

# A novel adhesive bonding process for the next generation of wood milling tools

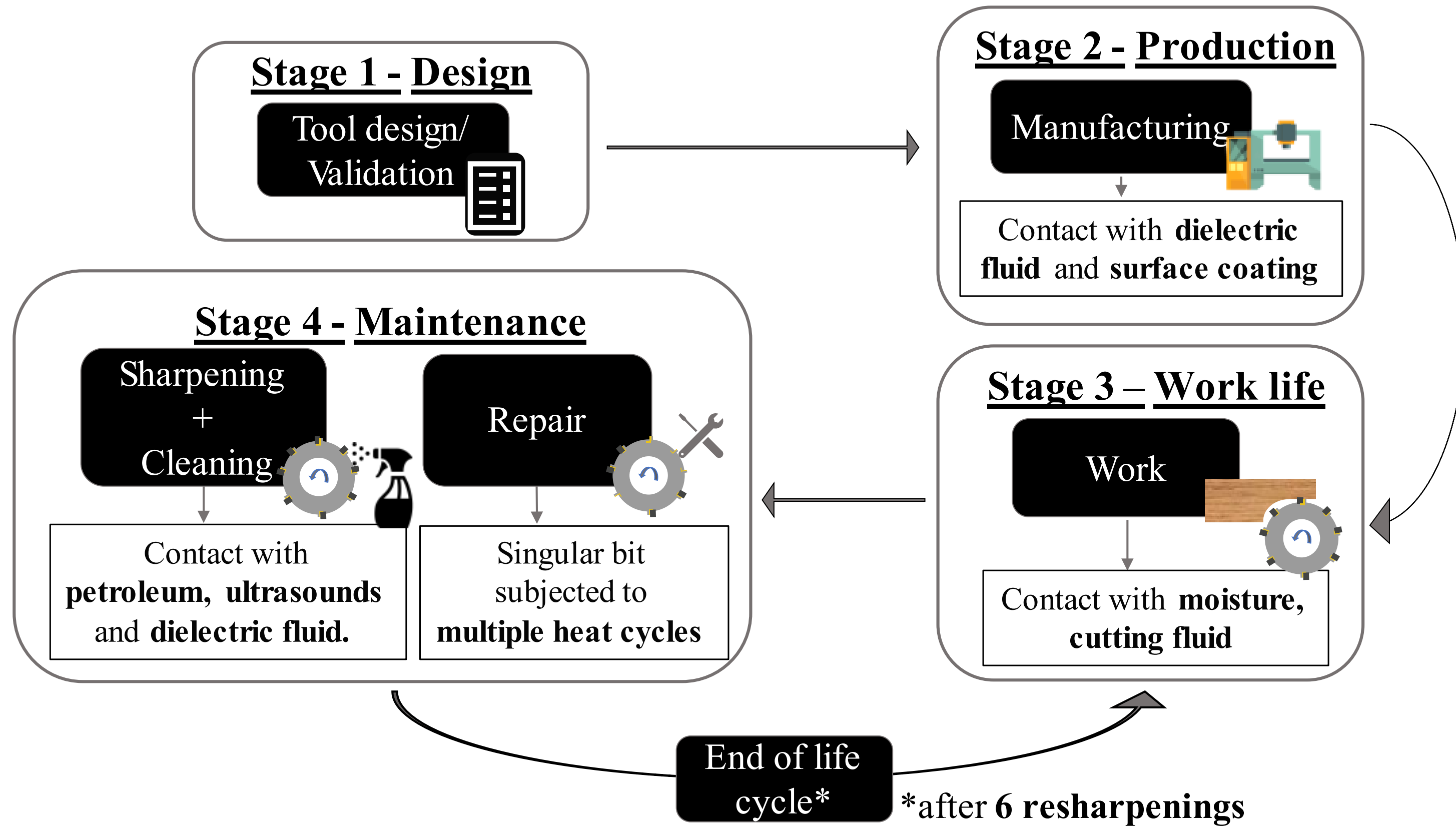
R. de Sousa, P. Gomes, D.S. Correia (INEGI, Portugal), E. Marques, R. Carbas, P. Neves, W. Afonso, L.F.M. da Silva

## Introduction

Adhesives are being introduced in the milling tool industry seeking to replace brazing and mechanical fastening when joining the cutting bits to the tool body [1]. Steel (St) and aluminum (Al) bodies were studied, due to the versatility of steel and the market's preference for lightweight tools, respectively. But the durability of these joints is still a big concern. This work aims to evaluate and characterize the effect of environmental factors associated with the tool's life cycle on the performance of these bonded joints [2].

## Experimental methodology

Several stages of the tool's life cycle can be a source of degradation, as seen in Figure 1.



**Figure 1** – Typical life cycle of a milling tool [2].

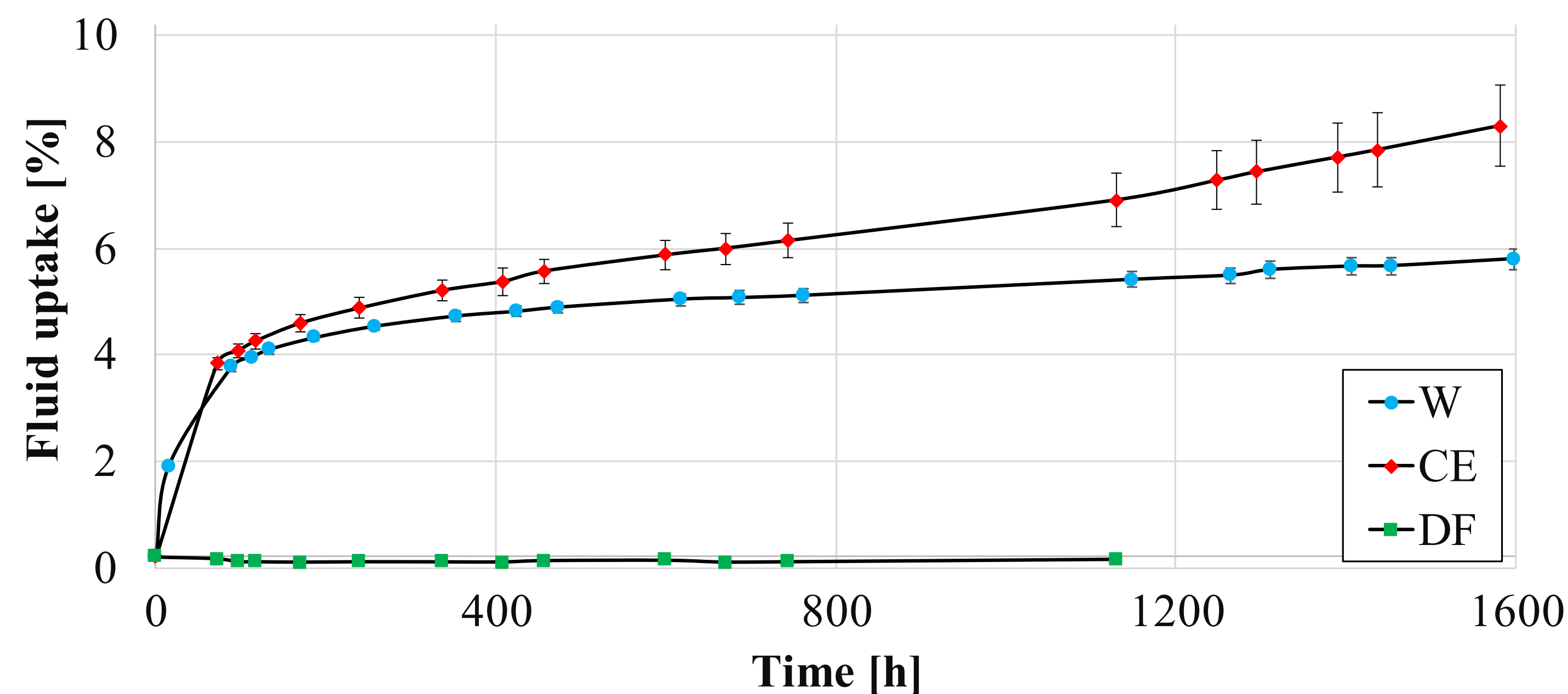
Gravimetric (Grav) and real joint shear (RJS) tests were performed to access the degree of adhesive and joint degradation in each medium, respectively. As such a testing plan, presented in Table 1, was devised to understand this issue in both continuous and cyclic ageing conditions.

**Table 1** – Ageing testing plan for each life cycle stage [2].

Stage 2		Stage 3	
Dielectric fluid (DF)	Oxidation (Oxi) Nickle-plating (NiP)	Water (W)	Cutting emulsion (CE)
Grav/RJS test (St/Al)	RJS test (St)	Grav/RJS test (St/Al)	Grav/RJS test (St/Al)
Stage 4			
Petroleum (PO)	Ultrasound (US)	Sandblast (SB)	Repair at 150°C (Rep)
RJS test (Al)	RJS test (Al)	RJS test (Al)	RJS test (St/Al)

## Experimental results

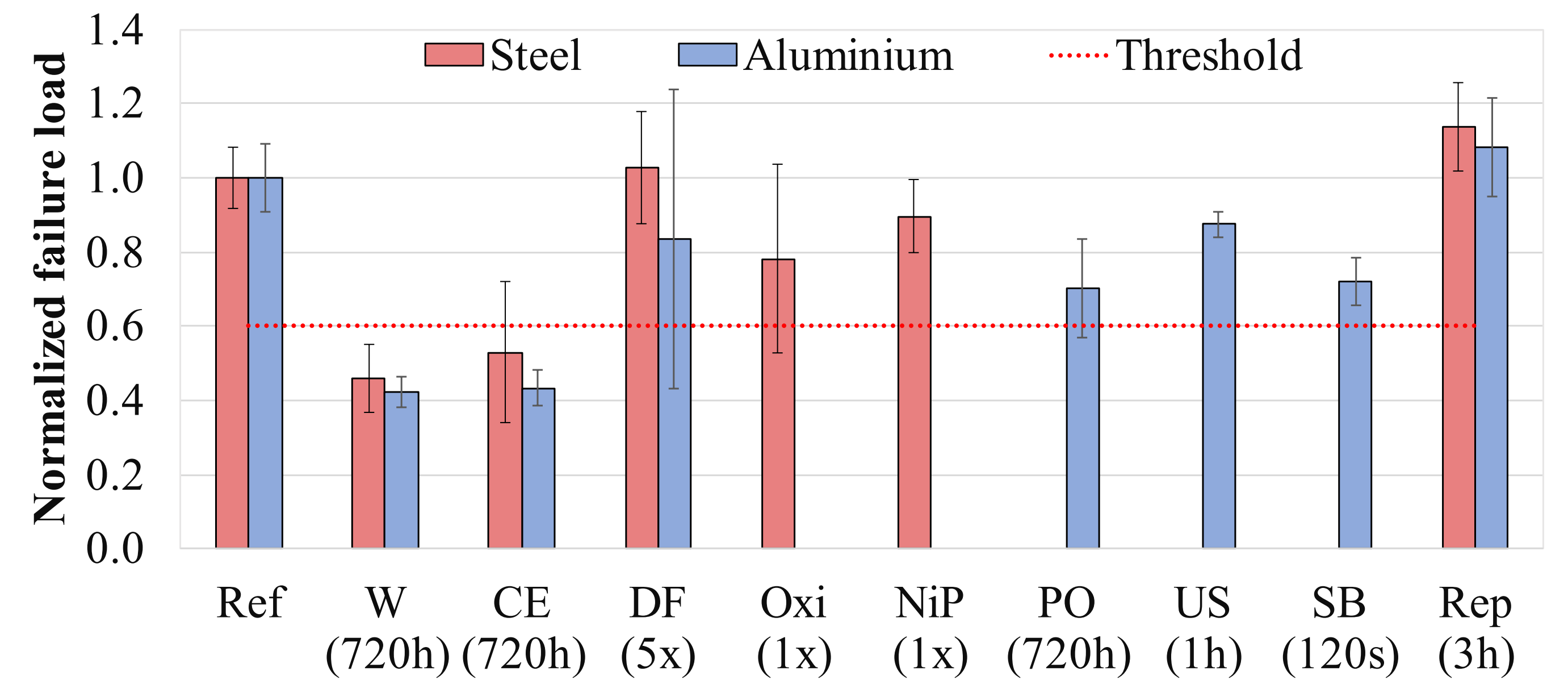
The gravimetric test results can be seen in Figure 2, for water, cutting fluid and dielectric fluid, respectively.



**Figure 2** – Experimental results for the gravimetric analysis [2].

Gravimetric analysis on water and the cutting emulsion presented similar behaviors (Dual-Fickian) having, the second, a higher uptake in the relaxation dominated stage.

The dielectric fluid was not absorbed by the adhesive proving that only the first two can damage the adhesive itself.



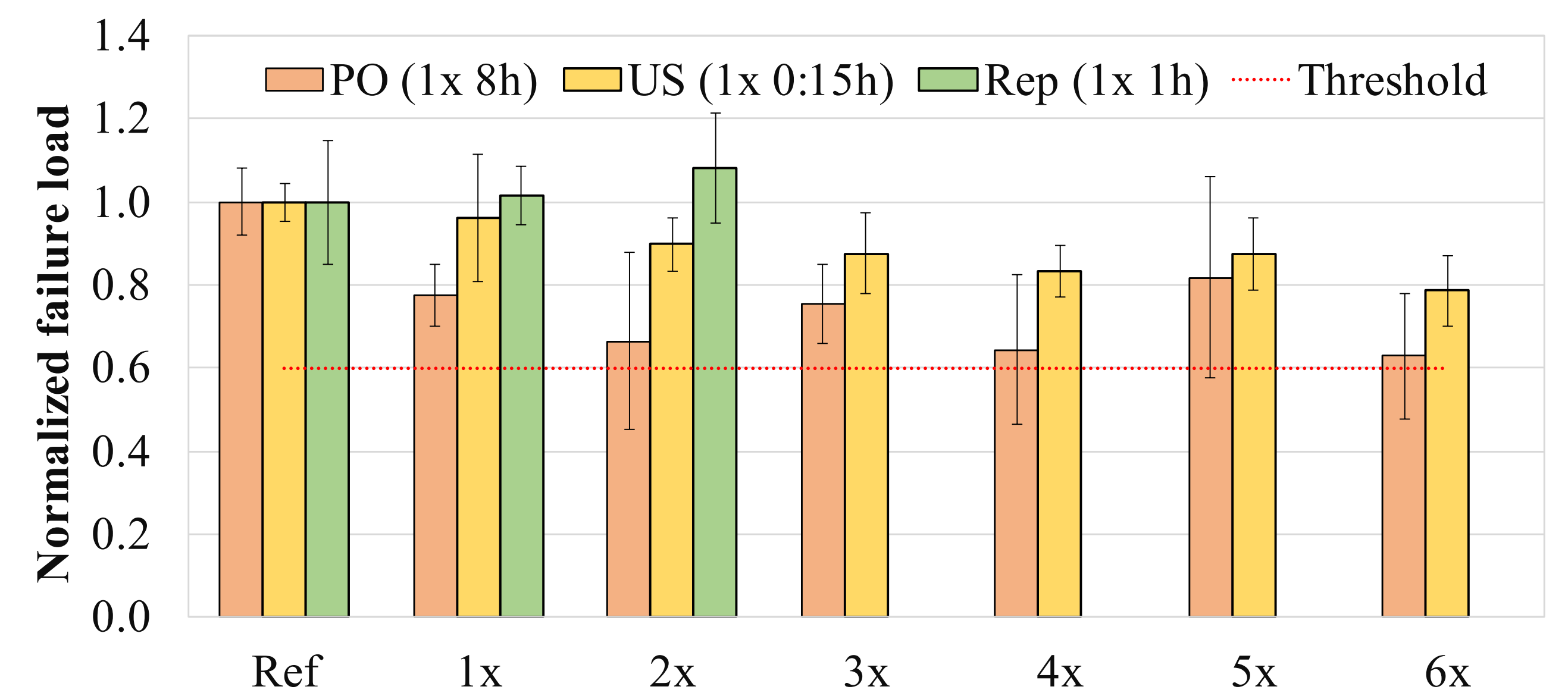
**Figure 3** – Normalized shear strength of RJS joints continuously aged [2].

The normalized continuous ageing results are presented in Figure 3, for each respective maximum exposure time chosen. The values used depend on the usual exposure time of each fluid.

A limit threshold value of 60% of the reference joint strength was set by the partner company as a safety measure.

The most severe continuous ageing appended for water-based fluids, as their strength went below the threshold value.

As depicted in Figure 4, six petroleum and ultrasound cleaning cycles, as well as 3 repair cycles were also tested.



**Figure 4** – Normalized shear strength of RJS joints cyclically aged [2].

Results showed that repairing a broken insert does not affect the strength of the undamaged bits due to thermal cycles. From the cyclic cleaning procedures, ultrasounds presented a smaller and more progressive degradation, in comparison to the petroleum fluid which did not present a clear cyclic trend.

## Conclusions

Unlike brazing, adhesives are much more susceptible to long term degradation. The most severe cases were due to water-based fluids (W/CE) both in adhesive and joint degradation. Nonetheless, although the adhesive might not be affected by other fluids (DF,...) in a real joint the interface can be degraded. Tool cleaning is recommended using ultrasounds and repair can be implemented with no real effect on the pristine inserts.

## References

- [1] Correia et al., Practical imple. and valid. of a novel process for manufacturing milling tools using adhesive bonding. *2<sup>nd</sup> International Conference on Advanced Joining Processes: Selected Contributions of AJP 2021*, 2021.
- [2] de Sousa et al., Analysis of the mechanical perform. and durability of adhesively bonded joints used in the milling industry. *Applied Sciences*, 2022.