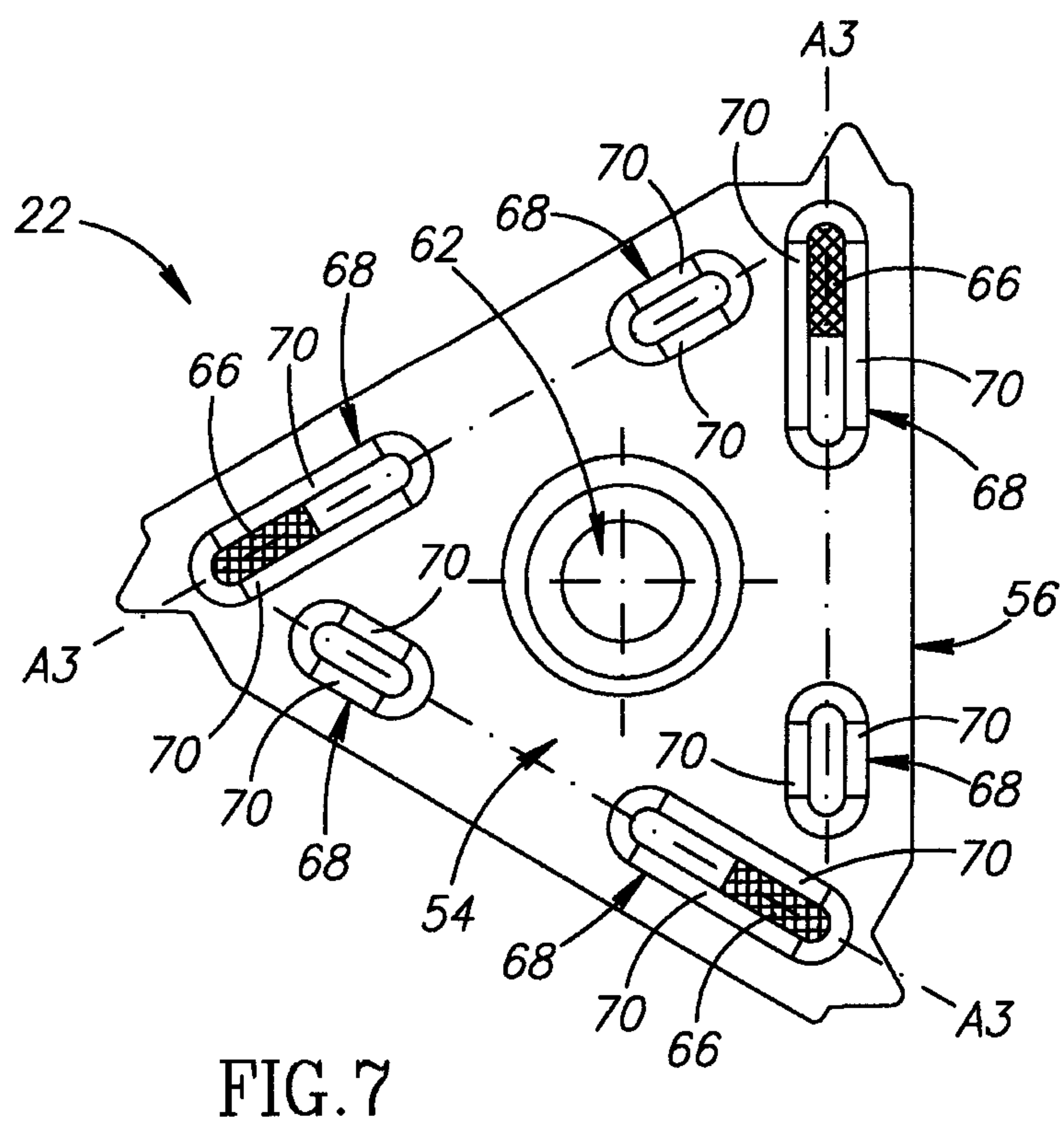
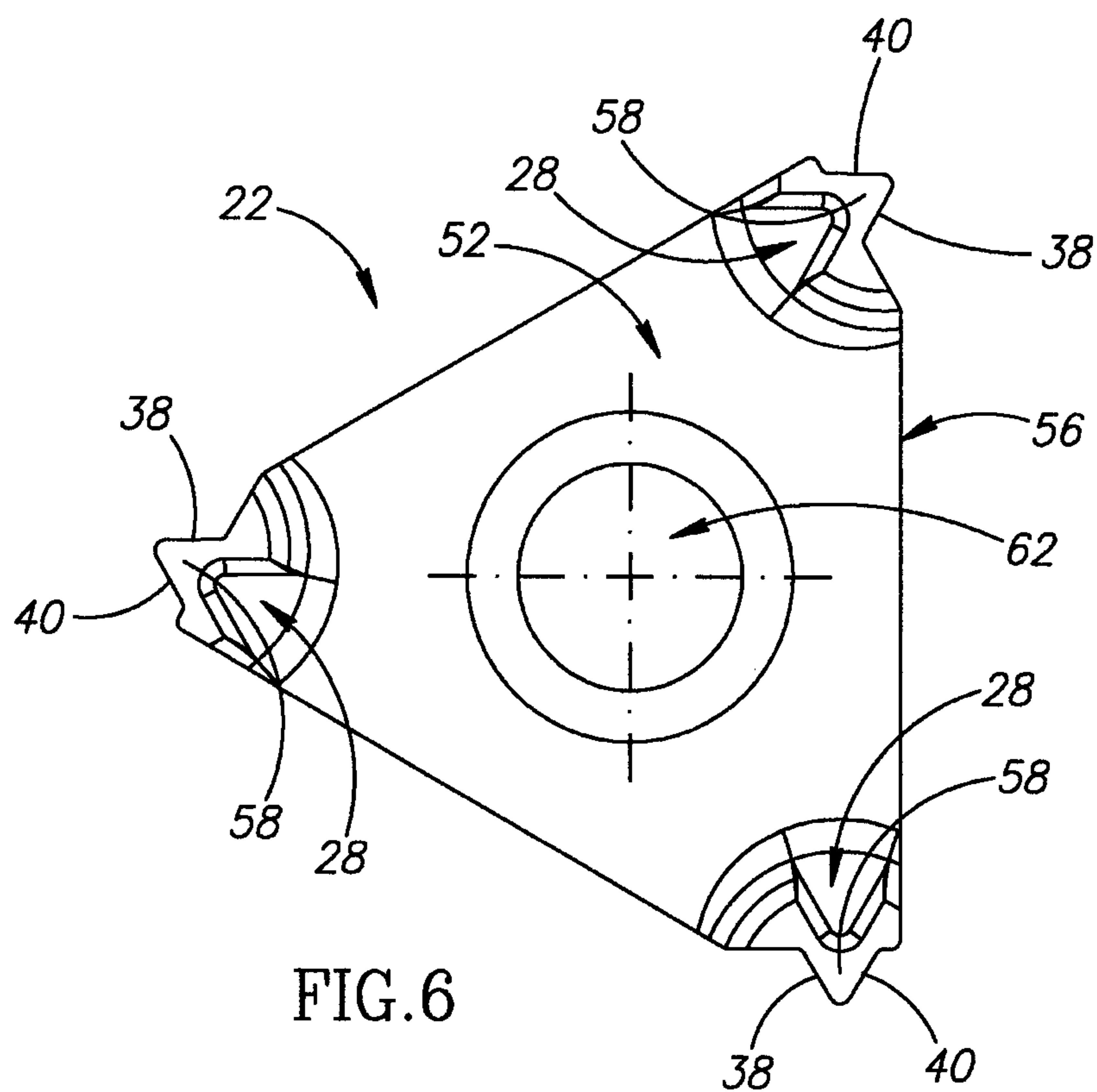


FIG. 5

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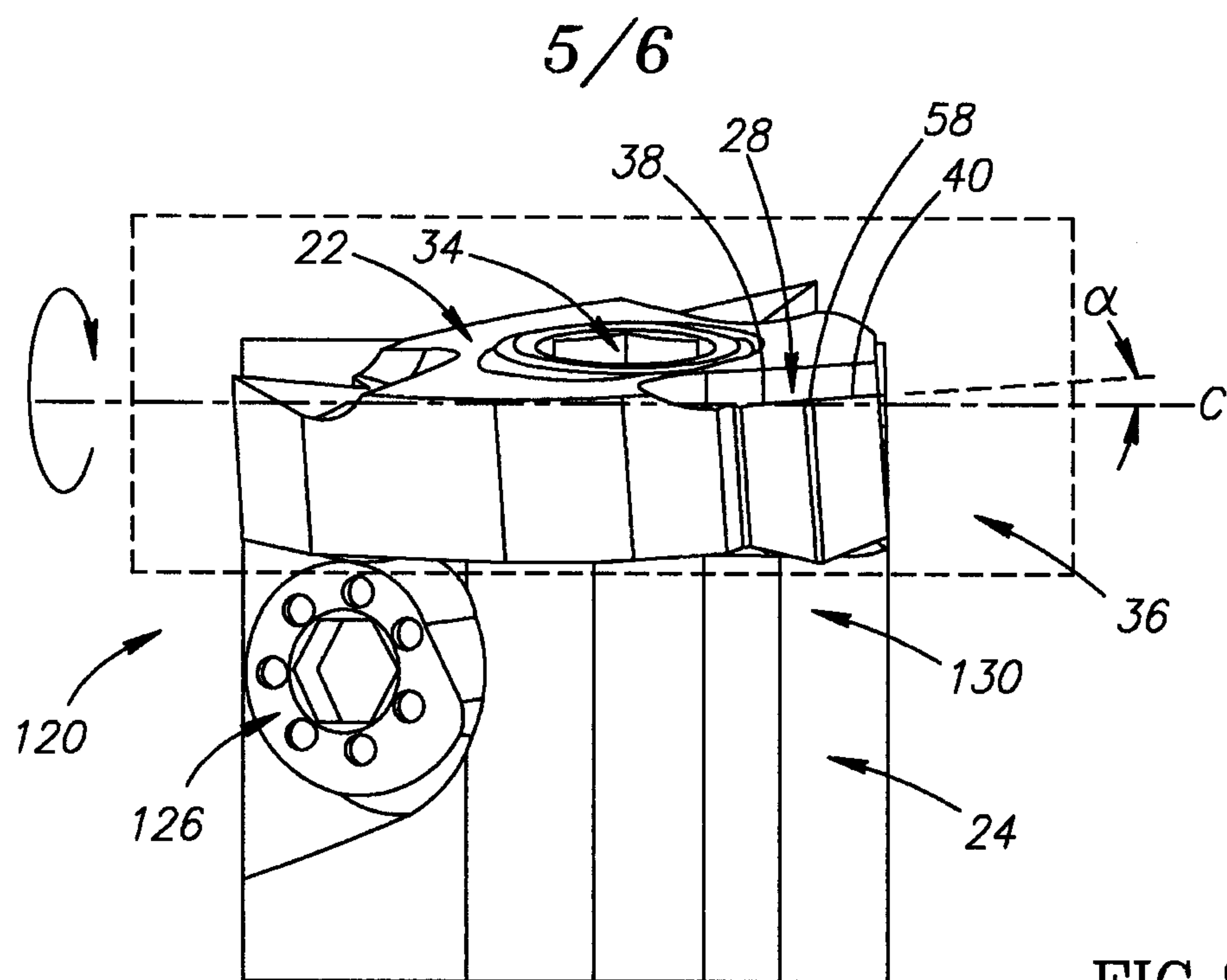
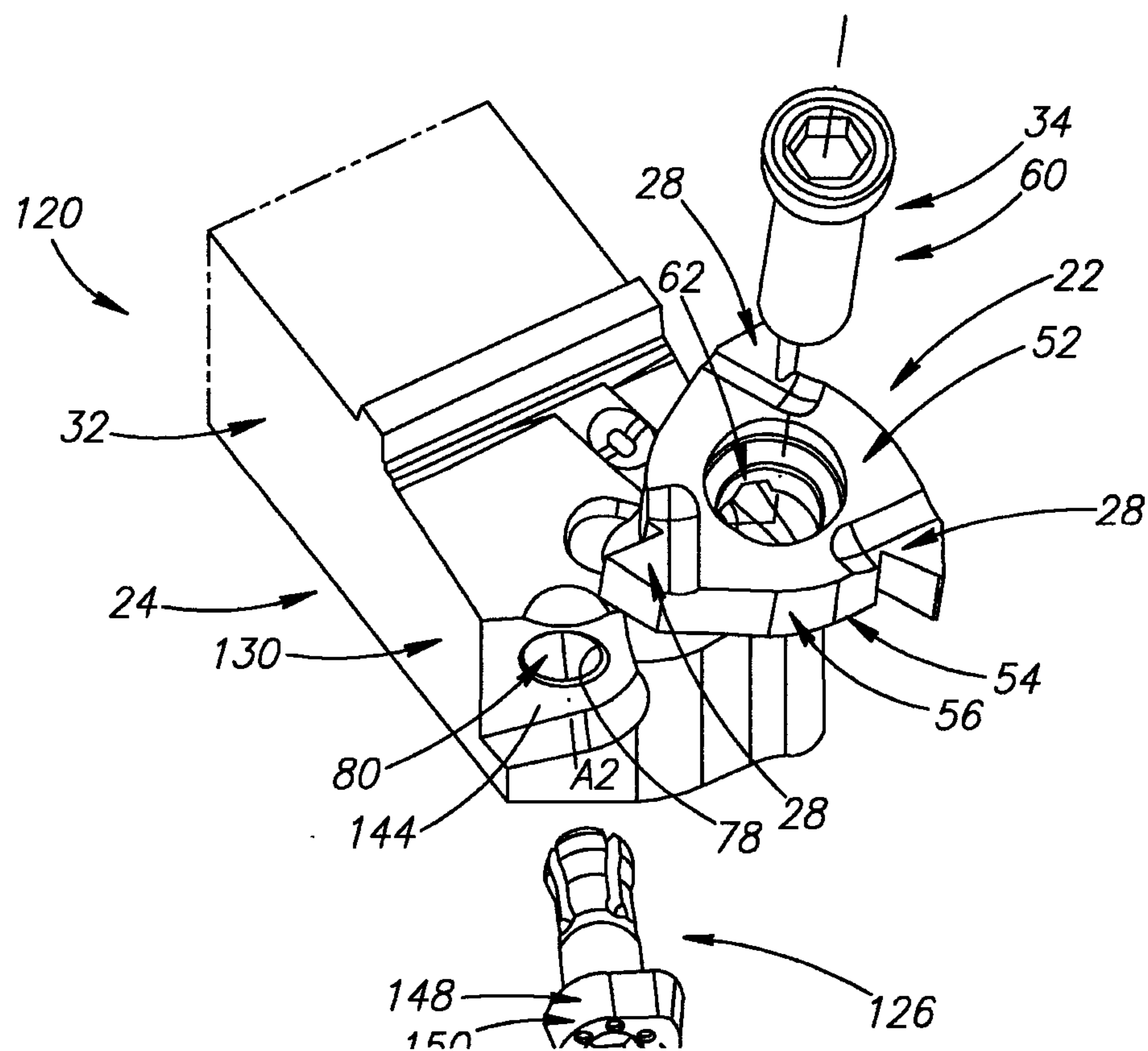


FIG. 8



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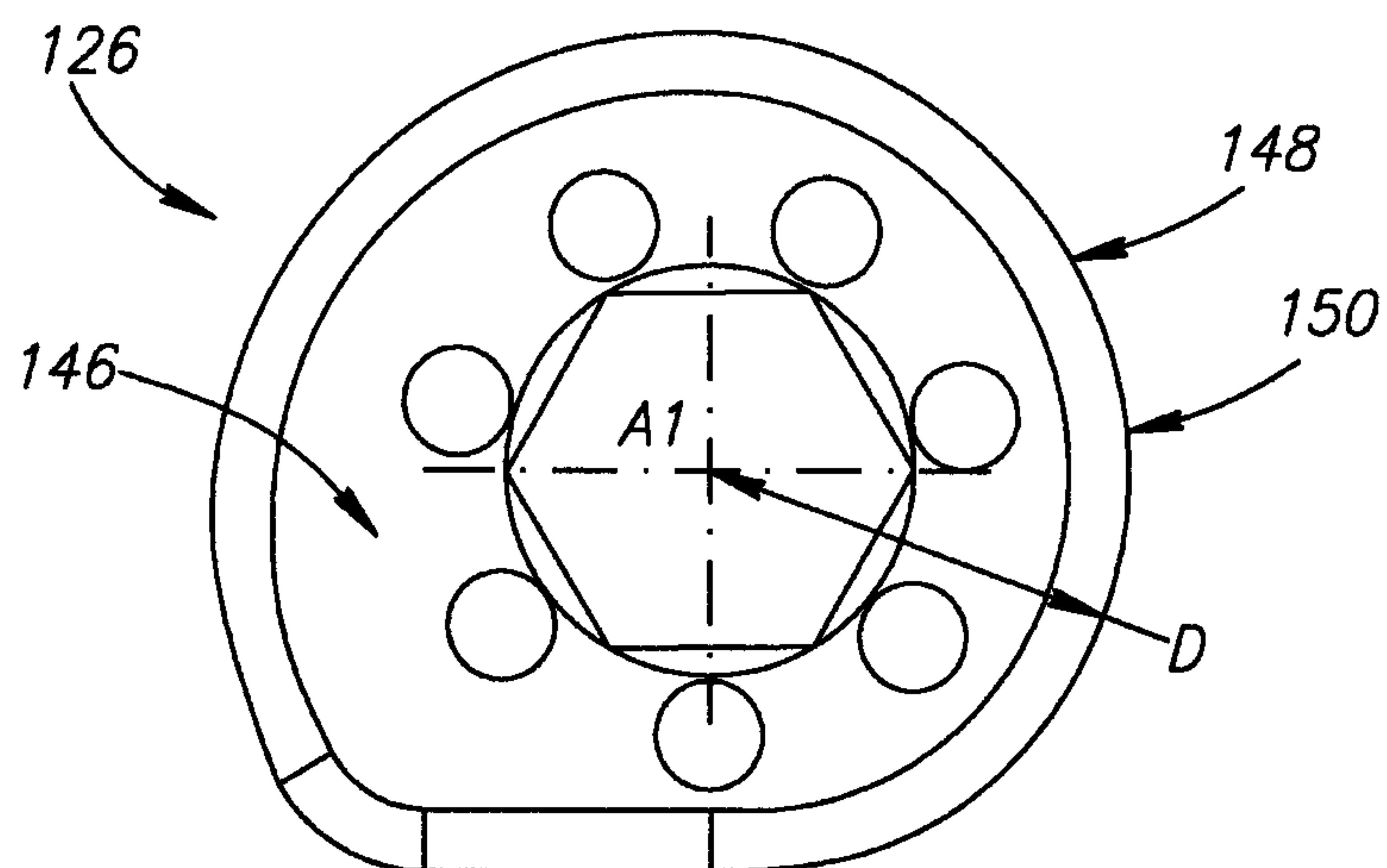


FIG. 10

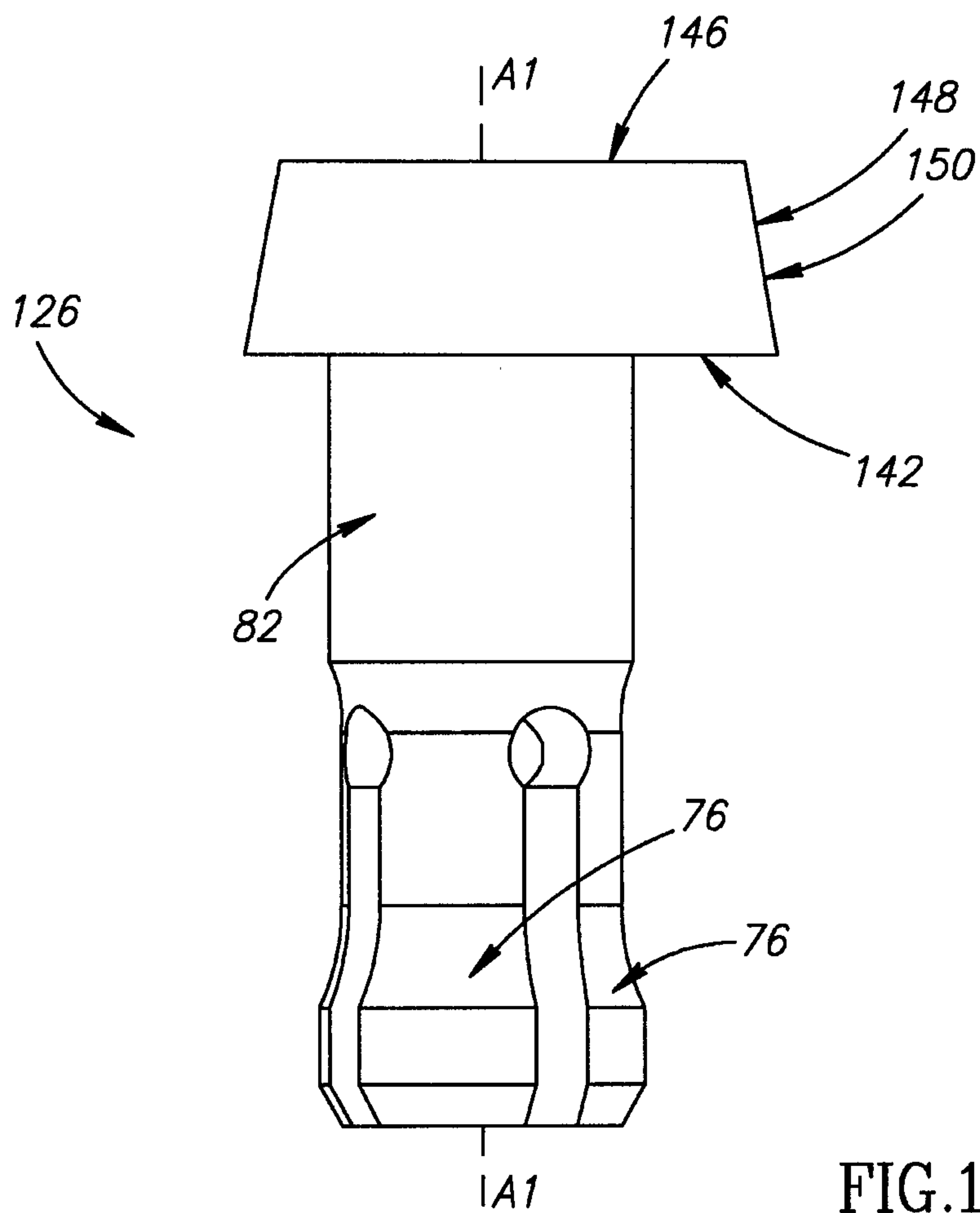


FIG. 11

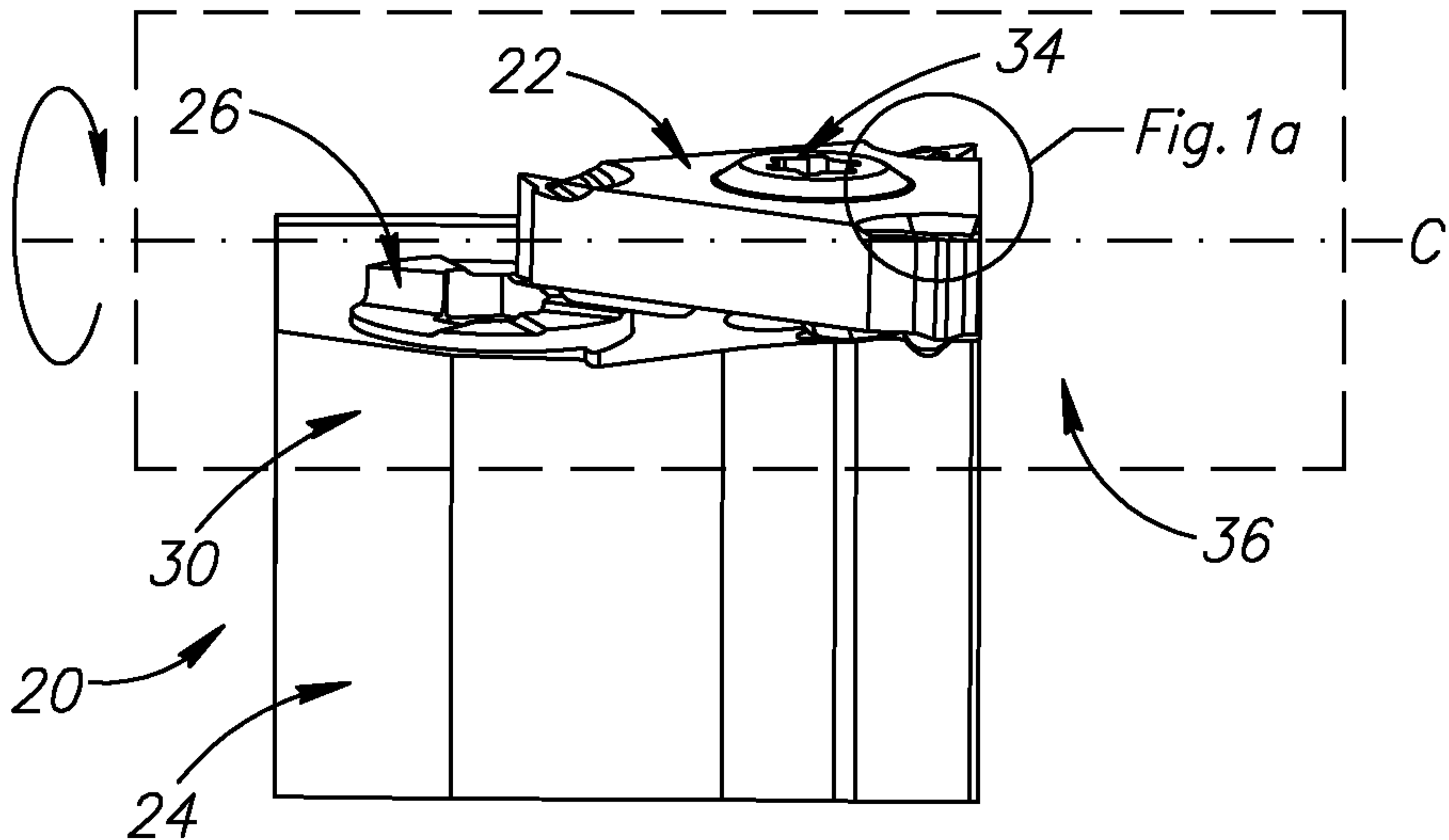


FIG.1