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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 the first editions of his books Manufacturing Processes for Engineering ...

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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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