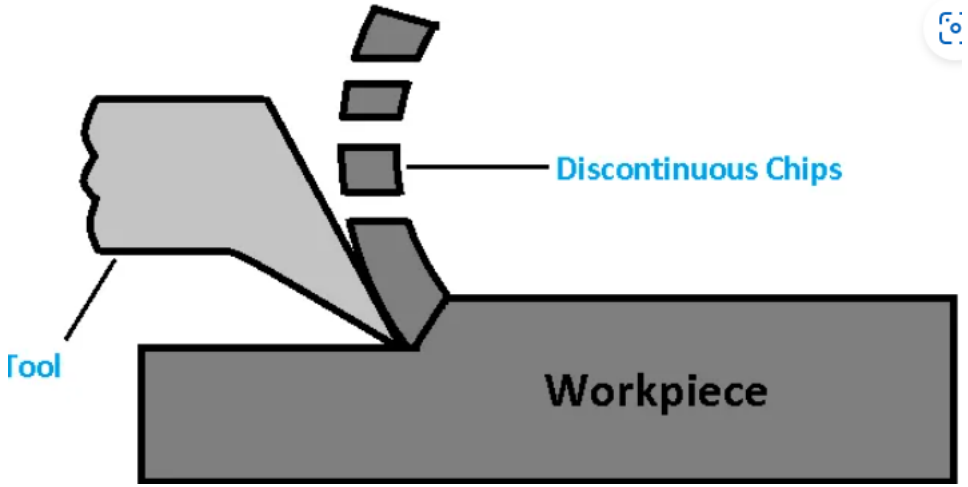
How do discontinuous chips form during machining?

1.Due to the low feed rate in the machining process.
2.The cutting speed of the machining is low.
3.High friction between chip and tool face.
4.Due to the large depth of cut.
5.The rake angle of the tool is small.



Advantages of Discontinuous Chips

1.These types of chips provide a good surface finish in brittle materials.
2.It gives a long lifespan to the tool.
3.It reduces the consumption of power.

Disadvantages of Discontinuous Chips

1.By using ductile material, it gives a poor surface finish.
2.Excessive wear and tear of equipment occur.

Why do Continuous Chips With Built Up Edges occur when you machine?

1.By using the ductile material while machining.
2.Due to the smaller rake angle of the tool.
3.The cutting speed of the tool is slow.
4.Lack of coolant may cause increases in friction between chip-tool faces.
5.The thickness of the chip is high.
6.Due to the high temperature between the workpiece and tool.
7.High rate of feed of the tool.

Advantages of Continuous Chips with BUE

1.Due to the high friction, while machining, it protects the tool from damage.
2.Also, it increases the tool lifespan.

Disadvantages of Continuous Chips with BUE

1.The drawback of this type of chip is that it provides a rough surface finish.
2.It may cause a reduction in rake angle and cutting forces.