FIG. 1

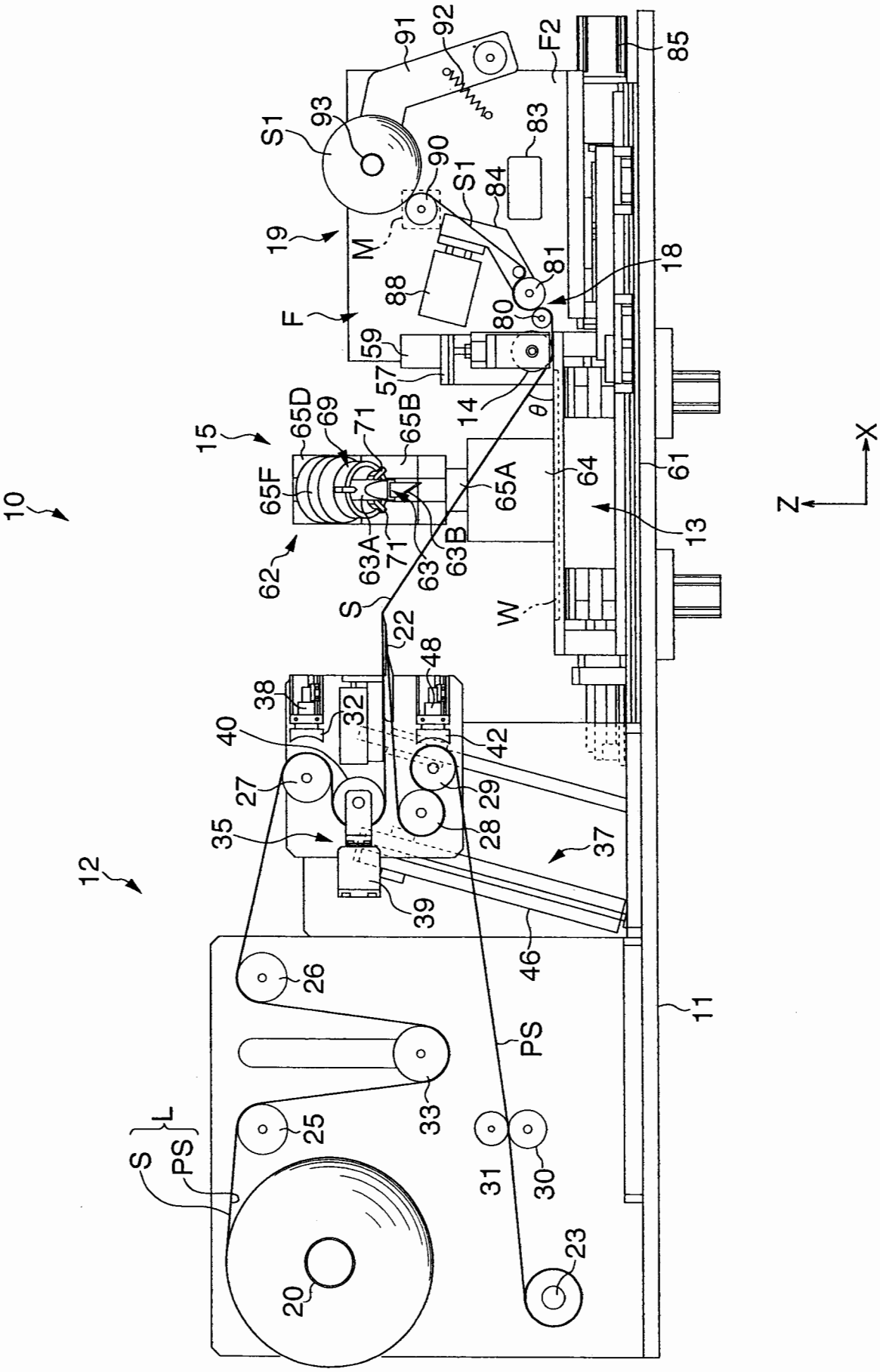

10
11
12
13
14
15
18
19
20
22
23
25
26
27
28
29
30
31
32
33
35
37
38
39
40
42
46
48
57
59
61
62
63
63A
63B
64
65A
65B
65D
65F
69
71
80
81
83
84
85
88
90
91
92
93
S1
F
F2
M
S
PS
L
W
θ
X
Z

FIG. 2

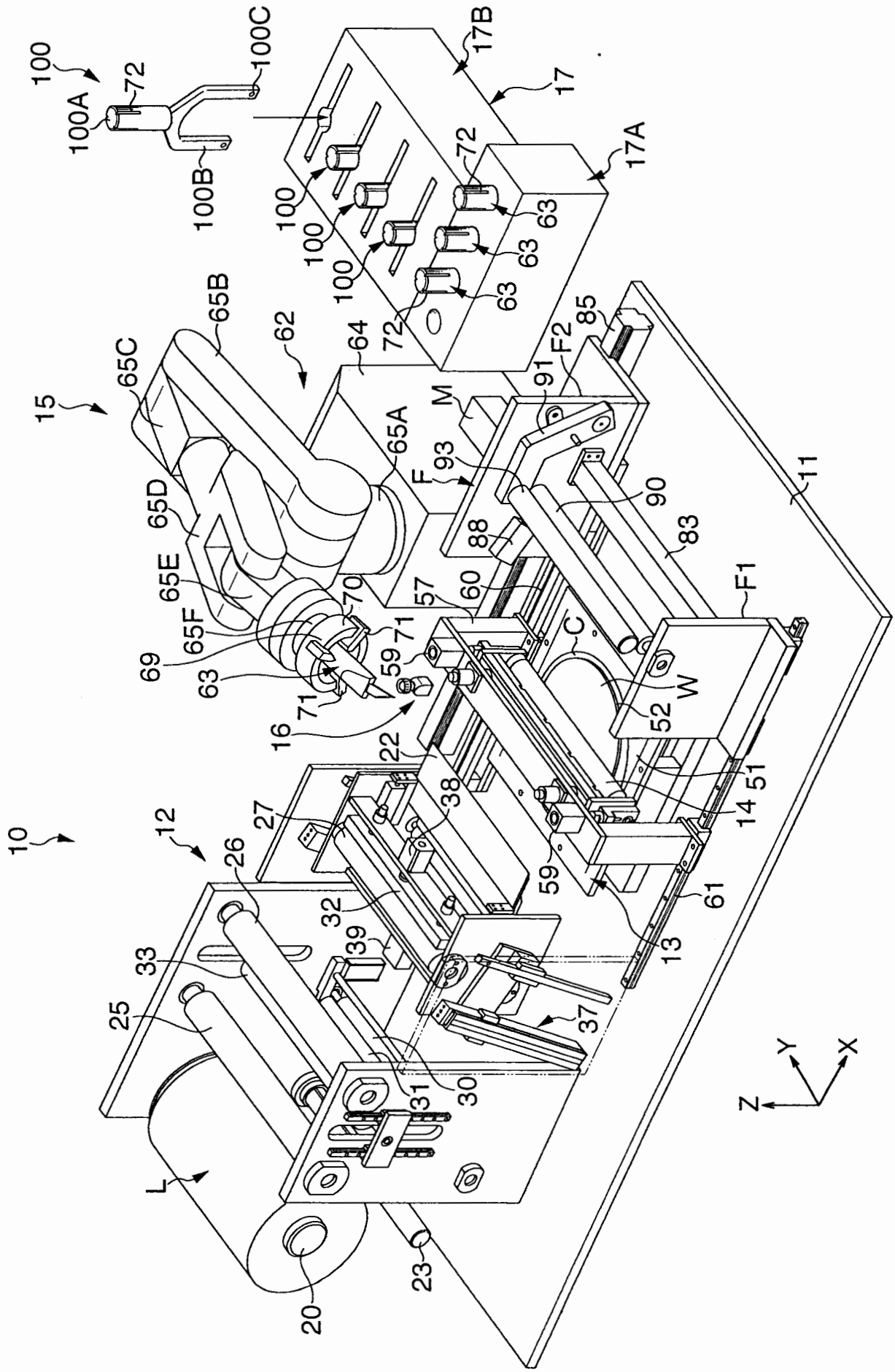

10
11
12
13
14
15
16
17
17A
17B
20
22
23
25
26
27
30
31
32
33
37
38
39
51
52
57
59
60
61
62
63
64
65A
65B
65C
65D
65E
65F
69
70
71
72
83
85
88
90
91
93
100
100A
100B
100C
C
F
F1
F2
L
M
W
X
Y
Z

FIG. 3

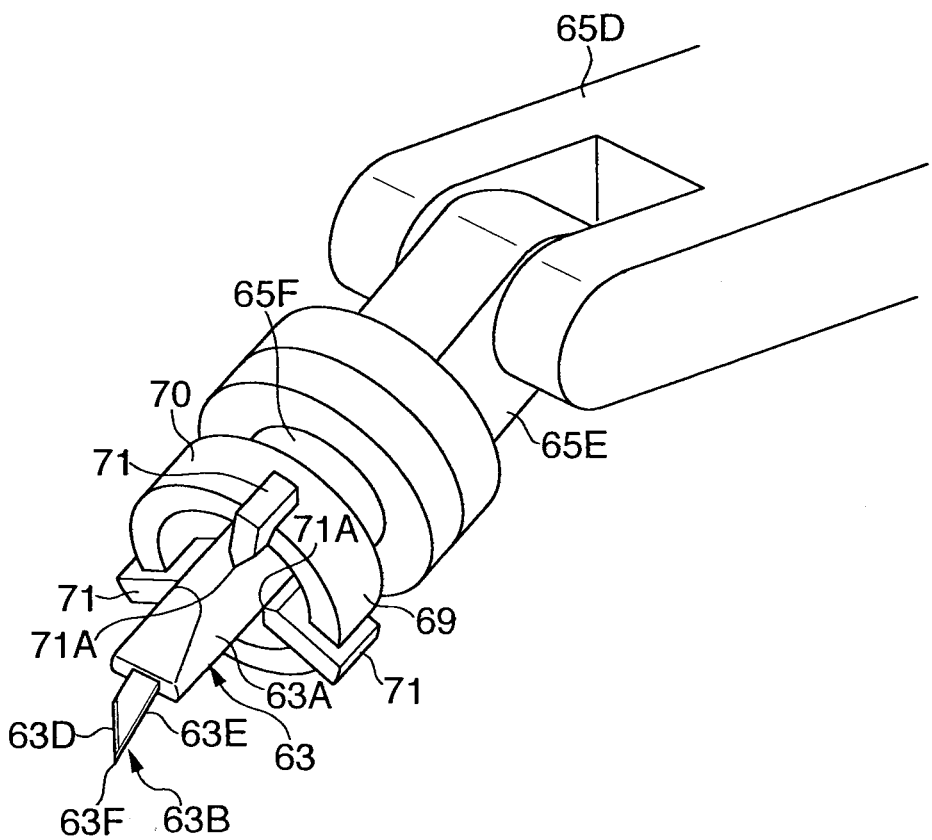


FIG. 4

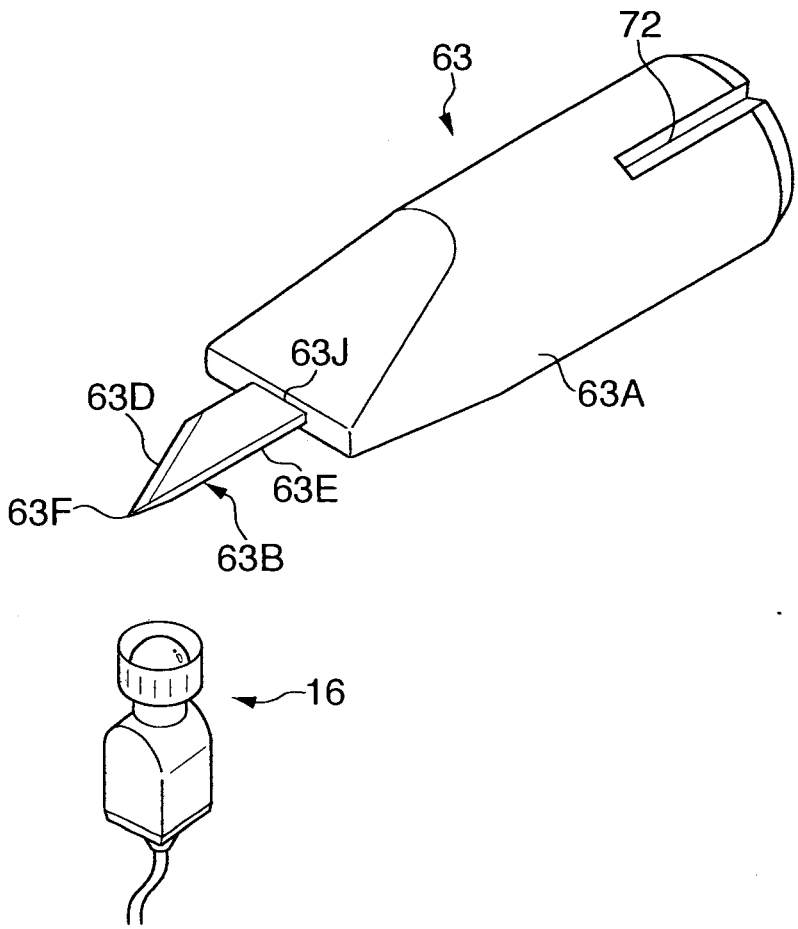


FIG. 5

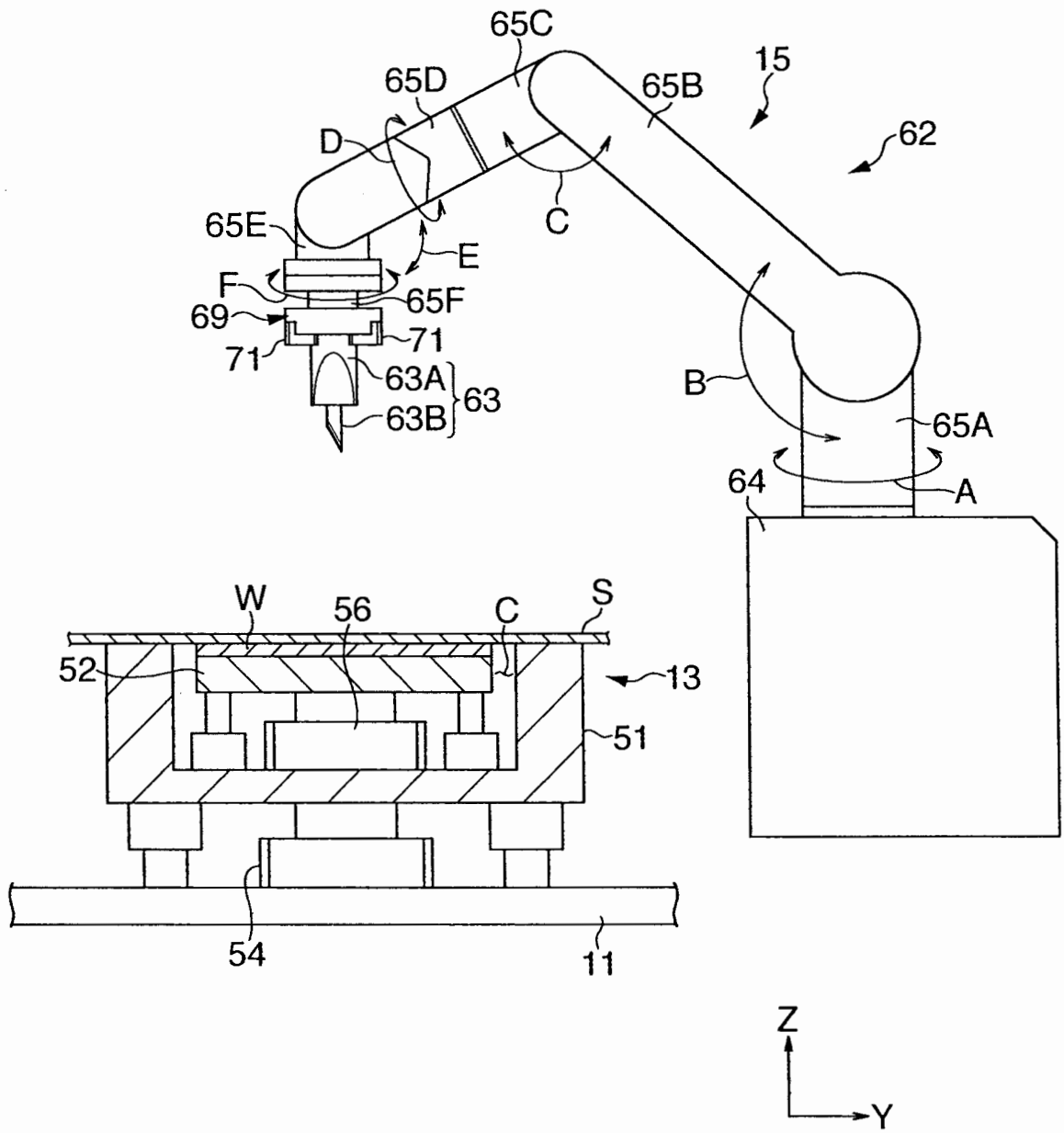

65C
65D
65B
15
62
D
C
65E
E
F
65F
69
71
71
63A
63
63B
B
65A
64
A
W
56
C
S
52
13
51
54
11
Z
Y

FIG. 6

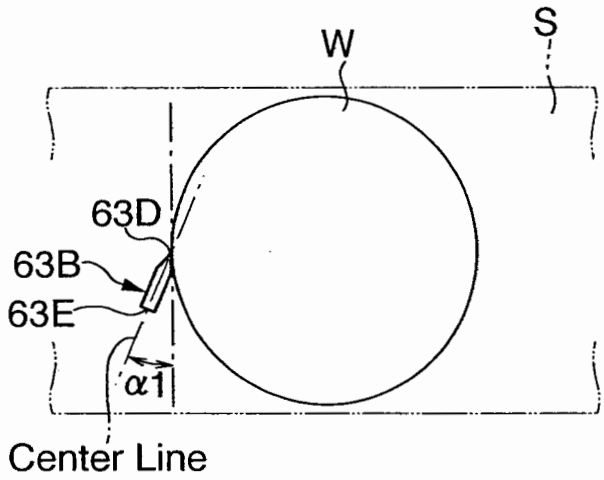

W
S
63D
63B
63E
α1
Center Line

FIG. 7

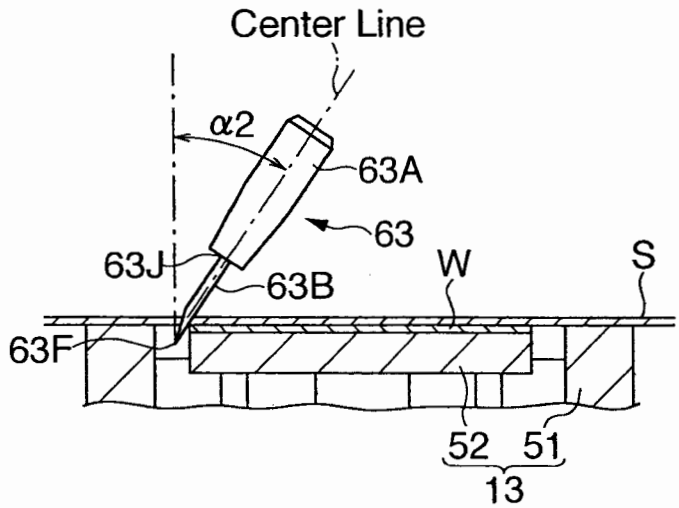

Center Line
α2
63A
63
63J
63B
W
S
63F
52
51
13

FIG. 8

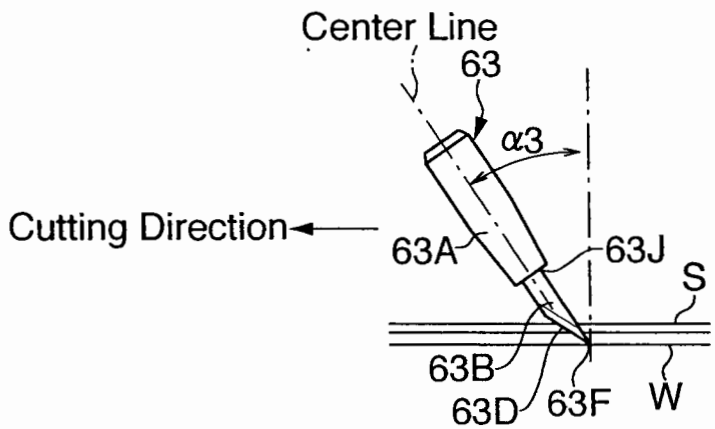
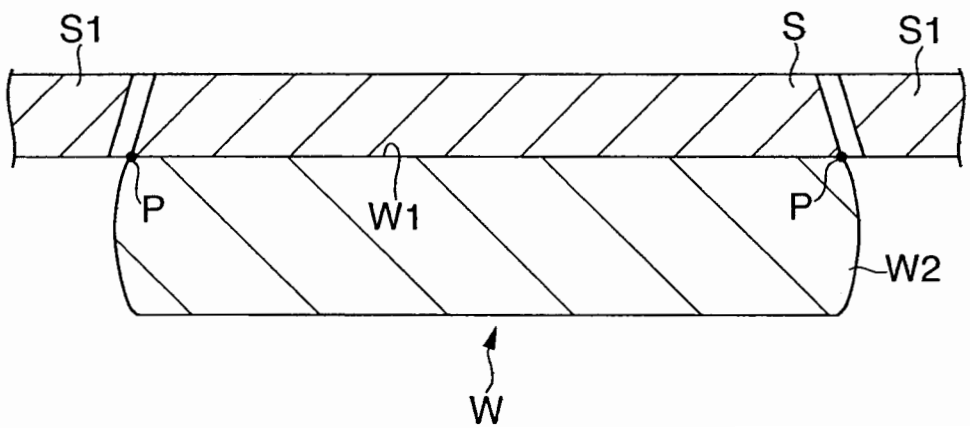

Center Line
63
α3
Cutting Direction
63A
63J
S
63B
63D
63F
W

FIG. 9


S1
S
S1
P
W1
P
W2
W