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Supplying abundant examples, illustrations, and homework problems, Fundamentals of Machining and Machine Tools, Third Edition is an ideal textbook for senior undergraduate and graduate students studying metal cutting, machining, machine tool technology, machining applications, and manufacturing processes.

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Fundamentals of Machining 21.1 Introduction Parts manufactured by casting, forming, and shaping processes often require further operations before the product is ready to use. Features such as smooth shiny surfaces, small-diameter deep holes in a part, threaded section, and threaded holes all require further manufacturing operations.

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of machine tools and metal machining in universities and colleges. It should also prove useful to those concerned with manufacturing in industry.

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Students must keep up with developments in analytical modeling of machining processes, modern cutting tool materials, and how these changes affect the economics of machining. With coverage reflecting state-of-the-art industry practice, Fundamentals of Machining and Machine Tools, Third Edition emphasizes underlying concepts, analytical methods, and economic considerations, requiring only basic mathematics and physics.

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Chapter 20 Fundamentals of Machining/ Orthogonal Machining. grain structure of cast iron is filled with flake graphite. these flakes produce regions that act like sharp-cornered flaws or voids, and concentrate the compression stresses. The shear fronts cannot cross the regions. Under the large strains the metal fractures through the flake and the chips come out segmented or in fractured chunks.

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