



1 **Research of mechanical model based on characteristics of**
2 **fracture mechanics of ice cutting for scientific drilling in**
3 **polar region**

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10 **Abstract:** Scientific drilling in polar regions plays a crucial role in obtaining ice cores and using them
11 to understand climate change and to study the dynamics of the polar ice sheet and its impact on global
12 environmental changes (sea level, ocean current cycle, atmospheric circulation, etc.). Mechanical rotary
13 cutting is a widely used drilling method that drives the cutter to rotate to cut and drill through ice layers.
14 It is necessary to conduct in-depth research on the brittle fracture behavior of ice and mechanical model,
15 and analyze the factors and specific mechanisms (cutter's angle, rotation speed of the drill bit, and cutting
16 depth) affecting cutting force for the rational design of ice-core drill system, improving the efficiency of
17 ice-core drilling, and ensuring the drilling process smoothly. Therefore, in this paper, the process of ice
18 cutting was observed, the fracture mechanics characteristics of ice cutting process was analyzed, the
19 formation process of ice chips was divided into three stages, and the mathematical model for the cutting
20 force was established based on the observation results. It describes the damage conditions of ice failure
21 and points out the influencing factors and specific influencing laws on cutting force. Furthermore, the
22 cutting force generated under various experimental conditions was tested. Based on typical real-time data
23 curves of cutting force, the characteristics of cutting force were analyzed during the cutting and drilling
24 process. Based on the comparison results of the average cutting force, the influence mechanism of various
25 parameters on the cutting force is obtained. This proves the correctness of the mathematical model of the
26 cutting force and provides a theoretical reference for the calculation of cutting force during ice cutting
27 and drilling in polar regions.

28 **1. Introduction**



29 As the largest cold source on Earth, Polar ice sheets/glaciers are an important component of the Earth's
30 system related to the Earth's crust, glaciers, ice shelf, ocean, and atmosphere, it has a profound impact
31 on global changes such as climate change and sea level rise et al (Lin Yang et al., 2023). Many scientific
32 issues related to polar regions can be solved and validated by carrying out scientific drilling in ice sheets
33 and obtaining ice cores (S.H. Faria et al., 2014; P. Talalay et al., 2015; P.L. Cao et al., 2019). Mechanical
34 rotary drills have been widely used in the field of polar ice core drilling (Ueda and Garfield, 1968, 1969;
35 Gundestrup et al., 1984; Kudryashov et al., 1994; Stanford, 1992; Wumkes, 1994; Fujii et al., 1999;
36 Takahashi et al., 2002; Johnsen et al., 2007; Shturmakov et al., 2007). The process of ice core drilling
37 mainly consists of three steps: Cutting and drilling of the ice sheet, removal and transport of the ice chips
38 generated at the hole bottom, and the collection of ice core and chips precipitation (Litvinenko VS and
39 Nikolay I Vasiliev et al., 2014). These three steps are interrelated, and all of them have significant effects
40 on the process of drilling. The cutting and drilling of the ice sheet generate a cutting force, which not
41 only affects the selection of the motor system of the drill but also the design of the anti-torsion system,
42 and even determines the success or failure of the cutting and drilling of the ice sheet. By conducting in-
43 depth research on the fracture mechanics characteristics of solid ice, establishing a mechanical model for
44 ice cutting, and determining the factors and specific mechanisms affecting cutting force, it can contribute
45 to the rational design of the drilling tool system, the improvement of drilling efficiency, and ensure the
46 smooth progress of drilling.

47 During ice core drilling, ice cutting is periodically carried out. At first, the moving cutters cut into the
48 ice and compress it. When the level of stress near the edge of the cutter exceeds the cutting point, a crack
49 is formed in the direction from the edge to the surface. This means that the horizontal force of cutting,
50 called P_x , creates a repeated series of breaks, and its value is considered to be the mean force over the
51 cutting length. Griffith (1920) assumed that when the energy of elastic strain exceeds the surface energy,
52 the existing micro-crack starts to extend like an avalanche, and the materials break. Mellor and Sellman
53 (1976) suggested that cutting force P_x can be calculated by using specific energy E_s (N/m^2), which is
54 the energy consumed per unit of cutting volume:

$$55 \quad P_x = bhE_s \quad (1)$$

56 where b is the width of the cutter; h is the depth of cut.



57 Using the formula (1) to calculate cutting force is difficult because specific energy is a vague concept.
58 The formula ignores the influence of the structure of the cutter on the cutting force and lacks a certain
59 degree of practicality. Due to the difficulty of conducting strict theoretical methods for the design of
60 rock-cutting machines, many of the same experimental methods were developed by Mellor (1981).
61 Maeno (1988) assumed that in any deformation process caused by compression, tension, bending, or
62 cutting, the mechanics of ice failure are determined by the processes of inter/intragrain sliding. Taking
63 the ideal monocrystal of ice, the theoretical stress needed for the formation of sliding zones is near 100
64 MPa, but for real ice, it does not exceed 0.1– 0.5 MPa (Lavrov, 1969). The contradiction is explained by
65 the disposition theory. According to this theory, the deformation of the ice is determined by the defects
66 which already exist in the ice crystal. The internal defects gradually expand under the action of external
67 forces, the ice destruction occurs.

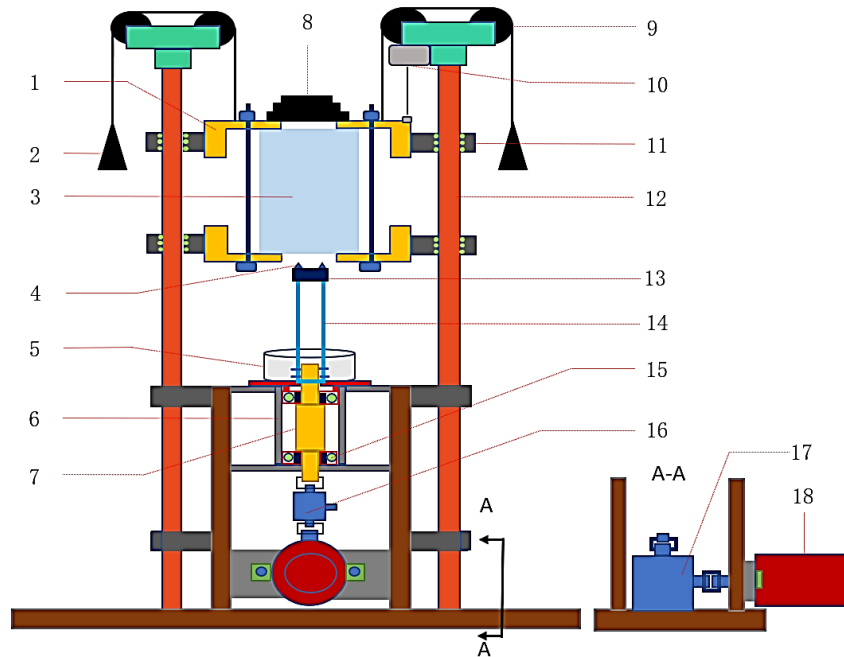
68 Research about the calculation of cutting resistance of soil and sand is abundant, however, most of
69 which are empirical formulas based on an experimental basis (Jiang Pengnian, 1982). Due to the non-
70 uniformity, hard brittle, and the factors that affect cutting resistance are complex, most studies on solid
71 ice are conducted to investigate the influence of a certain variable on cutting resistance (Chiaia, 2008; S.
72 Hell et al., 2014; A. Chao Correias et al., 2022). The in-depth study of the cutting properties of solid ice
73 was rarely reported.

74 In this paper, images of the cutting and drilling process of the ice under various experimental
75 conditions were captured, the fracture mechanics characteristics of the ice cutting process were analyzed,
76 and the formation process of ice chips was clear and divided into three stages. Based on the result, a
77 mechanics and mathematical model of ice cutting was built, and the influencing factors and specific
78 influencing laws on cutting force were analyzed. Finally, the influencing factors and laws were verified
79 through experimental tests. Which provides a theoretical reference for the calculation of cutting force
80 during ice cutting and drilling.

81 **2. Observation of ice fissure propagation in the process of ice cutting for ice-core drilling**

82 **2.1. Test stand design for study on ice cutting process**

83 To observe the cutting and drilling process of the ice under various experimental conditions, an ice
84 cutting and drilling simulation test stand has been designed (Fig. 1).



85

86 **Figure 1.** Schematic diagram of the experimental platform: 1-ice box; 2-balance weight 1; 3-ice block; 4-cutter; 5-
87 ice chips collector; 6-cup set; 7-stepped shaft; 8-dead weight; 9-fixed pulley; 10-draw-wire displacement sensor;
88 11-slider; 12- slide rail; 13-drill bit; 14- drill pipe; 15- bearing; 16-torque sensor; 17- directional converter; 18-
89 servo motor

90 To ensure the ice cutting and drilling proceed smoothly and the WOB is constant during the drilling
91 process, the drilling direction is inverted upward. Therefore, the ice chips generated in the drilling process
92 directly fall into the ice chips collector due to gravity, there will be no adhesion or blockage on the drill
93 bit. During the experimental process, the ice block and ice box can slide nearly frictionless as they are
94 connected to two parallel slide rails through four sliders, and the slider is equipped with rolling balls
95 inside to ensure that the slider slides almost frictionless on the slide rail. So, during the drilling process,
96 constant drilling pressure can be ensured, and multiple drilling pressure tests can be achieved by
97 increasing or decreasing balance weight and dead weight. The drill pipe, drill bit, and cutters are driven
98 to rotate by the servo motor system, and its rotation speed can be adjusted arbitrarily between 0-1000rpm.
99 In this way, the adjustment of the rotation speed of the drill bit is achieved. The cutter equipped in the
100 experimental test stand can be replaced arbitrarily according to the experimental requirements, therefore,
101 it is possible to conduct cutting and drilling tests on cutters with various structures.



102 During the experiment, the torque generated by driving the rotation of drill pipes, step shafts, and other
103 components, as well as the cutting torque generated by ice cutting is measured by the torque sensor.
104 Before conducting the cutting and drilling experiment, adjust the rotation speed of the drill bit to the
105 rotation speed for the next experiment, and let the drill bit and other components blank run. After the
106 torque measured by the torque sensor stabilizes, the torque is recorded as T_1 . Next, perform cutting and
107 drilling. After the cutting and drilling process stabilizes, the recording of cutting torque begins. after the
108 drilling process, the average cutting torque during this period is recorded as T_2 . So, the torque for ice
109 blocks cutting T_c can be calculated according to the following formula (2).

$$110 \quad T_c = T_2 - T_1 \quad (2)$$

111 The drilling depth and time are measured by the Draw-wire displacement sensor. The formation
112 process of ice chips is captured by a high-speed camera.

113 2.2. Test stand building and observation of ice fissure propagation during ice-core drilling testing

114 Based on the above working principle, the ice core drilling test stand has been established (Fig. 2).



115
116 **Figure 2.** Test stand: A-light source; B-high speed camera; C-image display computer; D-draw-wire
117 displacement sensor; E-drill bit; F-counterweight block; G-drill bit shoe; H-cutter

118 The specific parameters of the main equipment in the test stand are shown in Table 1.



119

Table 1. Main parameters of equipment

equipment and sensor	Model	Main parameters
		Drive voltage: 130-220VAC
Driver	3DM2080-DSP	Pulse mode: Mono pulse
		Adjustment range: 0-1000rpm
Servo motor system	Motor 130BYG350D	Maximum output torque: 60N.M
		Step angle: 1.2°
		Rated voltage and current: 220V and 8.5A
	Pulse generator CS10-3	Output mode: Steering + pulse
		Adjustment range: 0-1000rpm
		Output signal voltage: 5V; Power range:9-30V
Torque sensor	LLBLS-I	Measuring range: 60N.M; Overall accuracy:0.3%
		Maximum speed: 6000rpm
Draw-wire displacement sensor	MPS-M	Measuring distance:0-1500mm
		Resolving power:0.01mm;
		Pulling force of stay wire:4N
Slide rail and slider system	Ø50; SK50	Friction coefficient: 0.0010-0.0015
		Technology: CMOS active pixel
		Resolution: 2048×1536
High-speed camera	Ispeed-7	Frames per second: 1000000fps
		Shutter: 1us
		Lens options: F mount/G mount/C mount

120 Before the experiment, the cutters (Fig.2.H) made from tool steel (W18Cr4V) shall be installed on the
 121 drill bit (Fig.2.E) through bolts and pins (Fig.2.H) that also serve as the shoes with adjustable height. The
 122 height of the bolts is lower than the height of the cutter’s tip when the ice block slides into contact with
 123 the shoes, the cutters have been cut into the ice block at the designed depth. Thus, the cutting and drilling
 124 at the designed cutting depth is realized and the cutting depth has been accurately controlled.

125 Aiming the high-speed camera (Fig.2.B) at the cutting edge of the cutter, adjusting the frame number
 126 of the high-speed camera to 100,000, meanwhile, supplementing the light on the object with the light
 127 source (Fig.2.A), until the image displayed in the computer (Fig.2.C) is clear. After the experiment, the
 128 images of the formation process of ice chips are captured and saved in a high-speed camera. The
 129 observation experiment of the cutting and drilling process is conducted under various experimental
 130 conditions (multiple cutter angles, cutting depths, and rotation speed of drill bit). The specific parameters
 131 of experimental conditions are shown in Table 2. The cutters tested in the experiment are shown in Fig.

132 3.



133

Table 2. The specific parameters of experimental conditions

Structure of cutter						
Width (mm)	Rake angle (°)	Relief angle (°)	Cutting depth (mm)	Rotation speed (rpm)	Ice sample dimension (mm)	Ice core diameter (mm)
	20	5	1	50		
25	30	10	2	100	~250×250×450	60
	40	15	3	150		

134



135

136 **Figure 3.** Multi-group structure cutters

137

The ice blocks used in this experiment are frozen by an ice-making machine (Fig.4), which can
 138 produce transparent ice samples without bubbles. Then, we divided these blocks into experimental ice
 139 blocks with uniform dimensions (Fig.5) of ~250×250×450 mm. and all tests were carried out in the
 140 refrigerated container with a constant temperature of -15°C.



141

142 **Figure 4.** Ice-making machine



Figure 5. Experimental ice samples

143

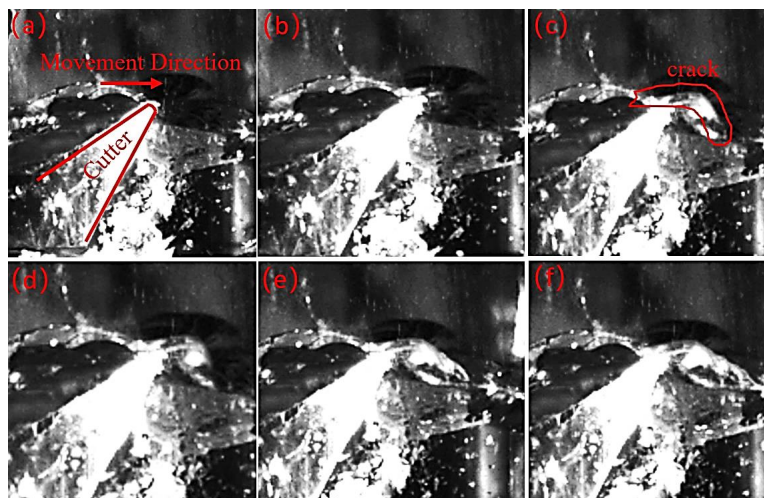
3. Analysis of characteristics of ice fracture mechanics in the process of ice cutting

144

Under various experimental conditions, the ice cutting process is similar. It is preliminarily observed
 145 after the mechanical testing of ice under a special experimental condition (rake angle is 30°, relief angle



146 is 25°, cutting depth is 2mm and the rotation speed of the drill bit is 100 rpm). The actual ice-cutting
147 process captured by a high-speed camera is shown in Fig. 6.



148
149 **Figure 6.** Cutting process captured by high-speed video camera

150 In the cutting process, the cutting of the ice is constantly repeated, the main damaged form of ice is a
151 brittle fracture, the chips show wedge block, but the wedge itself does not significantly deform, and
152 wedge-shaped ice chips with different particle sizes are constantly formed. The formation process of a
153 single large particle of ice chips can be divided into three stages. In the first stage, the cutter invades the
154 ice, and the ice is compressed by the rake and relief surfaces of the cutter, resulting in ice crushing and
155 smaller ice chip formation (Fig. 6. a, b). In the second stage, with the rotation of the drill bit, cracks
156 appeared in the ice, and the cracks began to expand along a direction that approximately presented an
157 angle of 45° with the horizontal direction (Fig. 6. c, d). However, there were no gaps or separations
158 between the ice and cutters on both sides of the cracks. In the third stage, the cutter moved forward, the
159 crack expanded to form ice chips with large particle size that slid forward, and finally detached from the
160 ice. At the same time, ice chips with small particle sizes were also generated on the sliding surface (Fig.
161 6. e, f).

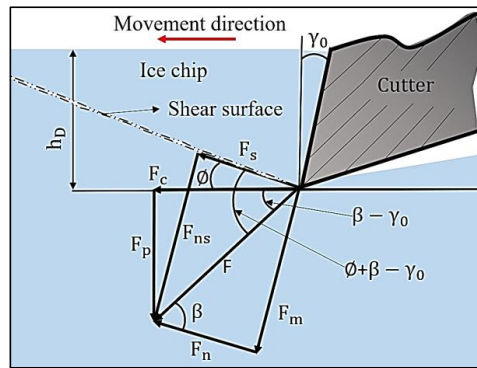
162 **4. Study on a mechanical model of ice cutting process**

163 **4.1. Mechanical model building based on the characteristics of ice fracture mechanics**

164 According to the observation results of the ice cutting, it can be considered that the damage of the ice is
165 the result of shear slip failure caused by the compression effect of the cutter. In this process, the force



166 exerted on the ice chips mainly includes the squeezing force F_n towards the ice, and along the normal
 167 direction of the cutter's rake face. The frictional force F_m exerted by the cutter when the ice chips flow
 168 out; At the same time, the shear surface of the ice will also be subjected to normal pressure F_{ns} and
 169 shear force F_s . Before the cutting of the ice, these two pairs of forces are in equilibrium. The
 170 relationships between these forces are analyzed in front of the cutting edge (Fig. 7).



171
 172 **Figure 7.** Relationship between force and angle

173 Where F is the combined force of F_m and F_n , ϕ is the shear angle, β (Friction angle) is the angle
 174 between F_n and F , γ_0 is the rake angle of the cutter, F_p is the component force perpendicular to the
 175 movement direction of the cutter, which is applied to the cutter and mainly provided by the weight on
 176 drill bit during the ice layer cutting and drilling, causing the cutter to cut into the ice to a certain depth.
 177 Where F_c is the component force acting on the ice layer, and during the ice layer cutting and drilling
 178 process, this force is mainly provided by the motor, which is called the cutting force. h_D is the cutting
 179 thickness.

180 If the cutting width is represented by b_D , The cutting width represents the width of the annular gap
 181 between the ice core and the hole wall in the process of ice drilling (cutting width, width of the cutter),
 182 The area of the nominal cross-section of the cutting layer is represented by A_D ($A_D = h_D b_D$). The area
 183 of shear surface is represented by A_s ($A_s = A_D / \sin\phi$), the shear stress on the shear plane is represented
 184 by τ , then

185
$$F_s = \tau A_s = \frac{\tau A_D}{\sin\phi} \quad (3)$$

186 According to Fig. 7, it can be concluded that:

187
$$F_s = F \cos(\phi + \beta - \gamma_0) \quad (4)$$



188 According to the relationship between various forces, it can be concluded that:

$$189 \quad F = \frac{F_s}{\cos(\theta + \beta - \gamma_0)} = \frac{\tau A_D}{\sin\theta \cos(\theta + \beta - \gamma_0)} \quad (5)$$

$$190 \quad F_p = F \sin(\beta - \gamma_0) = \frac{\tau A_D \sin(\beta - \gamma_0)}{\sin\theta \cos(\theta + \beta - \gamma_0)} \quad (6)$$

$$191 \quad F_c = F \cos(\beta - \gamma_0) = \frac{\tau A_D \cos(\beta - \gamma_0)}{\sin\theta \cos(\theta + \beta - \gamma_0)} \quad (7)$$

192 4.2. Analysis of factors influencing cutting forces via the mechanical model

193 According to Fig. 7, there is no shear stress in the plane perpendicular to the combined force F, so the
194 main stress is completely determined by the F. The material is in the state of plane stress, and the included
195 angle between the direction of the maximum shear stress and the direction of the maximum principal
196 stress is 45°, the included angle between the maximum principal stress and the F is 45°, then there is:

$$197 \quad \theta + \beta - \gamma_0 = \frac{\pi}{4} \quad (8)$$

198 So:

$$199 \quad \theta = \frac{\pi}{4} - \beta + \gamma_0 \quad (9)$$

200 The shear angle θ is affected by the rake angle of the cutter γ_0 and friction angle β . As the rake angle
201 of the cutter γ_0 increases, the shear angle θ increases; as the friction angle β increases, θ decreases.

202 The area of the nominal cross-section of the cutting layer is represented by A_D ($A_D = h_D b_D$), The
203 area of the shear surface is represented by A_s ($A_s = A_D / \sin\theta$), the shear stress on the shear plane is
204 represented by τ , then, according to equation (5) and the relationship between the nominal cross-section
205 and the shear plane, it can be obtained that:

$$206 \quad F_c = \frac{\tau A_D \cos(\beta - \gamma_0)}{\sin\theta \cos(\theta + \beta - \gamma_0)} \quad (10)$$

207 When the ice is about to break, the shear stress on the shear plane reaches its maximum value. This
208 value is determined by the properties of the ice and will not change as the drilling conditions. Therefore,
209 the cutting force is influenced by the cutting width of the cutter and the cutting depth. The cutting force
210 shows a linear increasing trend with the increase of the cutting width and the cutting depth. In addition,
211 the cutting force is also affected by the shear angle θ , friction angle β , and cutter's rake angle γ_0 . The
212 friction angle β is a certain value as the properties of the ice and cutter's material. The shear angle θ is
213 determined by the friction angle and the cutter's rake angle as shown in formula (9). Substituting equation
214 (9) into (10) and solving for the combined cutting force F_c , the following equation can be given:



215
$$F_c = \frac{\tau h_D b_D \cos(\beta - \gamma_0)}{\sin(\frac{\pi}{4} - \beta + \gamma_0) \cos(\frac{\pi}{4})} \quad (11)$$

216 After simplifying the above equation, it can be obtained that:

217
$$F_c = \frac{2\tau h_D b_D}{1 - \tan(\beta - \gamma_0)} \quad (12)$$

218 It can be seen from the formula (12) that the factors affecting the cutting force mainly consist of four
219 sides: The first aspect, it related to the shear strength of the ice, with the increase of shear strength, the
220 cutting force increases gradually. The second aspect, it influenced by the cutting depth, with the increase
221 of cutting depth, the cutting force increases gradually. The third aspect, it affected by the cutting width,
222 with the increase of cutting width, the cutting force increases gradually. Finally, the rake angle of the
223 cutter also has an impact on the cutting force. Formula (12) shows that: within the $\beta - \gamma_0 \leq \frac{\pi}{2}$ range,
224 as the rake angle of the cutter γ_0 increases, $\beta - \gamma_0$ gradually decreases, and the $\tan(\beta - \gamma_0)$
225 decreases, $1 - \tan(\beta - \gamma_0)$ increases, F_c decreases.

226 **5. Test on the characteristics of cutting force and its influencing factors for verifying the**
227 **mechanical model**

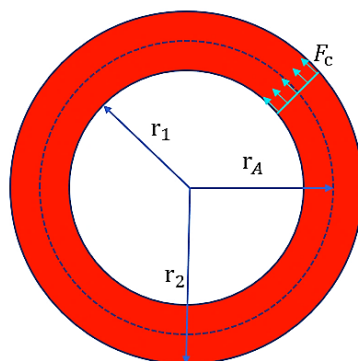
228 **5.1 Analysis of the characteristics of cutting force**

229 To verify the theoretical analysis results of the factors affecting cutting force, the cutting torque collected
230 by the torque sensor under various cutter angles, rotation speed of the drill bit, and cutting depth
231 conditions were measured.

232 After the experiment, the torque for ice cutting and drilling can be obtained through formula (2). The
233 schematic diagram of the torque and cutting force generated during the ice cutting drilling process is
234 shown in Figure 8, The relationship between the cutting force F_c generated by cutting the area of the
235 circular ring and the torque T_c measured by the torque sensor is as follow.

236
$$T_c = F_c r_A \quad (13)$$

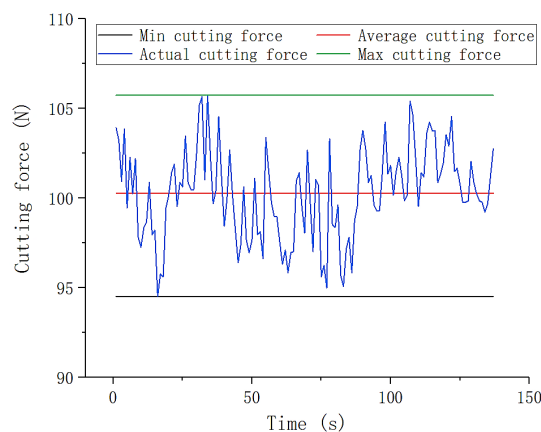
237 Where r_A is the average radius of the circular ring.



238

239 **Figure 8.** The schematic diagram of the torque and cutting force

240 By processing the data collected by the torque sensor, the cutting force generated by one cutter during
241 the ice block cutting and drilling is obtained. The typical cutting force trace generated during the ice
242 cutting process is shown in Fig. 9.



243

244 **Figure 9.** Typical cutting force trace (Cutting depth is 1mm; Rotation speed of drill bit is 50rpm; Rake angle is 30°;
245 Relief angle is 5°)

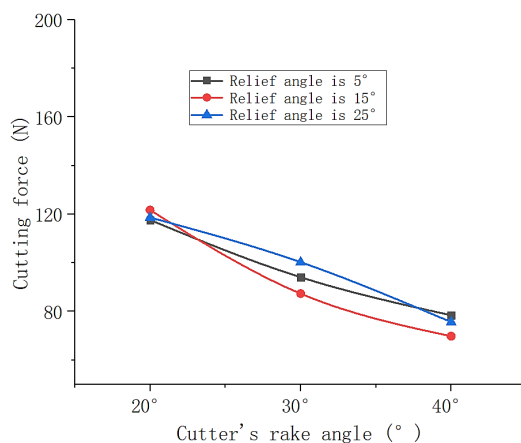
246 During the ice core drilling, all cutting force traces fluctuate at a certain frequency within a certain
247 range, and the fluctuation consists primarily of two frequencies. The higher frequency is related to the
248 resolution of the sensor. The sensor outputs data at a certain interval during the recording process, the
249 output data is not continuous, resulting in fluctuations in the trace. The lower frequency is related to the
250 formation of large particle ice chips and should vary with the rotation speed of the cutter. As the cutter
251 is pressed into the ice, the cutting force begins to rise. When the cutting force reaches the point required



252 for the ice layer to break, the ice layer undergoes shear-slip deformation, and ice chips form. Then, before
253 the cycle repeats, the force suddenly decreases, the cutting force fluctuates, and the drill speed accelerates,
254 the frequency of this cutting force fluctuation increases.

255 5.2. Test of the factors influencing cutting force

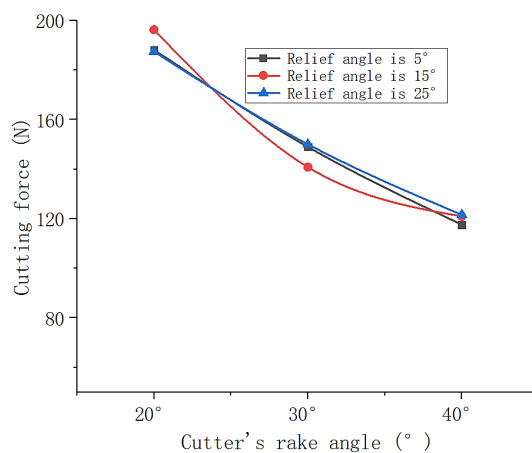
256 After the cutting and drilling experiments, the average cutting force was obtained under each
257 experimental condition. Plots of the average cutting force versus the cutter's rake angle are shown in Fig.
258 10.



259

260

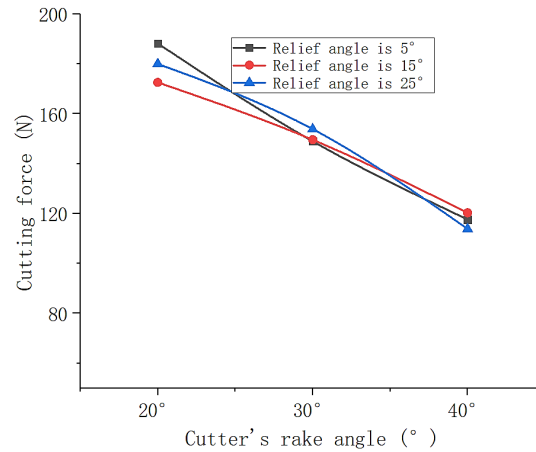
(a) The cutting depth is 1 mm, and the rotation speed of the drill bit is 100rpm



261

262

(b) The cutting depth is 2 mm, and the rotation speed of the drill bit is 100rpm



263

264

(c) The cutting depth is 2 mm, and the rotation speed of the drill bit is 50rpm

265

Figure 10. Cutting force versus cutter's rake angle

266

As shown in Fig. 10, when the cutting depth is 2mm, the rotation speed of the drill bit is 100 rpm, and

267

the rake angle of the cutter is 20 °, the cutting force reaches the maximum value of 196.3451N. When

268

the cutting depth is 1mm, the rotation speed of the drill bit is 100 rpm, and the rake angle of the cutter is

269

40 °, the cutting force reaches the minimum value of 69.83529N. The cutting force varies within this

270

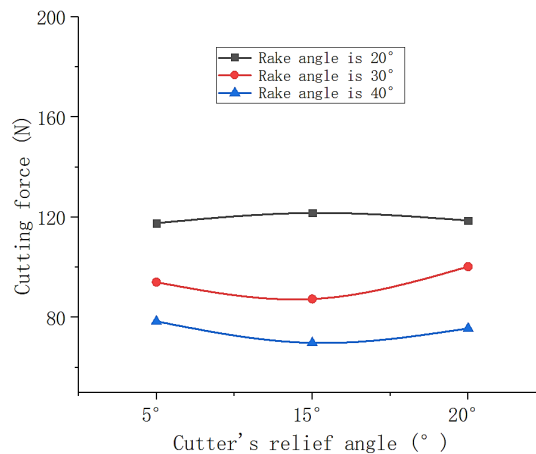
range under the other experimental conditions. That is, under various cutting depths and drill speed

271

conditions, the cutting force gradually decreases with the increase of the cutter's rake angle.

272

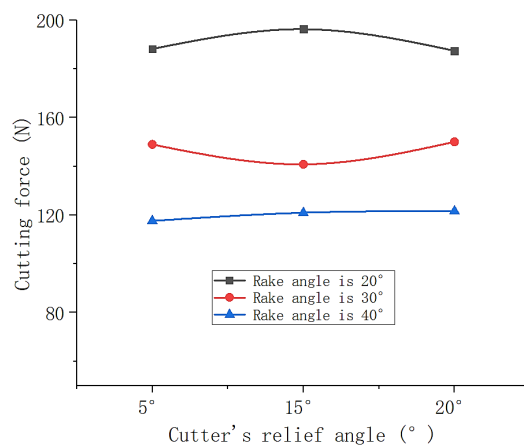
Plots of the average cutting force versus the cutter's relief angle are shown in Fig. 11.



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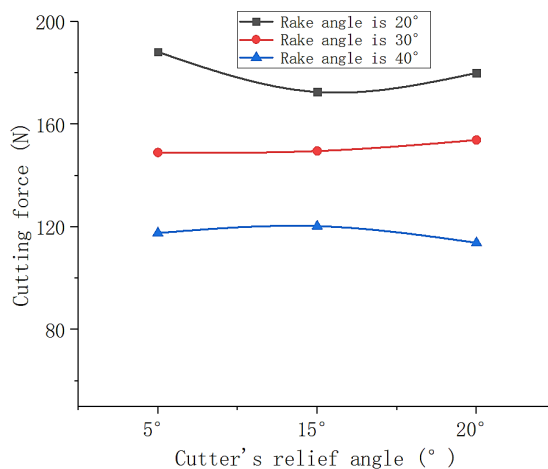
(a) The cutting depth is 1 mm, and the rotation speed of the drill bit is 100rpm



275

276

(b) The cutting depth is 2 mm, and the rotation speed of the drill bit is 100rpm



277

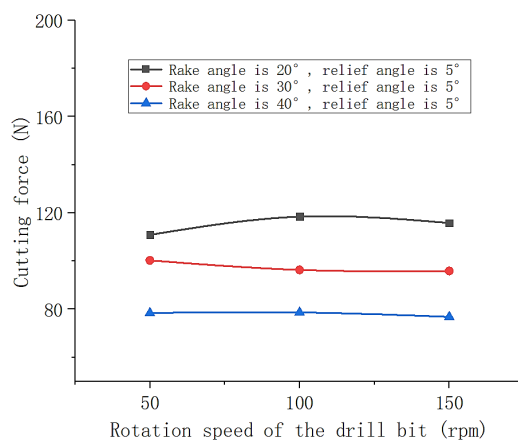
278

(c) The cutting depth is 2 mm, and the rotation speed of the drill bit is 50rpm

279 **Figure 11.** Cutting force versus cutter's relief angle

280 Under various experimental conditions, the relief angle of the cutter changes, and the cutting force
281 only changes slightly. Moreover, with the change of the relief angle of the cutter, the cutting force does
282 not show a clear and consistent change pattern. Therefore, it can be inferred that the relief angle of the
283 cutter has no clear effect on the cutting force.

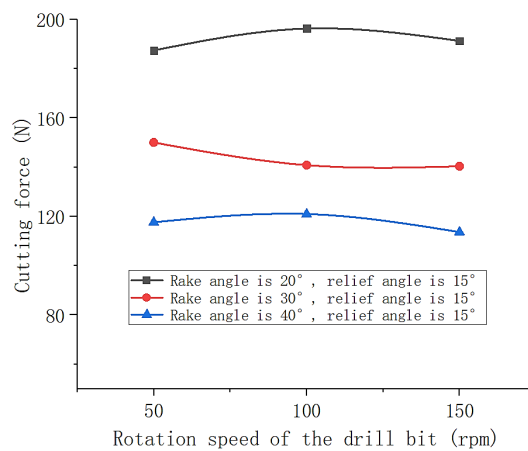
284 Plots of the average cutting force versus the rotation speed of the drill bit are shown in Fig. 12.



285

286

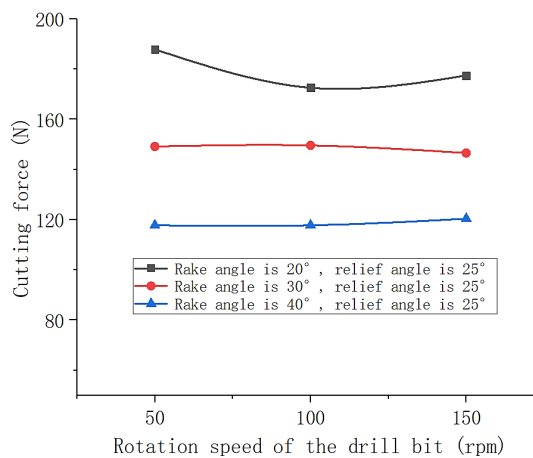
(a) The cutting depth is 1mm



287

288

(b) The cutting depth is 2mm



289

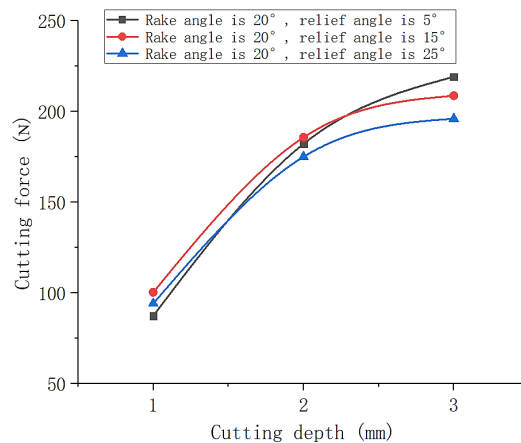


290 (c) The cutting depth is 2mm

291 **Figure 12.** Cutting force versus rotation speed of the drill bit

292 Under various experimental conditions, there is only a slight change in cutting force during the process of the
293 rotation speed changing, and there is no clear pattern of change. The rotation speed of the drill bit does not affect the
294 cutting force.

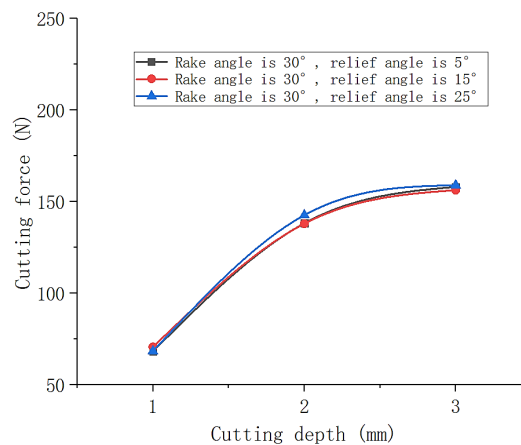
295 Plots of the average cutting force versus cutting depth are shown in Fig. 13.



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(a) The rotation speed of the drill bit is 50 rpm

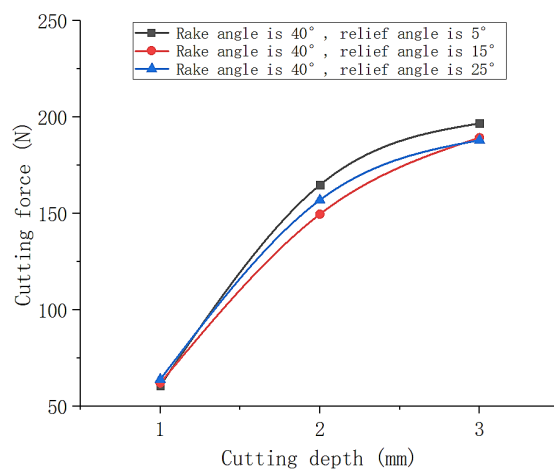


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(b) The rotation speed of the drill bit is 100 rpm



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(c) The rotation speed of the drill bit is 100 rpm

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Figure 13. Cutting force versus cutting depth

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Under all experimental conditions, as the cutting depth increases, the cutting force shows a gradually increasing trend. When the cutting depth is 3mm, the maximum cutting force reaches 219.13725N. And, under the same experimental condition, the cutting depth increasing from 1 mm to 2 mm results in an approximate doubling of the cutting force. As the depth of penetration increases, the cutting force continues to increase, but the increasing trend gradually weakens.

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6. Conclusions

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It is preliminarily observed after the mechanical testing of ice, that the main damage form of ice is a brittle fracture in the cutting process. During this process, the cutters press into the ice to a certain depth and rotate, the ice withstands a squeezing effect from the rake face of the cutter and the shear slip deformation occurs. When the shear slip deformation reaches a certain degree, the ice undergoes shear failure and then forms ice chips. This process is constantly repeated throughout the cutting and drilling of the ice.

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Based on the characteristics of ice cutting and the stress characteristics during the ice cutting and drilling process, a mechanical model of ice cutting was established. The mechanical model shows that the cutting force is not only affected by the mechanical properties of ice but also by the cutting width, cutting depth, and the rake angle of the cutter. As the cutting width and cutting depth increase, the cutting force increases; as the increase of rake angle of the cutter, the cutting force decreases. Additionally, the

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321 characteristics of cutting force were analyzed through experimental methods, and we found that the
322 cutting force fluctuated within a certain range. As the cutter is pressed into the ice, the cutting force
323 begins to rise. When the cutting force reaches the point required for the ice layer to break, the ice layer
324 undergoes shear-slip deformation, and ice chips form. Then, before the cycle repeats, the force suddenly
325 decreases, and the cutting force fluctuates. Finally, the influencing factors and laws of cutting force were
326 verified by analyzing the cutting force generated under various experimental conditions.

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328 *Date availability.* No data sets were used in this article

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331 Methodology, Validation, Formal analysis, Visualization; Ting Wang: Methodology, Validation, Formal
332 analysis, Visualization; Yumin Wen: Conceptualization, Writing – review & editing, Methodology,
333 Validation; An Liu: Methodology, Validation, Formal analysis, Visualization; Rusheng Wang:
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335

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