1. INTRODUCTION

Chatter vibration is an important problem that must be solved first before any problems that occurred in machining processes. Chatter is very destructive and harmful, because it will decrease the product quality and the machining efficiency. Regenerative chatter can be occurred because of the intermittent cut on milling process are unstable and result chip load different phase. Regenerative chatter will be occurred continuously with the same time delay. Munooa et al. [1] denoted that regenerative chatter maximum caused by high amplitude vibration. Resonance occurs when the natural frequency and the frequency of passing the tooth have an integer ratio, with amplitude resonance will be increased significantly. Resonance occurred when there is a maximum frequency shifting when the others are stable and will result a bad surface product by Song et al. [2]. An innovative cutting tool geometry is developed to control maximum regenerative chatter and resonance. Helix angle which is one of geometry parts that hold an important role to mitigate maximum regenerative chatter and resonance. Variable helix angle in cutting tool create time delay variation from the contiguous flutes. Time delay variations can mitigate regenerative chatter and avoid tooth passing frequency from machining natural frequency so that resonance can be prevented in certain machining parameters, according to Wang et al.[3].

Chatter can be controlled by right parameter selections such as axial depth of cut, rotation speed, and feed rate milling. The role of that parameters are also important in machining process because there will be cutting force dynamics that cause inaccuracies in chatter fluctuation and surface product by Sonief, et al.[4] and Balasubramanym, et al.[5]. It also can limit the Material Removal Rate (MRR) in machining process and productivity decrease according to Kashyapi et al.[6]. The detection of the machining chatter can be done by spectrum analysis, which is applied to process the cutting force signal which is closely related to the machining conditions as said by Mei et al.[7]

The efforts to control machining chatter will be based on spectrum frequency analysis when the resonance occurred on each machining parameters role. Therefore, it is required to optimize machining parameter in end milling process. In this study, comparison between end mill process using normal helix and
variable helix angle cutting tool on cutting parameters and justified with surface product qualities.

2. METHODS AND MATERIALS

The experimental machining is using CNC Training Unit 3 Axis (CNC TU-3A), using Normal Helix Angle Tool (NHA) 40° and Variable Helix Angle (VHA) 40°/42° as in Figure 1. Aluminium Al-2011 work piece is set on cnc milling machine. Vibration transducer is installed right on the tool holder which is connected on computer with NI myRio Labview 2013 program to measure the vibration signals and Fast Fourier Transform (FFT). Experimental set up as in figure 2 and cutting parameter in table 1. Measurement data and spectrum analysis were taken in each cutting parameters. The justification will be done by conduct surface roughness value (Ra) test by surface roughness prober (Mitutoyo SJ-301) in every work pieces.

![Figure 1. NHA tool (a) and VHA tool (b)](image)

| Specification                          | Grade       |
|----------------------------------------|-------------|
| Rotation speed (rpm)                   | 600 ; 900 ; 1200 |
| Feed rate milling (mm/min)             | 50 ; 75 ; 100 |
| Axial depth of cut (ADOC) (mm)         | 0,6 ; 1,2 ; 1,8 |
| Normal Helix Angle (NHA) (°)           | 40          |
| Variable Helix Angle (VHA) (°)         | 40/42       |
| Diameter tool (mm)                     | 6           |

![Figure 2. Experimental setup](image)
3. RESULT AND DISCUSSION

The experimental spectrum analysis results in both milling process using normal helix angle and variable helix angle can be seen in these figures. On figure 3.a, shows the spectrum analysis result on 0.6 mm depth of cut variation with normal helix end mill (NHA) tool. In this condition, chatter was occurred in 41 Hz frequency and amplitude 0.893 x 10^{-3} rms. While in figure 4.b., shows the spectrum analysis results on 600 rpm spindle speeds variation with variable helix angle (VHA) tool, with the same frequency, the amplitude was decreased in to 0.0591 x 10^{-3} rms.

![Figure 3.a. Frequency spectrum graphic NHA under doc variation](image1)

![Figure 3.b. Frequency spectrum graphic VHA under doc variation](image2)

Figure 4.a., indicate the outcome of spectrum analysis of 600 rpm spindle speed variation for the milling tool (NHA). In this condition it is recorded that chatter take place at a certain frequency for 41 Hz with an amplitude of 0.975 x 10^{-3} rms. Whereas in Figure 4.b., indicate the outcome of spectrum analysis of 600 rpm spindle speed variation in the Variable Helix Angle (VHA) end-mill tool, with the same frequency the amplitude decreases to 0.1393 x 10^{-3} rms.

![Figure 4.a. Frequency spectrum graphic NHA under ss variation](image3)
In figure 5.a., shows the results of spectrum analysis for variation of the feed rate (fr) 75 mm / min on end-mill Normal Helix Angle (NHA) tool. In this condition it is recorded that that chatter take place at a certain frequency for 42 Hz with an amplitude of 1.015 x 10⁻³ rms. Whereas in Figure 5.b., the spectrum analysis results of the variation of the feed rate (fr) 75 mm / min on the end-mill Variable Helix Angle (VHA) tool, with the same frequency the amplitude decreases to 0.0964 x 10⁻³ rms.

Overall, all cutting parameters can be seen in tabel 2.
Table 2. Spectrum analysis in NHA and VHA Tools

| Cutting Parameter | Normal Helix Angle (NHA) | Variable Helix Angle (VHA) |
|-------------------|--------------------------|---------------------------|
| Variation         | Amplitude (rms)          | Frequency (Hz)            | Amplitude (rms) | Frequency (Hz) |
| Doc (mm)          | (x10^{-3})               |                            | (x10^{-3})      |                |
| 0.6               | 0.893                    | 41                         | 0.0591          | 41             |
| 1.2               | 2.112                    | 40                         | 0.1073          | 40             |
| 1.8               | 3.865                    | 40                         | 0.1144          | 40             |
| Ss (rpm)          |                          |                            |                |                |
| 600               | 0.975                    | 41                         | 0.1393          | 41             |
| 900               | 1.034                    | 39                         | 0.2245          | 39             |
| 1200              | 1.164                    | 42                         | 0.1197          | 42             |
| Fr (mm/ten)       |                          |                            |                |                |
| 50                | 1.351                    | 39                         | 0.0989          | 39             |
| 75                | 1.015                    | 42                         | 0.0954          | 42             |
| 100               | 1.018                    | 38                         | 0.1020          | 38             |

With spectrum analysis on the NHA tools, it shows the resonance chatter at 38–42 Hz frequency, this also shows the natural frequency of the tool. Resonance occurs when the comparison between the natural frequency and the frequency of passing the tooth have an integer ratio that appears to occur in all variations of cutting parameters. This comparison can be analysed, machining using a normal helix angle tool has the same tooth passing frequency in each flute. This makes the normal helix angle tool tend to be exposed to resonance as seen in all images (a). Whereas in machining with variable helix angle tool which has different tooth passing frequency in each contiguous flute. This makes variable helix angle able to avoid resonance by Niu et al. [8].

Comparison of the occurrence of chatter between NHA and VHA shows a significant decrease in amplitude, this caused by VHA with variable helix angle has varying pitch angle values. Variety in pitch angle causes tooth passing variations in frequency, so that the VHA device may evade maximum regenerative chatter. Likewise, the VHA tool with the pitch angle variation will cause time delay variations on tool so that the tooth passing frequency has a varying value. Therefore, these variations can prevent resonance so that the vibration displacement amplitude does not increase significantly. Although the principle said that both maximum regenerative and resonant chatter can cause an increase in vibration displacement amplitude, YUE et al.[9]. But the VHA tool will be able to prevent the maximum regenerative and resonant chatter, so the amplitude displacement is lower than the tool with NHA tool, Yusoff et al.[10]. This also justified by measuring the average surface roughness as display in table 3, with VHA tool that reduces vibration amplitude, the mean of Ra value also decreases which resulting better product quality, in accordance with Bala et al.[11].

Table 3. Surface roughness analysis in NHA and VHA Tools

| Cutting Parameter | Normal Helix Angle (NHA) | Variable Helix Angle (VHA) |
|-------------------|--------------------------|---------------------------|
| Variation         | Mean Surface Roughness (µm) | Mean Surface Roughness (µm) |
| Doc (mm)          |                          |                            |                |
| 0.6               | 1.150                    | 0.390                      |
| 1.2               | 1.558                    | 0.469                      |
| 1.8               | 1.633                    | 0.543                      |
| Ss (rpm)          |                          |                            |                |
| 600               | 0.473                    | 0.411                      |
| 900               | 0.364                    | 0.313                      |
| 1200              | 0.383                    | 0.290                      |
| Fr (mm/ten)       |                          |                            |                |
| 50                | 0.384                    | 0.368                      |
| 75                | 0.488                    | 0.440                      |
| 100               | 0.786                    | 0.555                      |
4. CONCLUSIONS

Based on the comparative spectrum chatter vibration analysis between normal helix angel (NHA) and variable helix angel end-mill tools as follows:

- Spectrum analysis is able to detect the emergence of resonance chatter.
- Spectrum analysis can assess natural frequency in the range of 38-42 Hz.
- Variable helix angel could degrade chatter than normal helix angel tool.
- The highest chatter from successive cutting parameter variations is depth of cut, spindle speed and feed rate.
- Depth of cut and spindle speed variations as chatter stability parameters.

5. REFERENCES

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