

FIG.1

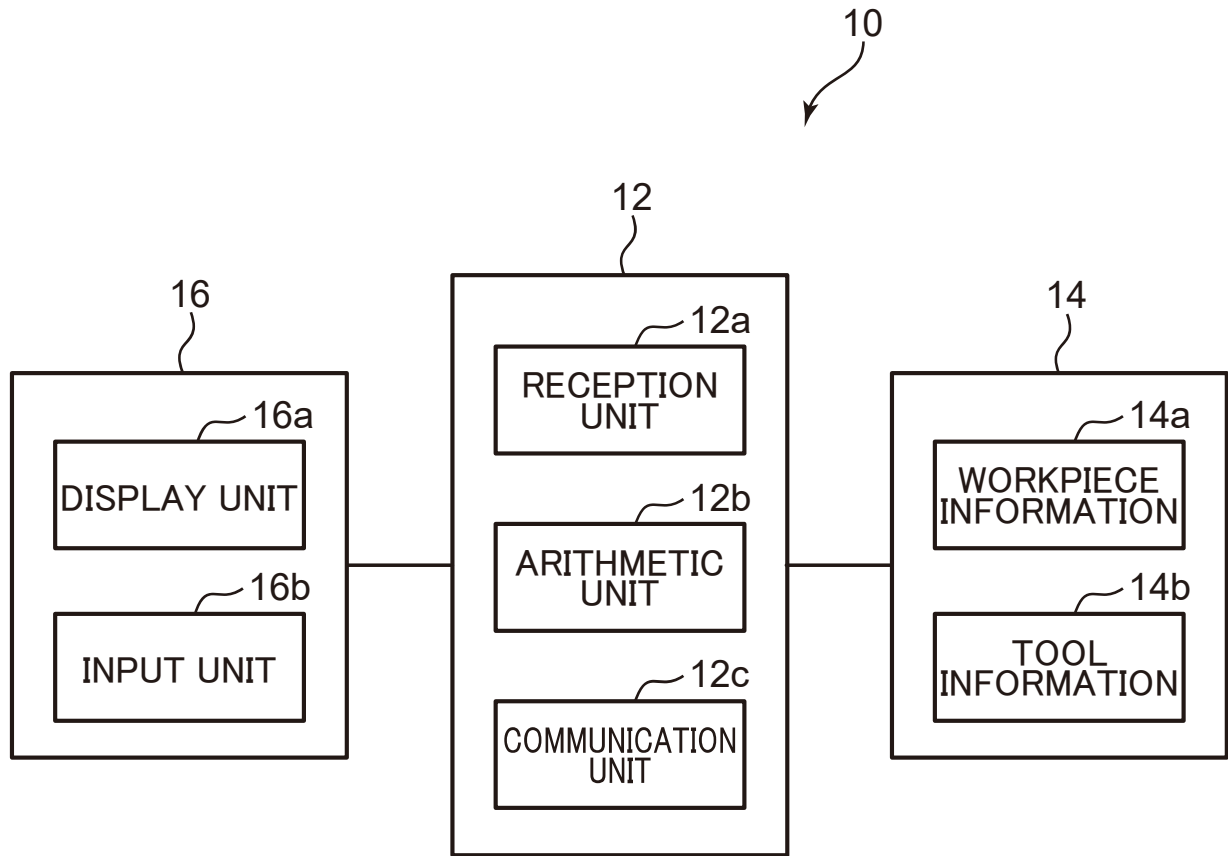


FIG.2

☐ WORKPIECE

☐ HOLDER SHAPE

☐ MANUAL INPUT

☐ CHIP SHAPE

☐ CUSTOMIZED

☐ CUTTING CONDITION

☐ COOLANT

☐ YES
 ☐ NONE

☐ AUTOMATIC SAVE AT END

☐ BREAKABILITY

☐ PRIME TARGET

☐ CUTTABLE ↑

☐ NOT CUTTABLE ↓

☐ WHETHER CHIP IS BROKEN

☐ TOOL CANDIDATE
 ☐ CUSTOMIZATION PRIORITY

☐ MITSUBISHI MATERIALS (TNMG220408 C)

☐ TUNGALOY VCMT160404 PSF

☐ TUNGALOY CCMT060204 PSF

☐ SANDVIK CCMT060204 UF

☐ TUNGALOY CCMT060204 PS

☐ CHAMFER

☐ (0.938)

☐ (0.367)

☐ (0.271)

☐ (0.240)

☐ TOOL CANDIDATE
 ☐ CUSTOMIZATION PRIORITY

☐ MITSUBISHI MATERIALS (TNMG220408 C)

☐ TUNGALOY VCMT160404 PSF

☐ TUNGALOY CCMT060204 PSF

☐ SANDVIK CCMT060204 UF

☐ TUNGALOY CCMT060204 PS

☐ CHAMFER

☐ (0.938)

☐ (0.367)

☐ (0.271)

☐ (0.240)

FIG.3

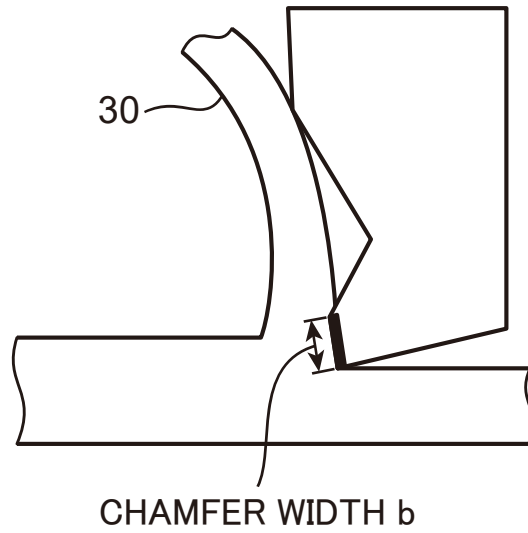


FIG.4

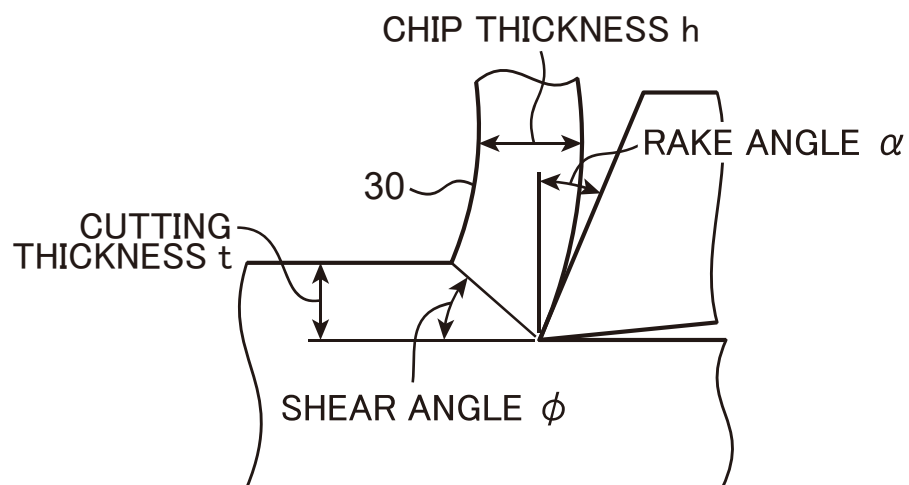


FIG.5

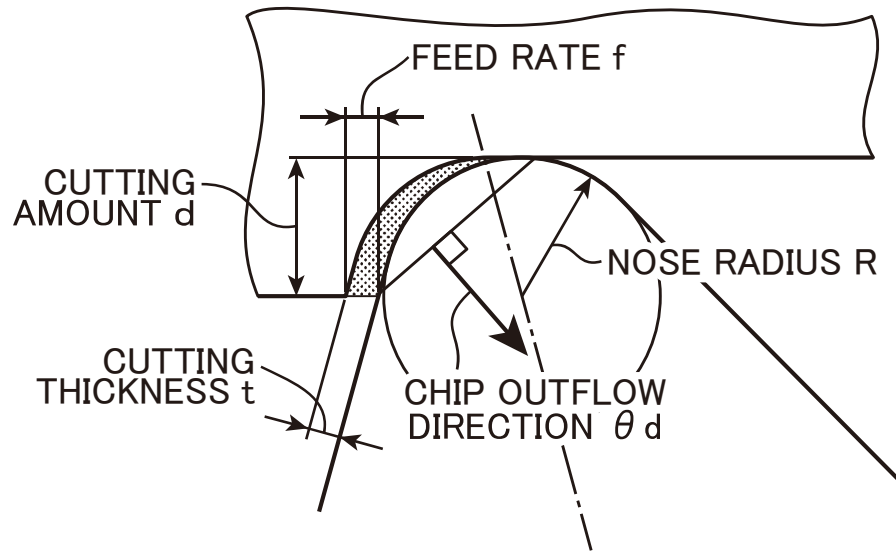


FIG.6

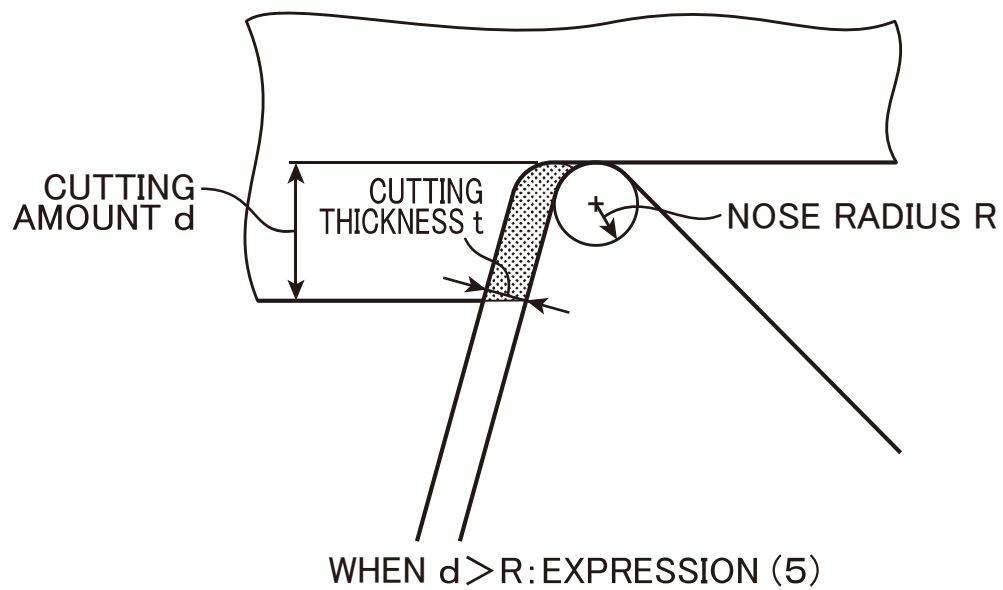
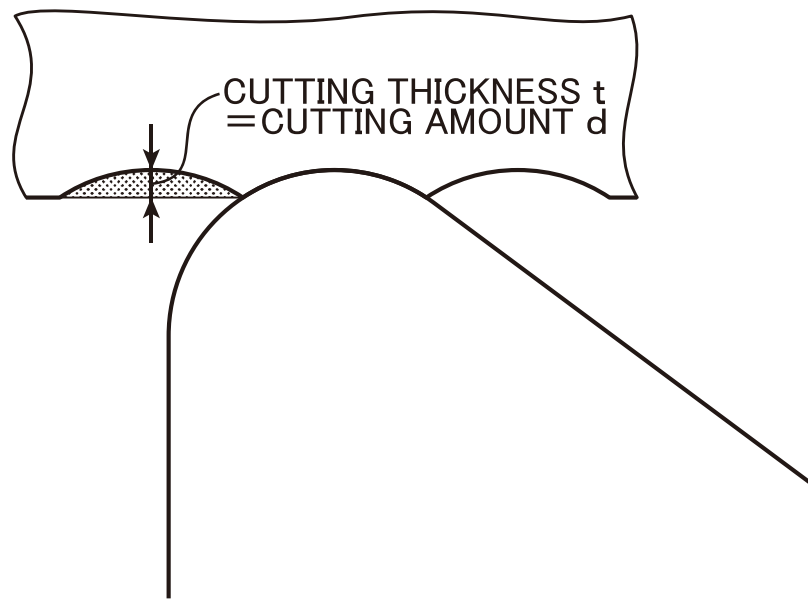
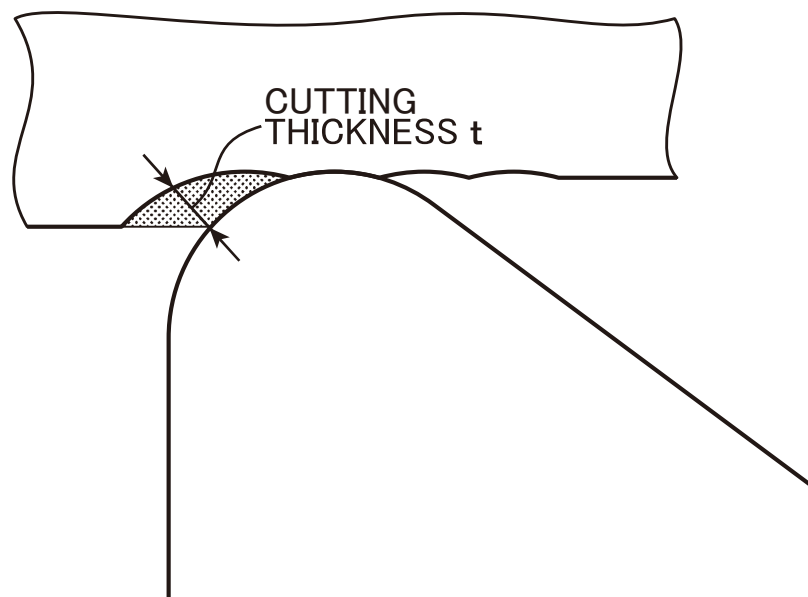


FIG.7



WHEN $a < 0$: EXPRESSION (7)

FIG.8



WHEN $a > 0$: EXPRESSION (8)

FIG.9

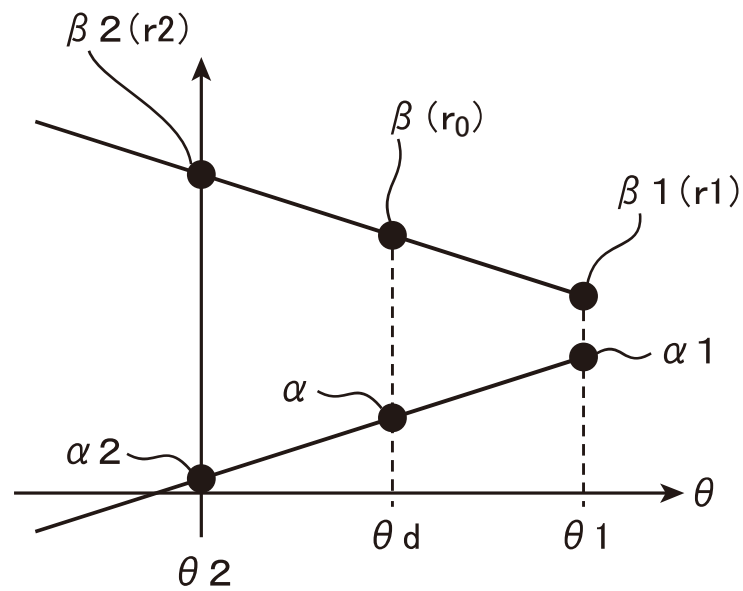


FIG.10

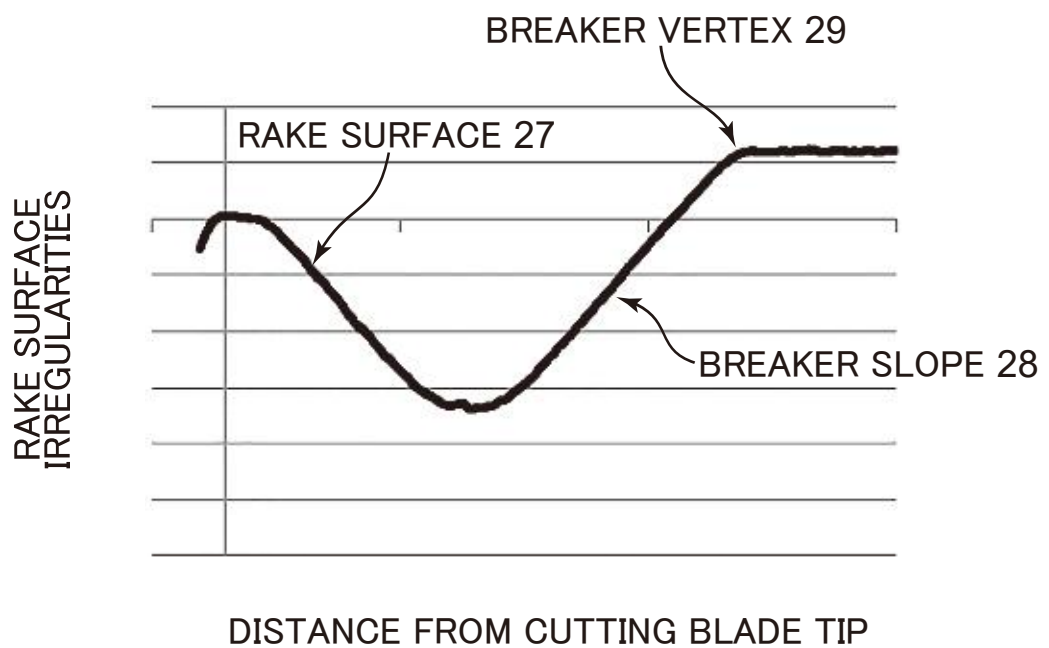


FIG.11A

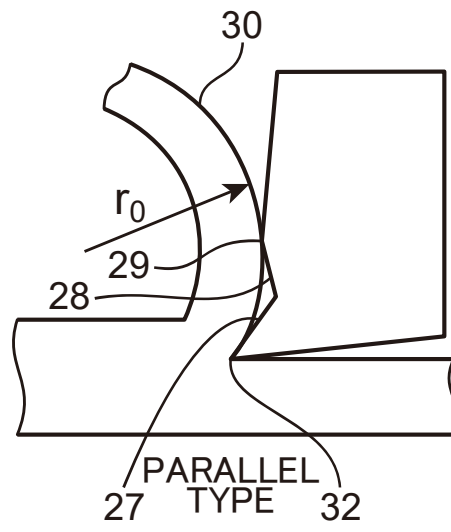


FIG.11B

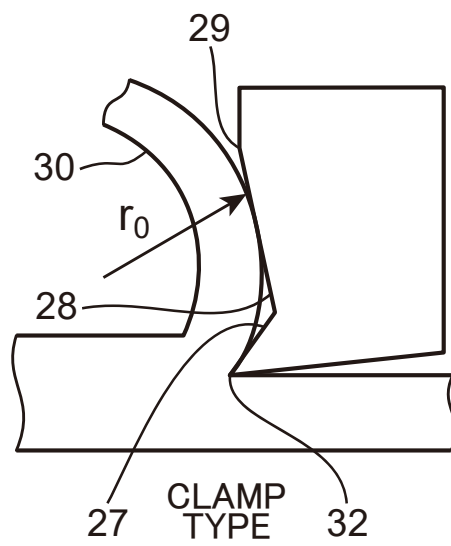


FIG.12

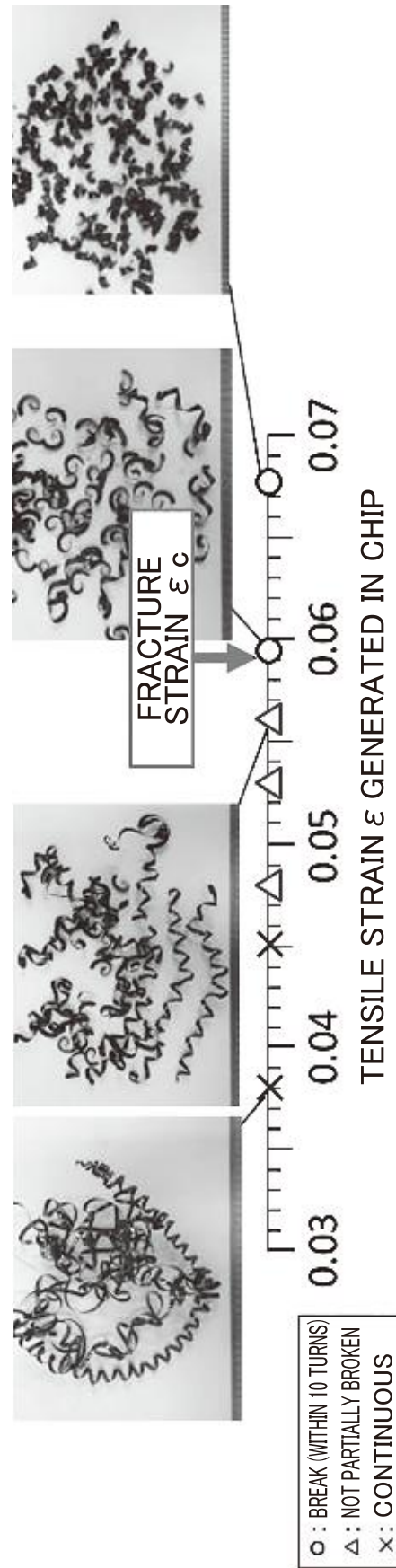


FIG.13

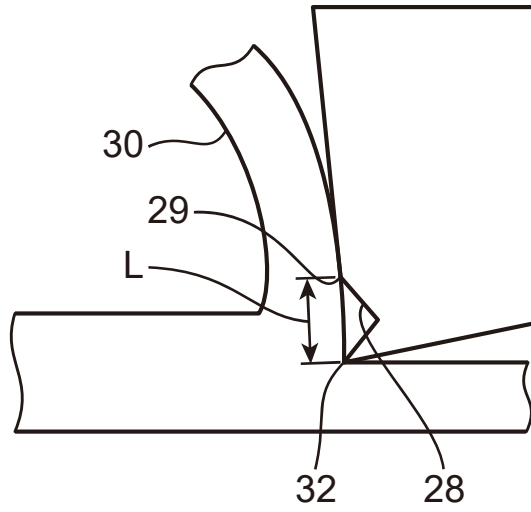


FIG.14

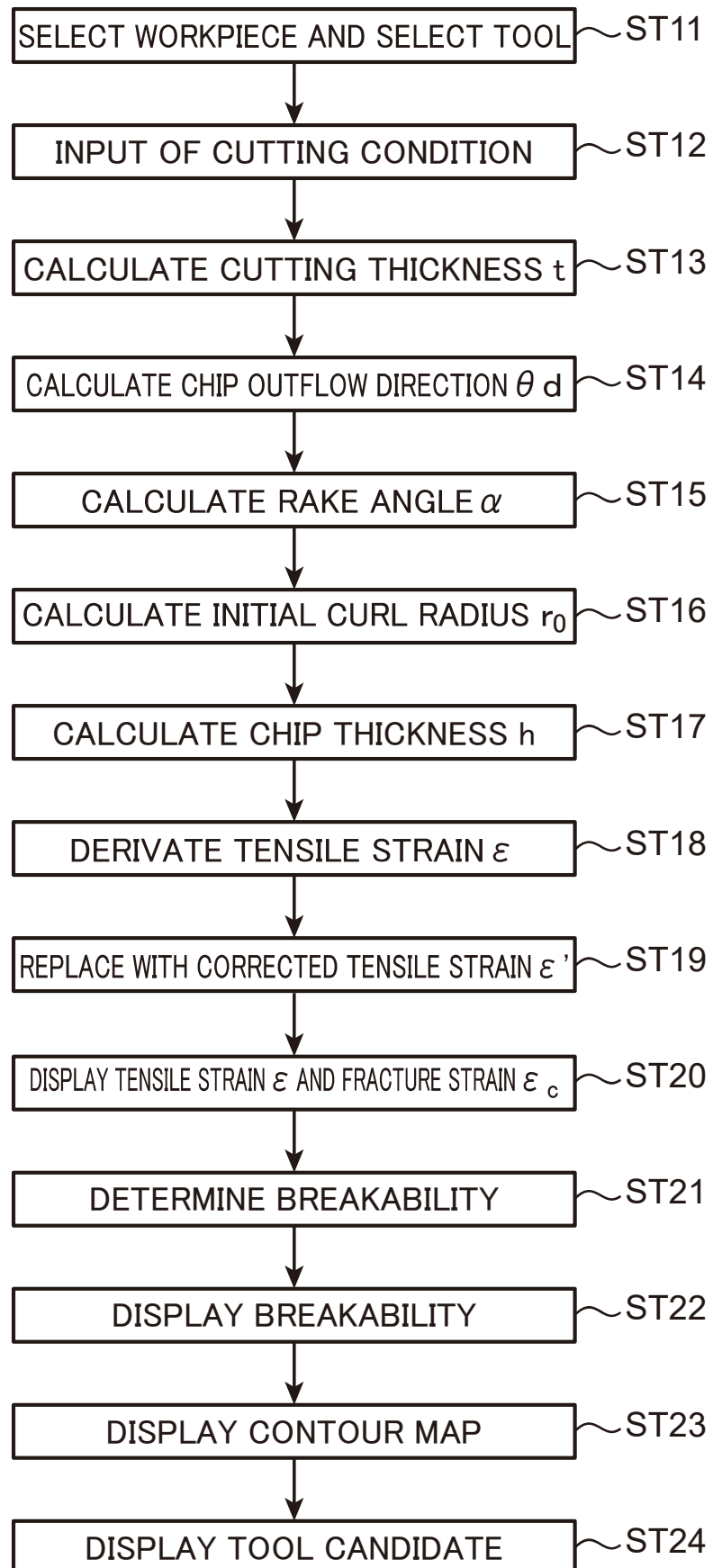


FIG.15

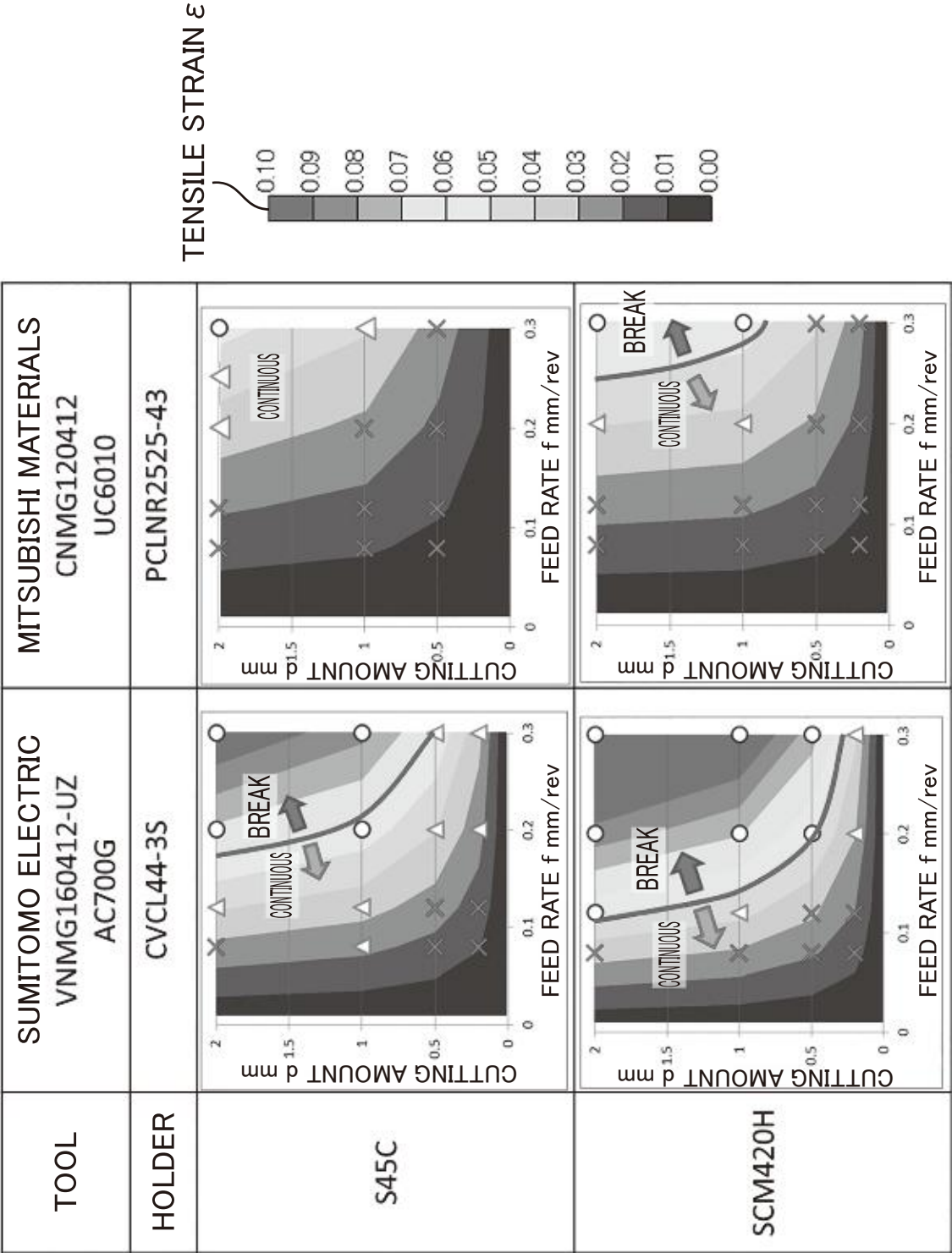


FIG.16A

FRACTURE BOUNDARY
BEFORE CORRECTION

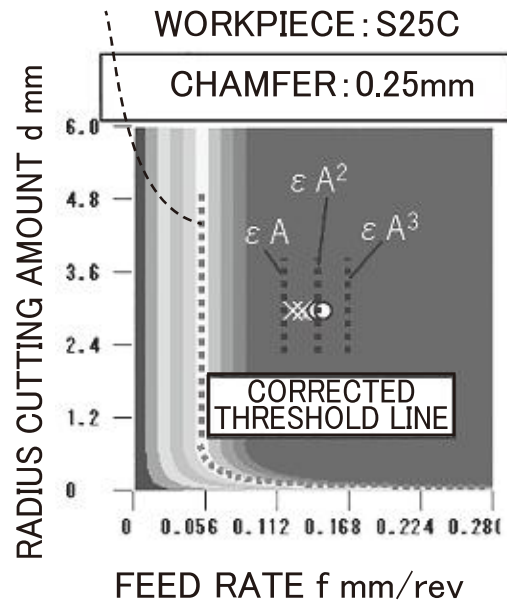


FIG.16B

FRACTURE BOUNDARY
BEFORE CORRECTION

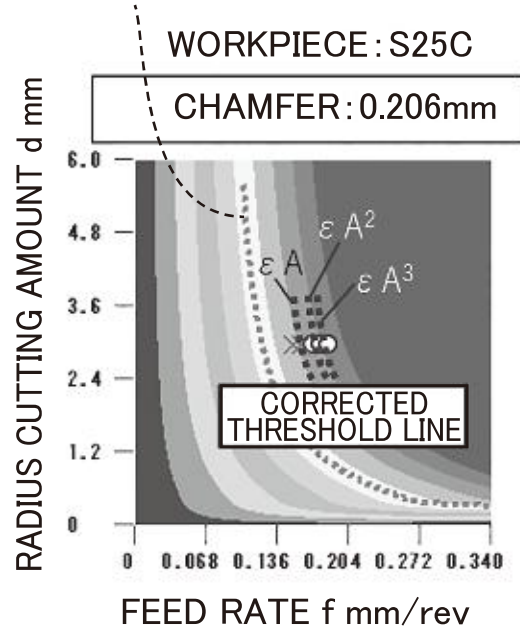


FIG.16C

FRACTURE BOUNDARY
BEFORE CORRECTION

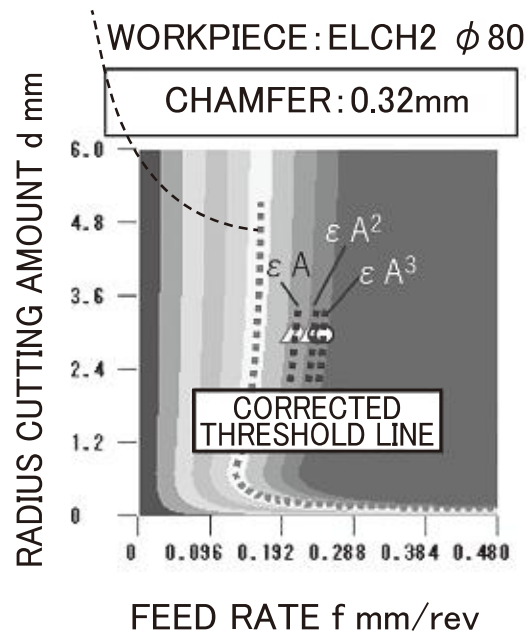


FIG.17

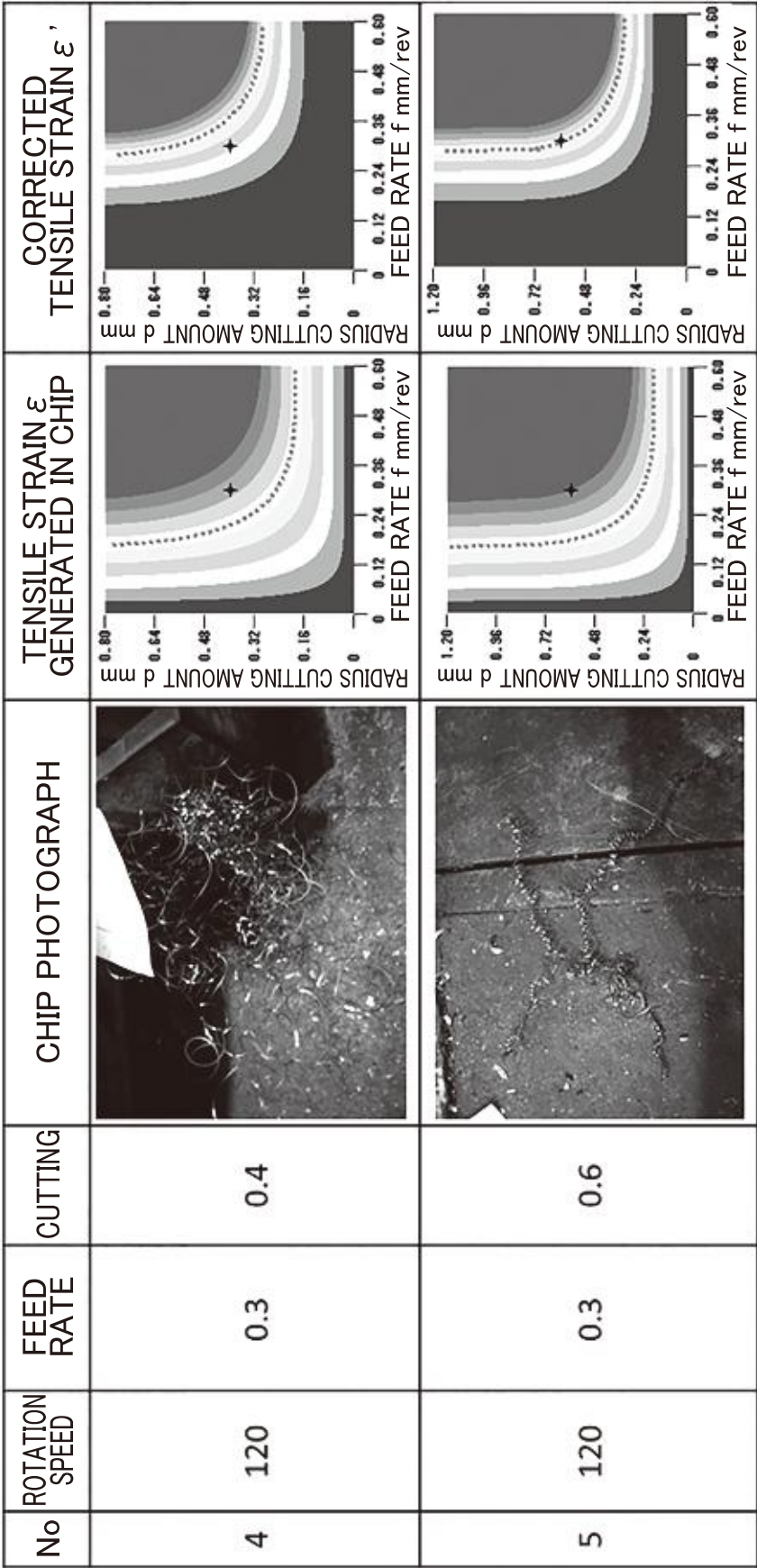


FIG.18

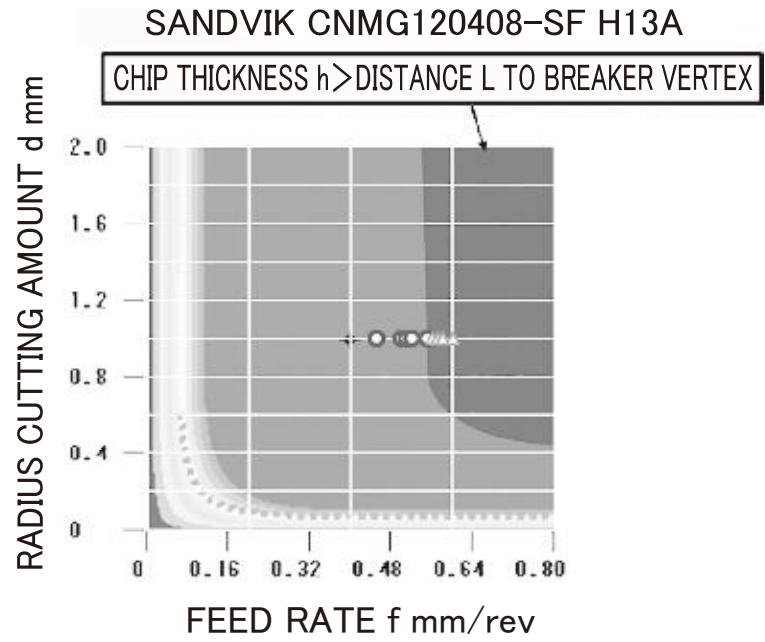


FIG.19

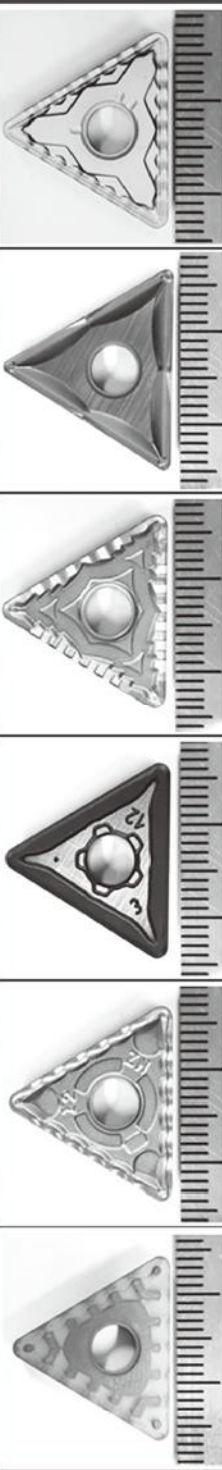
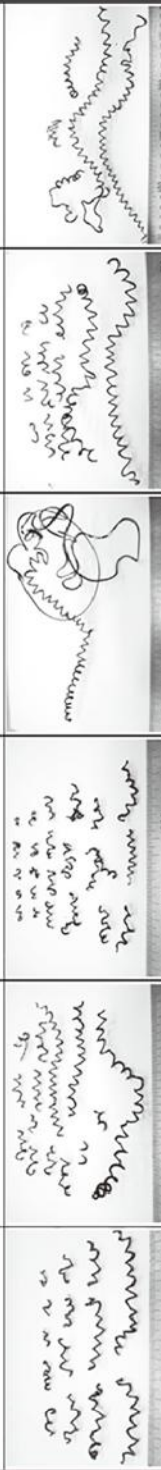
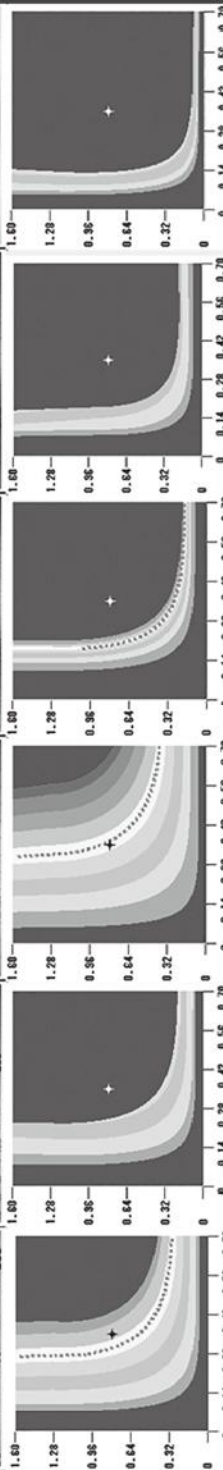
MANUFACTURER	TUNGALOY	TUNGALOY	ISCAR	KYOCERA	MITSUBISHI MATERIALS	MITSUBISHI MATERIALS
CHIP MODEL NUMBER	TNMG220412	TNMG220412	TNMG220412	TNMG220412	TNMG20408	TNMG220412
CHIP BREAKER SYMBOL (MATERIAL TYPE)	27	ZM(T9125)	M3M(IC6015)	CQ(CA515)	C(NX3035)	SA(UE6110)
TOOL PHOTOGRAPH						
						
CHIP PHOTOGRAPH V:200 m/min f:0.35 mm/rev						
BREAKABILITY PREDICTION RESULT						

FIG.20

