



(51) International Patent Classification:

B23B 51/02 (2006.01) B23B 5/16 (2006.01)

B23B 5/00 (2006.01)

(21) International Application Number:

PCT/US2019/043682

(22) International Filing Date:

26 July 2019 (26.07.2019)

(25) Filing Language:

English

(26) Publication Language:

English

(30) Priority Data:

62/716,615 09 August 2018 (09.08.2018) US

(71) Applicant: KYOCERA SGS PRECISION TOOLS, INC. [US/US]; 55 South Main Street, Munroe Falls, Ohio 44262 (US).

(72) Inventors: HAMIL, Brian; 2193 Pontius Street NE, Mogadore, Ohio 44260 (US). BONFIGLIO, Doug; 126 Dangel Ave., Akron, Ohio 44312 (US). CURTICIAN, Steve; 5114 Campbellsport Road, Ravenna, Ohio 44266 (US). RAK, Jacob; 1104 Koons Road, North Canton, Ohio 44720 (US).

(74) Agent: GUTTMAN, Scott M. et al.; 52 East Gay Street, Columbus, Ohio 43215 (US).

(81) Designated States (unless otherwise indicated, for every kind of national protection available): AE, AG, AL, AM, AO, AT, AU, AZ, BA, BB, BG, BH, BN, BR, BW, BY, BZ, CA, CH, CL, CN, CO, CR, CU, CZ, DE, DJ, DK, DM, DO, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, GT, HN, HR, HU, ID, IL, IN, IR, IS, JO, JP, KE, KG, KH, KN, KP, KR, KW, KZ, LA, LC, LK, LR, LS, LU, LY, MA, MD, ME, MG, MK, MN, MW, MX, MY, MZ, NA, NG, NI, NO, NZ, OM, PA, PE, PG, PH, PL, PT, QA, RO, RS, RU, RW, SA, SC, SD, SE, SG, SK, SL, SM, ST, SV, SY, TH, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, ZA, ZM, ZW.

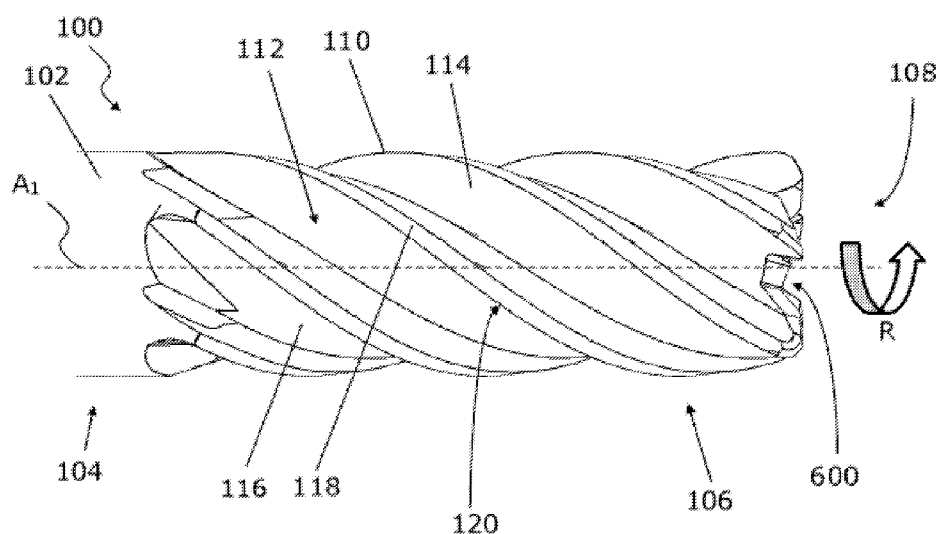
(84) Designated States (unless otherwise indicated, for every kind of regional protection available): ARIPO (BW, GH, GM, KE, LR, LS, MW, MZ, NA, RW, SD, SL, ST, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, RU, TJ, TM), European (AL, AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HR, HU, IE, IS, IT, LT, LU, LV, MC, MK, MT, NL, NO, PL, PT, RO, RS, SE, SI, SK, SM, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, KM, ML, MR, NE, SN, TD, TG).

Published:

— with international search report (Art. 21(3))

(54) Title: VARIABLE RADIUS GASH

FIG. 1



(57) Abstract: A variable radius gash geometry may be provided on a variety of rotary cutting tools. The rotary cutting tools extend along a longitudinal axis, from a shank towards a cutting face that engages a material to be cut during a plunge or ramp operation, and a plurality of gashes may be provided in the cutting face of the rotary cutting tool. The gashes may each be a full radius gash, and the radius defining each of the gashes may be unique or different from one another and tangent to an axial rake face and clearance face surrounding the gash.



VARIABLE RADIUS GASH

CROSS-REFERENCE TO RELATED APPLICATION

[0001] This application claims priority to and the benefit of pending U.S. Provisional Application No. 62/716,615 filed August 9, 2018, which is incorporated by reference herein in its entirety.

BACKGROUND

[0002] High-performance rotary cutting tools, such as end mills, may incorporate various geometrical designs, including symmetrical (or equal) geometry designs and variable (or unequal) geometry designs. Symmetrical, equal geometry designs may resonate at natural frequencies during use, and thus vibrate, known as "chatter" in machining terms and which can cause damage to the tool and unacceptable surface finish to the work piece. To control chatter in such standard, non-variable geometry cutting tools, cutting rates need to be reduced, sometimes significantly, thus hindering productivity.

[0003] Thus, modern high-performance rotary cutting tools may incorporate variable or unequal geometry designs. Exemplary variable geometry designs include, but are not limited to, unequal flute indexing, variable helix, variable rake, variable edge treatment, etc., and high-performance cutting tools may include one or more of these variable design features. By disrupting the natural frequencies that occur with equal, symmetrical geometry designs, the variable or unequal geometry designs reduce or eliminate "chatter" which can cause improve tool life and surface finish. However, variable geometry designs may subject the tool to varying chip loads, which may result in irregular wear of the cutting edges of the cutting tool.

SUMMARY

[0004] In accordance with the present disclosure, a variable radius gash geometry is provided. The variable radius gash geometry may be utilized in a variety of rotary cutting tools having cutting faces at an axial end of the

rotary cutting tool. In some examples, the variable radius gash geometry may include a plurality of gash grinds each associated with an end cutting edge, wherein each of the gash grinds is defined by a unique radius such that the end cutting edges have equal length. In some of these examples, each of the gash grinds may be a full radius gash grind that is tangent to an axial rake face and a clearance face; and in some of these examples, the axial rake face and the clearance face associated with each of the plurality of gash grinds may be formed via the gash grind associated therewith. In some examples, the end cutting edges are each formed via the gash grind associated therewith. In some examples, each of the end cutting edges is associated with a flute, the flutes having an unequal flute indexing arrangement.

[0005] Also disclosed herein is a variable radius gash geometry for a rotary cutting tool. In some examples, the variable radius gash geometry may include a plurality of gash grinds each associated with an end cutting edge and each tangent to an axial rake face and a clearance face, wherein each of the gash grinds develops the end cutting edge associated therewith with a length equal to the other end cutting edges. In some of these examples, each of the gash grinds may be defined by a unique radius that is different from the other gash grinds. In some examples, the axial rake face and the clearance face associated with each of the plurality of gash grinds may be formed via the gash grind associated therewith. In some examples, the end cutting edges may each be formed via the gash grind associated therewith. In some examples, each of the end cutting edges is associated with a flute, and the flutes may have an unequal flute indexing arrangement. In some examples, each of the gash grinds defines a full radius providing a gash surface having continuous curvature equal to the full radius.

[0006] Also disclosed herein is a rotary cutting tool. In these examples, the rotary cutting tool includes a cylindrical body having a cutting portion that extends longitudinally along an axis of the cylindrical body towards an axial end of the cylindrical body; and a cutting face provided at the axial end, the cutting face having a plurality of end cutting edges that are each

developed by a gash grind in the cutting face, wherein each gash grind is defined by a different radius that equalizes length of the end cutting edges.

[0007] Also disclosed herein is a method of providing a variable radius gash geometry on a cutting face of a rotary cutting tool. This method may include plunging a plurality of grinding wheels into the cutting face, wherein each grinding wheel has a different radius; and grinding a gash into the cutting face with each of the grinding wheels, wherein each of the gashes is defined by a unique radius that corresponds to the different radius of the grinding wheel associated therewith and that develops an associated end cutting edge such that each of the associated end cutting edges have equal length. In some examples, this method may include forming a full radius gash into the cutting face with each of the grinding wheels, wherein each full radius gash is tangent to an axial rake face and a clearance face associated with the full radius gash. In some examples, the method is a method of radius gash grinding that provides an axial rake face and a clearance face tangent to a radius of a gash interposing the axial rake face and clearance face.

[0008] Also disclosed herein is a method of equalizing length of end cutting edges on a cutting face of a rotary cutting tool having variable flute indexing. This method may include plunging a plurality of grinding wheels into the cutting face, wherein each grinding wheel has a different radius; and grinding gash grinds that each have a unique radius corresponding with the different radius of the grinding wheel utilized to form the gash grind, wherein the gash grinds develop the end cutting edges having equal lengths.

BRIEF DESCRIPTION OF THE DRAWINGS

[0009] The following figures are included to illustrate certain aspects of the present disclosure, and should not be viewed as exclusive embodiments. The subject matter disclosed is capable of considerable modifications, alterations, combinations, and equivalents in form and function, without departing from the scope of this disclosure.

[0010] FIG. 1 is a side view of an exemplary cutting tool that may incorporate the principles of the present disclosure.

[0011] FIG. 2 illustrates a cutting face of a tool having an exemplary center cutting design.

[0012] FIG. 3 illustrates an example plunge operation of the tool having the center-cutting design of FIG. 2.

[0013] FIG. 4 illustrates a cutting face of a tool having an exemplary non-center-cutting design.

[0014] FIG. 5 illustrates an example ramping operation of the tool having the non-center-cutting design of FIG. 4.

[0015] FIG. 6 is an isometric view of the cutting tool of FIG. 1.

[0016] FIG. 7 is a detailed side view of the axial end of the cutting tool of FIG. 1.

[0017] FIG. 8 illustrates the cutting face of a cutting tool having unequal flute indexing.

[0018] FIG. 9 illustrates the cutting face of FIG. 8 having end cutting edges of varying lengths due to the unequal flute indexing.

[0019] FIG. 10 is an isometric view of a cutting tool incorporating variable radius gash geometry, according to one or more embodiments of the present disclosure.

[0020] FIG. 11 is a detailed side view of the axial end of the cutting tool of FIG. 10.

[0021] FIG. 12 illustrates the cutting face of a cutting tool with unequal flute indexing and incorporating variable radius gash geometry, according to one or more embodiments of the present disclosure.

[0022] FIG. 13 illustrates the cutting face of FIG. 12 with end cutting edges of equal lengths due to the variable radius gash geometry.

[0023] FIG. 14 is a detailed perspective view of a cutting face of a cutting tool having a plurality of variable radius gash grinds, according to one or more embodiments of the present disclosure.

[0024] FIG. 15 is an alternate perspective view of FIG. 14.

[0025] FIG. 16 is a top view of a cutting face of a cutting tool having a plurality of variable radius gash grinds, according to one or more embodiments of the present disclosure.

DETAILED DESCRIPTION

[0026] The present disclosure is related to rotary cutting tools having variable radius geometries and, more particularly, to rotary cutting tools with variable radius gash geometries.

[0027] The embodiments described herein provide variable radius gash geometry for rotary cutting tools, such as end mills, that reduce or eliminate uneven wear of the cutting edges.

[0028] FIG. 1 is a side view of an example rotary cutting tool 100 (hereinafter, the "cutting tool 100") that may be modified to incorporate the principles of the present disclosure. The depicted cutting tool 100 is just one example cutting tool that can suitably incorporate the principles of the present disclosure. Indeed, many alternative designs and configurations of the cutting tool 100 may be employed, without departing from the scope of this disclosure. For example, the principles of the present disclosure may be incorporated with various types of rotary cutting tools, such as end mills, drills, countersinks, counter bores, taps and dies, reamers, routers, etc. Thus, while the cutting tool 100 is illustrated and described as an end mill, it will nevertheless be appreciated that chip breaking features disclosed herein may be incorporated onto other types of rotary cutting tools without departing from the present disclosure. In the illustrated example, the cutting tool 100 is configured as an end mill having five (5) flutes and may be used to mill a variety of materials including ferrous type work piece materials such as steel, stainless steel, titanium, etc. However, the cutting tool 100 may be

differently configured with more or less flutes, for example, a multi-flute router, used for routing CFRP and plastic type materials. In some examples, the cutting tool 100 may include seven (7) flutes or any other flute counts. Regardless, embodiments described herein may be utilized with any number of cutting tools, regardless of their flute count. Thus, embodiments described herein are not limited by the flute count of the cutting tool on which it is disposed.

[0029] As illustrated, the cutting tool 100 generally includes a cylindrical body 102 that extends longitudinally along an axis A_1 of the cylindrical body 102. Here, the cylindrical body 102 includes a shank portion 104 and a cutting portion 106 that generally defines the length of cut of the cutting tool 100, and the cutting portion 106 extends longitudinally along the axis A_1 to an axial face or axial end 108 of the cutting tool 100. The cutting portion 106 is illustrated as having a generally cylindrical shaped periphery, but it may be configured with various other geometries without departing from the present disclosure, including but not limited to a frusto-conical shape or ball nose shape.

[0030] The cutting portion 106 includes a plurality of blades 110 that are separated by a plurality of flutes 112. Each of the blades 110 has a leading face surface 114, a trailing face surface 116, and at least one radial relief surface 118 that bridge the leading face surface 114 and trailing face surface 116. As to each of the blades 110, a cutting edge (or lateral or side cutting edge) 120 is formed at the intersection between the leading face surface 114 and the radial relief surface 118. Here, the blades 110 and flutes 112 extend along the cutting portion 106, helically about the axis A_1 . The blades 110 may be oriented at various helix angles that are measured with respect to the axis A_1 , and in other non-illustrated embodiments, the blades 110 and the flutes 112 may even be oriented parallel to the axis A_1 . During operation, the cutting tool 100 rotates in a direction R about the axis A_1 , and chips are removed from the work piece upward through the flutes 112 and towards the shank portion 104.

[0031] The radial relief surface 118 may have various configurations. For example, the radial relief surface 118 may exhibit a generally cylindrical configuration, a generally planar configuration, a not-concave configuration, a faceted configuration, or an eccentric configuration when evaluated in cross section. Also, the radial relief surface 118 may include one or more relief surfaces that are oriented at one or more corresponding relief angles. For example, the radial relief surface 118 may include a primary relief surface disposed contiguous with the cutting edge 120 extending at a first relief angle relative to a tangential line drawn at the cutting edge 120. In other examples, the radial relief surface 118 may include a secondary relief surface that is disposed on a side of the primary relief surface opposite of the cutting edge 120 at a second relief angle relative to the previously mentioned tangential line, where the magnitude of the second relief angle is greater than the magnitude of the first relief angle. In even other examples, the radial relief surface 118 may include additional relief surfaces, such as a tertiary portion disposed on a side of the second relief surface that is opposite of the first relief surface. These relief surfaces may be provided linearly, or may extend arcuately to blend into each other and/or the trailing face surface 116.

[0032] In some examples, the cutting tool 100 has at least one end cutting edge extending beyond half a diameter of the cutting tool 100, thereby allowing cutting across the entire diameter of the cutting tool. This is referred to as center-cutting end design, and FIG. 2 illustrates an exemplary center cutting end design 200, according to one or more embodiments. Here, the center cutting end design 200 includes two (2) flutes 202 that extend to (or beyond) a center 204 of a cutting diameter D of the tool, to thereby define center cutting edges 206 extending across the center 204. Here, a pair of end cutting edges 208 that do not extend to (or stop short of) the center 204 of the cutting diameter D and are thus shorter than the center cutting edges 206. The center cutting end design 200 enables the cutting tool 100 to do a direct plunge (axially) into a material to cut similar to a drilling operation. FIG. 3 illustrates a plunge operation of a cutting tool having the center cutting end design 200 of FIG. 2. This results in a hole in

the material from which the cutting tool 100 may then mill radially. Drill design, however, is more effective than end mill design for entering material axially to make a hole. And, although plunge milling with the cutting tool 100 having a center-cutting end design (e.g., such as the center cutting end design 200 of FIGS. 2-3) is an effective operation, it is limited in use due to its aggressiveness, especially in difficult to machine materials.

[0033] In other examples, however, the cutting tool 100 may have a non-center-cutting end design. FIG. 4 illustrates an exemplary non-center-cutting end design 400, according to one or more examples. Here, the non-center cutting end design 400 includes five (5) flutes 402 that do not extend to a center 404 of the tool's cutting diameter D. While the non-center-cutting end design 400 may inhibit direct axial plunging due to its open design where the flutes 402 do not extend to or past the center 404, the non-center-cutting end design 400 is effective at aggressively ramping into the material. In particular, the open design of the non-center-cutting end design 400 provides extra room for material or chip evacuation, thereby making the non-center-cutting end design 400 effective and/or efficient at ramping into a material. FIG. 5 illustrates a ramping operation of a cutting tool having the non-center-cutting design of FIG. 4. The non-center-cutting end design 400 provides flexibility as the cutting tool 100 having such design may be manufactured from a carbide blank with a central hole that permits the cutting tool 100 to be utilized with a through the spindle coolant delivery system.

[0034] The cutting tool 100 also includes a gash (or gash relief or gash grind) 600 formed into the axial end 108 of the cutting tool 100. The configuration of the gash 600 may determine whether the cutting tool 100 incorporates a center cutting end design or a non-center cutting end design, and may thus determine the axial feed capabilities of the cutting tool 100 (i.e., whether it may plunge into the material, and parameters at which it may plunge there-into, or whether it may ramp into the material, and the parameters at which it may ramp there-into). The gash 600 is more clearly illustrated in FIGS. 6-7, which are isometric and detailed side views of the cutting tool 100 of FIG. 1, respectively. The cutting tool 100 includes a

cutting face 602 at the axial end 108 of the cutting tool 100 that engages and cuts the material when plunging or ramping into the material. The gash 600 is a notch or clearance that is ground or otherwise arranged on the cutting face 602, between an axial rake face 604 and a clearance face 606, so as to provide room for chip evacuation as the cutting tool 100 is plunging or ramping into the material. As more fully described herein, the axial rake face 604 and the clearance face 606 may be formed when grinding the gash 600, for example, the axial rake face 604 and the clearance face 606 may be formed during radius gash grinding. The gash 600 is a grind that helps form or develop an end cutting edge 608 of the cutting tool 100 that engages material when feeding the cutting tool 100 into material in an axial direction along the axis A_1 . Thus, the end design of the cutting tool 100 may depend on the configuration of the gash 600.

[0035] Various parameters define the gash 600. For example, the gash 600 may be arranged at a gash angle 702 (see FIG. 7), which is the relief angle of the gash 600. The gash angle 702 is measured from a gash surface 610 (i.e., a bottom surface 610 of the gash 600) to a cutting diameter D (i.e., margin to margin) of the cutting face 602. As exemplified in FIG. 7, to measure the gash angle 702, the axial or end cutting edge 608 is rotated to a centerline of the cutting tool 100 (i.e., the axis A_1), and the gash angle 702 is measured parallel to the centerline (i.e., axis A_1) of the cutting tool 100. In addition, the gash 600 may have a depth parameter and a radius parameter. The gash angle, depth, and radius of the gash 600 may be designed and closely controlled to balance strength with efficient cutting of the cutting tool 100. In some examples where the cutting tool 100 includes a plurality of gashes 600, each of the gashes 600 may include the same gash angle, the same gash depth parameter, and the same gash radius parameter; however, in some examples, one or more of the gashes 600 may have one or more parameters different from one or more of the other gashes 600.

[0036] When forming the gash 600 in the cutting tool 100, the grinding wheel that produces the gash 600 enters the cutting face 602 of the cutting tool 100, and “walks” laterally to provide the gash 600 with a width dimension W . Laterally “walking” the grinding tool to form the gash 600 in

this manner imparts a square (or trapezoidal) shaped geometry on the gash 600 (i.e., a squarish gashing or trapezoidal gashing), as illustrated in FIG. 6 and FIG. 7. Here, the squarish (or trapezoidal) gashing includes a generally flat gash surface 610 and the axial rake face 604 and the clearance face 606 extend therefrom at respective junctions 612, 614 with the gash surface 610 (see FIG. 7). Also, radiused corners are ground at the junction 612 between the gash surface 610 and the axial rake face 604 and at the junction 614 between the gash surface 610 and the clearance face 606, and the radius of such radiused corners is equal to the radius of the grinding wheel (or other tool) utilized to grind the gashes 600. In some examples, a single conventional grinding wheel is utilized to grind the gashes 600 (i.e., to form the gash 600 grinds). However, such squarish (trapezoidal) gashing creates a weak point (or weakness) that is susceptible to breakage or failure, for example, breakage or chipping a corner 616 at the axial end 108 of the cutting tool 100. Also, gashes 600 formed in this manner often have equal widths W (i.e., the width W of the gash surface 610 is the same for each of the gashes 600 and flute 112 associated therewith) but, in examples where the cutting tool 100 has unequal indexing (or variable indexing), the gashes 600 formed (or ground) in that manner may result in the end cutting edges 608 having unequal (or different) lengths.

[0037] FIGS. 8-9 are exemplary end views of cutting tools having unequal (or variable) indexing of the blades 110 and the flutes 112, wherein the end cutting edges 608 produced by the gash 600 grinds have unequal lengths. In particular, FIG. 8 illustrates an example of the cutting face 602 having unequal flute indexing and FIG. 9 illustrates how grinding (or forming) the gashes 600 on the cutting face 602 of FIG. 8 that incorporates unequal flute indexing provides the end cutting edges 608 with unequal lengths. Here, the cutting tool 100 incorporates unequal flute indexing such that the flutes 112 are arranged at different index angles a° , b° , c° , d° , e° (FIG. 8), and grinding the gashes 600 into the cutting face 602 such that the gashes 600 each have equal widths W results in the end cutting edges 608 having unequal lengths a , b , c , d , e (FIG. 9). Thus, providing the gashes 600 with uniform dimensions (i.e., uniform dimensioned gashes 600) in a cutting tool

100 having unequal flute indexing may result in the end cutting edges 608 having varying (or different) lengths. However, this may result in irregular wear to the end cutting edges 608, for example, during aggressive ramping operations, in addition to weakening of the corners 616 as mentioned above.

[0038] In other embodiments, the cutting tool 100 may include a variable radius gash geometry. FIGS. 10-16 illustrate an exemplary variable radius gash geometry, according to one or more embodiments of the present disclosure. Variable radius gash geometry includes, or is defined by, a plurality of full radius gashes, each of unique size and each tangent to its neighboring axial rake face and clearance face. Thus, variable radius gash geometry is a grind feature that may include grinding each gash to have a unique or different radius to provide a plurality of variable radius gashes, and each such variable radius gash may be ground with a full radius (i.e., a continuous radius from the axial rake face to the clearance face) such that it is tangent to its associated axial rake face and the clearance face. This may be accomplished with a single angle form wheel utilized to cut gashes of different radii. Here, the single angle form wheel, that may vary in size according to the size of the cutting tool 100 being made or modified, generates the cutting face (axial rake face), the radius in the bottom of the gash, and the clearance face via multi-axis movements of the single angle form wheel controlled, for example, by a computer numerical control ("CNC") grinding program. Thus, the axial rake face, the radius of the gash, and clearance face may all be formed during the radius gash grinding. However, in other examples, differently sized grinding wheels (i.e., multiple formed wheels) may be utilized to form the gashes of different radii, and in such latter examples, the differently sized grinding wheels may each cut an individual variable radius gash via an individual plunge grind operation. Accordingly, a gash surface of each such variable radius gash includes a continuous curvature extending between its neighboring axial rake face and clearance face. In addition, variable radius gash geometry described herein may be incorporated into cutting tools having center cutting end designs or a non-center cutting end design.

[0039] The dimensions of the different gash radii utilized in the variable radius gash geometry may depend on dimensions of the cutting tool, the flute indexing, and/or the desired length of the resulting end cutting edges. For example, the size of the variable radius gash may be dependent on the flute count and diameter of the particular cutting tool into which the variable radius gash geometry is to be incorporated. In some examples, the variable radius gashes each have the same depth into the cutting face as measured along the longitudinal axis, but in other examples, one or more of them may have a different depth. Also, each of the full radius gashes may have the same gash angle, or one or more of the full radius gashes may have a gash angle that is different from the gash angles of one or more of the other full radius gashes. The gash angle of one or more of the full radius gash grinds may be selected from a range of gash angles, positive or negative, and in some examples the gash angle of one or more of the full radius gash grinds is selected based on the material to be machined. In addition, the gash angle of the various radius gash grind may vary from flute to flute such that, for example, the various radius gash grind in a first flute may oriented a positive gash angle and the gash angle of the various radius gash grind in a second flute may be oriented at a different positive gash angle or at a negative gash angle, etc. In some examples, variable radius gash geometry utilizes full radius gashes oriented at the same or different gash angles. This will allow the cutting tools incorporating variable radius gash geometry to include variable axial rake, similar to how the variable radial rake is provided in the Z-CARB-AP series tools provided by KYOCERA SGS Precision Tools. The diameters of the variable radius gashes depend on the diameter and flute count of each tool and may thus include any number of dimensions depending on those parameters.

[0040] By grinding a plurality of full radius gashes, each of unique size and tangent to the neighboring axial rake and clearance faces, the lengths of the end cutting edge will be the same. Thus, variable radius gash geometry may be incorporated into cutting tools having unequal flute indexing to equalize the lengths of the end cutting edges formed by the gash grind, and thereby improve ramping ability and overall performance. In addition,

because the gashes of the variable radius gash geometry have a full radius (rather than “walking” the grinding wheel to form squarish or trapezoidal gashing), the corners of the cutting tool are significantly strengthened. Indeed, load testing has shown that the variable radius gash geometry may increase the strength of the corners up to three (3) times compared to conventional gash geometry. The increased strength provided by the variable radius gash geometry also stabilizes the cutting tool during heavy milling, which promotes tool life.

[0041] The variable radius gash geometry may be provided on various types of rotary cutting tools, such as the cutting tool 100 described with reference to FIGS. 1-9. Thus, the variable radius gash geometry described herein may be incorporated into end mills, drills, countersinks, counter bores, taps and dies, reamers, routers, etc. However, while the variable radius gash geometry is described and illustrated with reference to an end mill, it will nevertheless be appreciated that the variable radius gash geometry disclosed herein may be incorporated onto other types of rotary cutting tools without departing from the present disclosure. In addition, the variable radius gash geometry may be incorporated into cutting tools with unequal flute indexing as mentioned above, but may also be incorporated into cutting tools having other types of flute indexing.

[0042] FIG. 10 is an isometric view of a cutting tool 1000 incorporating a variable radius gash geometry 1002, according to one or more embodiments of the present disclosure. As illustrated, the variable radius gash geometry 1002 includes a plurality of gashes 1004 arranged at an axial end 1006 of the cutting tool 1000. A plurality of end cutting edges 1008 are formed at the axial end 1006, with each of the end cutting edges 1008 corresponding with one of the gashes 1004. Also, each gash 1004 includes a gash surface 1016, with an axial rake face 1010 extending from the end cutting edge 1008 into a first side of the gash surface 1016 and a clearance face 1012 extending from an opposite second side of the gash surface 1016, away from the axial rake face 1010 and towards a neighboring end cutting edge 1008. Here, the gash surface 1016 includes a continuous curvature of constant radius, with the gash surfaces 1016 of the different gashes 1004

having unique or different radii. However, one or more of the gash surfaces 1016 may have a flat portion. Thus, grinding each of the gashes 1004 into a cutting face at the axial end 1006 of the cutting tool 1000 develops a corresponding one of the plurality of end cutting edges 1008, as well as the gash surfaces 1016 and the corresponding axial rake face 1010 and the corresponding clearance face 1012 of the gash 1004.

[0043] FIG. 11 is detailed side view of the variable radius gash geometry 1002 of FIG. 10. As illustrated, the gashes 1004 each include (or, are each defined by) a radius R . In particular, each of the gashes 1004 is a full radius gash, defined by its radius R , such that the gash 1004 is tangent to the axial rake face 1010 and the clearance face 1012 associated therewith. Grinding the gash 1004 as a full radius gash adds strength to a corner 1014 of the cutting tool 1000. Also, the radius R for each of the gashes 1004 is unique or different from the radii of the other gashes 1004, thereby providing the cutting tool 100 with the variable radius gash geometry 1002 and equalizing the lengths of the end cutting edges 1008 formed when grinding the gashes 1004. In the illustrated examples, the gash surface 1016 is ground with radius R that is tangent to the axial rake face 1010 and the clearance face 1012 surrounding the gash surface 1016.

[0044] FIGS. 12-13 illustrate how providing the gashes 1004, each with a unique size or radius and tangent to its corresponding axial rake and clearance faces, equalizes the lengths of the end cutting edges 1008. FIGS. 12 and 13 are end views of the cutting tool 1000 of FIGS. 10 and 11 configured with unequal indexing, and illustrate how the variable radius gash geometry 1002 equalizes the lengths of the end cutting edges 1008 formed by the gash 1004 grinds. In particular, FIG. 12 illustrates an example of the cutting tool 1000 having unequal flute indexing and FIG. 13 illustrates how grinding (or forming) grinding the variable radius gash geometry 1002 forms the end cutting edges 1008 with equal lengths a' , b' , c' , d' , e' . Here, the cutting tool 1000 incorporates unequal flute indexing such that the flutes are arranged at different index angles a° , b° , c° , d° , e° (FIG. 12), and grinding the gashes 1004, each with a unique and full radius R that is tangent to the

axial rake face 1010 and the clearance face 1012, results in the end cutting edges 1008 having equal lengths a' , b' , c' , d' , e' (i.e., $a' = b' = c' = d' = e'$).

[0045] FIGS. 14-15 are various perspective views of the cutting tool 1000 having the variable radius gash geometry 1002 of FIGS. 10-11, whereas FIG. 16 is a top view thereof. As illustrated, the gashes 1004 are each a full radius R , tangent to the axial rake face 1010 and the clearance face 1012, and the full radius R of each of the gashes 1004 is unique (or different) from the other gashes 1004. This results in the end cutting edges 1008 having equal lengths, which adds strength and durability to the corners 1014.

[0046] Also disclosed herein are various methods associated with the variable radius gash geometry. For example, this disclosure includes methods for forming a variable radius gash geometry, methods for manufacturing a rotary cutting tool having a variable radius gash geometry on a cutting face of the rotary cutting tool, methods for equalizing end cutting edges of a rotary cutting tool having variable flute indexing, etc. Such methods generally include generating a variable radius form for each of the variable radius gashes via use of a single form grinding wheel. Here, for example, the single form grinding wheel may be plunged into a cutting face (to form one variable radius gash at a time) and then walked along a radius tool path (corresponding with the unique radius of the particular gash being ground) to grind the radius form of each variable radius gash. For example, a CNC grinding program may control the single form grinding wheel to cut with multi-axis movements the cutting face (axial rake face), the radius in the bottom of the gash, and the clearance face. Thus, the axial rake face, the radius of the gash, and clearance face may all be formed during the radius gash grinding. However, such methods may instead generally include plunging a plurality of grinding wheels into a cutting face of a rotary cutting tool, one at a time or two or in groups of two or more at the same time, where each grinding wheel has a unique or different radius to form gash grinds having corresponding unique or different radii and to develop end cutting edges having the same length (i.e., to equalize length of the end cutting edges).

[0047] In one example, a method includes a step of providing a rotary cutting tool having a cylindrical body that extends along a longitudinal axis towards an axial end, wherein the rotary cutting tool further includes a cutting face at the axial end. This method may also include a step of providing a single form grinding wheel (or other cutting tool). This method may also include a step of plunging the grinding wheel into the cutting face, axially along the longitudinal axis, and then walking the grinding wheel along a first radius path, so as to form a first gash grind having a first unique (or different) radius that is tangent to the axial rake face and the clearance face associated therewith. This method then includes a step of plunging the grinding wheel into the cutting face, axially along the longitudinal axis, and then walking the grinding wheel along a second radius path, so as to form a second gash grind having a second unique (or different) radius that is tangent to the axial rake face and the clearance face associated therewith. It will be appreciated that this step of forming the unique gash grinds may be repeated "n" number of times, where the number "n" corresponds with the number of flutes present on the cutting tool. Thus, for a tool having seven (7) flutes, this method may then include a step of plunging the grinding wheel into the cutting face as described above, so as to form a third gash grind having a third unique radius, a fourth gash grind having a fourth unique radius, a fifth gash grind having a fifth unique radius, a sixth gash grind having a sixth unique radius, and a seventh gash grind having a seventh unique radius. Accordingly, this method may be utilized with rotary cutting tools having any number of flutes. By plunging the grinding wheel into the cutting face when forming each uniquely dimensioned gash grind, the grinding wheel enters the cutting face so as to form or develop a gash grind having a radius that is tangent to the axial rake face and the clearance face, and wherein the grinding wheel follows a unique radius tool path when forming each gash such that the radii of the gash grinds are different from each other (i.e., unique). This method may also include a step of removing or withdrawing each of the plurality of grinding wheels from the cutting face, one at a time or simultaneously.

[0048] In this method, the step of plunging the grinding wheel into the cutting face may include forming either the axial face or the clearance face of the gash, and then continuing along the radius tool path to form the gash surface tangent to the previously formed axial face or the clearance face, and then forming the other of the clearance face or axial face of the gash tangent to the unique radius of the radius tool path. Thus, when forming the axial face and the clearance face, the grinding tool may follow a linear tool path either when plunging into the cutting face or when being retracted therefrom. Thus, the method may include forming the gash surface of the gash, together with forming the axial rake face and clearance thereof that are tangent to a radius defining the gash surface.

[0049] In another example, a method includes a step of providing a rotary cutting tool having a cylindrical body that extends along a longitudinal axis towards an axial end, wherein the rotary cutting tool further includes a cutting face at the axial end. This method may also include a step of providing a plurality of grinding wheels (or other cutting tools) that each have a unique or different radius. This method may also include a step of plunging each of the plurality of grinding wheels into the cutting face, axially along the longitudinal axis, so as to form a plurality of gash grinds that each have a unique (or different) radius that is tangent to the axial rake face and the clearance face. By plunging the grinding wheels into the cutting face, each grinding wheel enters the cutting face so as to form or develop a gash grind having a radius that is tangent to the axial rake face and the clearance face, wherein the radii of the gash grinds are different from each other (i.e., unique). The grinding wheels may be plunged into the cutting face one at a time, or two or more of the grinding wheels may be plunged into the cutting face simultaneously. This method may also include a step of removing or withdrawing each of the plurality of grinding wheels from the cutting face, one at a time or simultaneously.

[0050] Therefore, the disclosed systems and methods are well adapted to attain the ends and advantages mentioned as well as those that are inherent therein. The particular embodiments disclosed above are illustrative only, as the teachings of the present disclosure may be modified

and practiced in different but equivalent manners apparent to those skilled in the art having the benefit of the teachings herein. Furthermore, no limitations are intended to the details of construction or design herein shown, other than as described in the claims below. It is therefore evident that the particular illustrative embodiments disclosed above may be altered, combined, or modified and all such variations are considered within the scope of the present disclosure. The systems and methods illustratively disclosed herein may suitably be practiced in the absence of any element that is not specifically disclosed herein and/or any optional element disclosed herein. While compositions and methods are described in terms of "comprising," "containing," or "including" various components or steps, the compositions and methods can also "consist essentially of" or "consist of" the various components and steps. All numbers and ranges disclosed above may vary by some amount. Whenever a numerical range with a lower limit and an upper limit is disclosed, any number and any included range falling within the range is specifically disclosed. In particular, every range of values (of the form, "from about a to about b," or, equivalently, "from approximately a to b," or, equivalently, "from approximately a-b") disclosed herein is to be understood to set forth every number and range encompassed within the broader range of values. Also, the terms in the claims have their plain, ordinary meaning unless otherwise explicitly and clearly defined by the patentee. Moreover, the indefinite articles "a" or "an," as used in the claims, are defined herein to mean one or more than one of the elements that it introduces. If there is any conflict in the usages of a word or term in this specification and one or more patent or other documents that may be incorporated herein by reference, the definitions that are consistent with this specification should be adopted.

[0051] The use of directional terms such as above, below, upper, lower, upward, downward, left, right, and the like are used in relation to the illustrative embodiments as they are depicted in the figures, the upward or upper direction being toward the top of the corresponding figure and the downward or lower direction being toward the bottom of the corresponding figure.

[0052] As used herein, the phrase "at least one of" preceding a series of items, with the terms "and" or "or" to separate any of the items, modifies the list as a whole, rather than each member of the list (i.e., each item). The phrase "at least one of" allows a meaning that includes at least one of any one of the items, and/or at least one of any combination of the items, and/or at least one of each of the items. By way of example, the phrases "at least one of A, B, and C" or "at least one of A, B, or C" each refer to only A, only B, or only C; any combination of A, B, and C; and/or at least one of each of A, B, and C.

CLAIMS

What is claimed is:

1. A variable radius gash geometry for a rotary cutting tool, the variable radius gash geometry comprising:

a plurality of gash grinds each associated with an end cutting edge, wherein each of the gash grinds is defined by a unique radius such that the end cutting edges have equal length.

2. The variable radius gash geometry of claim 1, wherein each of the gash grinds is a full radius gash grind that is tangent to an axial rake face and a clearance face.

3. The variable radius gash geometry of claim 2, wherein the axial rake face and the clearance face associated with each of the plurality of gash grinds are formed via the gash grind associated therewith.

4. The variable radius gash geometry of claim 1, wherein the end cutting edges are each formed via the gash grind associated therewith.

5. The variable radius gash geometry of claim 1, wherein each of the end cutting edges is associated with a flute, the flutes having an unequal flute indexing arrangement.

6. A variable radius gash geometry for a rotary cutting tool, the variable radius gash geometry comprising:

a plurality of gash grinds each associated with an end cutting edge and each tangent to an axial rake face and a clearance face, wherein each of the gash grinds develops the end cutting edge associated therewith with a length equal to the other end cutting edges.

7. The variable radius gash geometry of claim 6, wherein each of the gash grinds is defined by a unique radius that is different from the other gash grinds.

8. The variable radius gash geometry of claim 6, wherein the axial rake face and the clearance face associated with each of the plurality of gash grinds are formed via the gash grind associated therewith.

9. The variable radius gash geometry of claim 6, wherein the end cutting edges are each formed via the gash grind associated therewith.

10. The variable radius gash geometry of claim 6, wherein each of the end cutting edges is associated with a flute, the flutes having an unequal flute indexing arrangement.

11. The variable radius gash geometry of claim 6, wherein each of the gash grinds defines a full radius providing a gash surface having continuous curvature equal to the full radius.

12. A rotary cutting tool, comprising:

a cylindrical body having a cutting portion that extends longitudinally along an axis of the cylindrical body towards an axial end of the cylindrical body; and

a cutting face provided at the axial end, the cutting face having a plurality of end cutting edges that are each developed by a gash grind in the cutting face, wherein each gash grind is defined by a different radius that equalizes length of the end cutting edges.

13. The rotary cutting tool of claim 12, wherein each of the gash grinds is a full radius gash grind.

14. The rotary cutting tool of claim 13, wherein each of the full radius gash grinds is tangent to an axial rake face and a clearance face of the cutting face.

15. The rotary cutting tool of claim 14, wherein the axial rake face and the clearance face associated with each of the full radius gash grinds are formed via the full radius gash grind associated therewith.

16. The rotary cutting tool of claim 12, wherein the end cutting edges are each formed via the gash grind associated therewith.

17. The rotary cutting tool of claim 12, further comprising a plurality of flutes helically extending about the cutting portion of the cylindrical body in a variable flute indexing arrangement, wherein each of the end cutting edges is associated with one of the flutes.

18. A method of providing a variable radius gash geometry on a cutting face of a rotary cutting tool, comprising:

plunging a plurality of grinding wheels into the cutting face, wherein each grinding wheel has a different radius; and

grinding a gash into the cutting face with each of the grinding wheels, wherein each of the gashes is defined by a unique radius that corresponds to the different radius of the grinding wheel associated therewith and that develops an associated end cutting edge such that each of the associated end cutting edges have equal length.

19. The method of claim 18, wherein the step of grinding a gash into the cutting face with each of the grinding wheels further includes:

forming a full radius gash into the cutting face with each of the grinding wheels, wherein each full radius gash is tangent to an axial rake face and a clearance face associated with the full radius gash.

20. A method of equalizing length of end cutting edges on a cutting face of a rotary cutting tool having variable flute indexing, the method comprising:

plunging a plurality of grinding wheels into the cutting face, wherein each grinding wheel has a different radius; and

grinding gash grinds that each have a unique radius corresponding with the different radius of the grinding wheel utilized to form the gash grind, wherein the gash grinds develop the end cutting edges having equal lengths.

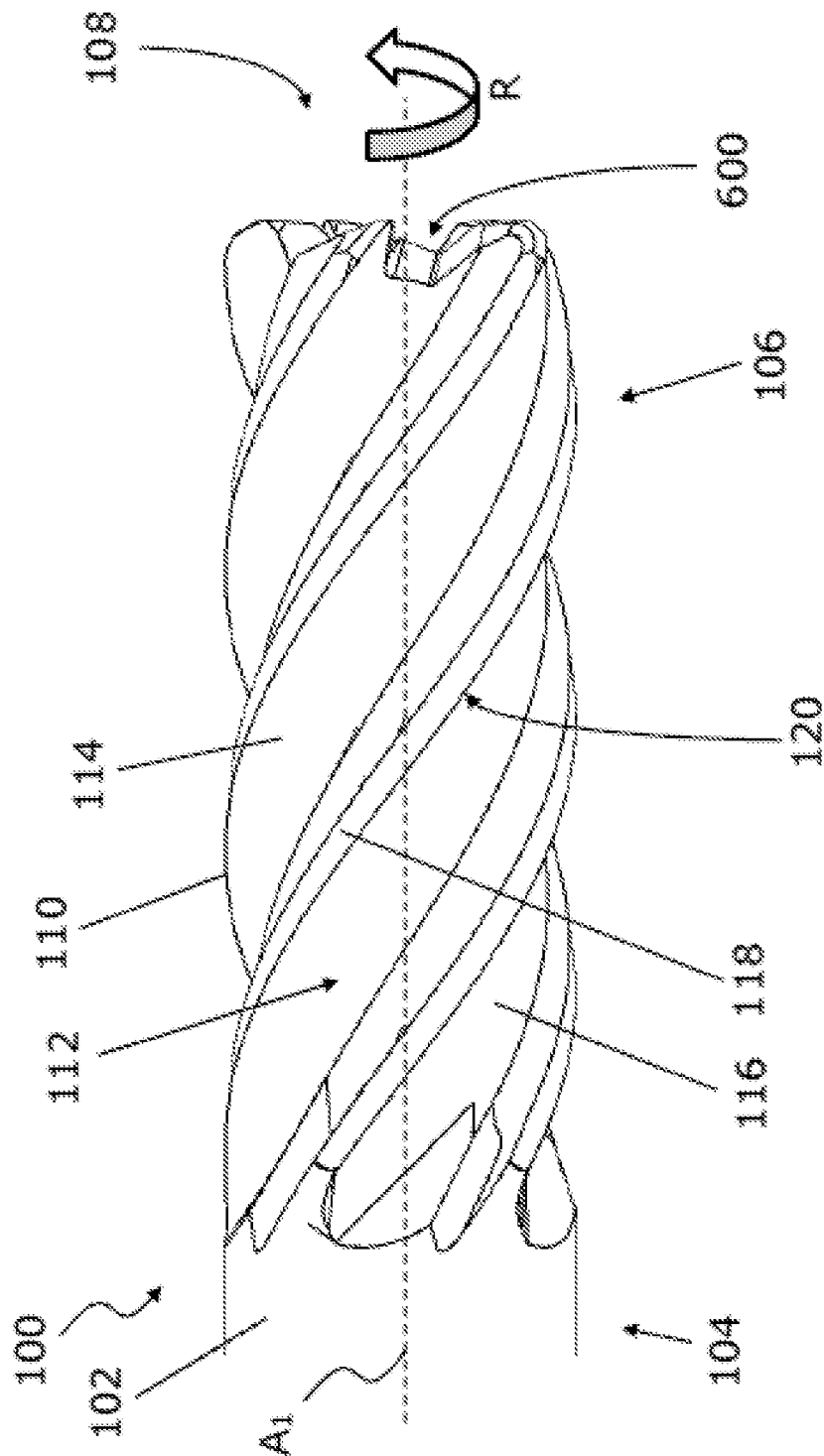


FIG. 1

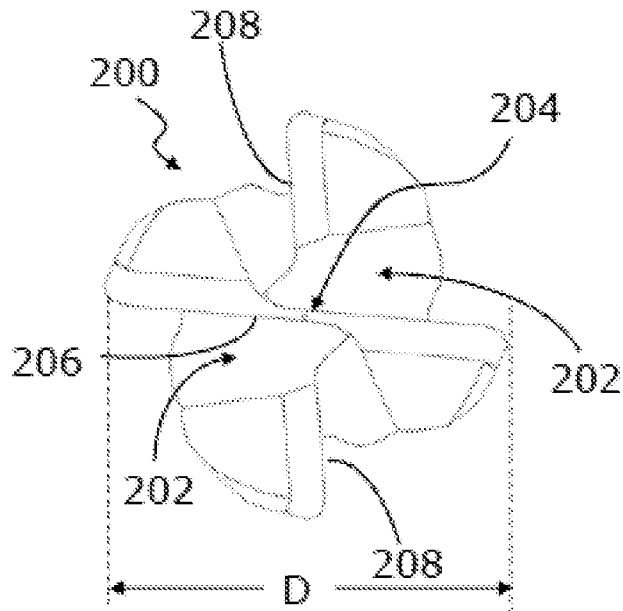


FIG. 2



FIG. 3

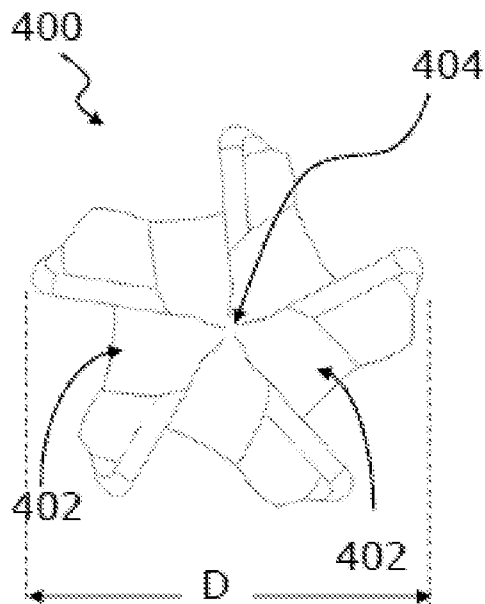


FIG. 4

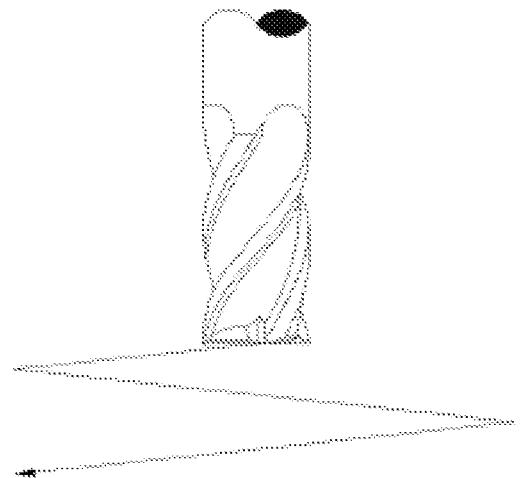
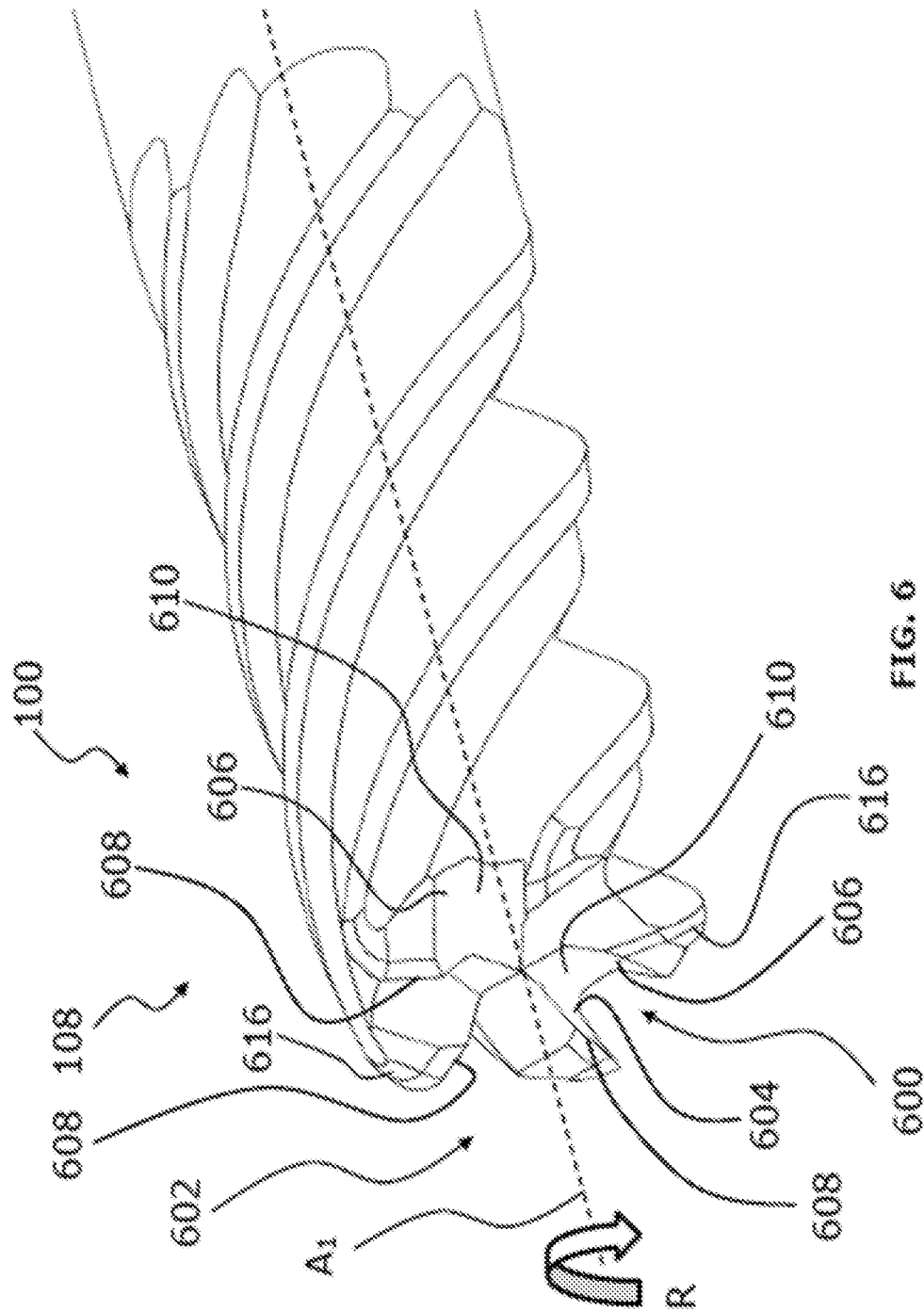


FIG. 5



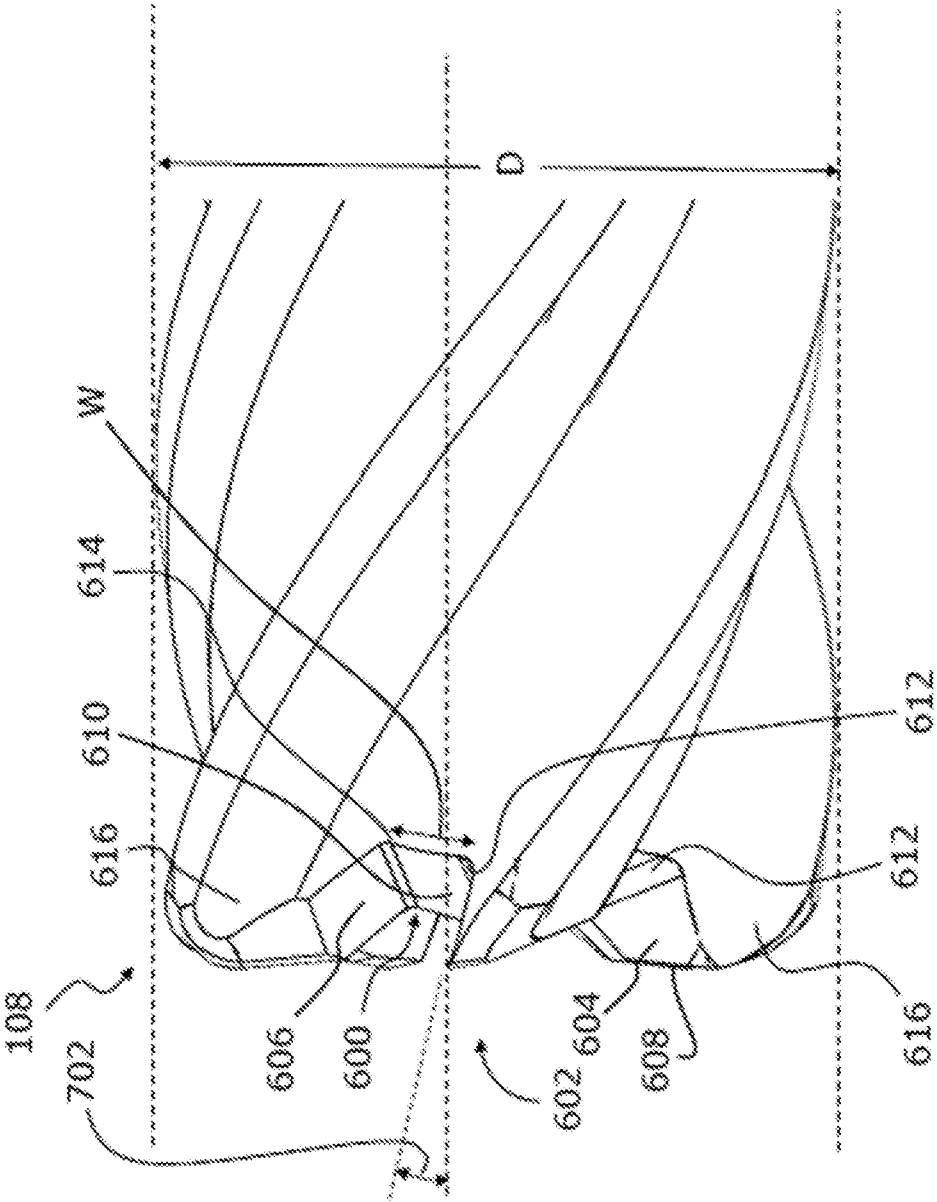
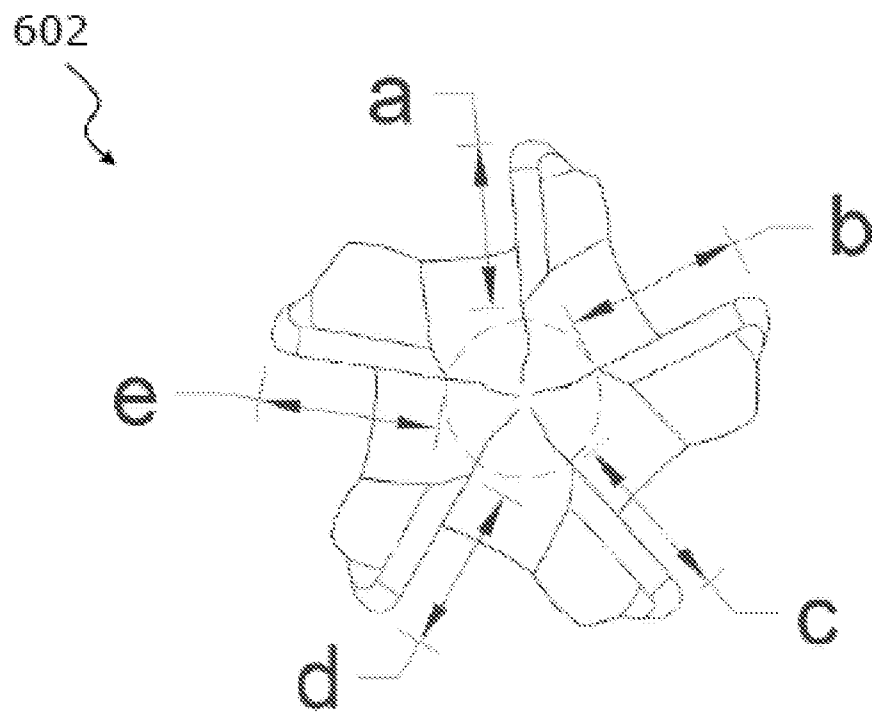
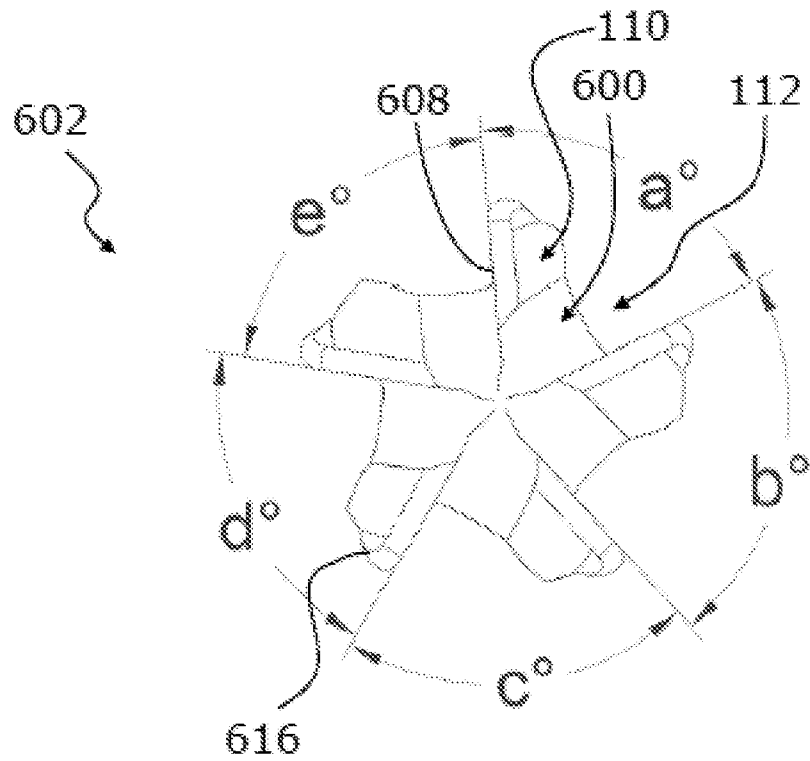


FIG. 7

5/9



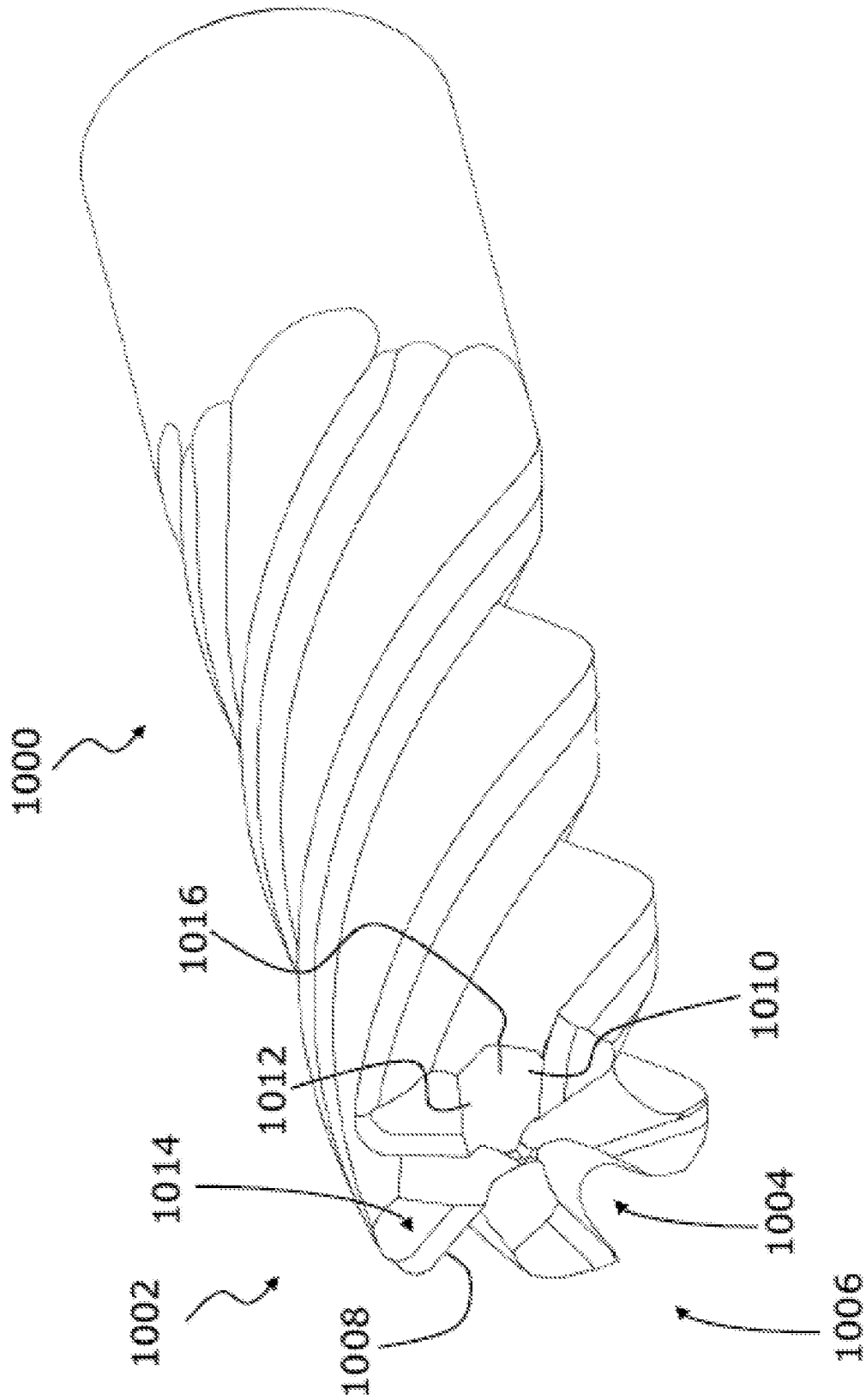


FIG. 10

7/9

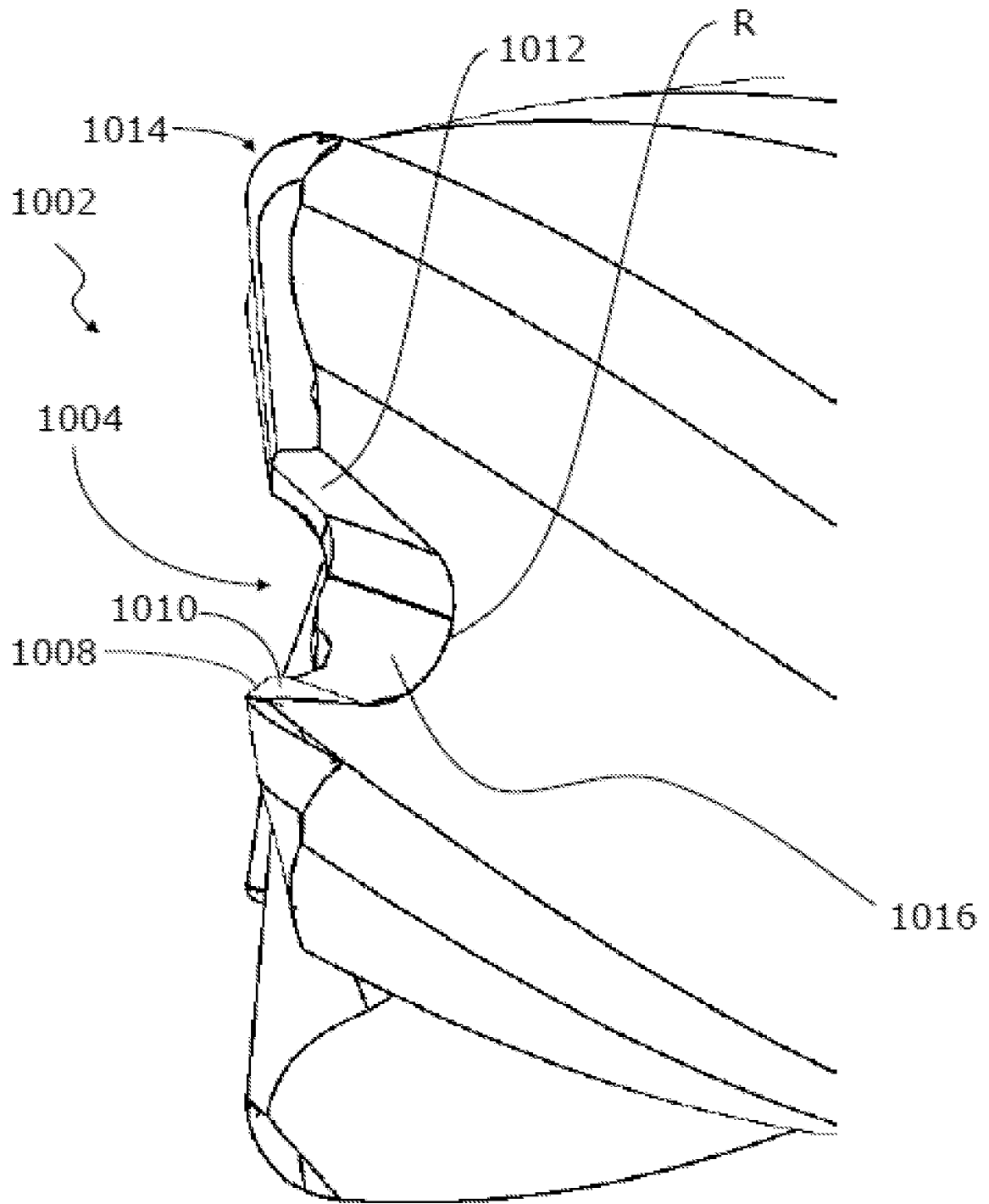


FIG. 11

8/9

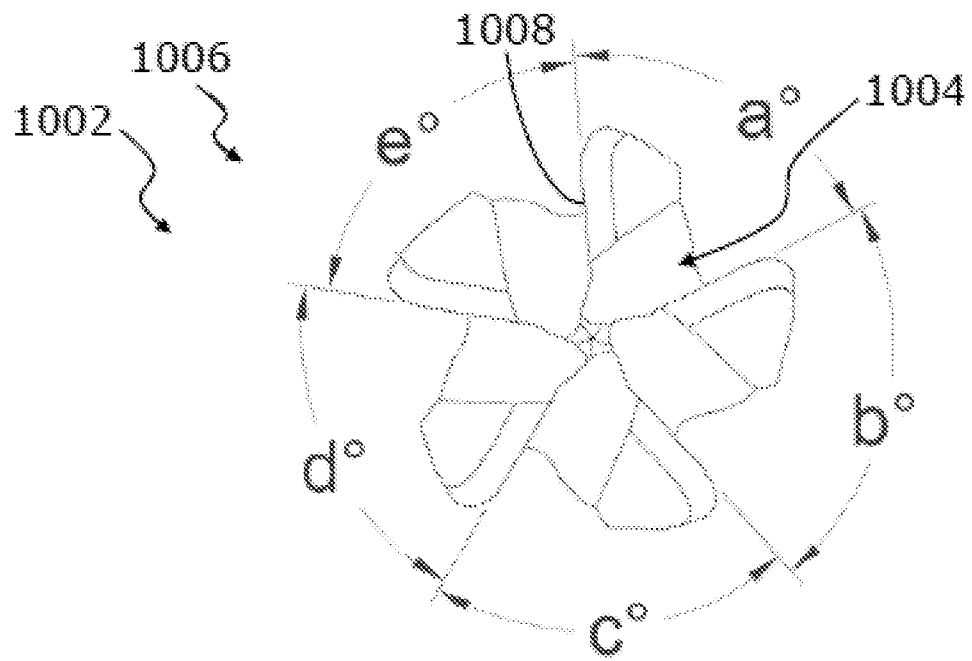


FIG. 12

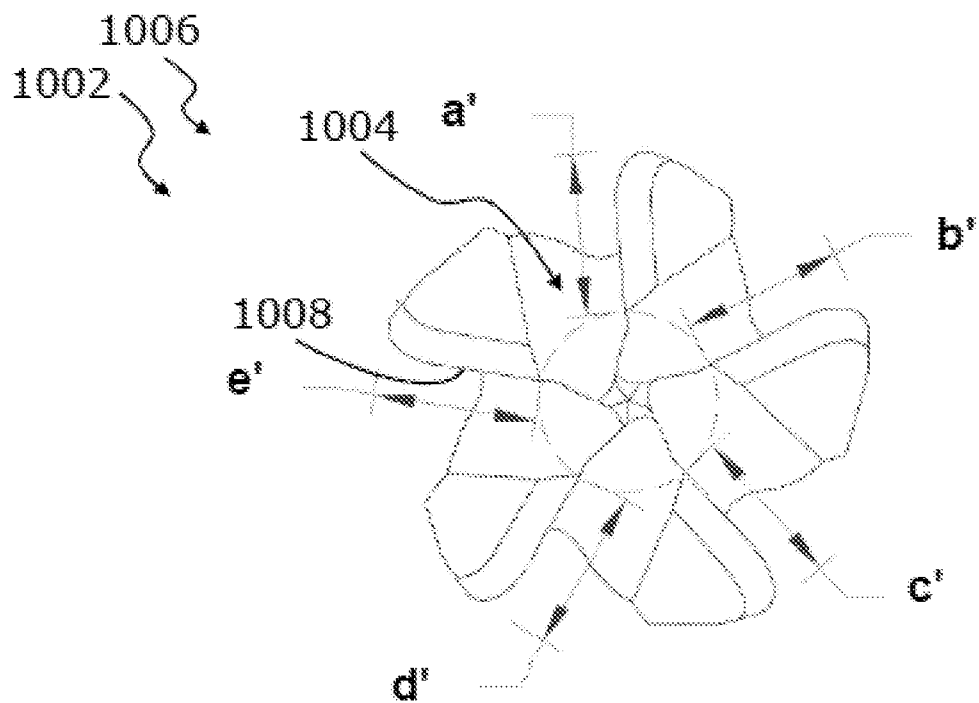


FIG. 13

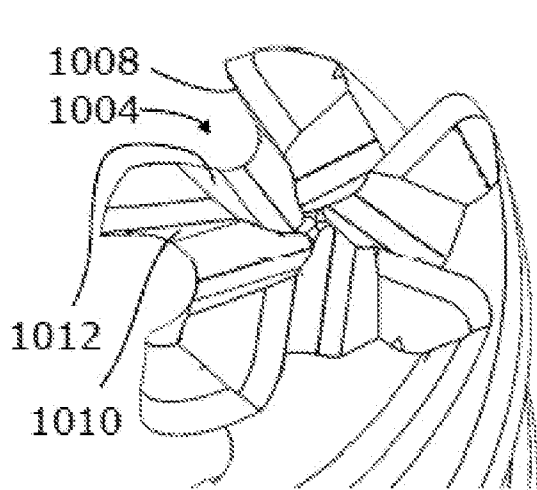


FIG. 14

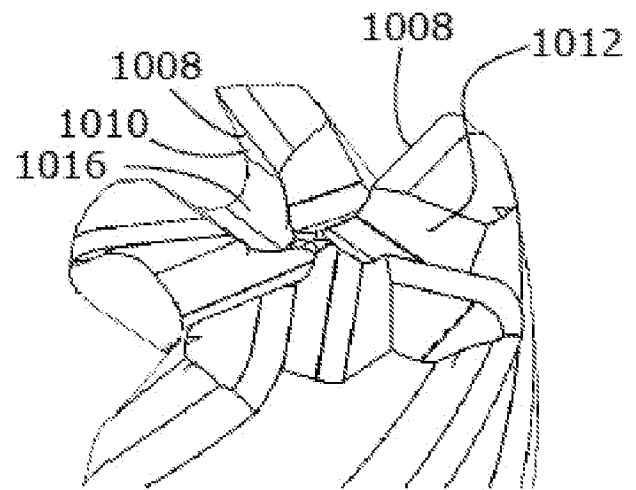


FIG. 15

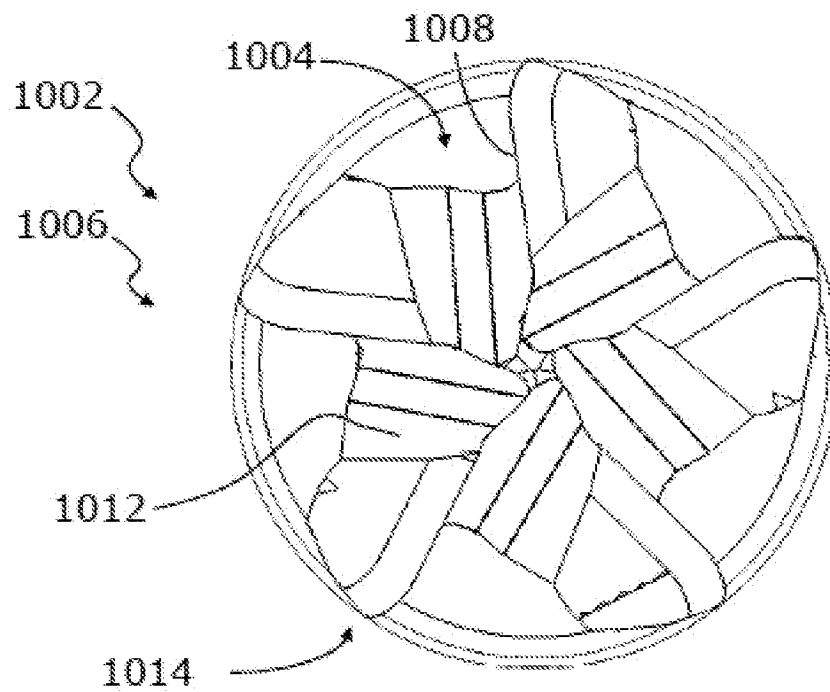


FIG. 16

INTERNATIONAL SEARCH REPORT

International application No.

PCT/US19/43682

A. CLASSIFICATION OF SUBJECT MATTER

IPC - B23B 51/02; B23C 5/00, 5/16 (2019.01)

CPC - B23B 51/02; B23C 5/00, 5/003, 5/006, 5/16

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)

See Search History document

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

See Search History document

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

See Search History document

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X --- Y --- A	US 2014/0205390 A1 (BABA, M., et al.) 24 July 2014; figure 1-3; paragraph [0189]	6, 8-9 --- 10 --- 1-5, 7, 12-20
X --- A	US 2009/0324347 A1 (KIRBY, M., et al.) 31 December 2009; figure 2-3; paragraph [0055]	6, 11 --- 1-5, 7, 12-20
Y --- A	US 2017/0028482 A1 (KENNAMETAL INC.) 2 February 2017; figure 4; paragraph [0023]	10 --- 20
A	US 2015/0147127 A1 (ISCAR, LTD.) 28 May 2015; figure 3-4; paragraph [0066-0067]	1-5, 7, 12-19
A	US 2016/0052072 A1 (KENNAMETAL INC.) 25 February 2016; figure 1-3; paragraph [0012-0014]	1-5, 7, 12-20
A	US 5,433,655 A (SHIOKAWA, T., et al.) 18 July 1995; figure 2B; column 1, lines 55-68	1-5, 7, 12-20

☐ Further documents are listed in the continuation of Box C.☐ See patent family annex.

* Special categories of cited documents:

"A" document defining the general state of the art which is not considered to be of particular relevance

"D" document cited by the applicant in the international application

"E" earlier application or patent but published on or after the international filing date

"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)

"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"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

30 September 2019 (30.09.2019)

Date of mailing of the international search report

21 OCT 2019

Name and mailing address of the ISA/US

Mail Stop PCT, Attn: ISA/US, Commissioner for Patents
P.O. Box 1450, Alexandria, Virginia 22313-1450

Facsimile No. 571-273-8300

Authorized officer

Shane Thomas

Telephone No. PCT Helpdesk: 571-272-4300