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Serope Kalpakjian is a professor emeritus of mechanical and materials engineering at the Illinois Institute of Technology, Chicago. He is the author of Mechanical Processing of Materials (Van Nostrand, 1967) and co-author of Lubricants and Lubrication in Metalworking Operations (with E.S. Nachtman, Dekker, 1985). Both of

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Fig. 1 shows the schematic illustration of the basic turning operation, showing depth-of-cut, d ; feed rate, f ; and spindle rotational speed, N in rev/min. Cutting speed is the surface speed of the ...

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