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(54) Title: A TOOL BODY INCLUDING A DAMPING APPARATUS AND A MACHINING TOOL HAVING SUCH A TOOL
BODY

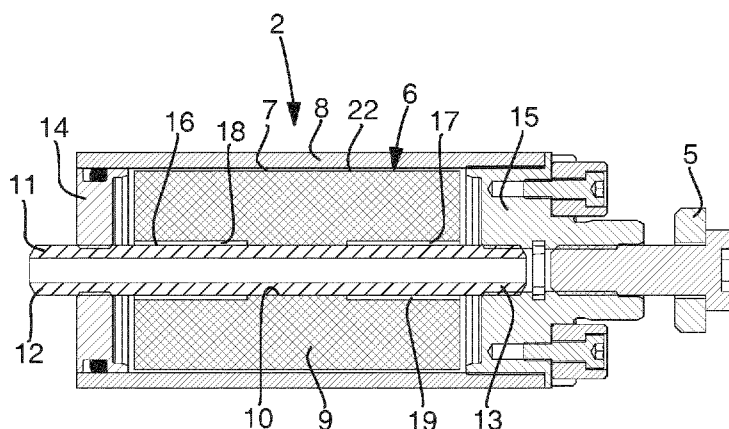


Fig 3

(57) Abstract: A tool body (2) includes a damping apparatus for damping vibrations in a machining tool having besides the tool body a member with at least one cutting edge to be secured to the tool body. The damping apparatus is arranged in an internal room (7) of the tool body and comprises a damper mass body (9) with an axial bore (10) and a central tube (11) extending through the bore and which is rigidly secured to the damper mass body inside the through bore. A central tube (11) is also at both ends (12, 13) thereof rigidly connected to a tool body fixed part (14, 15) and the central tube is made of a material with a spring property allowing the damper mass body (9) to oscillate in the internal room (7) perpendicularly to the longitudinal extension of the central tube.



A tool body including a damping apparatus and a machining tool having such a tool body

TECHNICAL FIELD OF THE INVENTION

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The present invention relates to a tool body including a damping apparatus for damping vibrations in a machining tool according to the preamble of claim 1 as well as a machining tool having such a tool body.

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The invention is not restricted to tool bodies and machining tools for any particular type of machining, and the tool body may for instance have members with cutting edges secured thereto in the form of cutting inserts for chip-removing machining of a work piece by turning, milling, drilling, or boring. Thus, the tool body may be designed to receive a cutting head including cutting edges or seats for cutting inserts. Both rotating and non-rotating machining tools are comprised. Neither is the invention restricted to any size of such machining tools, but these may for instance have a diameter of 500 millimetres and a length of 6 metres or be as small as having a diameter of only 10 millimetres.

The tool body is provided with such a damping apparatus for damping radial and tangential forces applied on the tool body by the machining action and by that improving the accuracy of the machining operation and prolonging the lifetime of cutting edges of the machining tool. The damping effect of such a damping apparatus is a result of an interaction between the damper mass body, which is of a high density material such as lead, and the machining tool member provided with a cutting edge through any type of resilient element.

The frequency by which the damper mass body will swing upon machining will depend upon the mass of the damper mass body and the spring constant of said resilient element. This frequency will increase with an increasing said spring constant and de-

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crease with an increasing mass of the damper mass body. The frequency needed for appropriate damping of self-induced vibrations in a machining tool will depend upon the design of the machining tool, such as the ratio of the length/diameter of the tool body, and weight distribution of the machining tool.

BACKGROUND ART

A tool body of the type defined in the introduction is known through WO 92/14947 and the resilient element of the damping apparatus of that tool body is provided by elastomer rings surrounding the central tube, which is secured to the damper mass body and moves with this as being an integral part therewith. These elastomer rings are rather soft, which results in a low spring constant and a low damping frequency for a given mass of a damper mass body restricting the range of possible shapes and dimensions of tool bodies and machining tools for which appropriate damping may be obtained. Furthermore, the elastomer material may not withstand the high temperatures which may occur during certain machining operations desired, so that excessive cooling will be required or the efficiency of the machining operation has to be lowered for keeping the temperature down. The properties of such elastomer material will also change over time due to aging.

SUMMARY OF THE INVENTION

The object of the present invention is to provide a tool body of the type defined in the introduction being improved in at least some aspect with the respect to such tool bodies already known.

This object is according to the invention obtained by providing such a tool body with the features listed in the characterizing part of appended claim 1. Thus, by rigidly connecting the central tube at both ends thereof to a tool body fixed part and making the central tube of a material with a spring property allowing the

damper mass body to oscillate in the internal room perpendicu-
larly to the longitudinal extension of the central tube said resili-
ent element will be provided by the central tube without any
elastomer rings needed therefor. By using the central tube as
5 resilient element substantially higher temperatures may be al-
lowed and the problems with ageing of the elastomer material
will be avoided. The term tool body fixed part is to be under-
stood as part of the tool body which is to be rigid or stiff with re-
spect to a said member 3 with at least one cutting edge to be
10 secured to the tool body, such as for example parts of the tool
body casing or parts rigidly secured thereto.

Furthermore, the spring constant of the resilient element in the
form of the central tube may be varied within a wide range by
15 the choice of diameter and wall thickness of the central tube.
This means that substantially higher damping frequencies than
by elastomer rings may be obtained when desired. But it is
pointed out that low damping frequencies are still possible to
obtain by embodiments of the invention.

20 According to an embodiment of the invention the central tube is
made of steel or carbon fibre. These are suitable materials with
spring properties for obtaining spring constants of desired mag-
nitudes.

25 According to an embodiment of the invention the central tube is
a machining tool cooling tube, which may transport any coolant
to a member carrying out chip-removing machining of a said
machining tool, for example a coolant liquid such as water or a
30 gas mixture as air.

According to an embodiment of the invention the through bore
has at at least one end thereof a length portion with larger
cross-section dimensions than the central tube leaving a space
35 between the damper mass body and the central tube, and an el-
ement is arranged to bridge this space between the central tube

and the damper mass body at a location along the central tube. The arrangement of such an element supporting the central tube with respect to the damper mass body will influence the spring constant of the damper apparatus. The choice of the location of
5 this bridging element will then also influence the magnitude of the spring constant and accordingly be used to obtain the spring constant desired.

10 According to an embodiment of the invention said element is rigid, and according to other embodiments of the invention this element has elastic properties and it may be in the form of an O-ring of rubber. The choice of the material of this bridging element will also influence the magnitude of the spring constant.

15 According to an embodiment of the invention said element is movable along the central tube between different said locations so as to change the spring constant of the central tube. It is then especially advantageous if the through bore has a said length portion and a said element at both ends of the through
20 bore. A frequency tuning can then be implemented by these movable elements, and the spring constant may be adjusted for one and the same damping apparatus, so that this may be used for machining tools with different lengths by allowing the spring constant to be adjusted to be appropriate for each such length.

25 According to an embodiment of the invention the damper mass body has a circular cylindrical shape with the through bore extending according to the centre axis of the cylinder so formed. This results in a uniform damping of the vibrations of a machining
30 tool in operation.

According to an embodiment of the invention the internal room of the tool body contains a damping fluid, such as oil, in an annular cavity separating the damper mass body radially from internal
35 walls defining the internal room. Such a damping fluid improves the damping action of the damping apparatus.

The invention also relates to a machining tool having a tool body according to the invention and a use of such a tool body to damp vibrations in a machining tool in operation.

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Other advantageous features as well as advantages of the present invention appear from the description following below.

BRIEF DESCRIPTION OF THE DRAWINGS

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With reference to the appended drawings, below follows a specific description of embodiments of the invention cited as examples.

15 In the drawings:

Fig. 1 is a perspective view of a machining tool including a tool body according to the present invention with a damping apparatus for damping vibrations in the machining tool and a member with a cutting insert,

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Fig. 2 is a view in the direction of the arrow II in fig. 1 of the tool body shown in fig. 1 without the member with a cutting insert,

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Fig. 3 is a cross section view according to III-III in fig. 2 of a tool body according to fig. 1, and

Fig. 4 is a view similar to that of fig. 3 of a tool body according to a second embodiment of the invention.

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DETAILED DESCRIPTION OF EMBODIMENTS OF THE INVENTION

35 Fig. 1 illustrates a machining tool 1 for turning having besides a tool body 2 according to an embodiment of the invention a

member 3 with a cutting insert 4 for chip-removing machining in the form of turning secured at an end 5 of the tool body. The tool body may just as well be used in a machining tool for other types of machining, such as milling, drilling, or boring, and a
5 corresponding member with at least one cutting edge for chip-removing machining is then to be secured to the end 5 of the tool body.

The tool body includes a damping apparatus 6 for damping vibrations in the machining tool caused by machining operation, and this damping apparatus is arranged in an internal room 7 (see fig. 3) of the tool body defined by a casing 8. The damping apparatus comprises a damper mass body 9 with a circular cylindrical shape of a high density material, such as of lead, with
10 an axial through bore 10. The internal room 7 contains a damping fluid, such as oil, in an annular cavity 22 separating the damper mass body 9 radially from internal walls of the casing 8 defining the internal room. A central tube 11 extends through the through bore 10 and is rigidly secured to the damper mass body
15 9 inside the through bore. The central tube 11 is at both ends 12, 13 thereof rigidly connected to a tool body fixed part 14, 15, i.e. a part of the tool body which is to be rigid or stiff with respect to a said member 3 with at least one cutting edge to be secured to the tool body, in this case end pieces. The central
20 tube 11 is made of a material with a spring property, such as steel or carbon fibre with this property, allowing the damper mass body 9 to oscillate in the internal room 7 of the tool body perpendicularly to the longitudinal extension of the central tube 11. The damping frequency of the damping apparatus will be
25 proportional to the square root of k/m , in which k is the spring constant of the spring formed by the central tube with a spring property and m is the mass of the damper mass body 9. The spring constant will depend upon the diameter and the wall thickness of the central tube as well as the material chosen for
30 that tube, so that said frequency may be selected to match the frequency of the vibrations to be damped by appropriately
35

choosing these characteristics of the central tube. Embodiments of the invention will by this without any problem allow to obtain such a frequency in the range of 300 Hz to 1 100 Hz, and frequencies outside this range are also conceivable.

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The through bore 10 of the damper mass body 9 has at each end thereof a length portion 16, 17 with larger cross section dimensions than the central tube leaving a space 18, 19 between the damper mass body 9 and the central tube 11. The choice of
10 length of these length portions will also influence the spring constant of the central tube 11.

Fig. 4 is a view similar to fig. 3 of a tool body according to a second embodiment of the invention differing from that shown in
15 fig. 3 by an arrangement of an element 20, 21 bridging the respective space 18, 19 between the damper mass body 9 and the central tube 11. These elements 20, 21 will form a support of the central tube 11 with respect to the damper mass body and will influence the spring property of the central tube 11. The ele-
20 ments 20, 21 may be chosen to be rigid or to have elastic properties, such as being O-rings surrounding the central tube 11. The properties chosen for these elements 20, 21 will also influence the magnitude of the spring constant of the central tube 11. Furthermore, the elements 20, 21 are preferably movable
25 along the central tube between different locations so as to change the spring constant of the central tube. This makes it possible to use the same tool body or identical tool bodies for obtaining appropriate damping of vibrations in machining tools of different types and/or dimensions generating vibrations of dif-
30 ferent frequencies by the machining operation thereof.

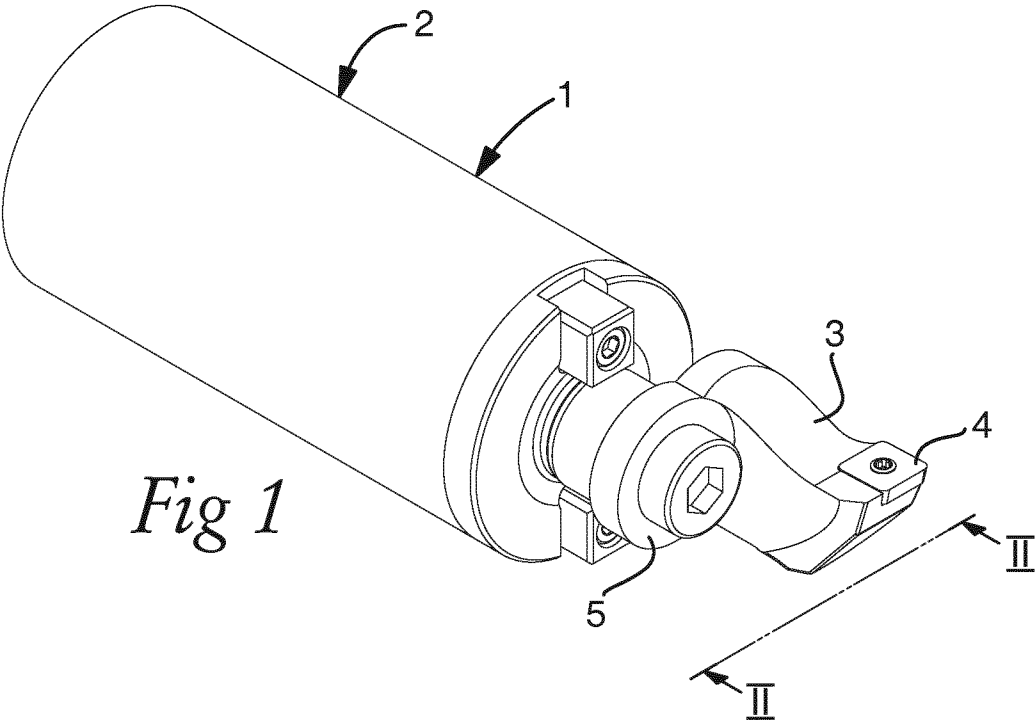
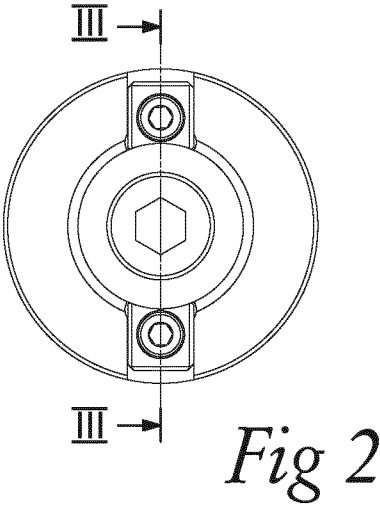
The invention is of course not restricted to the embodiments thereof described above, but many possibilities to modifications thereof would be apparent to a person with skill in the art without departing from the scope of the invention as defines in the
35 appended claims.

- The length portions with larger cross-sections dimensions of the through bore of the damper mass body may have other lengths than shown in the figures or not be there at all. It is of course
- 5 also possible to have the elements bridging the space between the central tube and the damper mass body immovably arranged or only one of them movable or having only one such element.

Claims

1. A tool body (2) including a damping apparatus for damping vibrations in a machining tool (1) having besides the tool
5 body a member (3) with at least one cutting edge to be secured to the tool body, wherein the damping apparatus (6) is arranged in an internal room (7) of the tool body and comprises
- a damper mass body (9)) with an axial through bore
10 (10), and
 - a central tube (11) extending through said bore and which is rigidly secured to the damper mass body (9) inside the through bore (10),
- characterized** in that the central tube (11) is at both ends
15 (12, 13) thereof rigidly connected to a tool body fixed part (14, 15) and the central tube is made of a material with a spring property allowing the damper mass body (9) to oscillate in the internal room (7) perpendicularly to the longitudinal extension of the central tube (11).
- 20
2. A tool body according to claim 1, **characterized** in that the central tube (11) is made of steel or carbon fibre.
3. A tool body according to claim 1 or 2, **characterized** in that
25 the through bore (10) has at at least one end thereof a length portion (16, 17) with larger cross-section dimensions than the central tube (11) leaving a space (18, 19) between the damper mass body (9) and the central tube (11), and that an element (21, 21) is arranged to bridge this space
30 between the central tube and the damper mass body at a location along the central tube.
4. A tool body according to claim 3, **characterized** in that said
35 element (20, 21) is rigid.

5. A tool body according to claim 3, **characterized** in that said element (20, 21) has elastic properties.
6. A tool body according to claim 5, **characterized** in that said
5 element (20, 21) is an O-ring of rubber.
7. A tool body according to any of claims 3-6, **characterized** in
that said element (20, 21) is movable along the central tube
(11) between different said locations so as to change the
10 spring constant of the central tube.
8. A tool body according to any of claims 3-7, **characterized** in
that the through bore (10) has a said length portion (16, 17)
and a said element (20, 21) at both ends of the through
15 bore.
9. A tool body according to any of the preceding claims, **char-
acterized** in that the central tube (11) is a machining tool
cooling tube.
20
10. A tool body according to any of the preceding claims, **char-
acterized** in that the damper mass body (9) has a circular
cylindrical shape with the through bore (10) extending ac-
cording to the centre axis of the cylinder so formed.
25
11. A tool body according to any of the preceding claims, **char-
acterized** in that the internal room (7) contains a damping
fluid, such as oil, in an annular cavity (22) separating the
damper mass body (9) radially from internal walls defining
30 the internal room (7).
12. A machining tool, **characterized** in that it has a tool body
(2) according to any of the preceding claims.
- 35 13. Use of a tool body according to any of claims 1-11 to damp
vibrations in a machining tool in operation.



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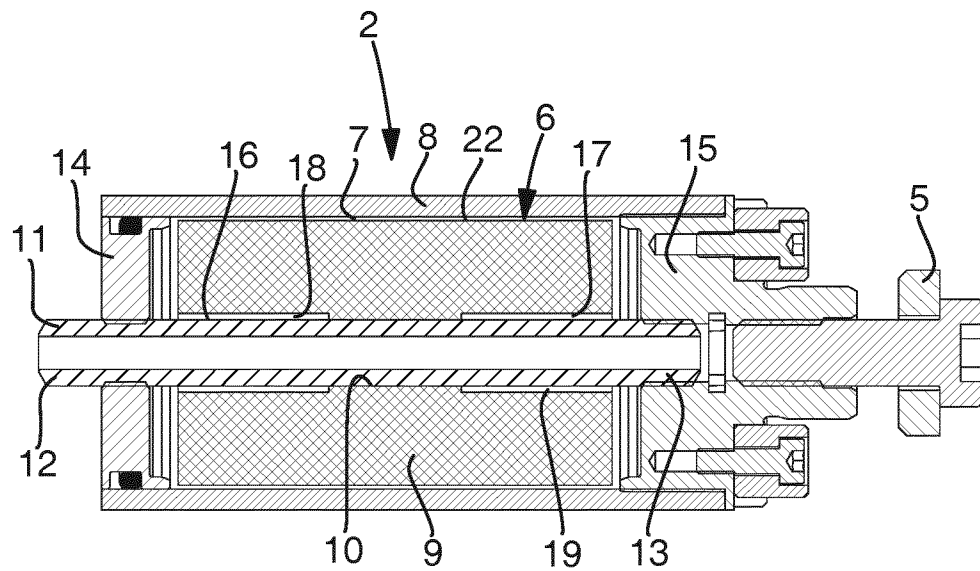


Fig 3

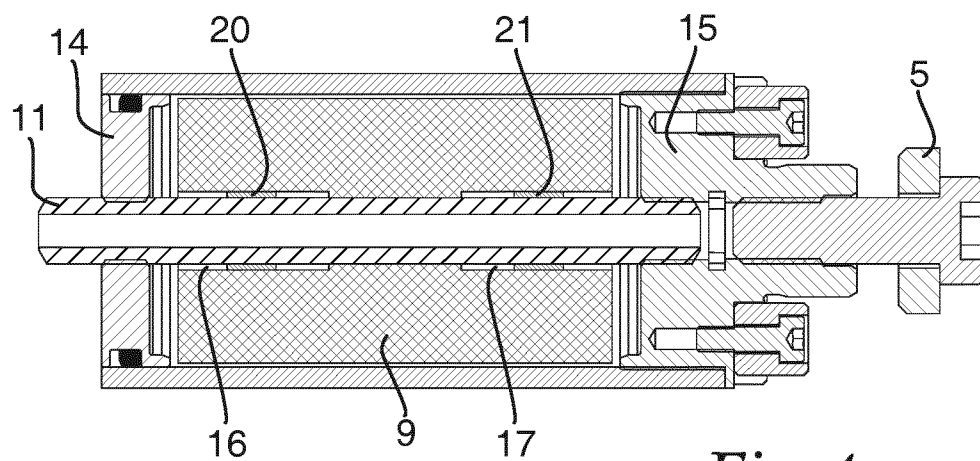


Fig 4

INTERNATIONAL SEARCH REPORT

International application No

PCT/EP2018/074471

A. CLASSIFICATION OF SUBJECT MATTER

INV. B23Q11/00 B23B29/02 F16F7/10
ADD.

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

B23Q B23B F16F

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

EPO-Internal, WPI Data

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	EP 2 890 915 A1 (SANDVIK INTELLECTUAL PROPERTY [SE]) 8 July 2015 (2015-07-08)	1-6, 8-10,12, 13
A	paragraph [0030] - paragraph [0032]; figures 1-3	7,11
X	US 2016/311031 A1 (GIANNETTI ENRICO R [US]) 27 October 2016 (2016-10-27)	1-6, 8-10,12, 13
A	paragraph [0035]; claim 41; figures 2, 4	7,11
X	US 3 690 414 A (AGGARWAL TRILOK C ET AL) 12 September 1972 (1972-09-12)	1-6, 8-10,12, 13
	abstract	



Further documents are listed in the continuation of Box C.



See patent family annex.

* Special categories of cited documents :

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"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art

"&" document member of the same patent family

Date of the actual completion of the international search

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INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No

PCT/EP2018/074471

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
EP 2890915	A1	08-07-2015	CN 104704260 A 10-06-2015
			DE 102012108098 A1 06-03-2014
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