

LIST OF FIGURES

Figure I-1 Thermal and physical signs of overheating during machining.	1
Figure I-2 Comparison of trochoidal and conventional milling strategies.	3
Figure I-3 Schematic of trochoidal toolpath showing interaction of spindle speed (RPM), feed rate (mm/min), and stepover (mm).	4
Figure I-4 Flowchart of developing a predictive model for tool temperature in PTFE machining	6
Figure III-5 Problem Solving Systematic Diagram	17
Figure III-6 Experimental setup for thermal data acquisition: VF-2 HAAS CNC machine, PTFE workpiece in a vice, 8 mm HSS flat end mill, and FLIR thermal camera for monitoring surface temperature. Thermal data was captured and processed using FLIR Tools+ software on a connected laptop.	21
Figure III-7 CNC milling setup for trochoidal experiments (a) shows key components, including the spindle and securely mounted PTFE workpiece. (b) shows the machining process in action under defined parameters.	22
Figure III-8 Thermal measurement comparison. (a) FLIR thermal image of a heated reference block. (b) Temperature profile comparison between FLIR and thermocouple sensors, showing close agreement after initial peak, validating FLIR's reliability for dynamic monitoring.	23
Figure III-9 Experimental setup with a FLIR thermal camera mounted on the CNC machine (b) to monitor workpiece temperature during machining. Image (a) shows the defined region of interest (ROI) used to capture peak temperature for analysis.	24
Figure III-10 Minitab regression model setup interface showing the “Fit Regression Model - Model” dialog, where Avg. Temp (°C) is selected as the response and Feedrate, Spindle Speed, and Stepover as predictors for developing the prediction models.	25
Figure IV-11 Experimental procedure and data analysis process for trochoidal milling experiments.	27
Figure IV-12 Illustration of data selection from a full temperature chart. "Selected Data" excludes the initial thermal spike (~first 30%) and final deceleration phase	

(~last 5 seconds), focusing analysis on the steady-state thermal behavior during machining.	28
Figure IV-13 Average Temperature for Each Run Across Different Machining Parameters	29
Figure IV-14 Temperature peaks at 48.9 °C at 750 mm/min, then drops slightly at 1000 mm/min. A similar rise occurs at 3 mm stepover, while at 4 mm stepover, temperature changes are minimal across feed rates.	30
Figure IV-15 Effect of spindle speed on average temperature at 2, 3, and 4 mm stepover: higher spindle speeds consistently raise temperatures, showing a strong link between cutting velocity and heat generation.	31
Figure IV-16 Effect of stepover on thermal generation shows varied trends, from linear to nonlinear, indicating complex interactions between tool engagement, heat buildup, and heat dissipation in trochoidal milling.	32
Figure IV-17 Comparison between predicted temperature values from linear, polynomial, and nonlinear (enzyme-reaction) regression models and the actual validation data.	35
Figure V-18 Relationship between feed rate and average temperature shows a non-linear trend, with a peak at 750 mm/min followed by a decline at higher rates under certain spindle speeds.	36
Figure V-19 (a) Trochoidal toolpath with alternating feed (red) and non-feed (blue) movements, allowing periodic tool disengagement. (b) Frequent transitions at higher feed rates improve chip evacuation, helping reduce localized heat buildup.	37
Figure V-20 Relationship between spindle speed and average temperature at 2 mm stepover shows a strong positive correlation across all feed rates, confirming spindle speed as a key heat contributor. Error bars indicate temperature variability.	39
Figure V-21 (a) End mill rotation represents spindle speed. (b) Red-marked tool teeth engage the material each revolution. Higher spindle speeds increase engagement frequency, raising friction and energy transfer, thus elevating tool temperature.	40
Figure V-22 Interaction of stepover and spindle speed on average temperature	41

Figure V-23 Comparative graph of average temperature between Conventional and Trochoidal Milling across varying machining parameters. 44