

Table of contents

1. General information	2
2. Machining techniques	3
2.1 Manufacturing processes	3
2.2 Cutting processes	3
2.3 Material removal processes	4
2.4 Turning processes	4
3. General principles	5
3.1 Central lathe movements	5
3.2 Cutting tool geometry	6
3.3 Chips and cuttings	7
3.4 Cutting materials	8
3.5 Tool life	13
3.6 Cutting speed, rotational speed, cutting profile, shape and positional tolerance, surface finish	14
3.7 Cooling lubricants	19
4. Turning	21
4.1 Turning processes according to DIN 8589	21
4.2 Machine lathe designs	23
4.3 Machine lathe components	26
4.4 Cutting tools	30
4.5 Clamping the workpiece	33
4.6 Clamping and aligning the lathe tool	37
4.7 Centring, thread cutting, relief groove cutting, taper turning, knurling, deburring	40
4.8 General rules for work safety	50
4.9 Environmental protection/energy efficiency	51
4.10 Exercises with answers	52
5. Recommended reading	55