

INVESTIGATIONS OF BROACH WEDGES WEAR

Stanislaw LEGUTKO, Kazimierz Wieczorowski, Tomasz KEDZIERSKI

Poznan University of Technology, Poznan, POLAND

e.mail: stanislaw.legutko@put.poznan.pl

One of the most important problems in broaching technology is wedge wear one. The main trouble is to establish proper criterion of admissible wedge wear. Theoretical analysis of the loading of cutting wedge during broaching has been presented. Subsequent phases of broach wedges wear have been shown, on the base of authors' own investigations. The research has brought the authors to the conclusion that broach wear should be determined by other indicator thanks to which the state of the process can be easily and quickly defined. Such an indication is the condition of the surface layer being machined.

Key words: broach, broaching, wedge wear

References

- [1] Storch B., *Near edge phenomena and surface roughness monitoring after machining with one wedge*, Koszalin University of Technology, Koszalin 2006 (in polish).
- [2] Tschätsch H., *Praxis der Zerspantechnik: Verfahren, Werkzeuge, Berechnung*, Wiesbaden Vieweg 1999.
- [3] Legutko S., Kedzierski T., Wieczorowski K., *Research of the Chosen Features of the Surface Layer after Pull Broaching*, Proceedings of the 1st Jubilee Scientific Conference "Manufacturing Engineering in Time of Information Society", published by Gdansk University of Technology, Gdansk 2006, pp. 233-240, ISBN 83-88579-61-4 (in polish).