FIG.1

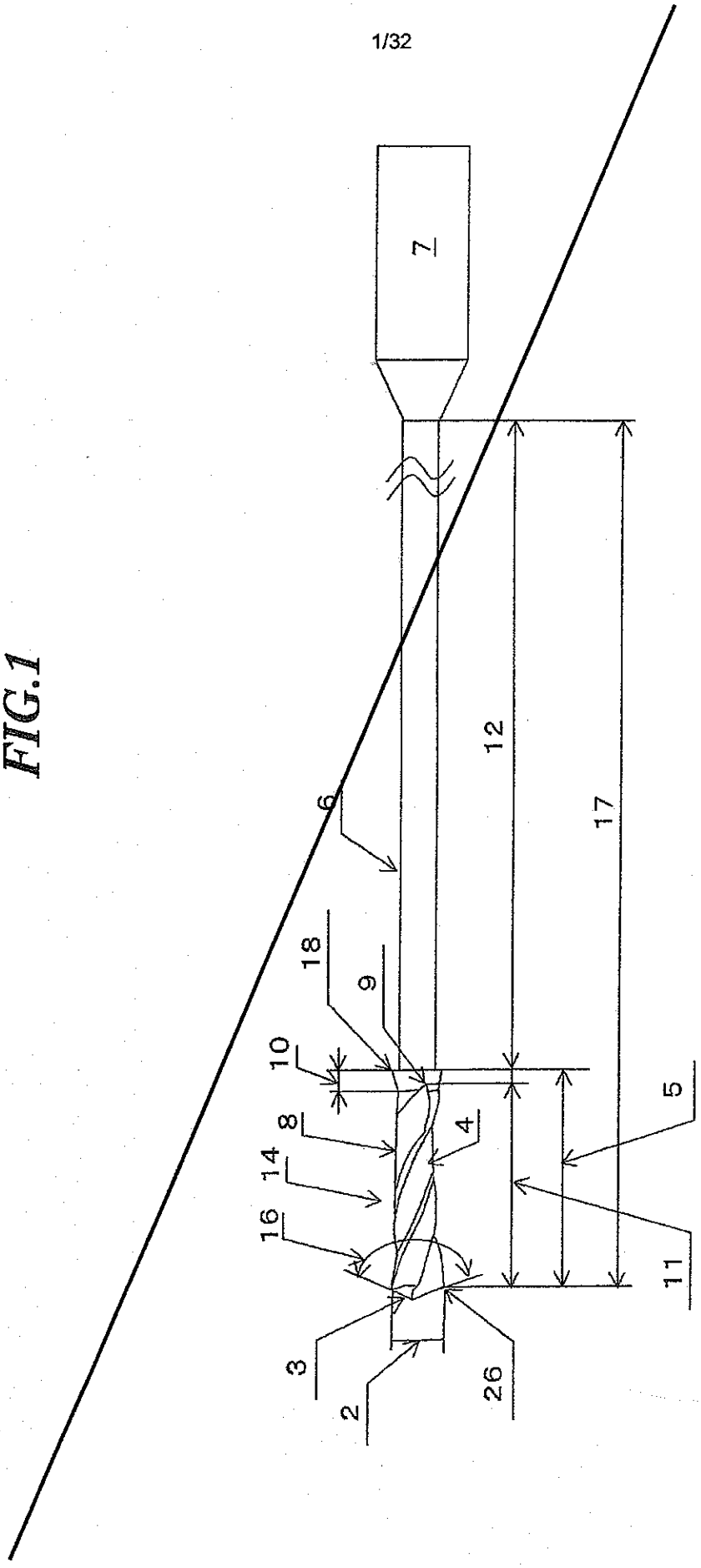
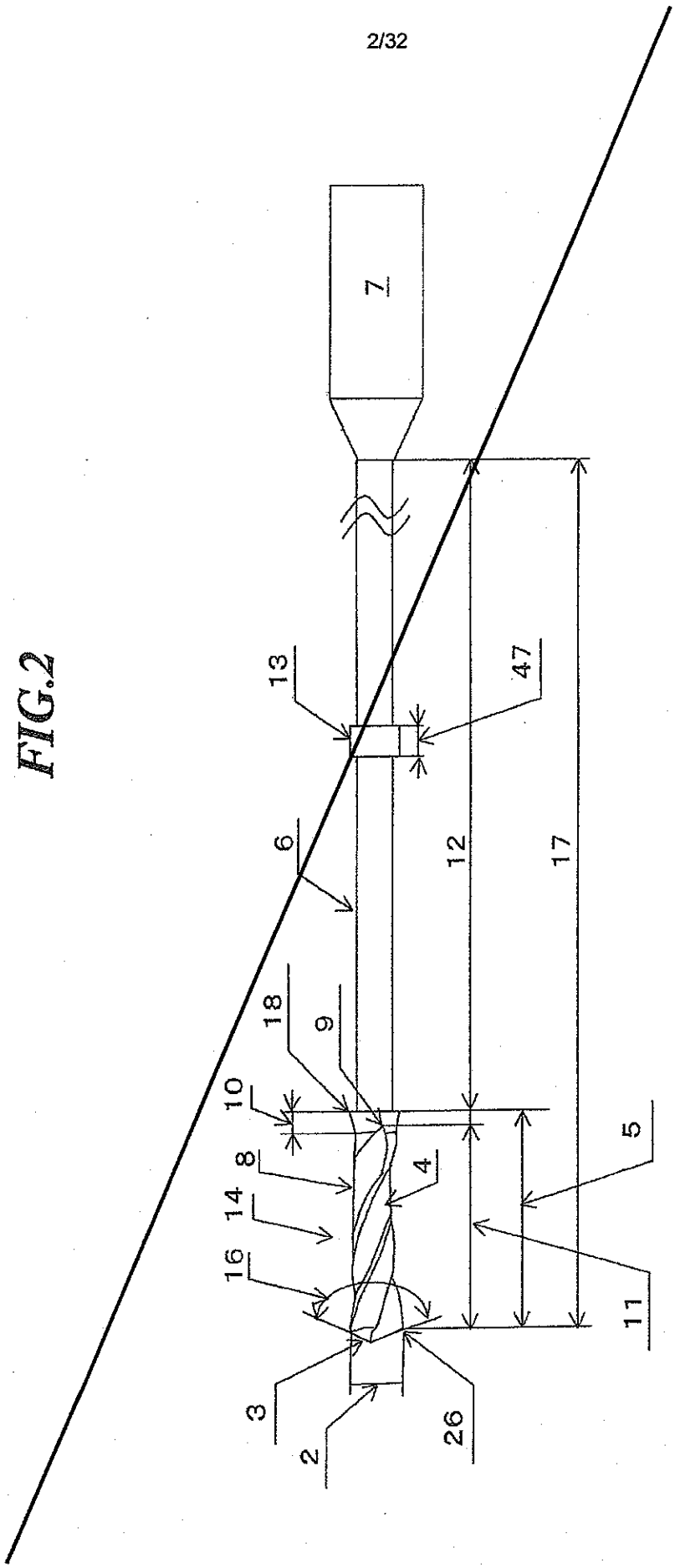


FIG.2



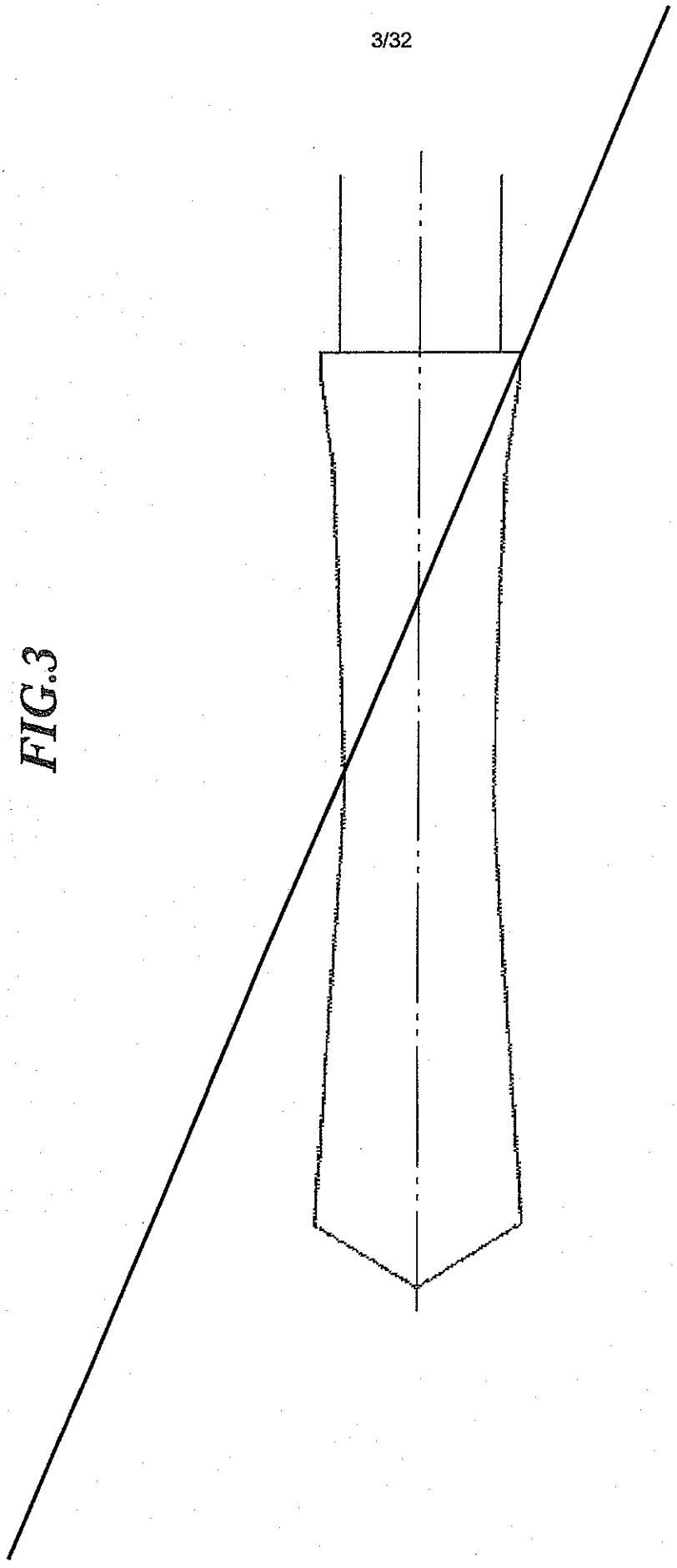


FIG.3

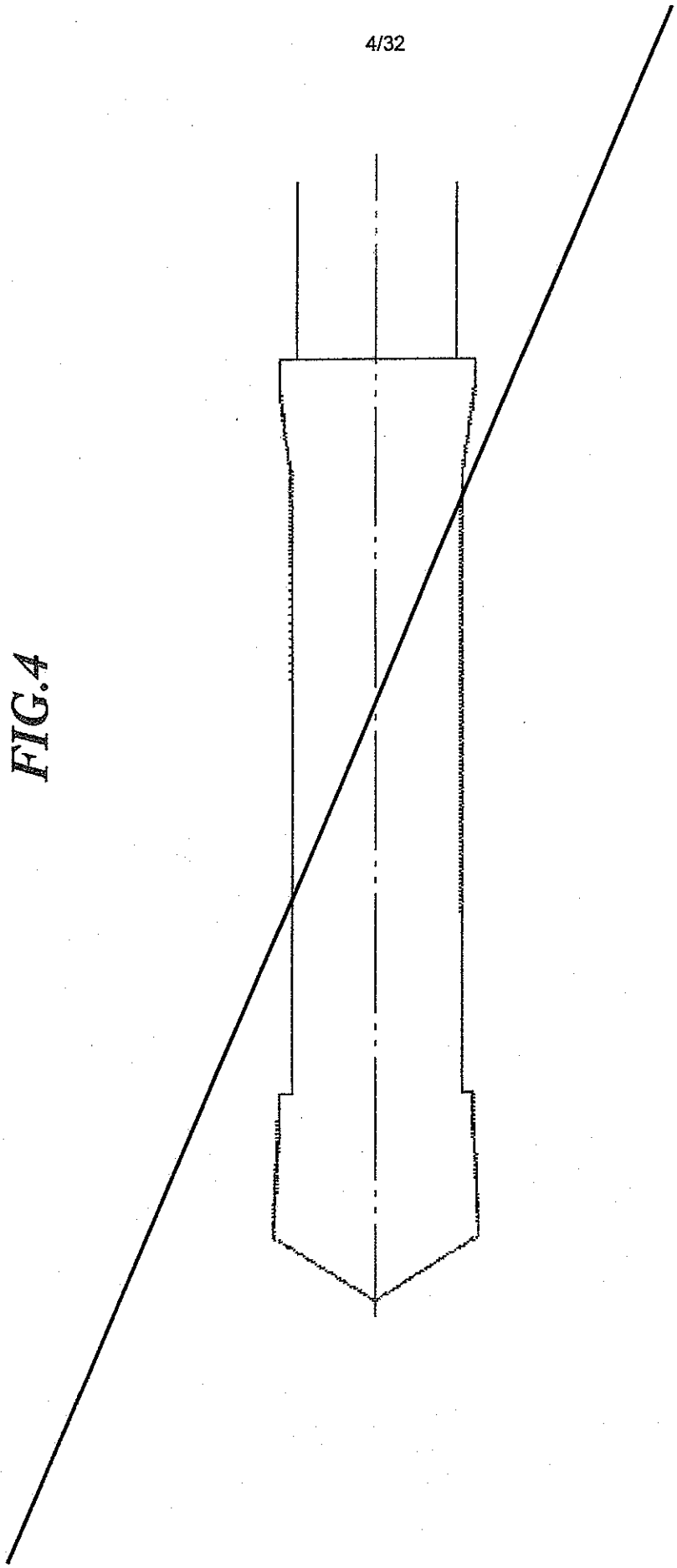


FIG.4

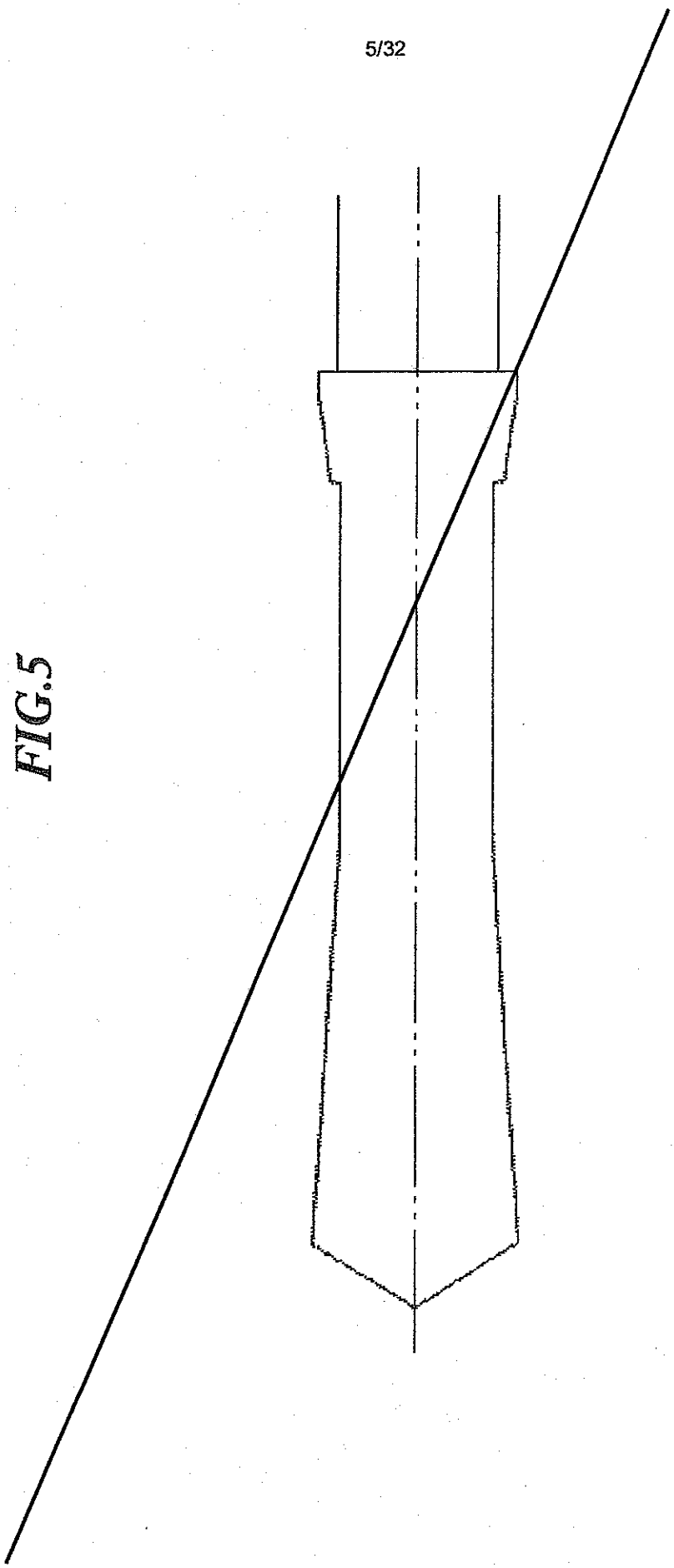


FIG.5

FIG.6

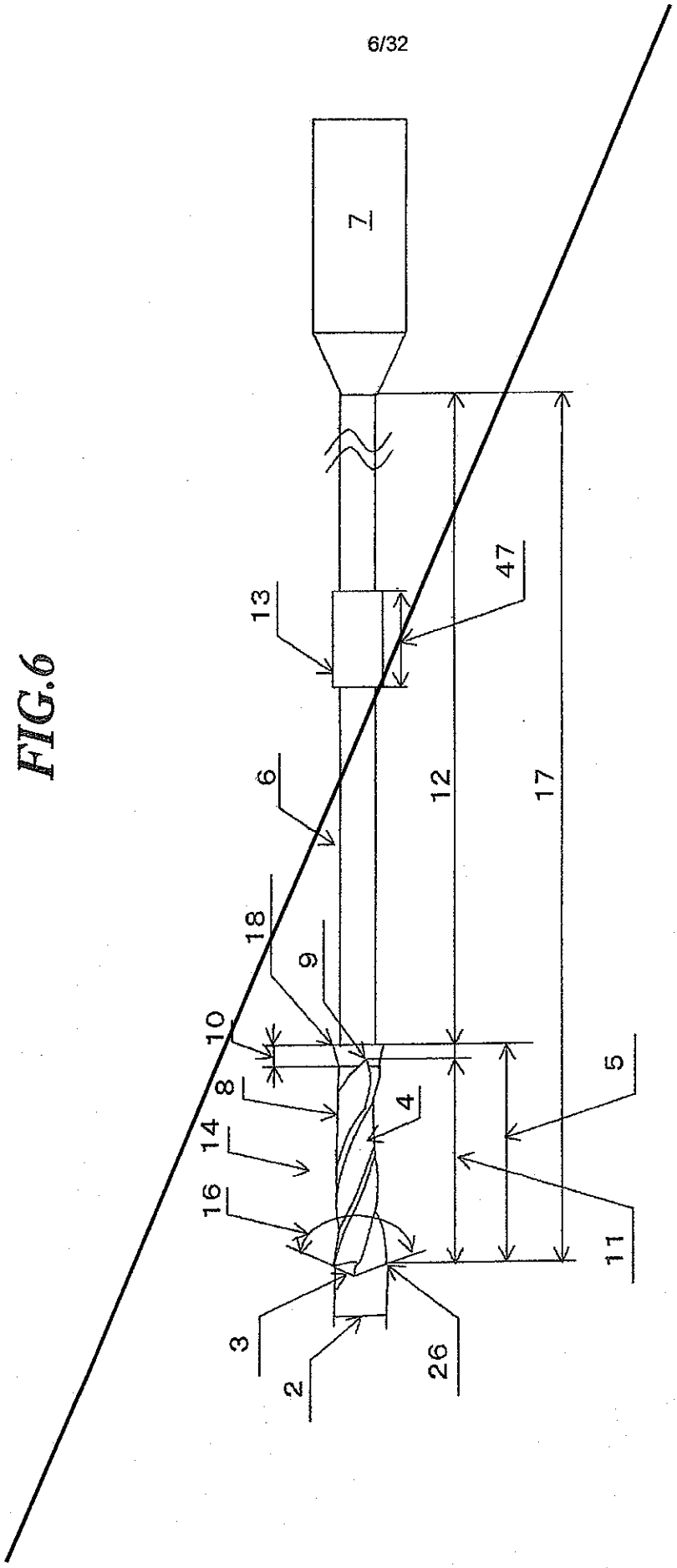


FIG.7

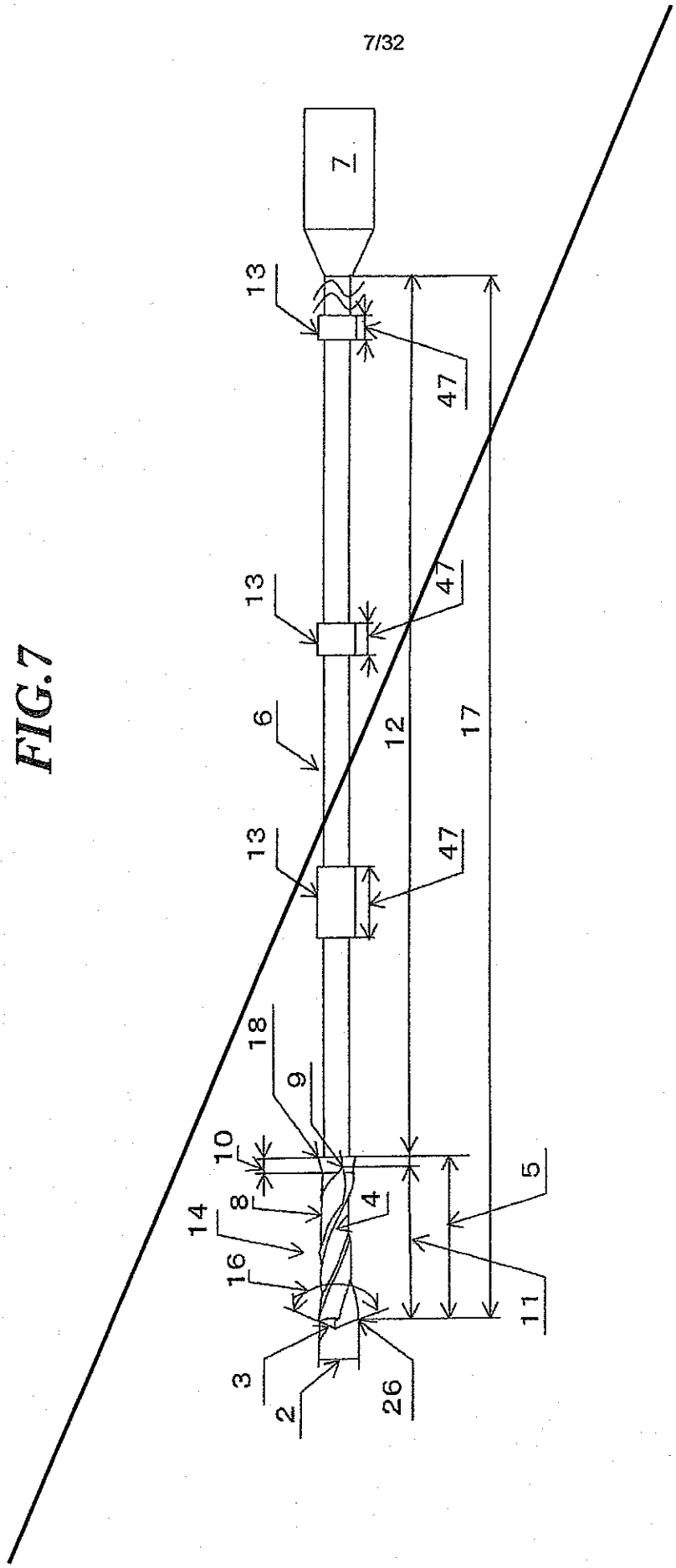


FIG.8

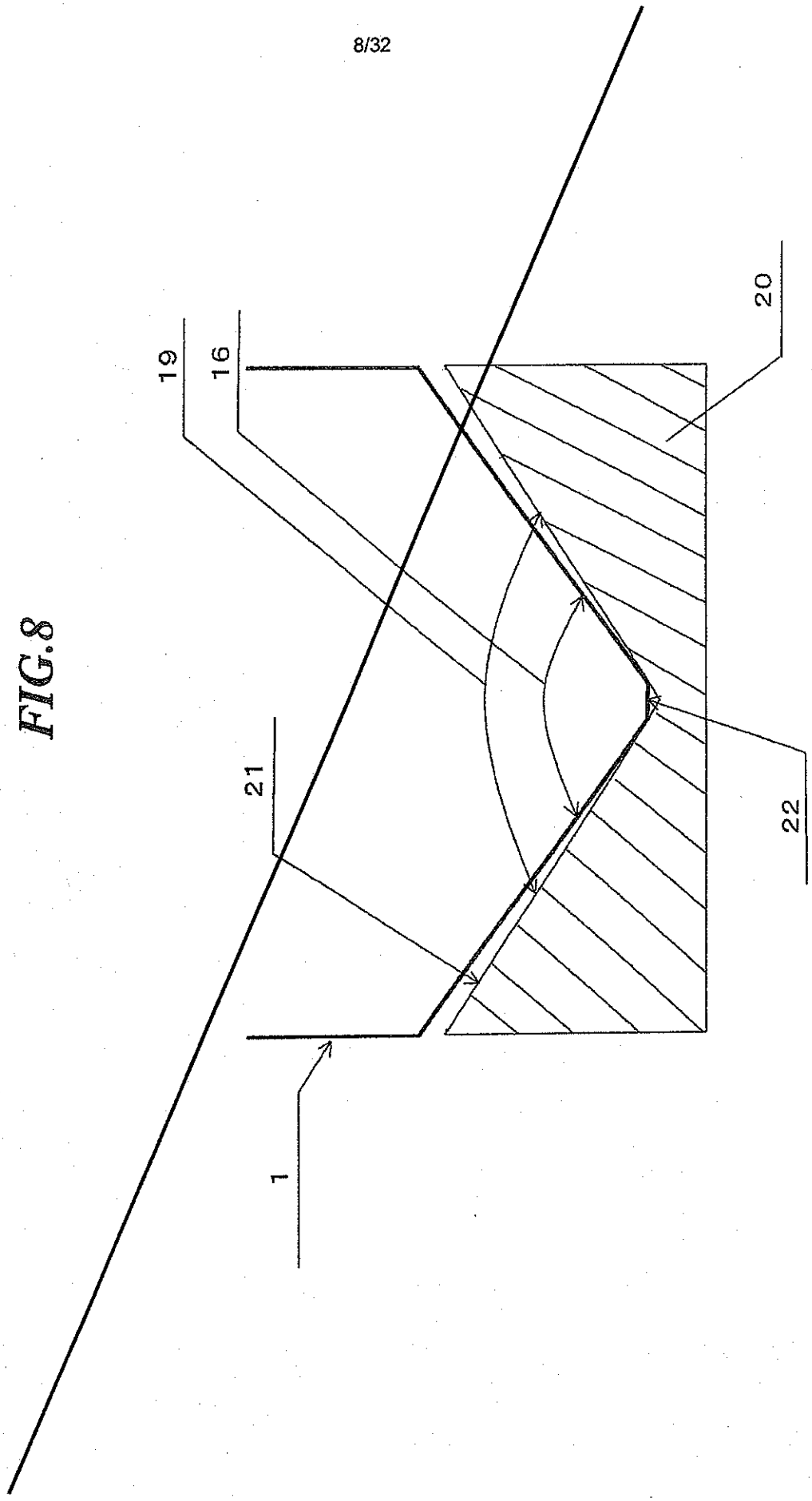


FIG.9

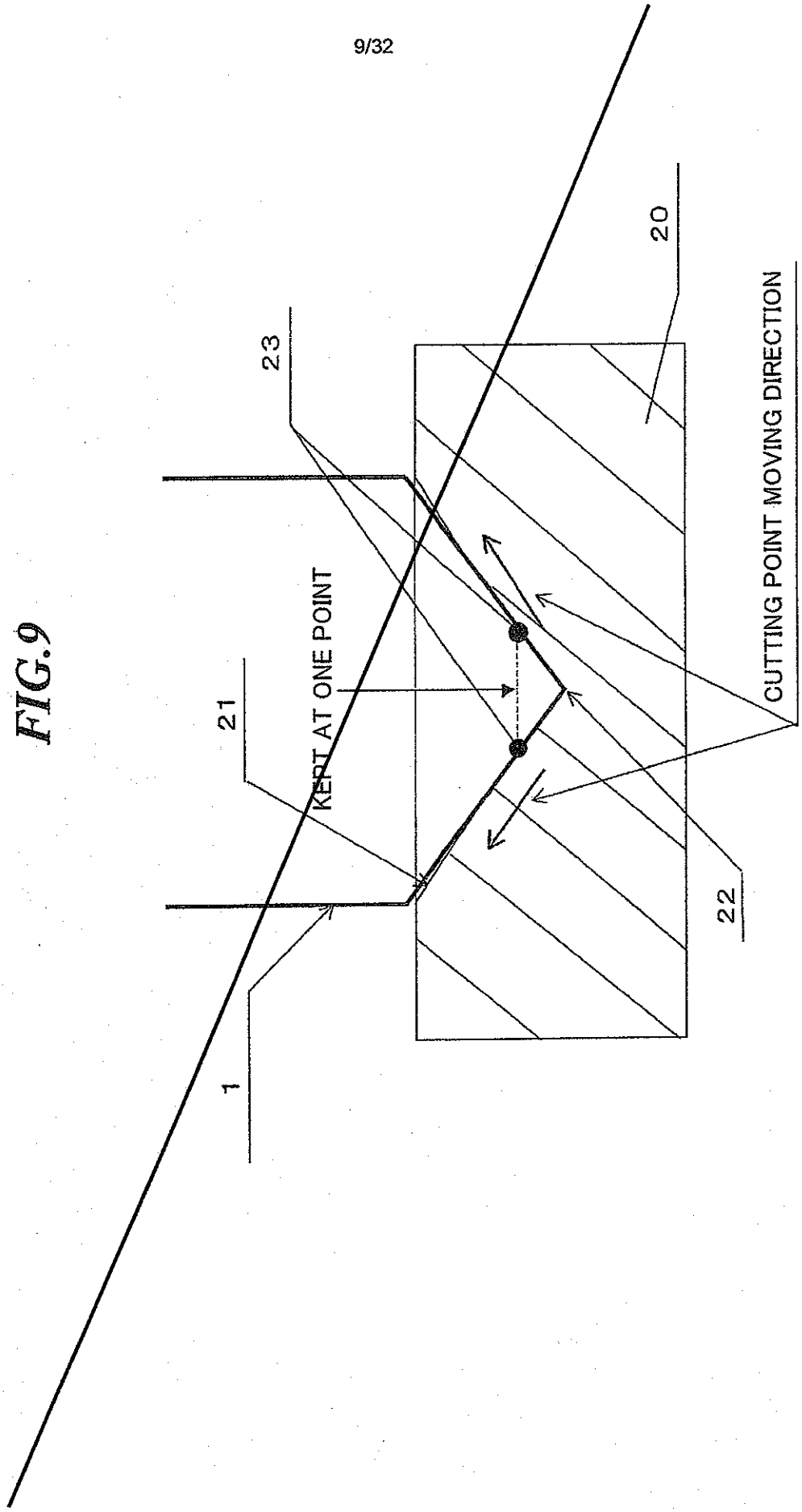
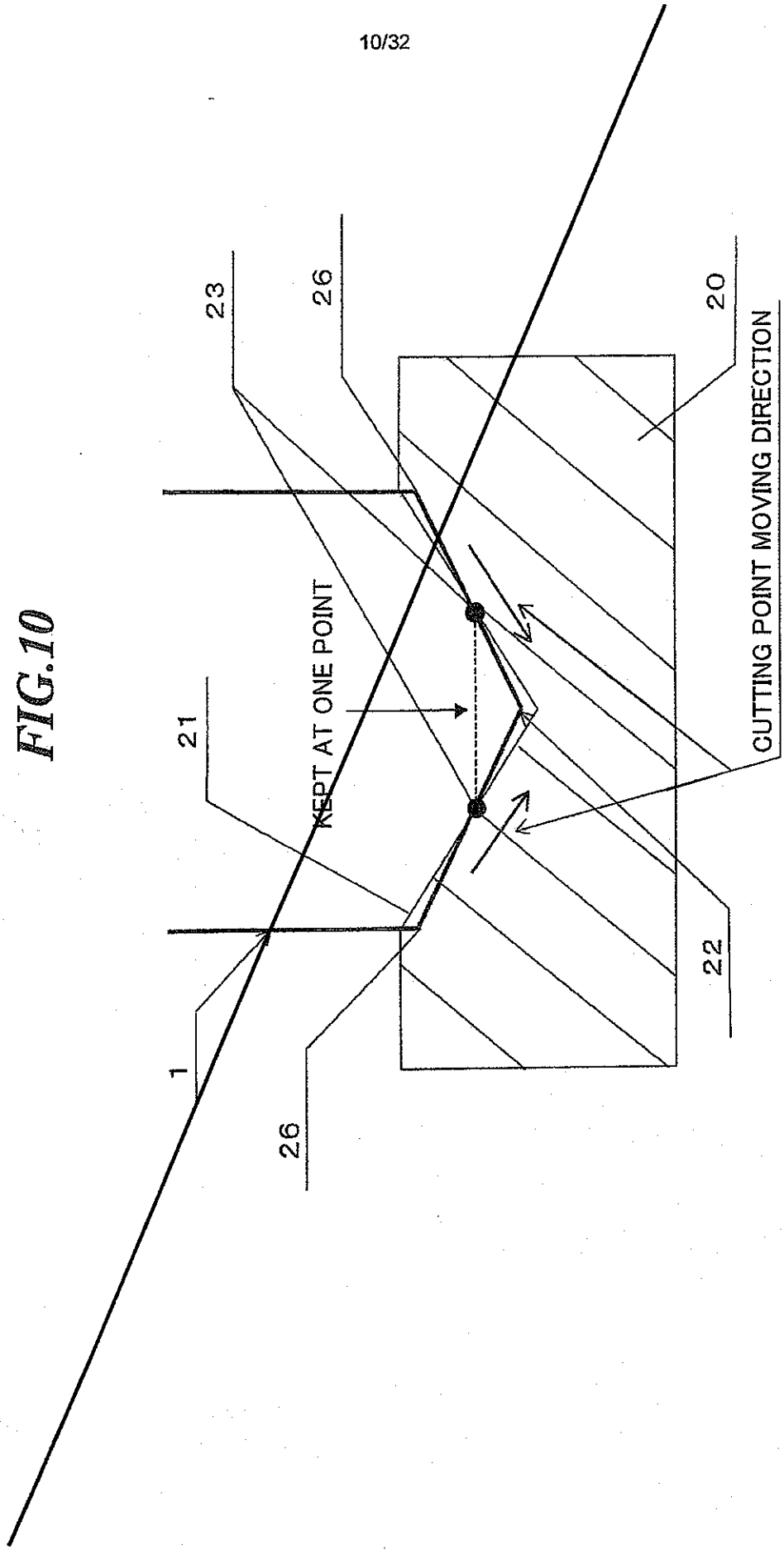

1
21
23
KEPT AT ONE POINT
20
22
CUTTING POINT MOVING DIRECTION

FIG.10


23
26
20
KEPT AT ONE POINT
21
CUTTING POINT MOVING DIRECTION
22
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26

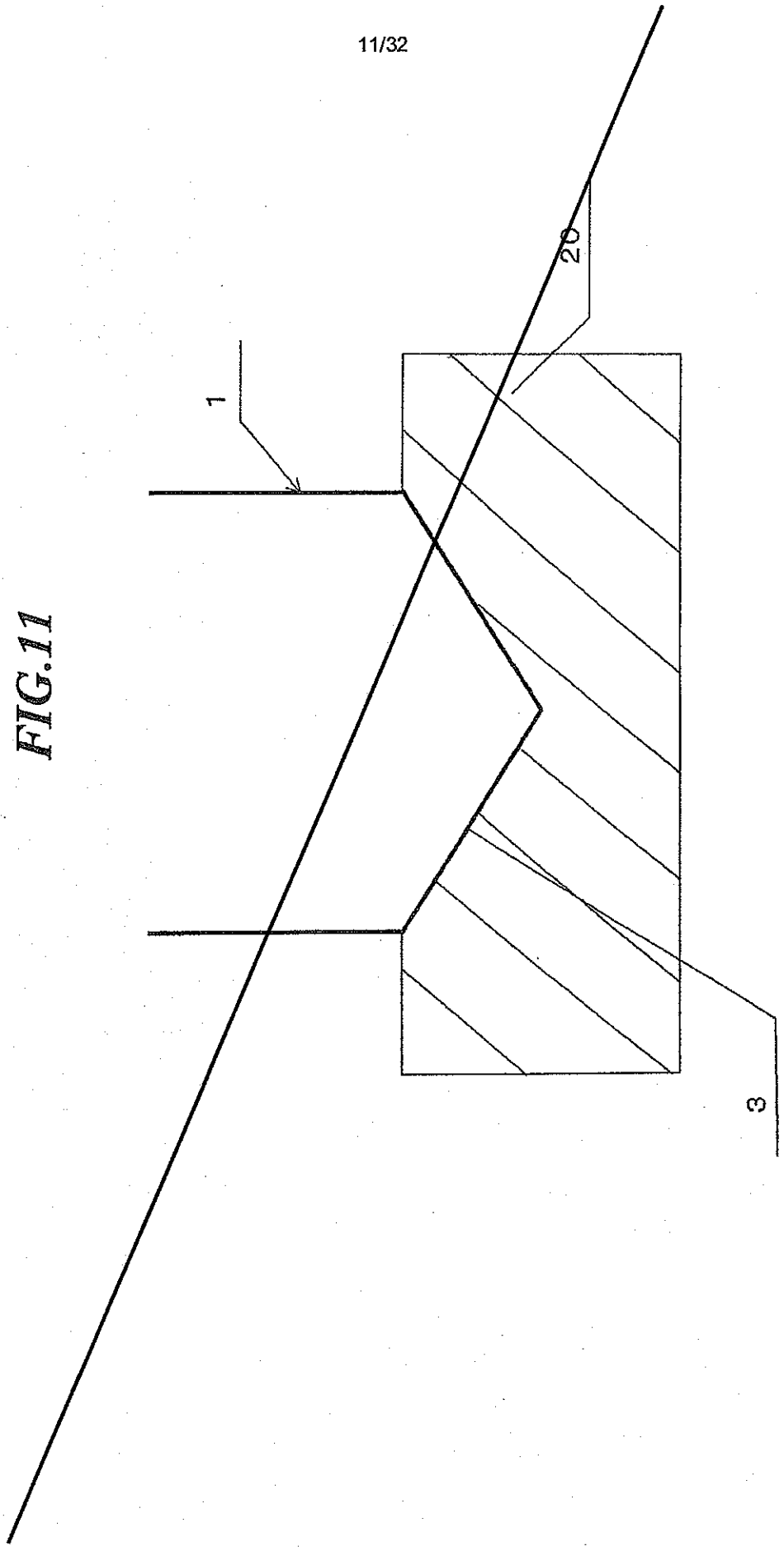


FIG.11

FIG.12

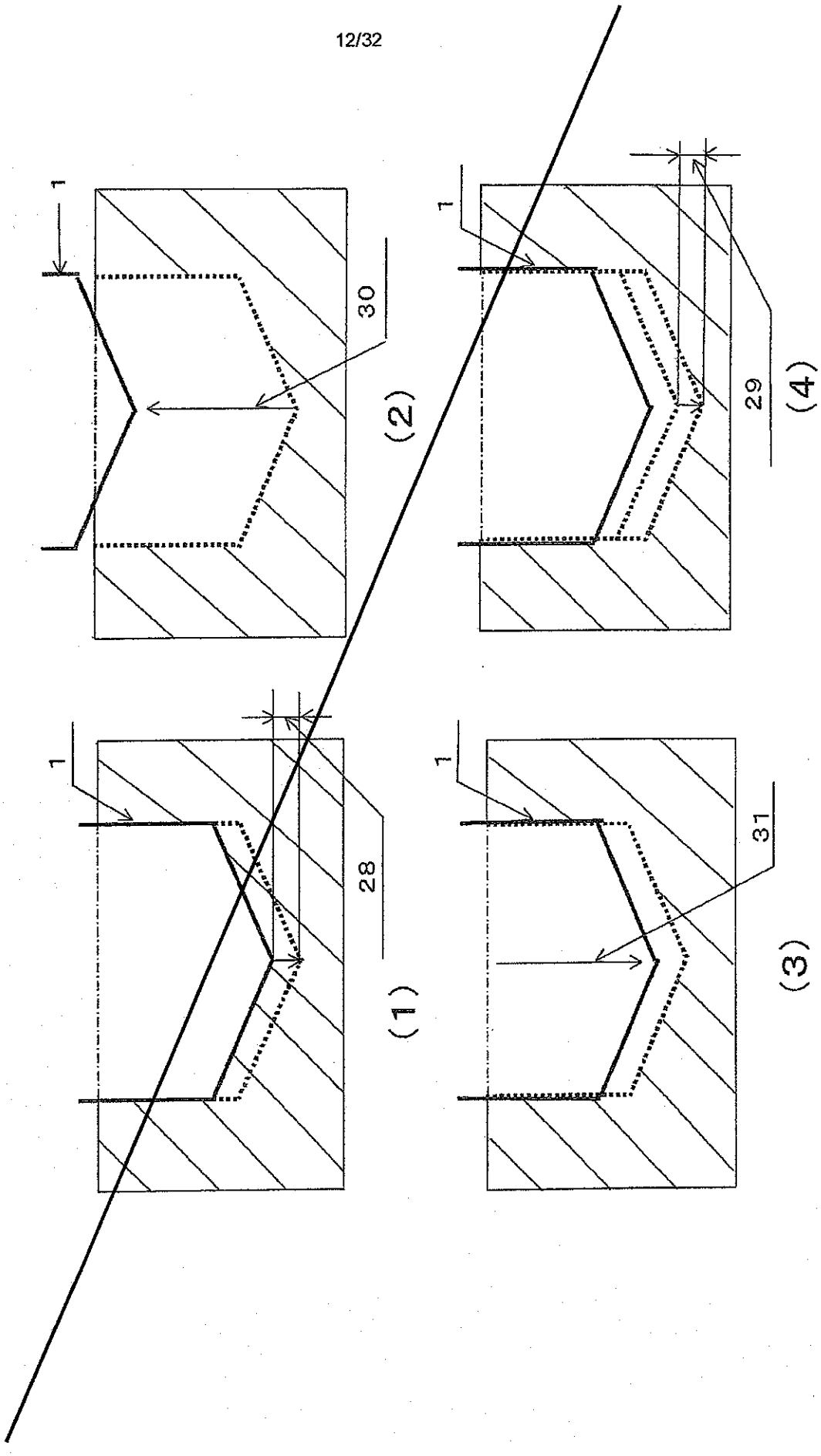


FIG.13

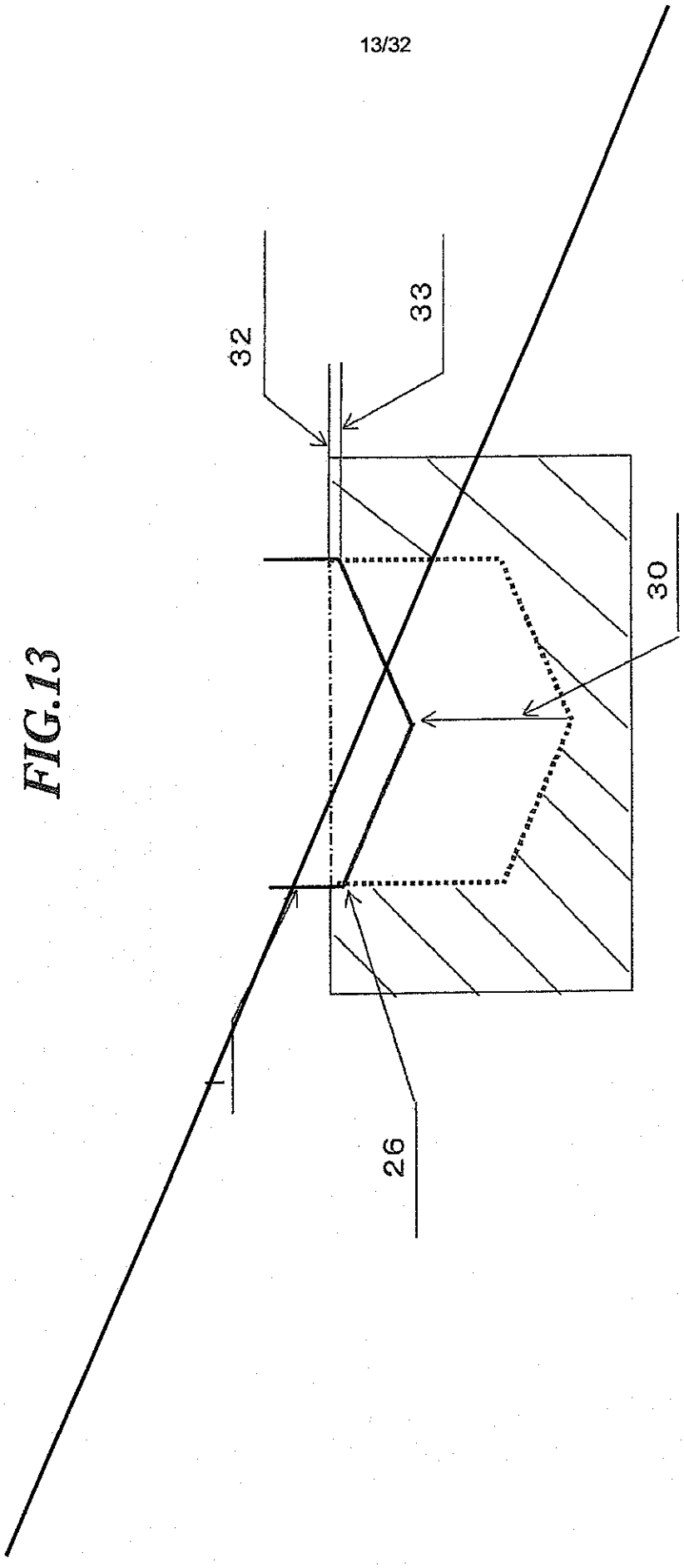


FIG.14

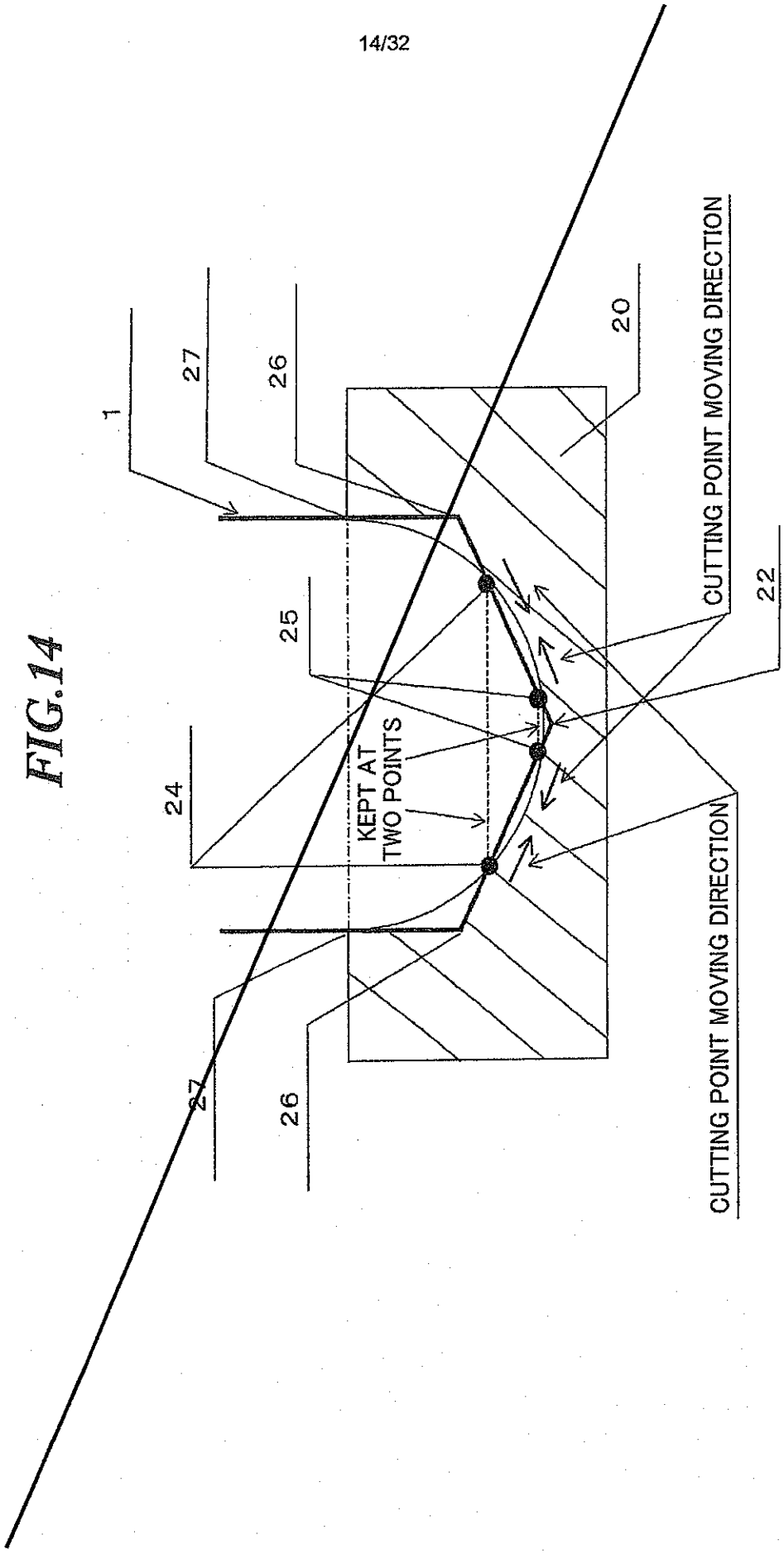

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KEPT AT
TWO POINTS
CUTTING POINT MOVING DIRECTION
27
26
CUTTING POINT MOVING DIRECTION

FIG.15

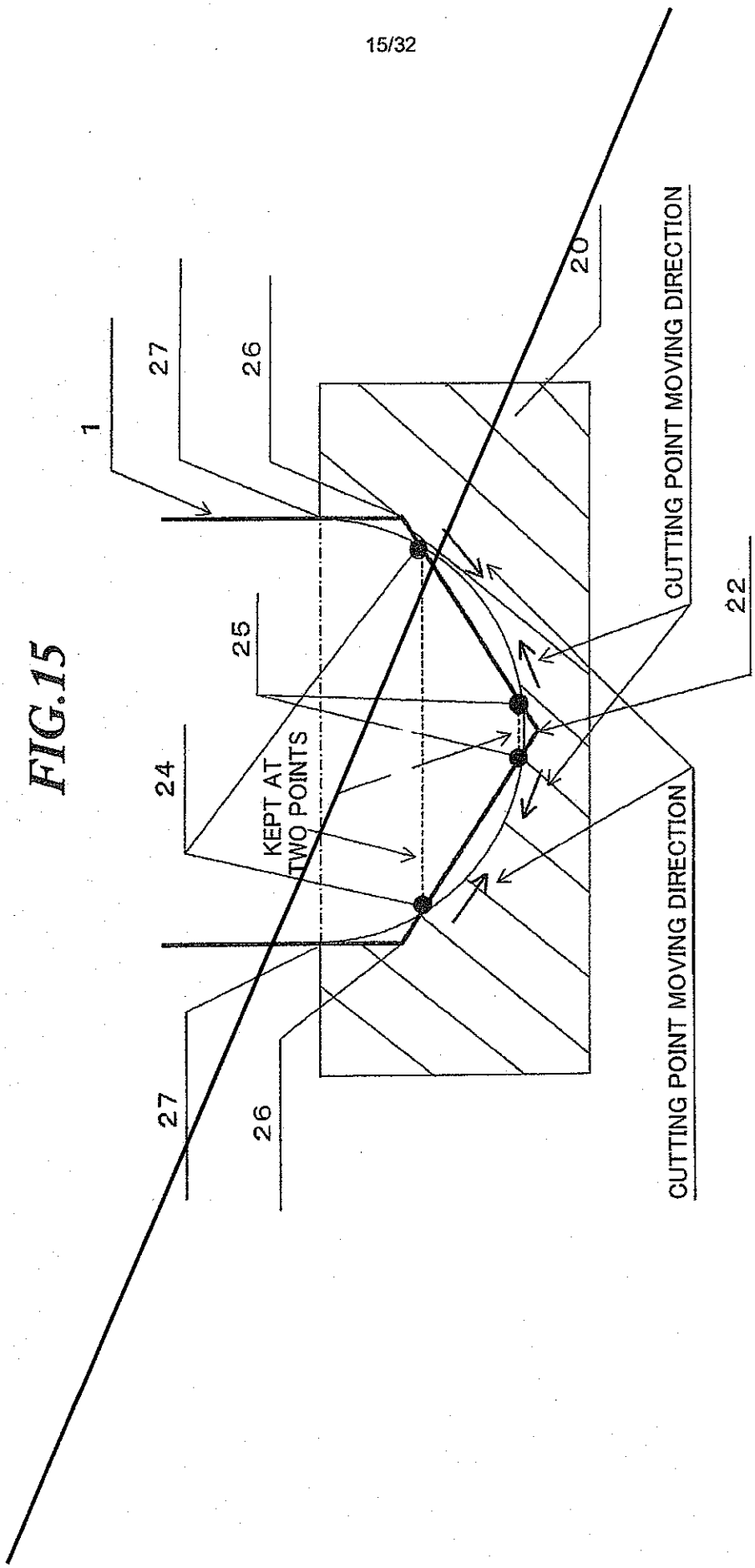

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KEPT AT
TWO POINTS
CUTTING POINT MOVING DIRECTION
27
26
CUTTING POINT MOVING DIRECTION

FIG.16

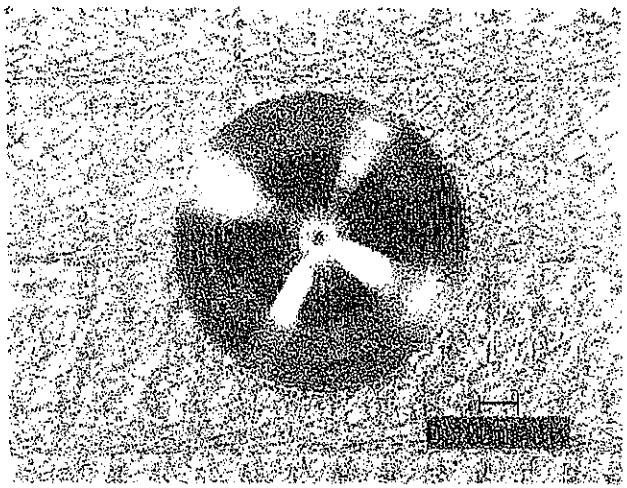
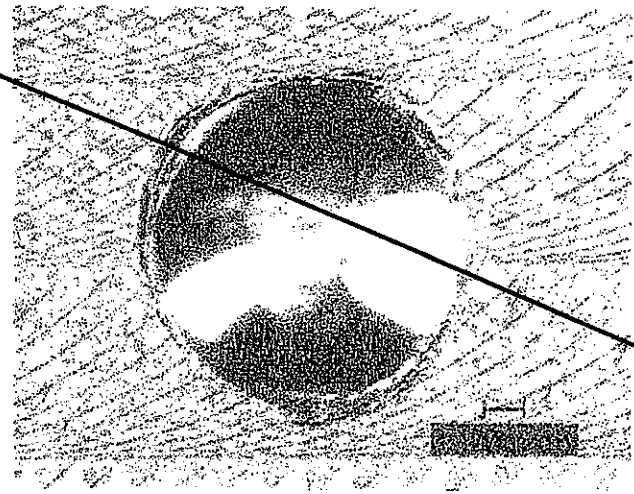
GUIDE HOLE DRILLING (Vf=100mm/min) USING A BALL END MILL (φ0.8mm) HAVING TWO CUTTING EDGES	GUIDE HOLE DRILLING (Vf=100mm/min) USING A SHORT DRILL(φ0.8mm)
	
HOLE DEPTH: 0.8mm HOLE DIAMETER: 0.799mm	HOLE DEPTH: 0.8mm HOLE DIAMETER: 0.874mm

FIG.17

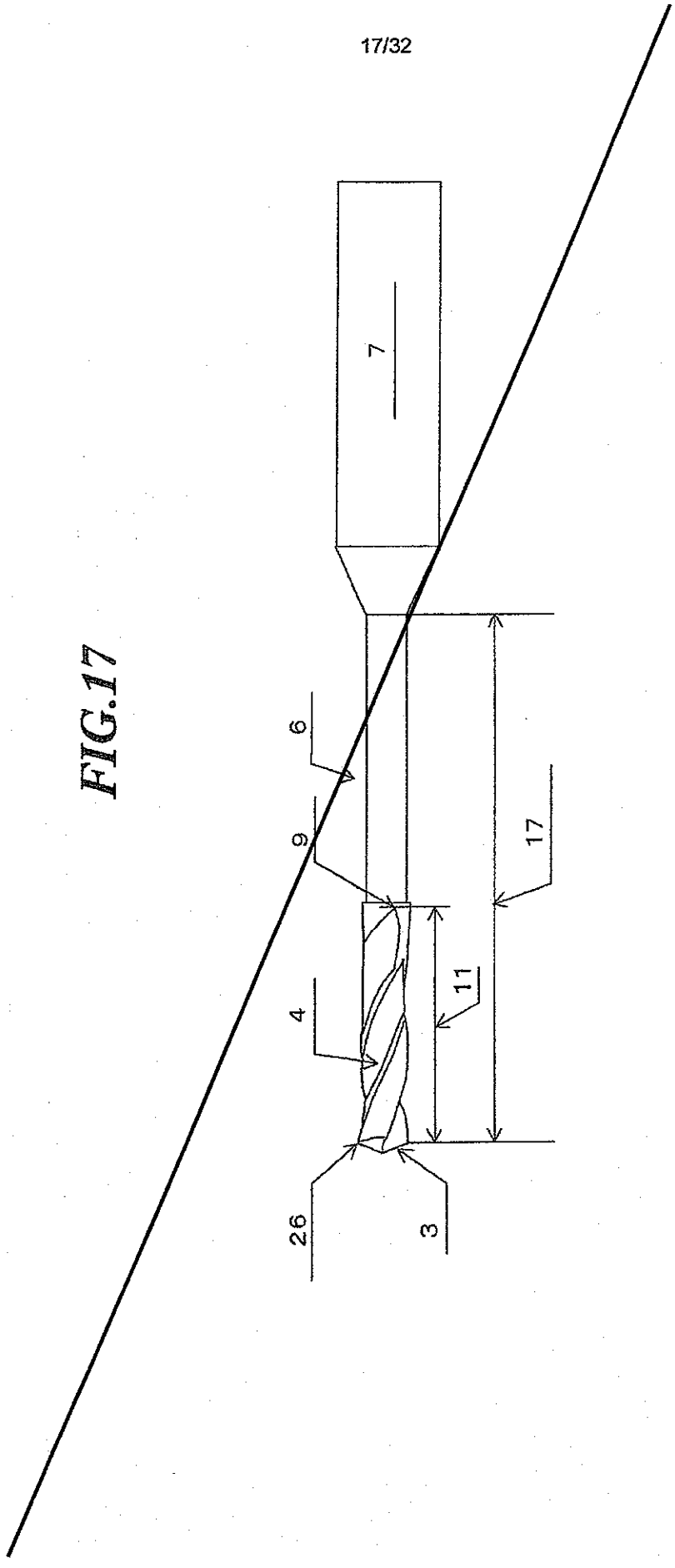


FIG.18

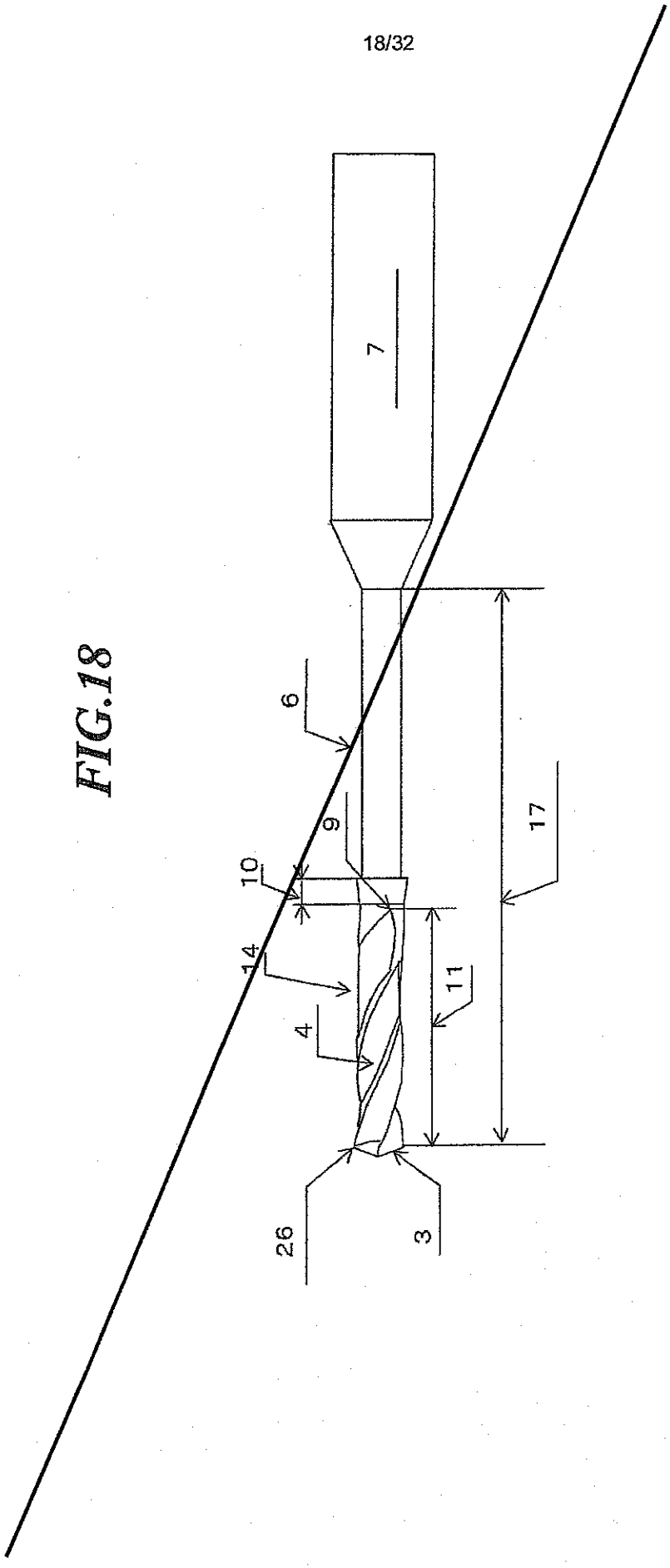
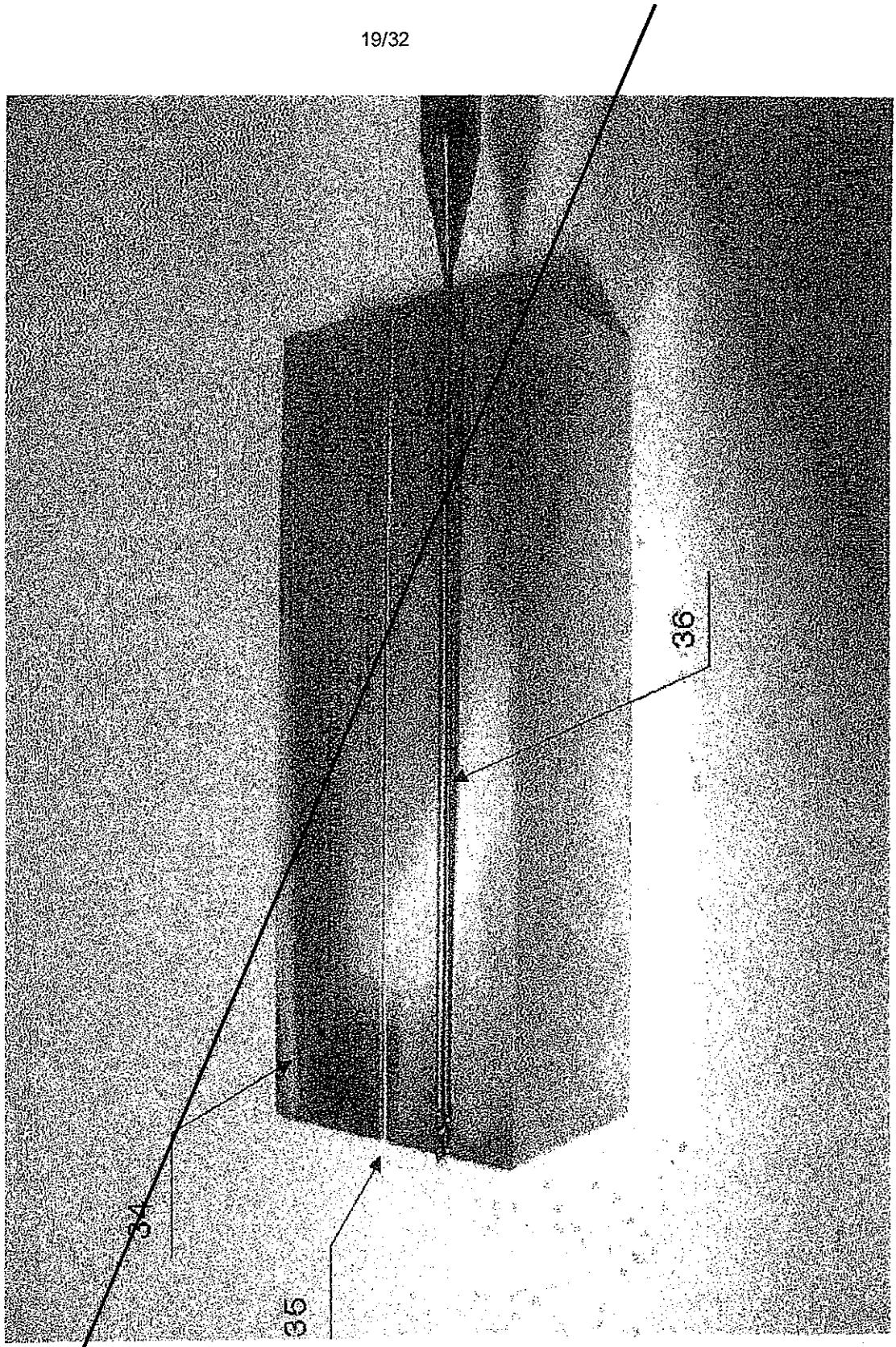


FIG.19



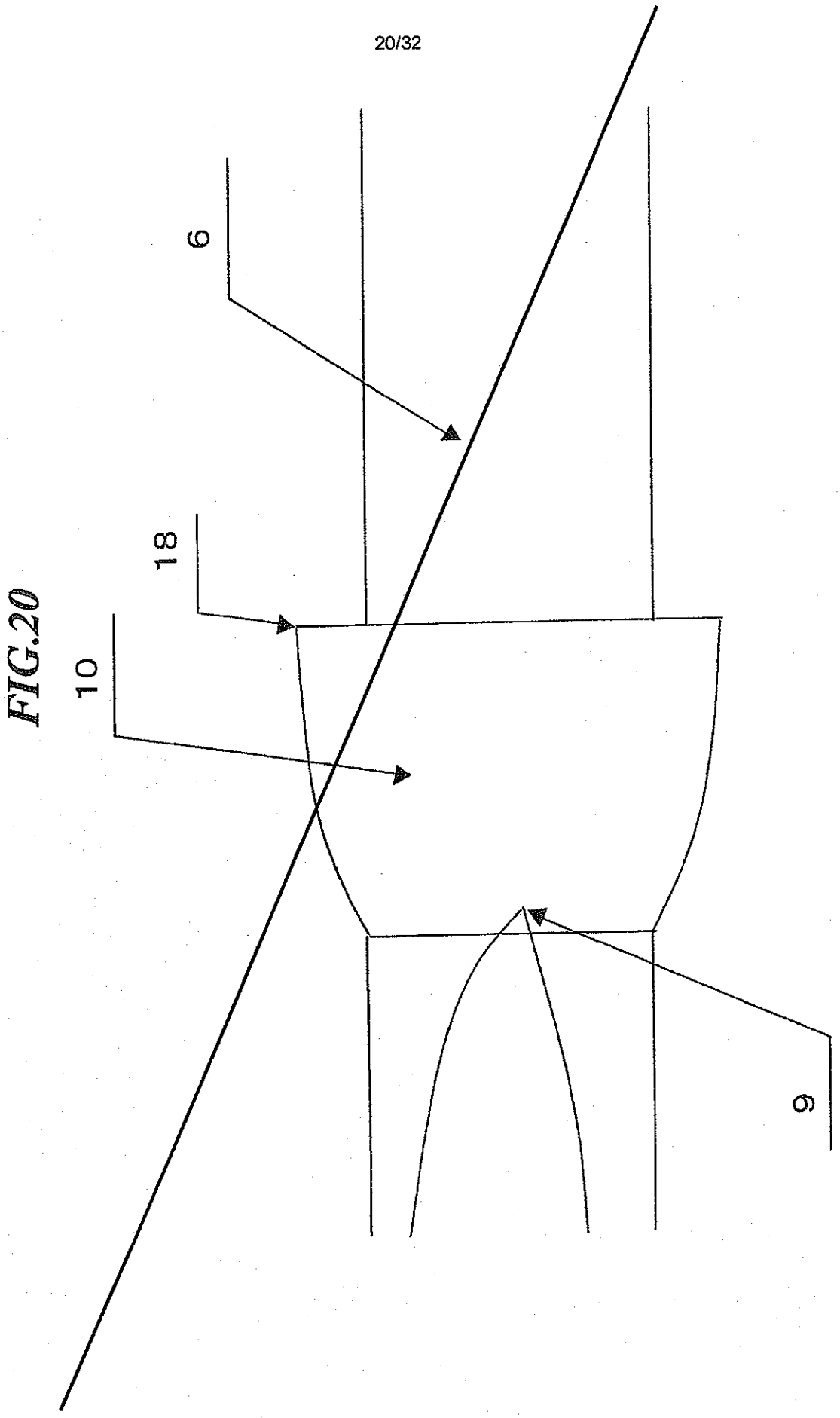


FIG.20

FIG.21

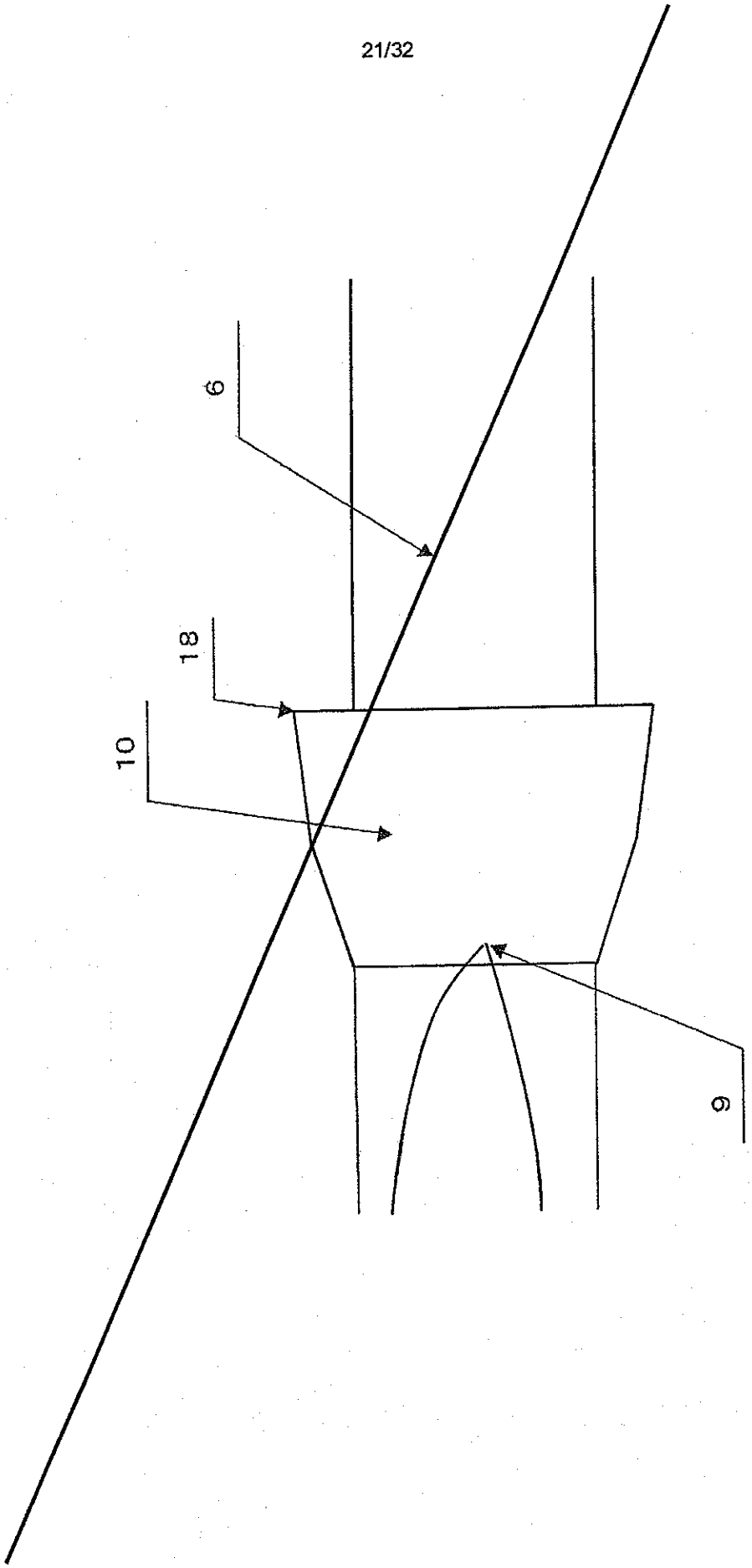


FIG.22

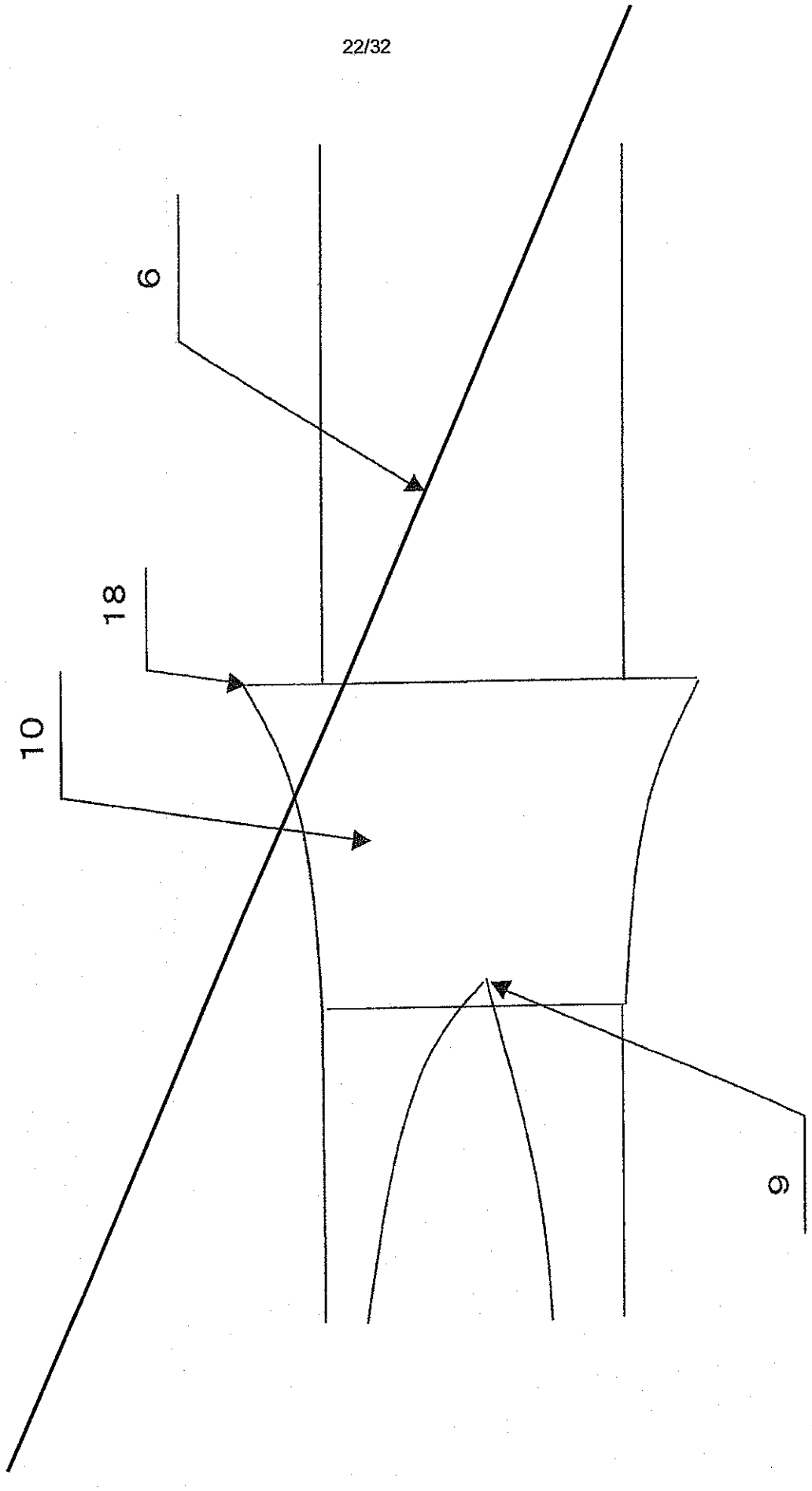


FIG.23

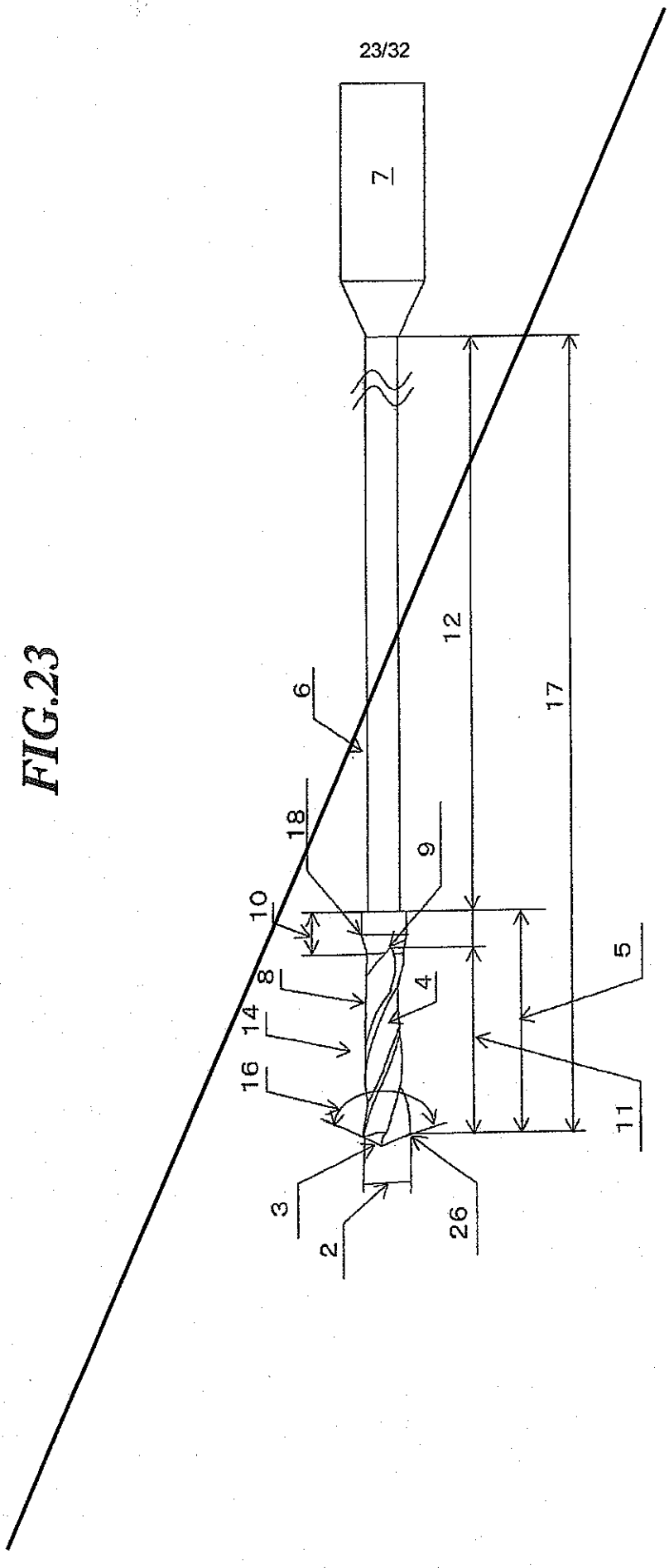


FIG.24

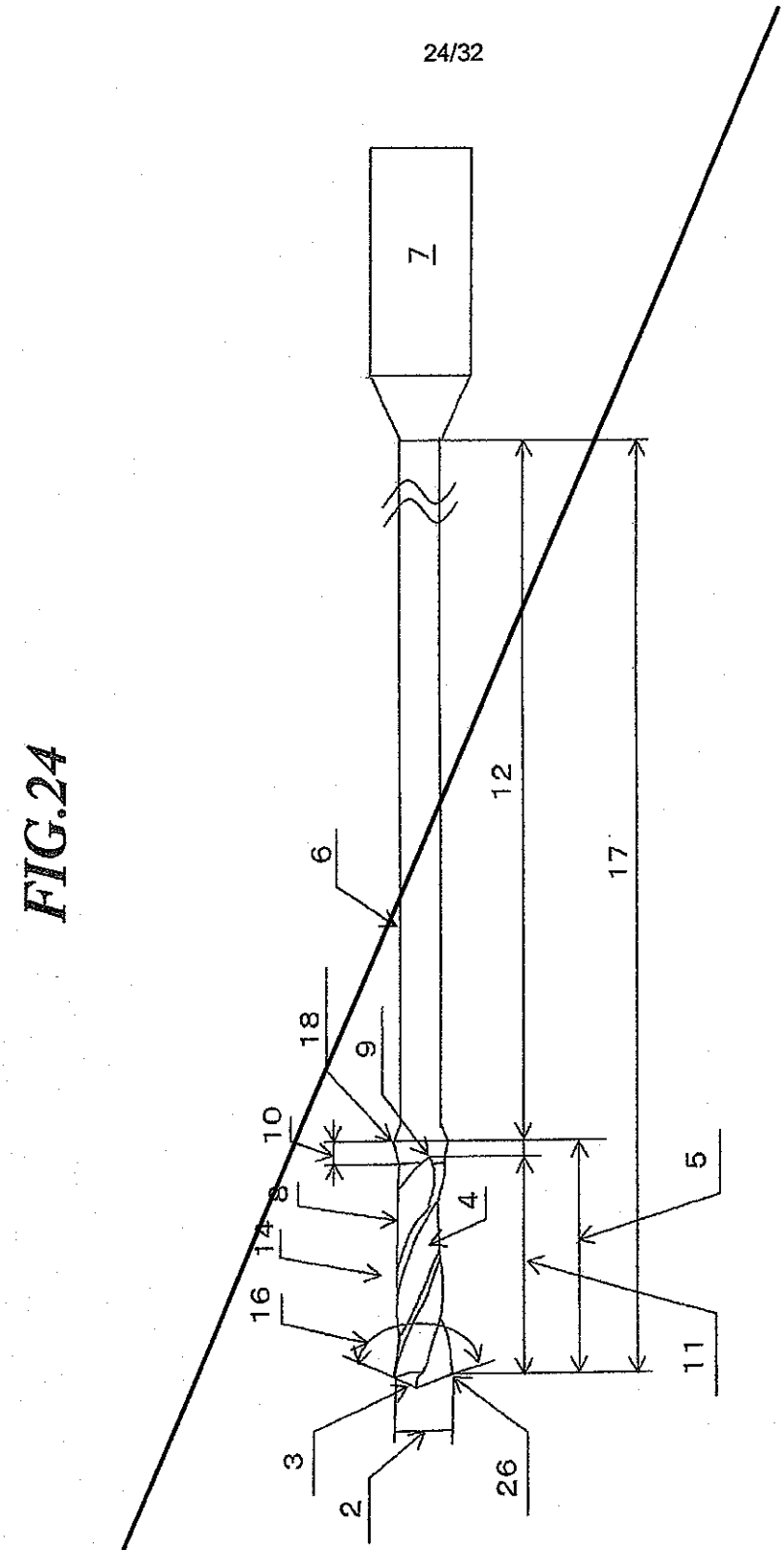


FIG.25

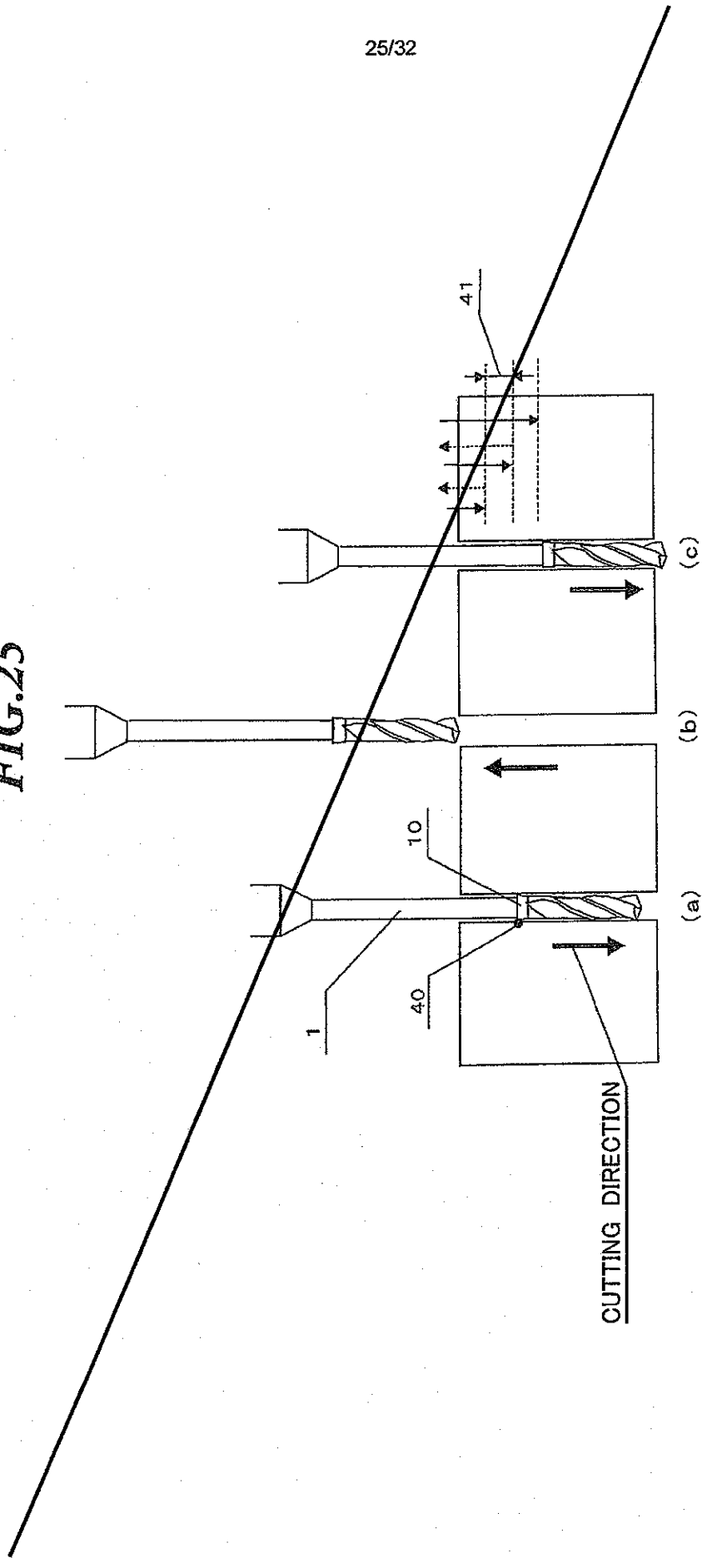


FIG.26(b)

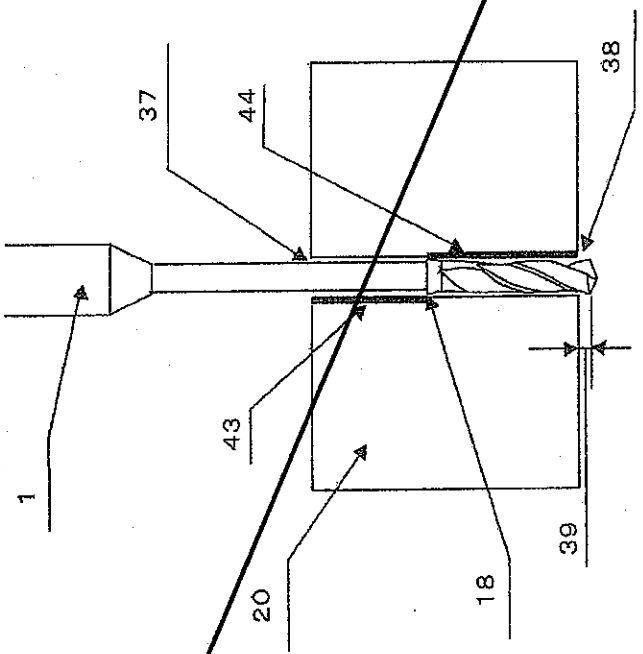


FIG.26(a)

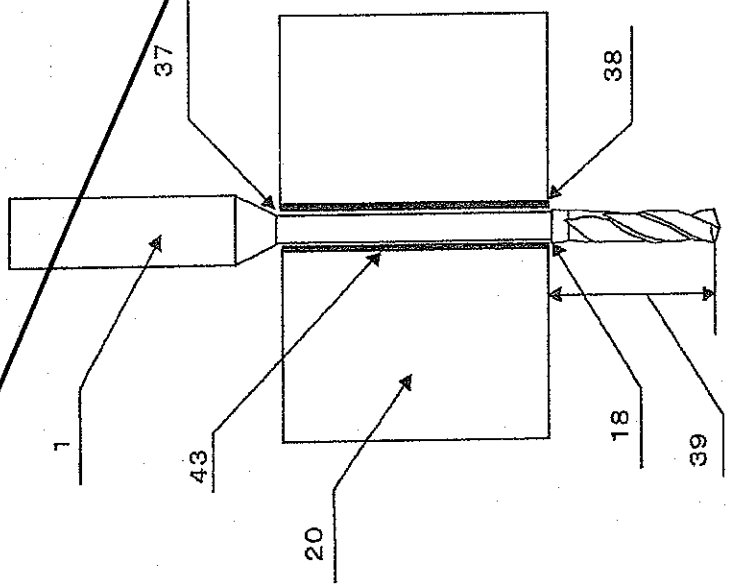


FIG.27

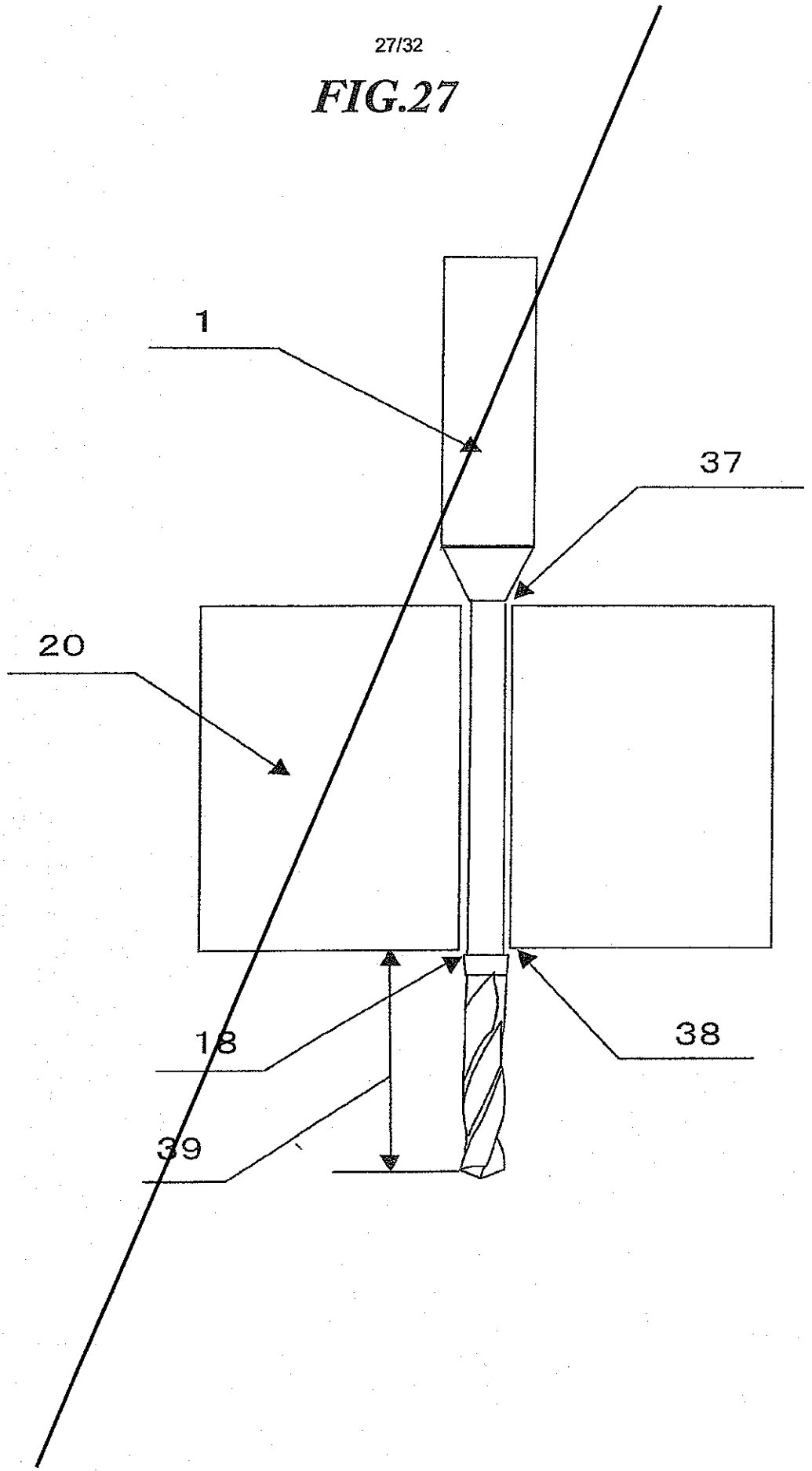


FIG.28

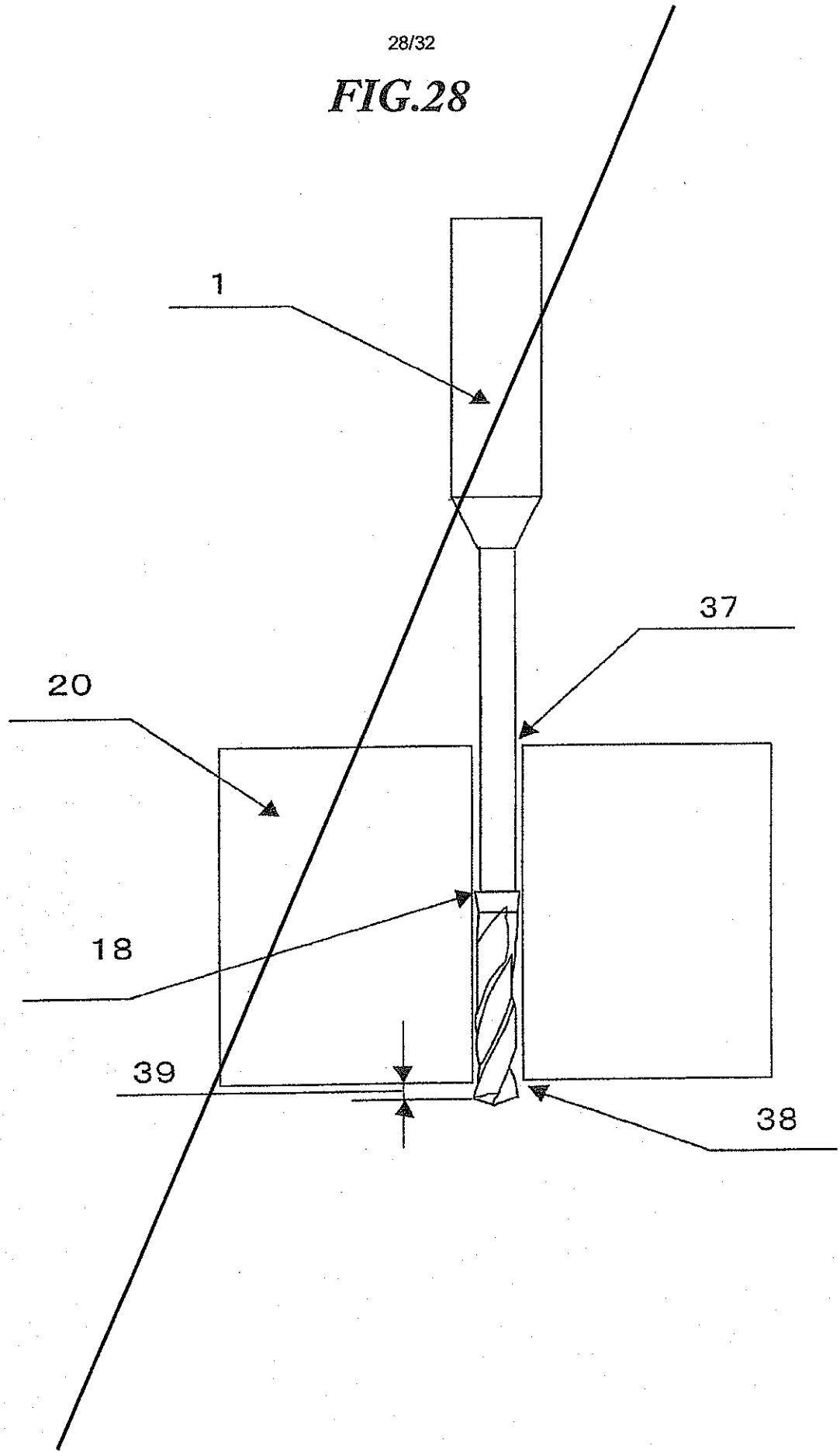


FIG.29

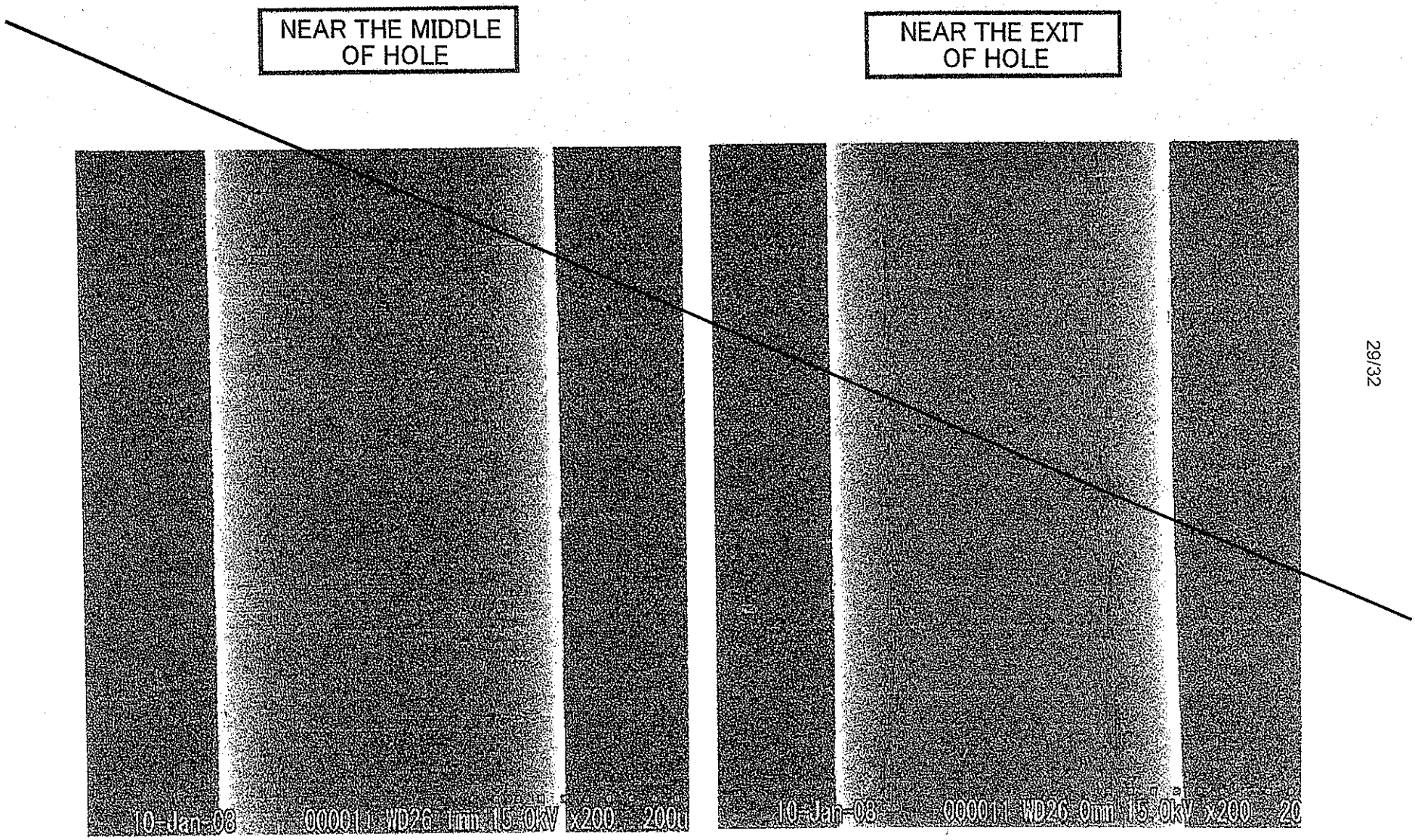

NEAR THE MIDDLE OF HOLE
NEAR THE EXIT OF HOLE
10-Jan-08
10-Jan-08

FIG.30

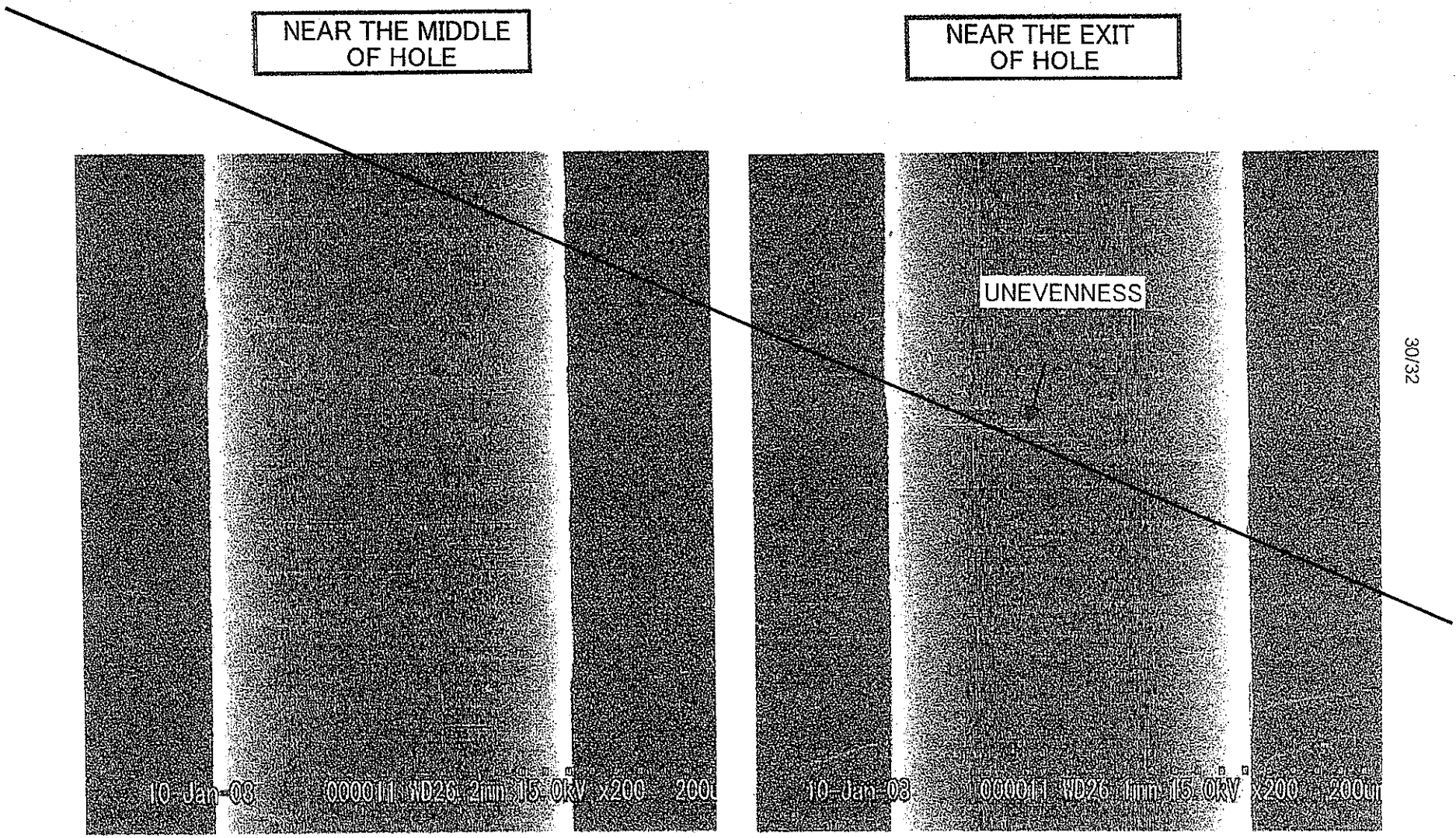

NEAR THE MIDDLE OF HOLE
NEAR THE EXIT OF HOLE
UNEVENNESS
10-Jan-08
10-Jan-08

FIG.31

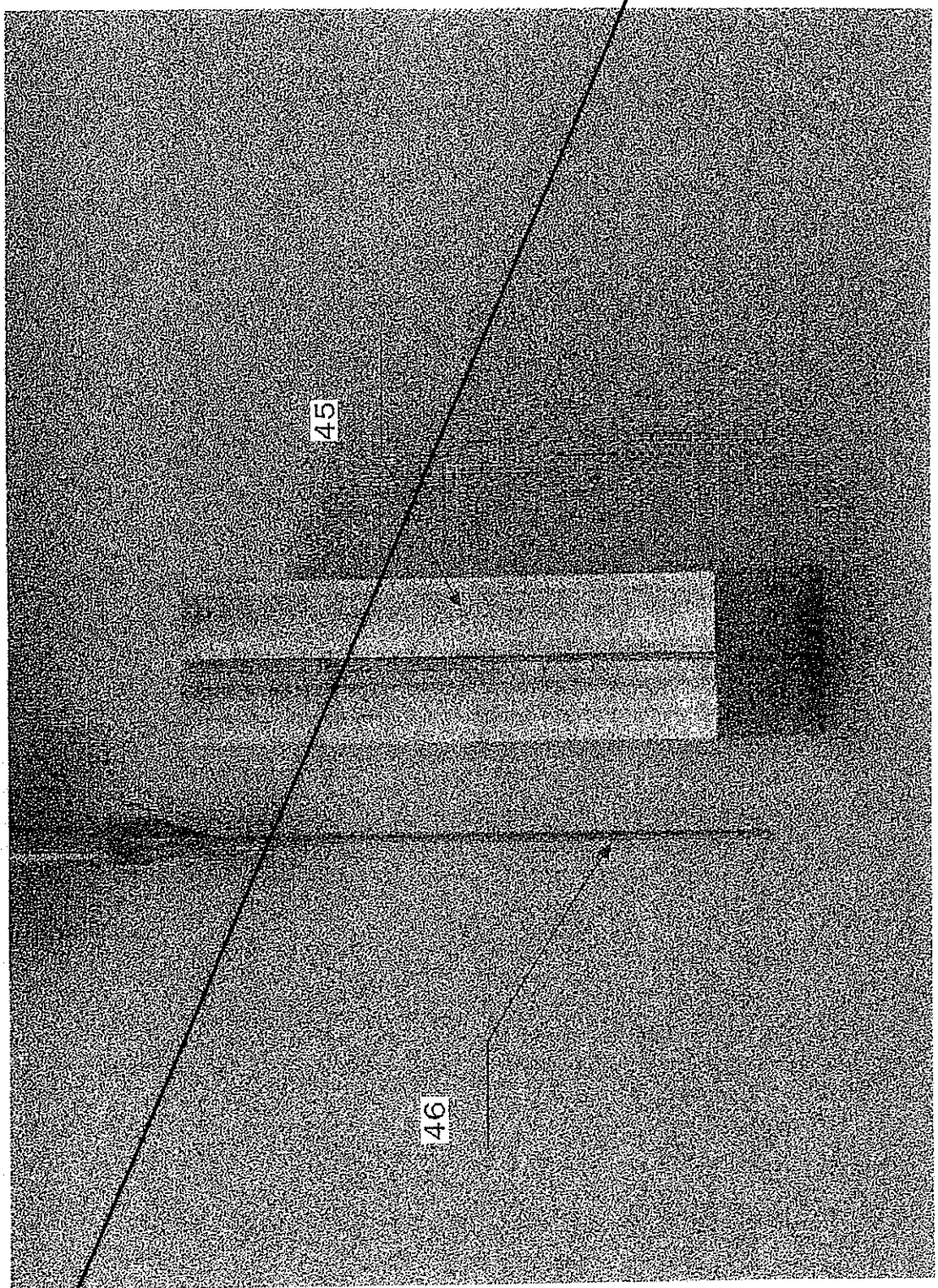


FIG.32(a)

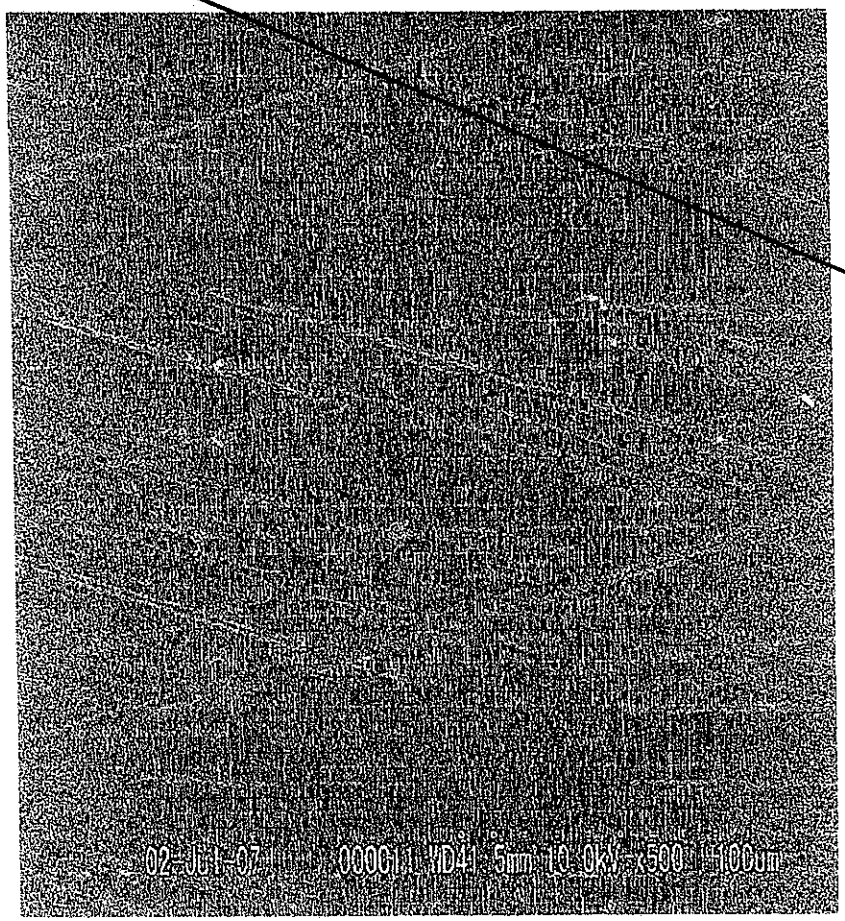


FIG.32(b)

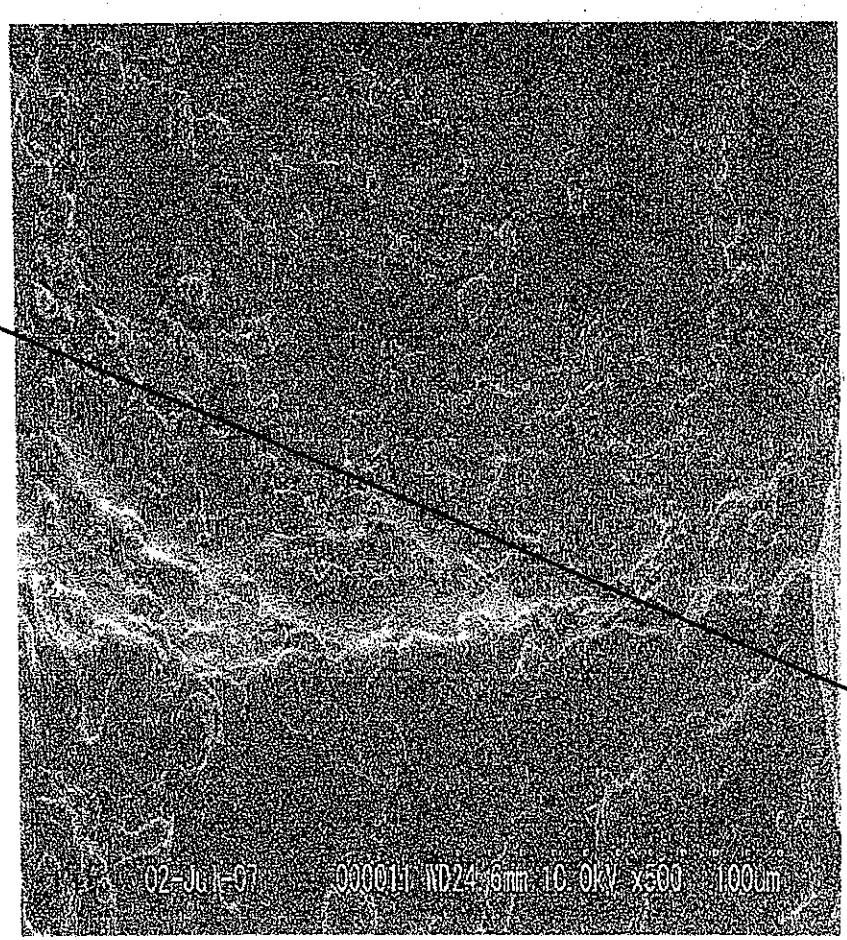


FIG.1

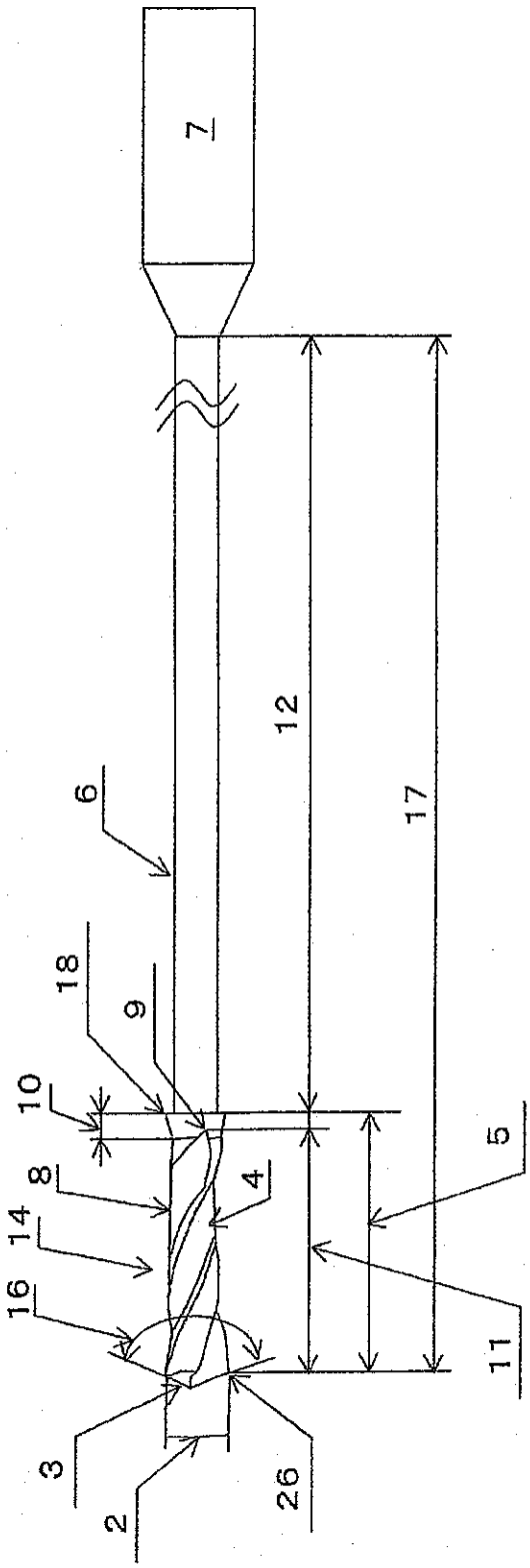


FIG.2

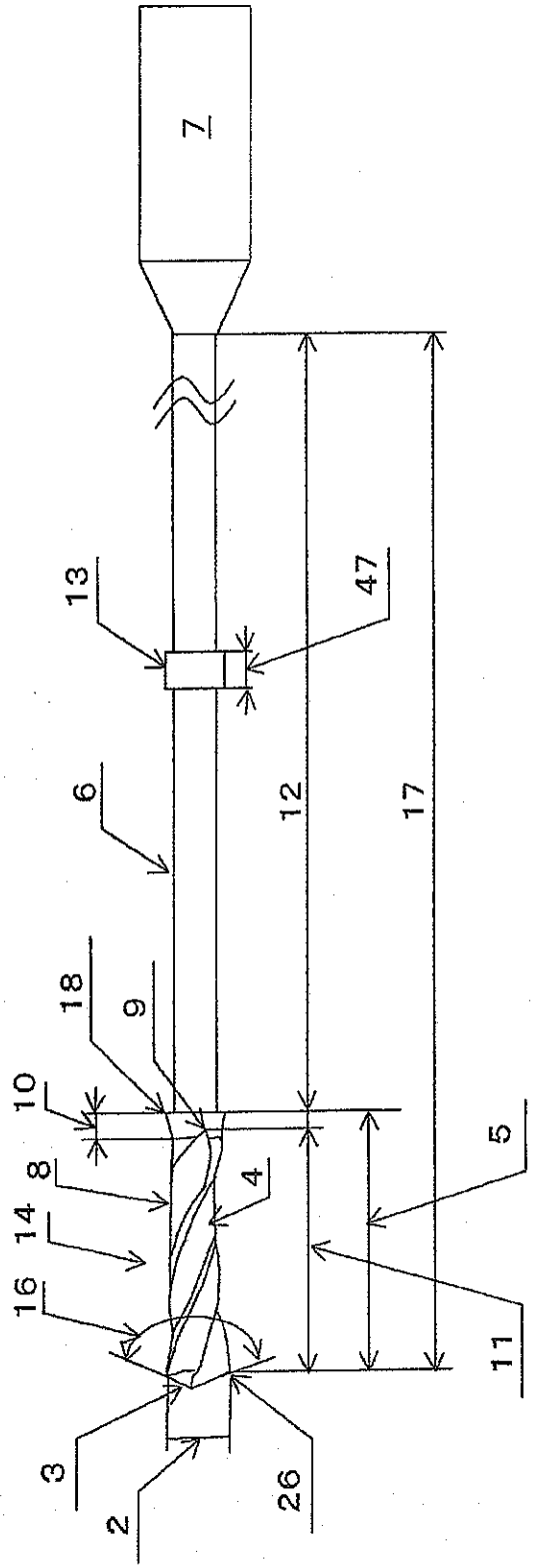


FIG.3

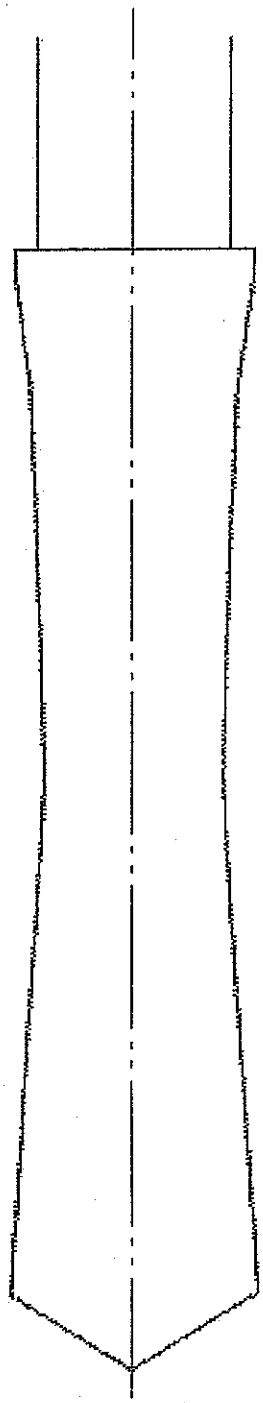


FIG.4

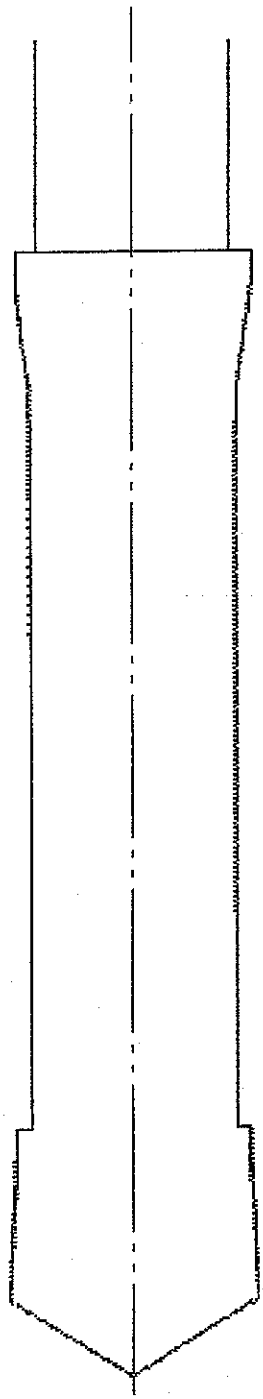


FIG.5

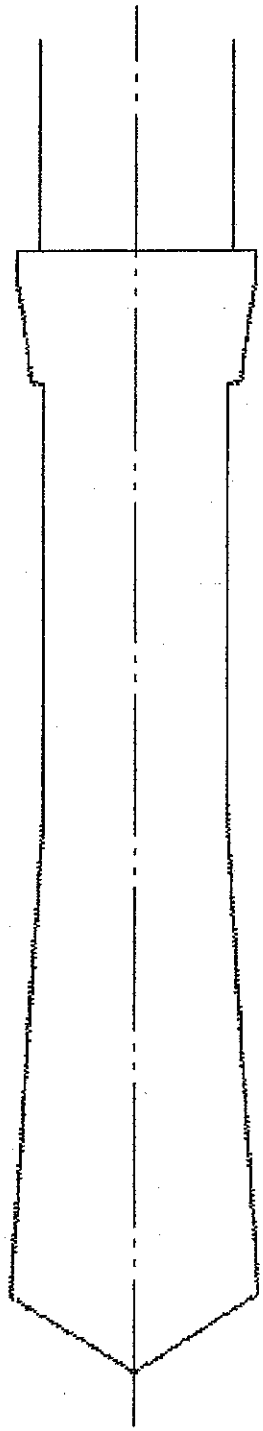


FIG.6

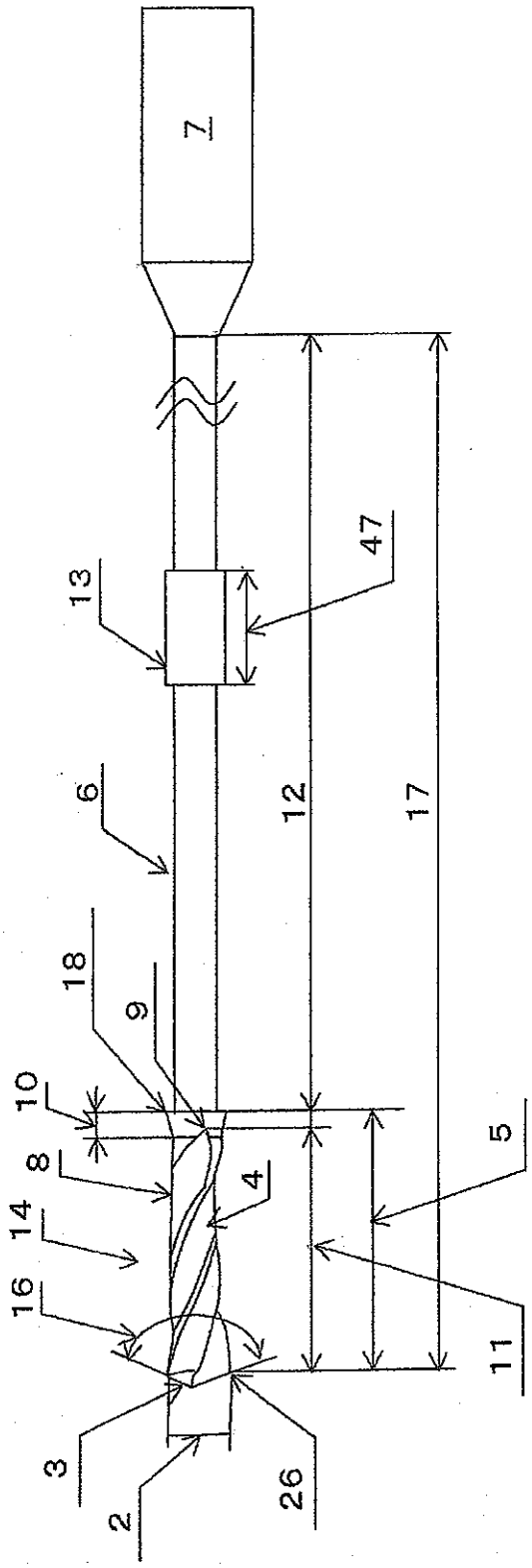


FIG.7

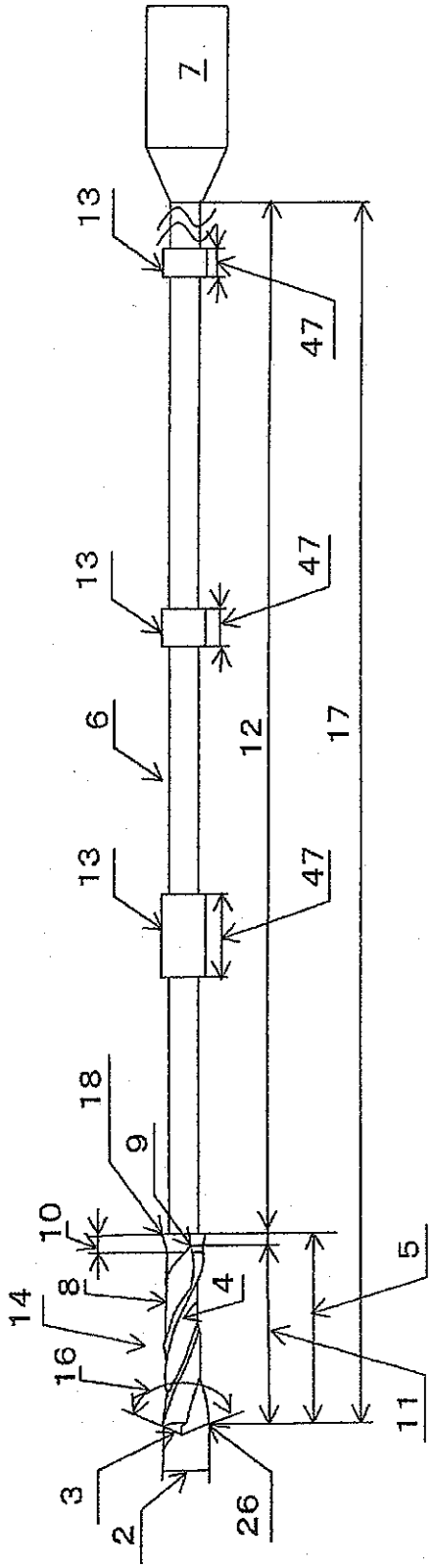


FIG.8

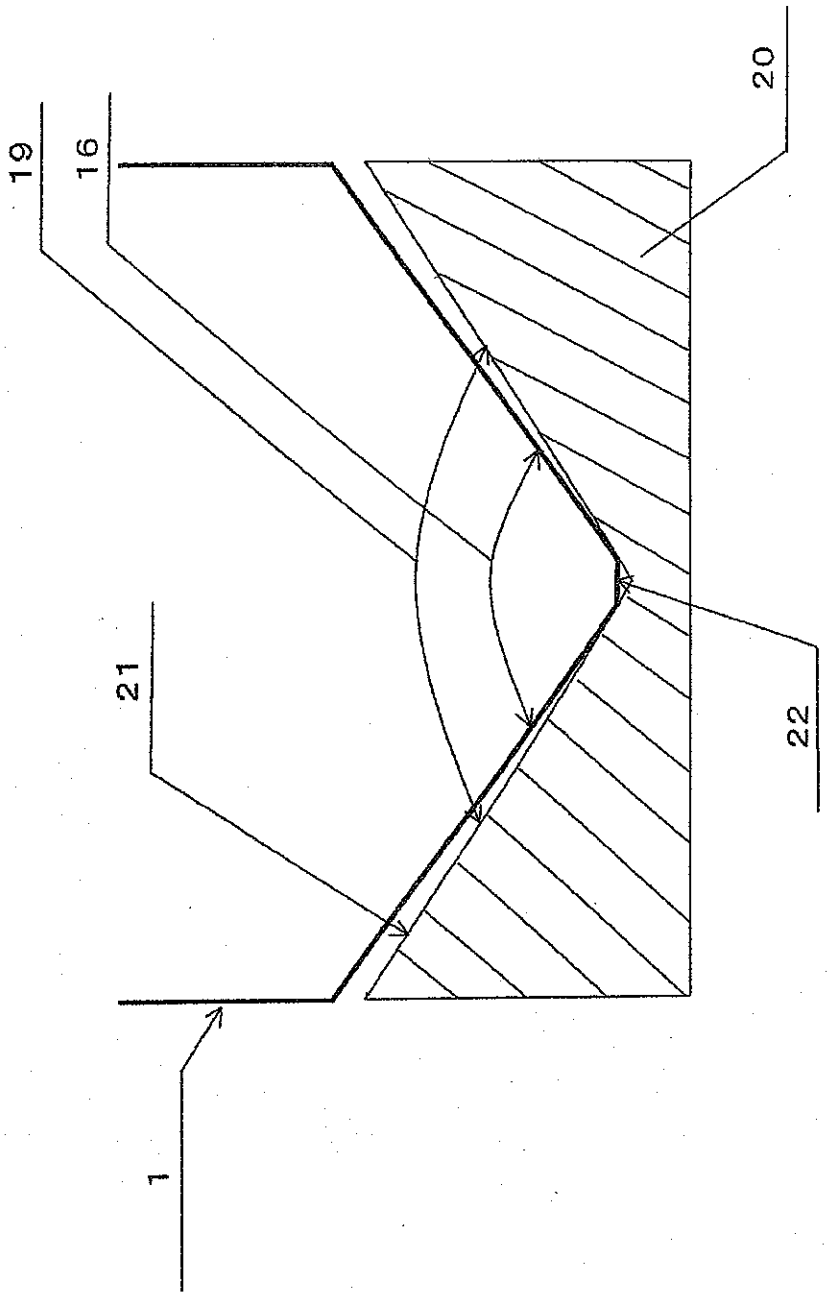


FIG.9

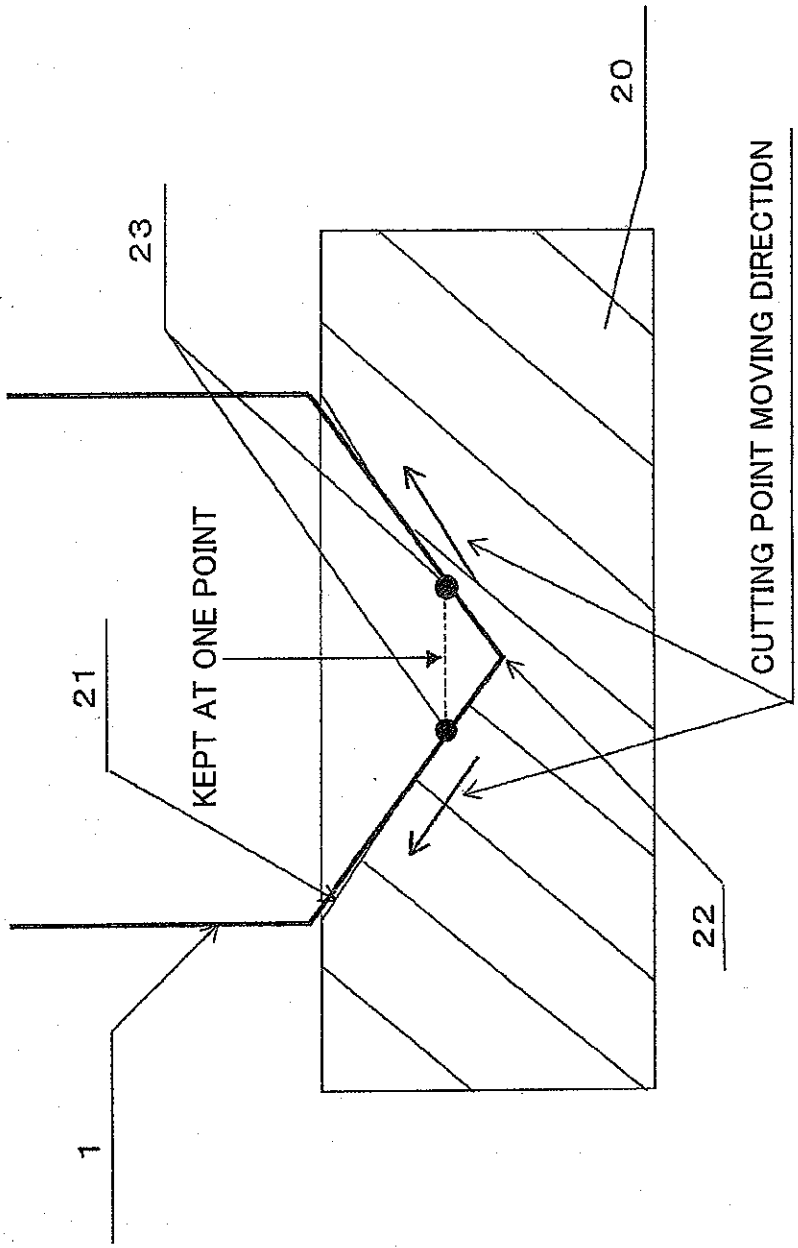

20
23
KEPT AT ONE POINT
21
CUTTING POINT MOVING DIRECTION
22
1

FIG.10

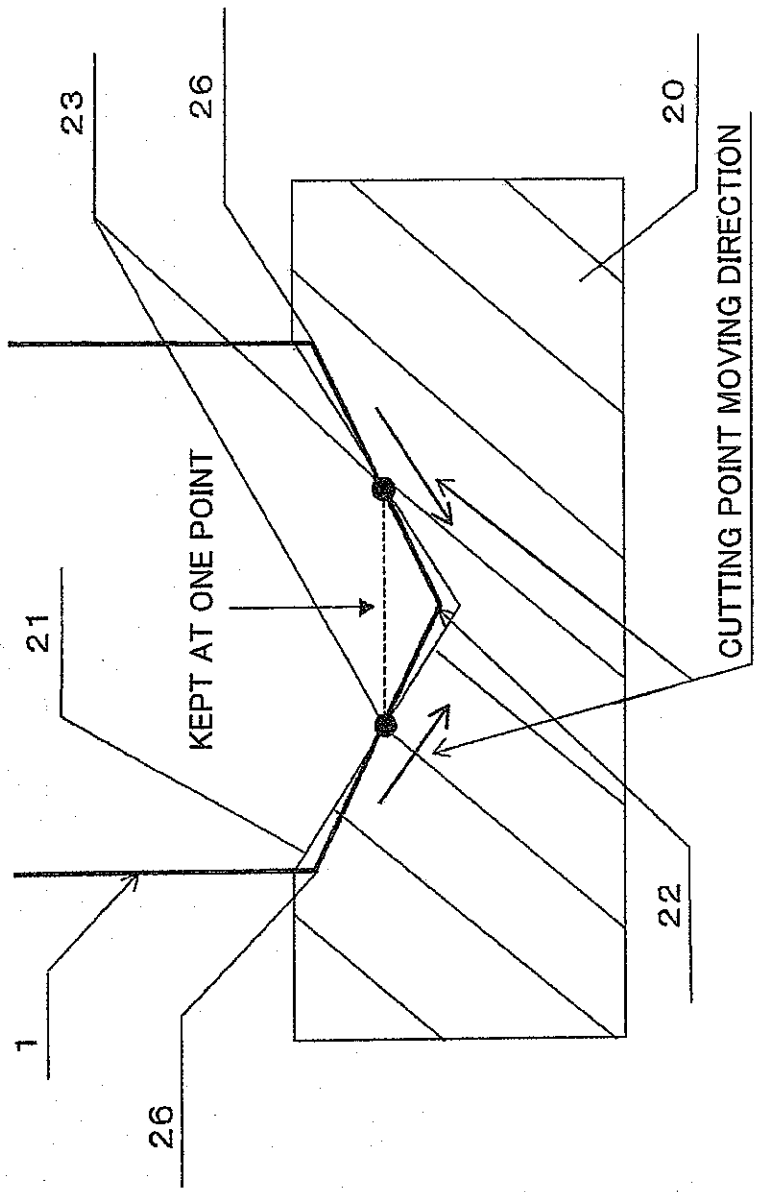

23
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KEPT AT ONE POINT
CUTTING POINT MOVING DIRECTION
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FIG.11

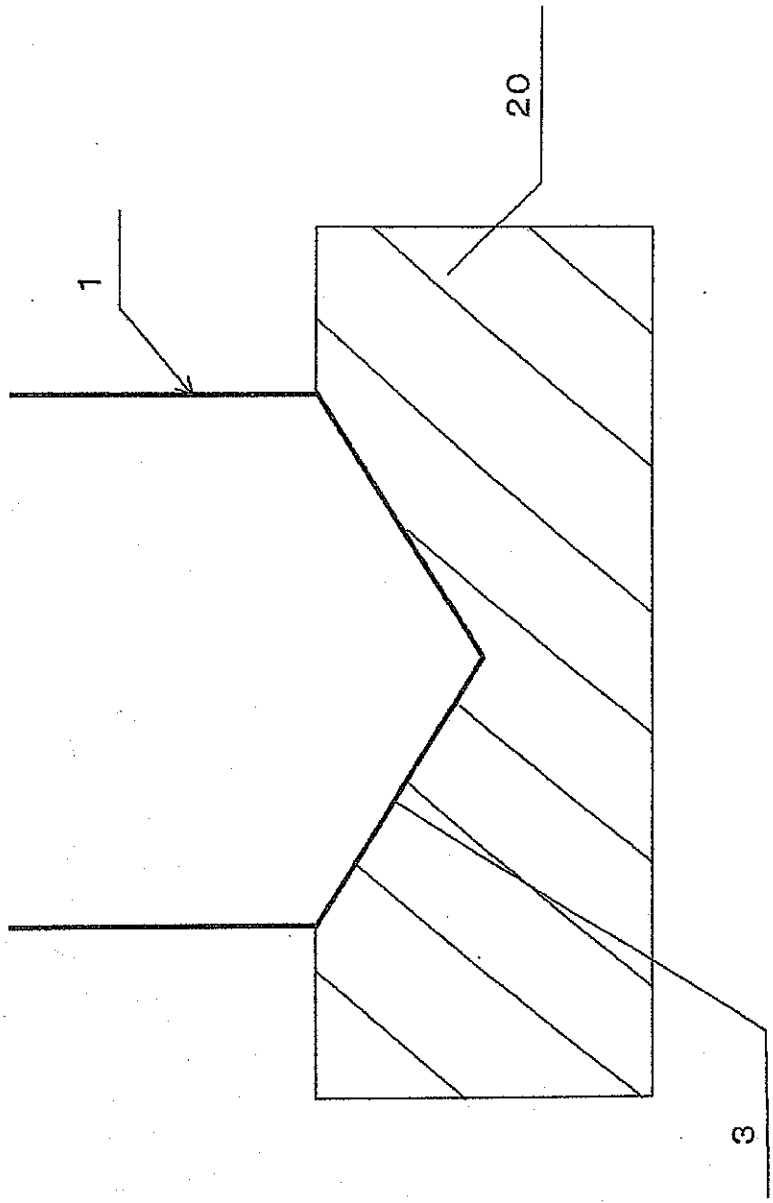


FIG.12

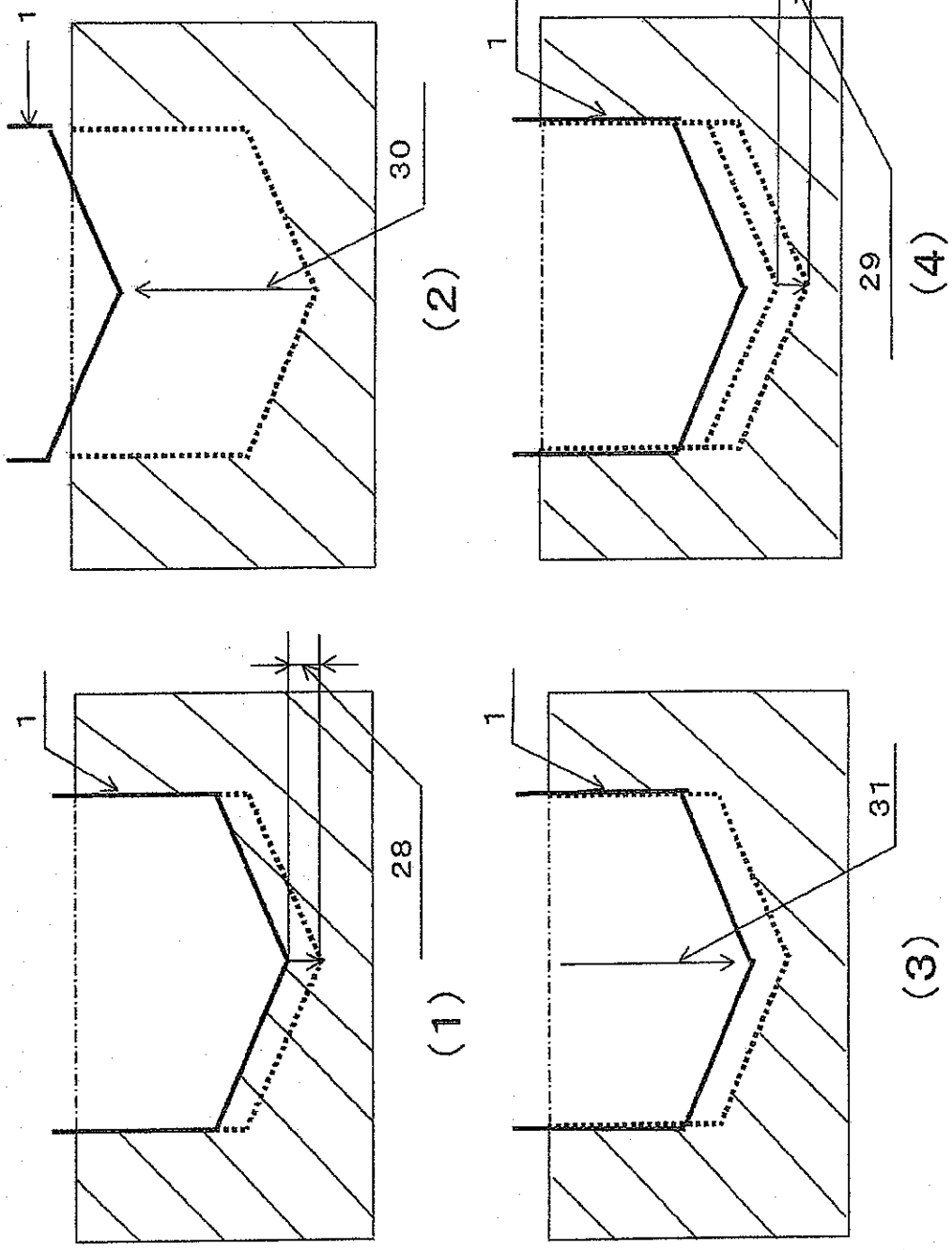


FIG.13

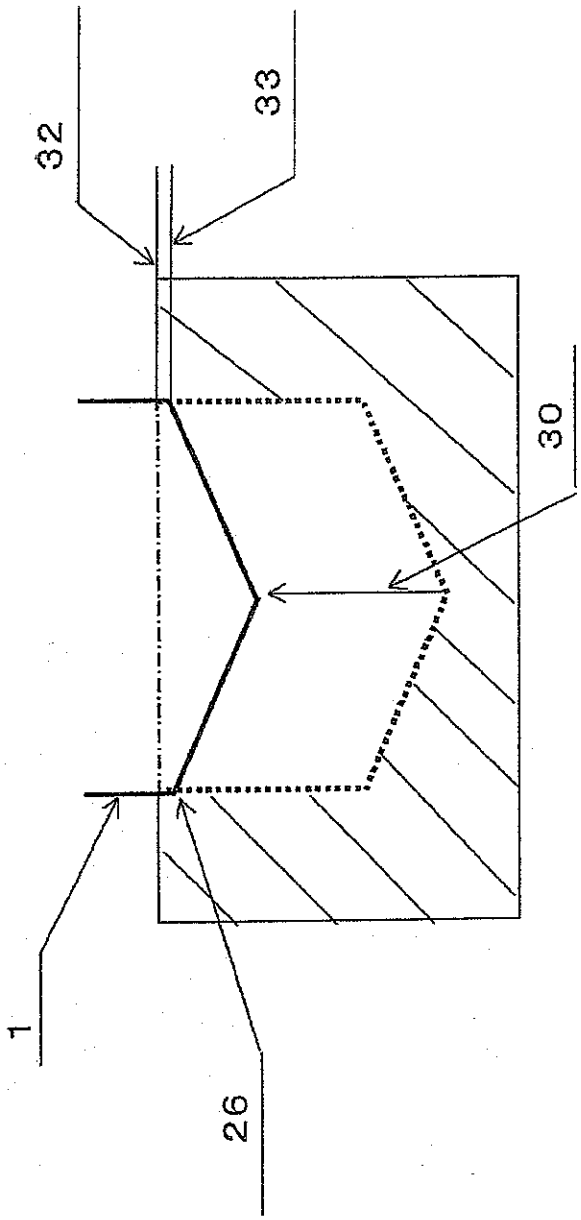


FIG.14

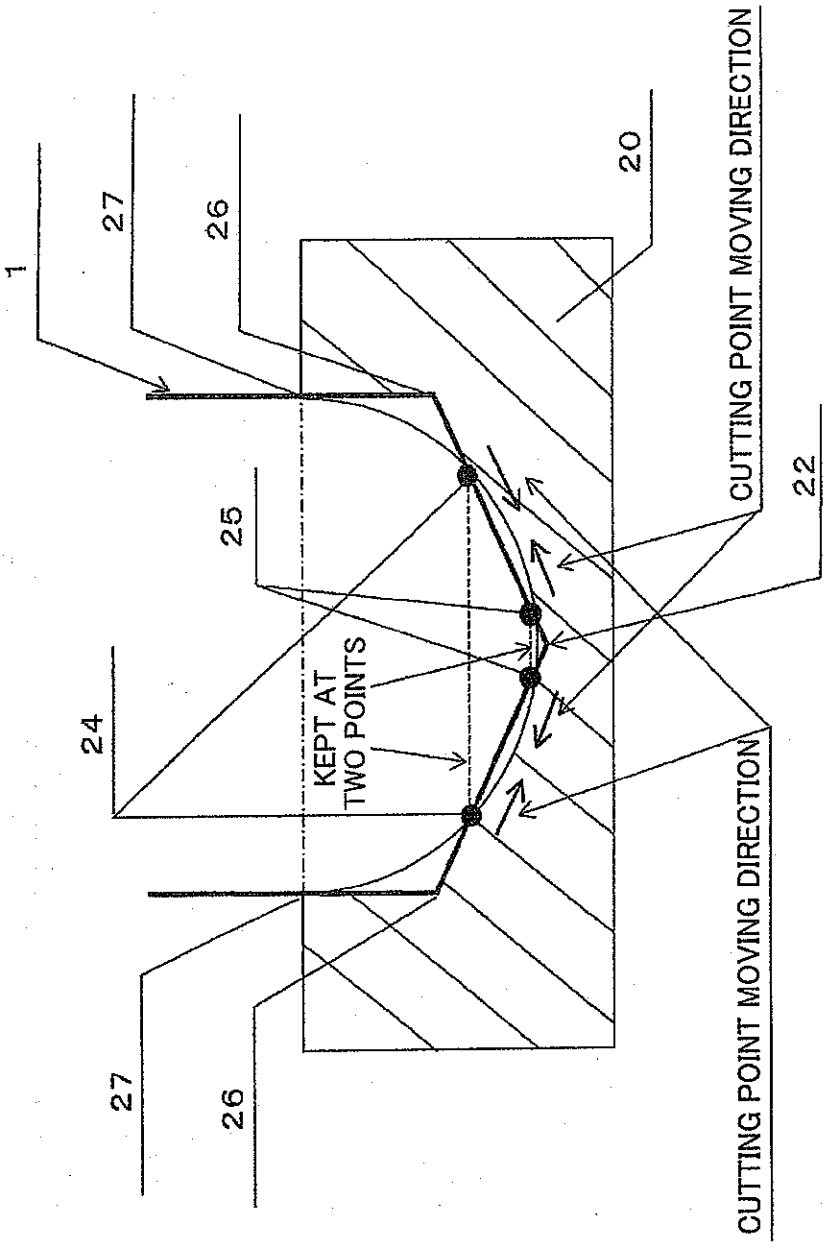

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KEPT AT
TWO POINTS
CUTTING POINT MOVING DIRECTION
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26
CUTTING POINT MOVING DIRECTION

FIG.15

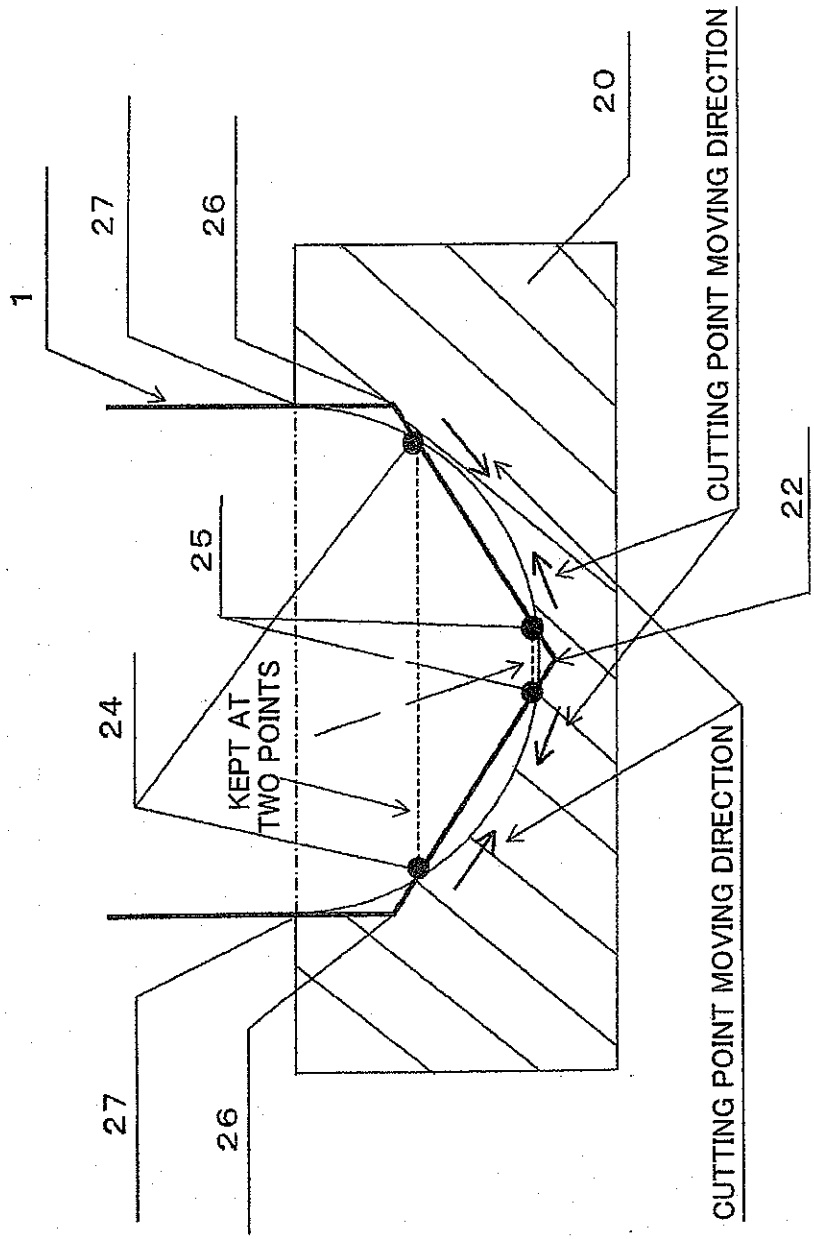

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KEPT AT
TWO POINTS
CUTTING POINT MOVING DIRECTION
27
26
CUTTING POINT MOVING DIRECTION

FIG.16

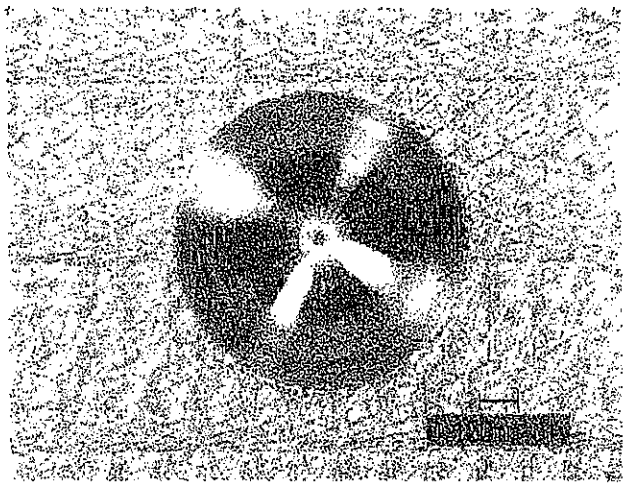
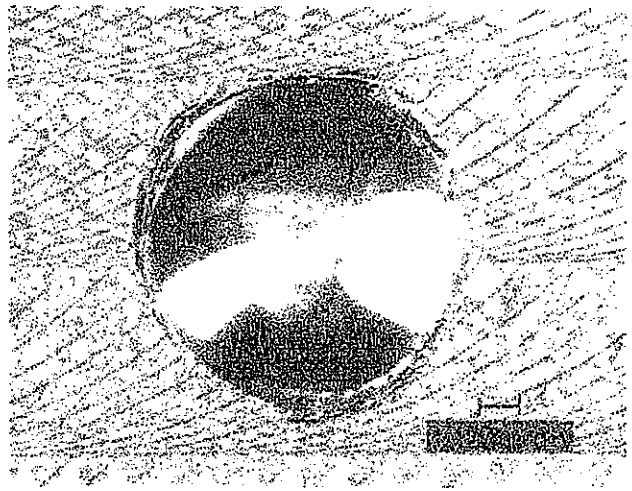
GUIDE HOLE DRILLING (Vf=100mm/min) USING A BALL END MILL (ϕ0.8mm) HAVING TWO CUTTING EDGES	GUIDE HOLE DRILLING (Vf=100mm/min) USING A SHORT DRILL(ϕ0.8mm)
	
HOLE DEPTH: 0.8mm HOLE DIAMETER: 0.799mm	HOLE DEPTH: 0.8mm HOLE DIAMETER: 0.874mm

FIG.17

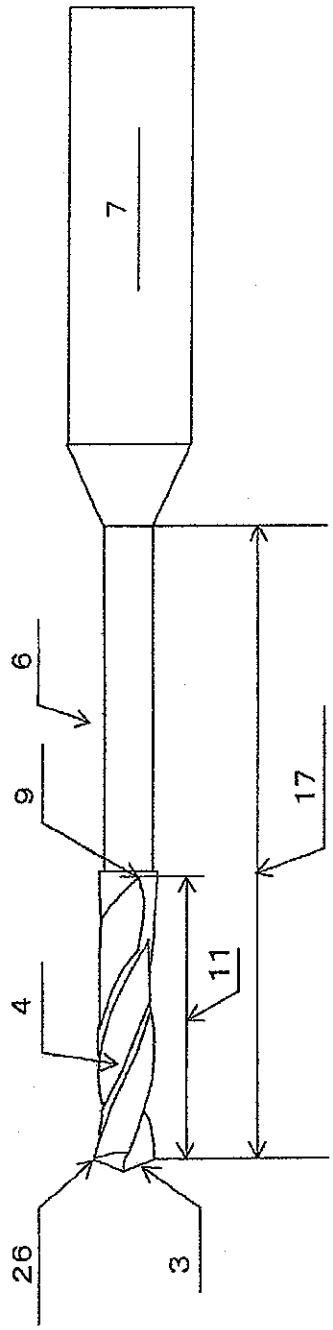


FIG.18

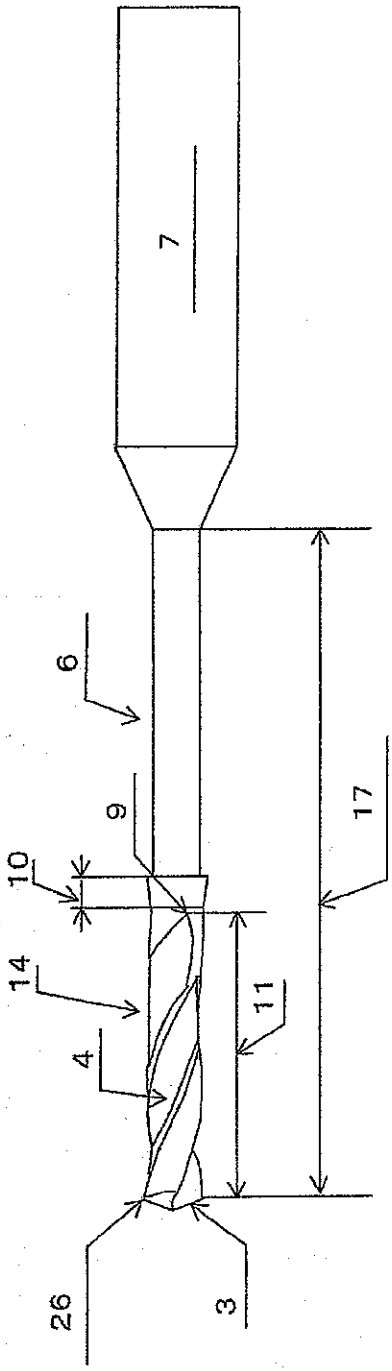


FIG.19

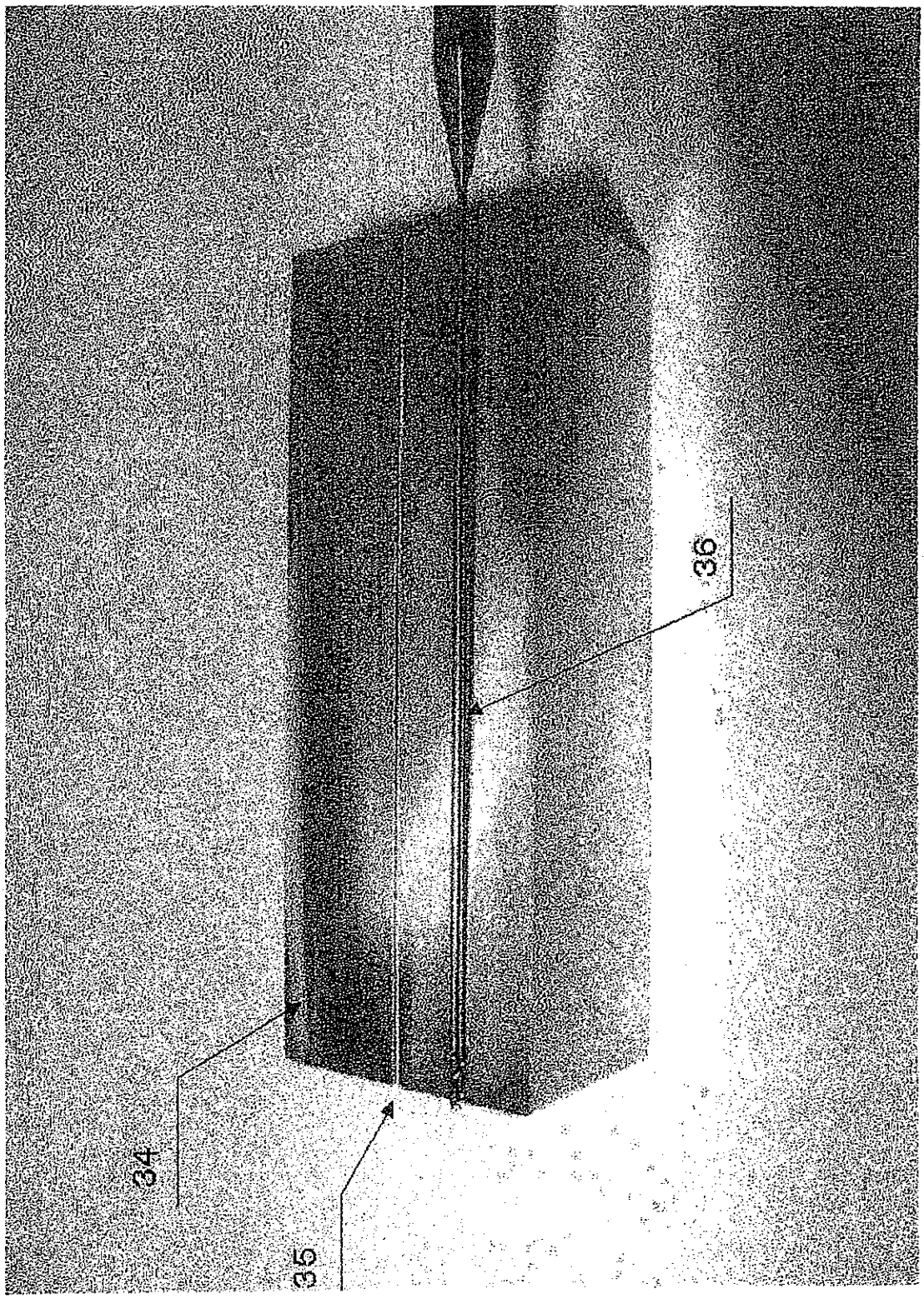


FIG.20

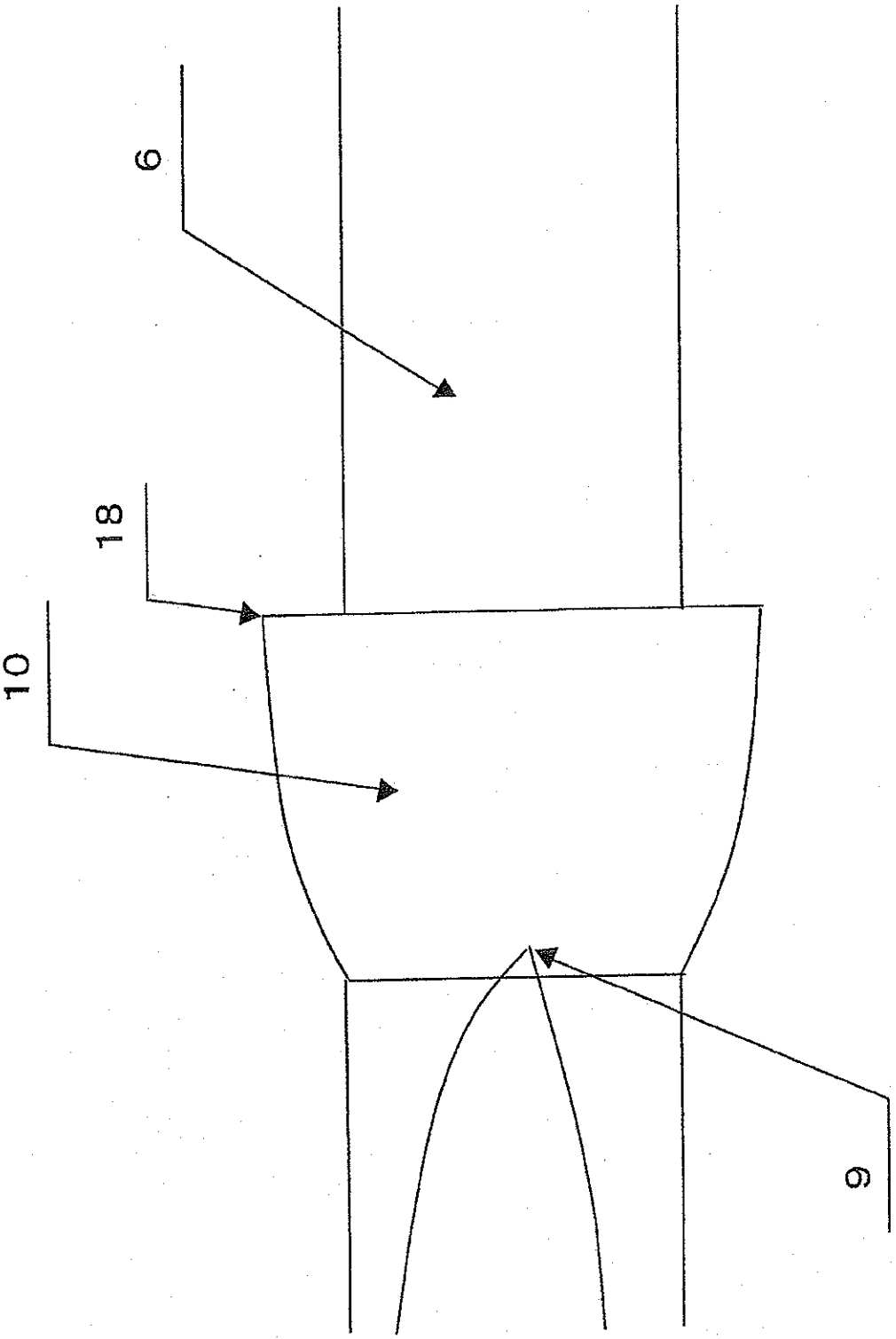


FIG.21

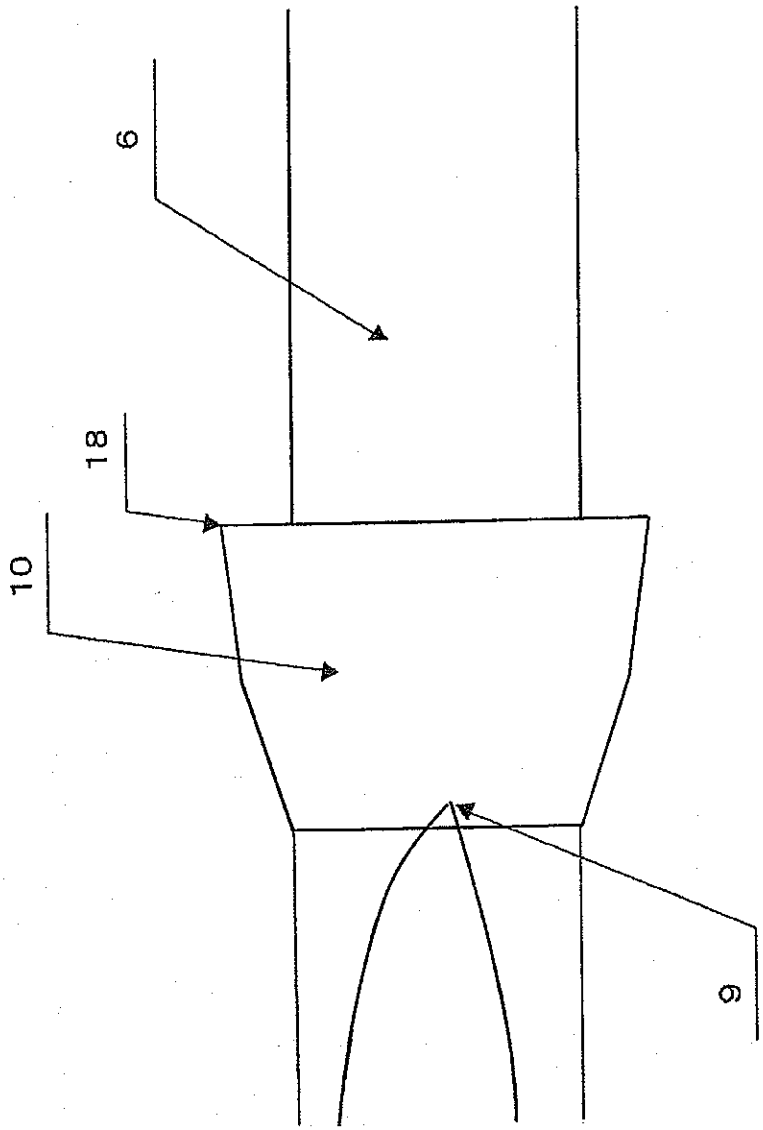


FIG.22

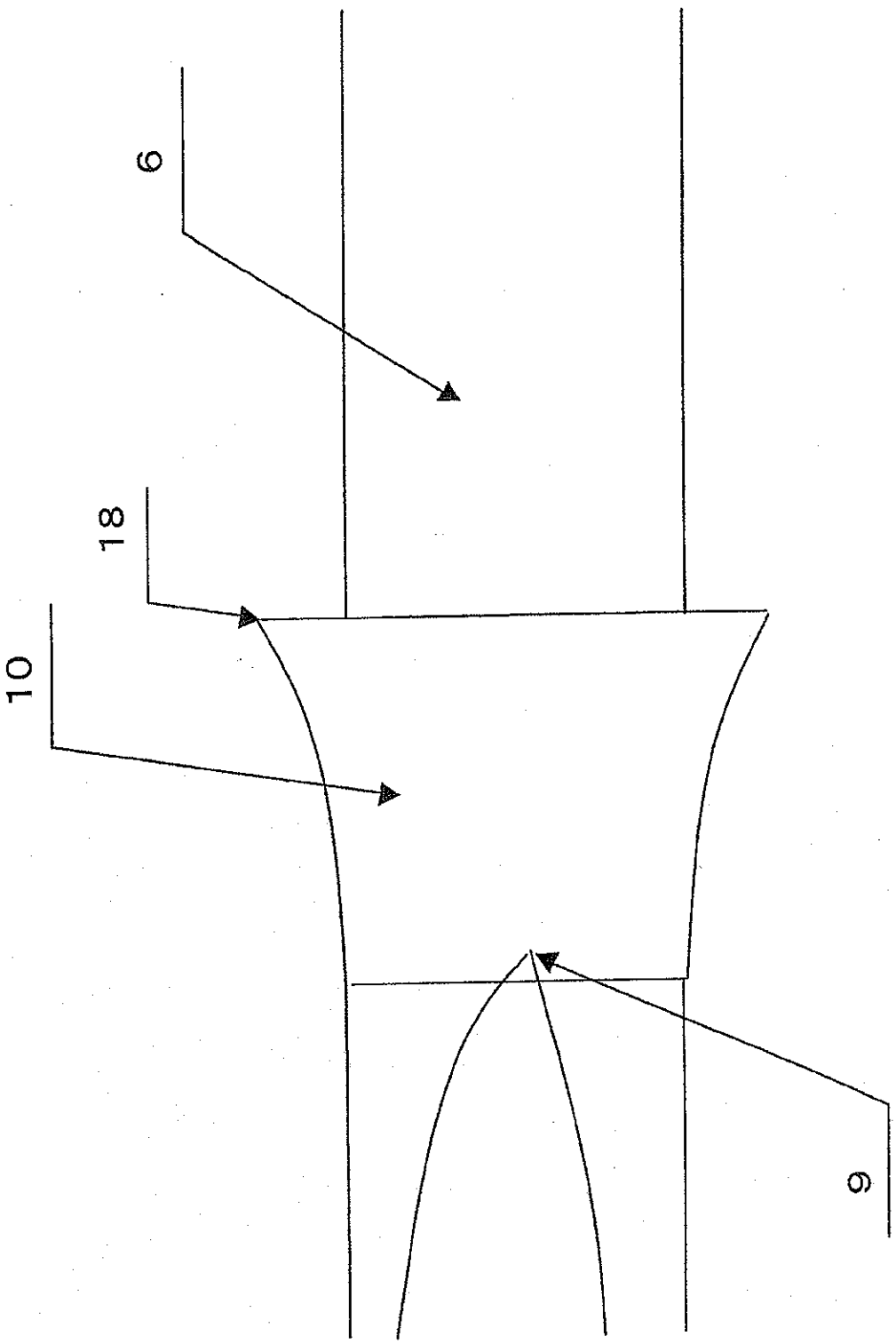


FIG.23

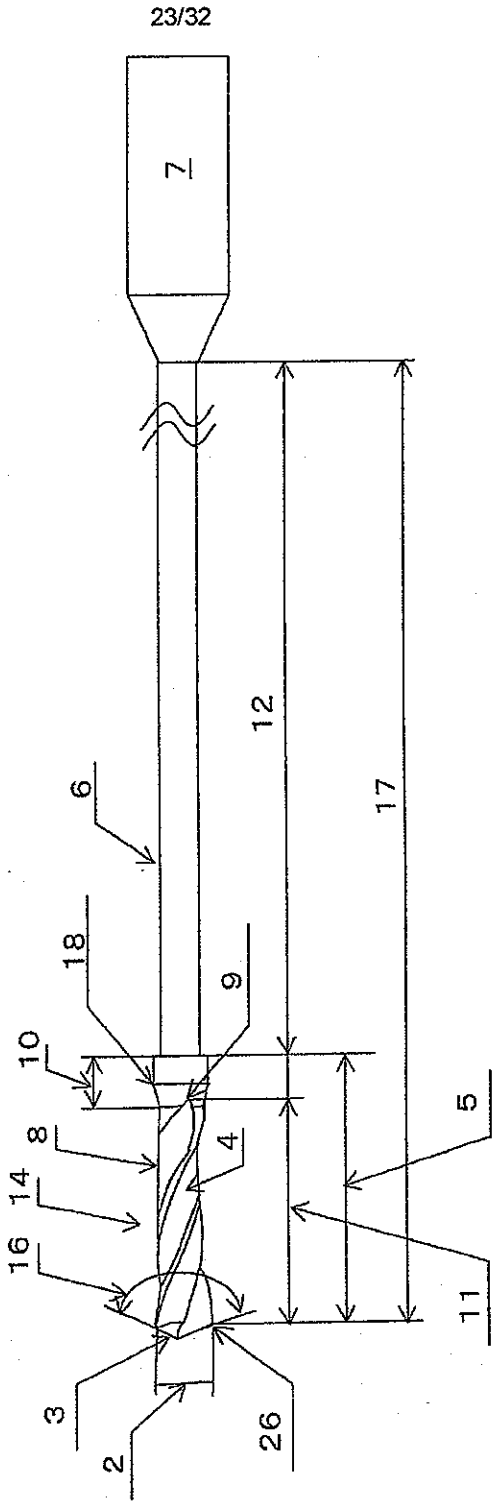


FIG.24

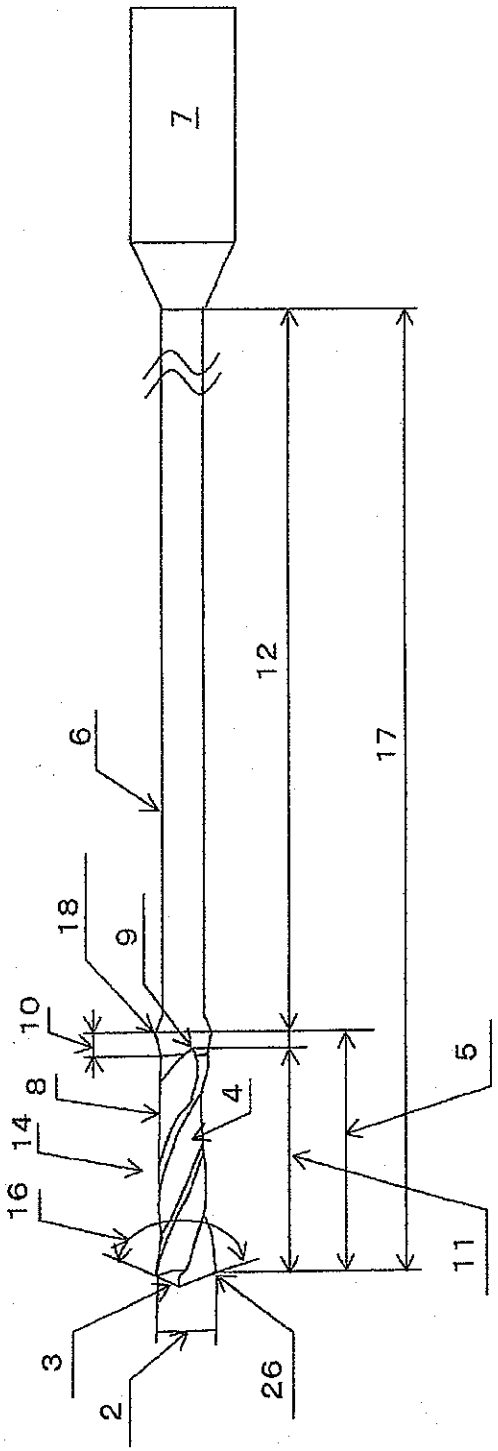


FIG.25

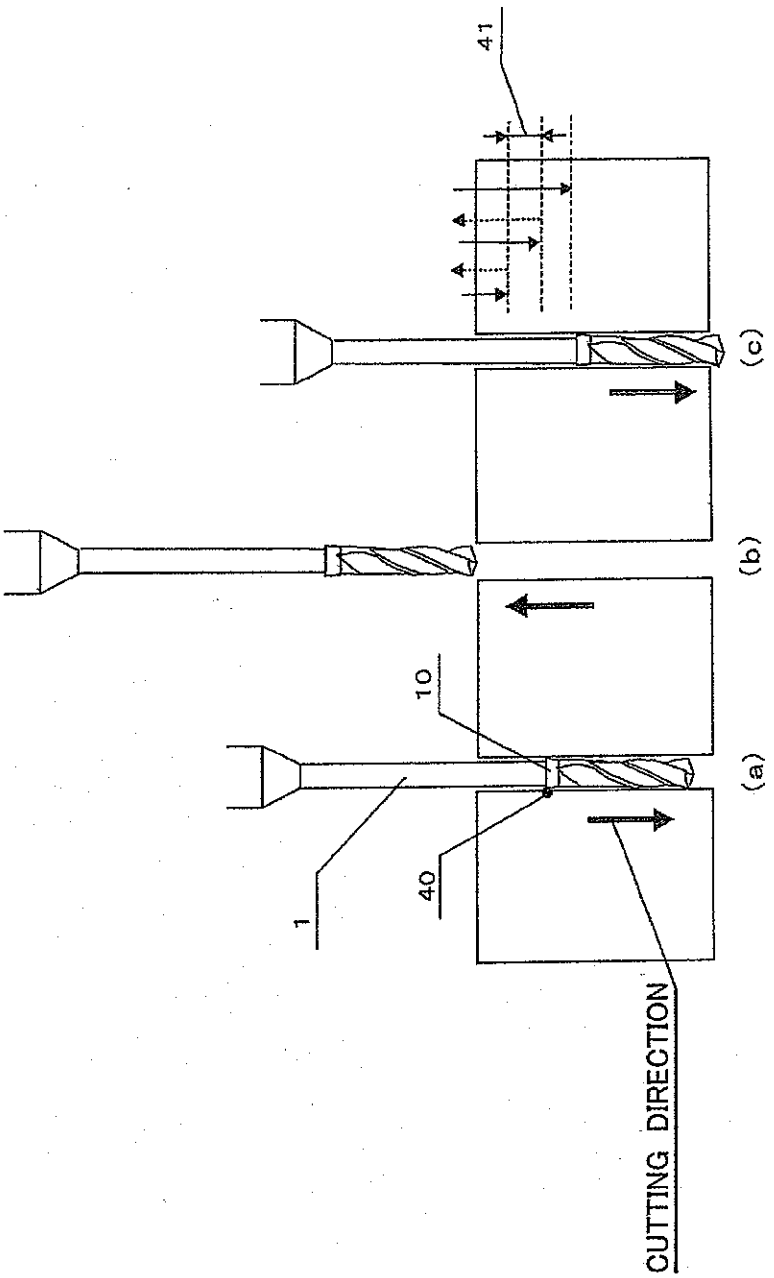


FIG.26(b)

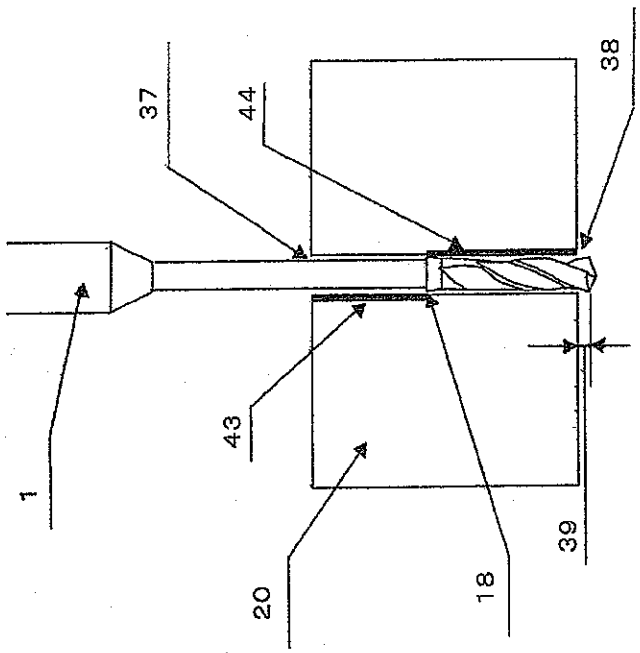


FIG.26(a)

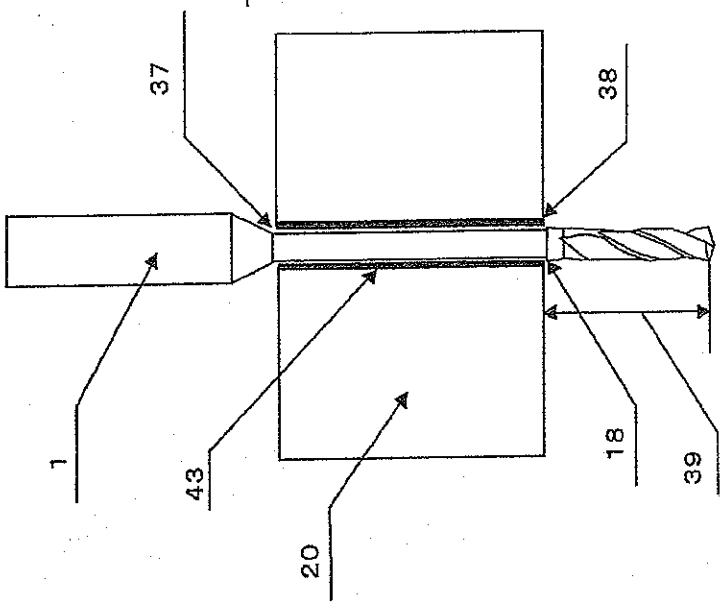


FIG.27

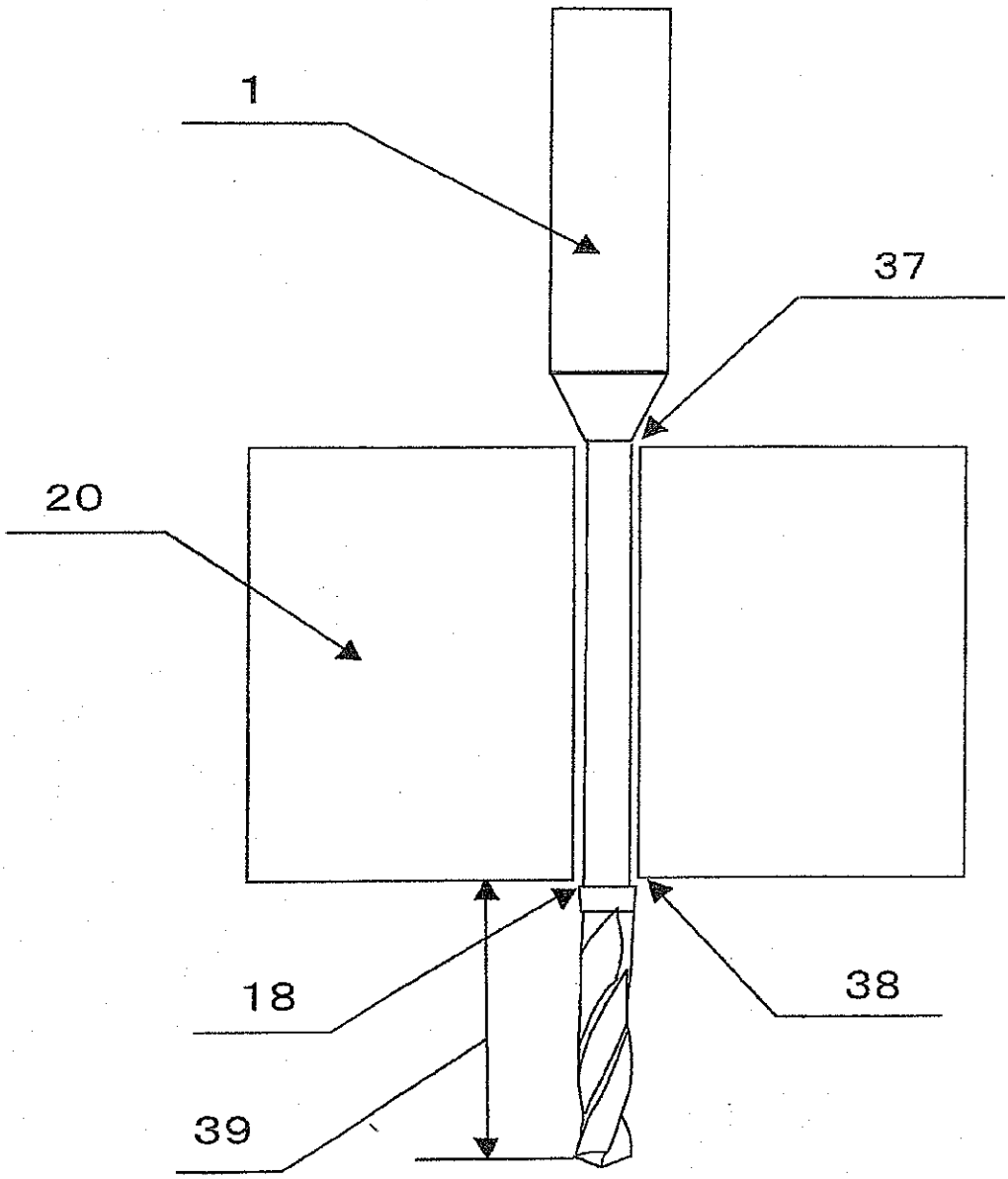


FIG.28

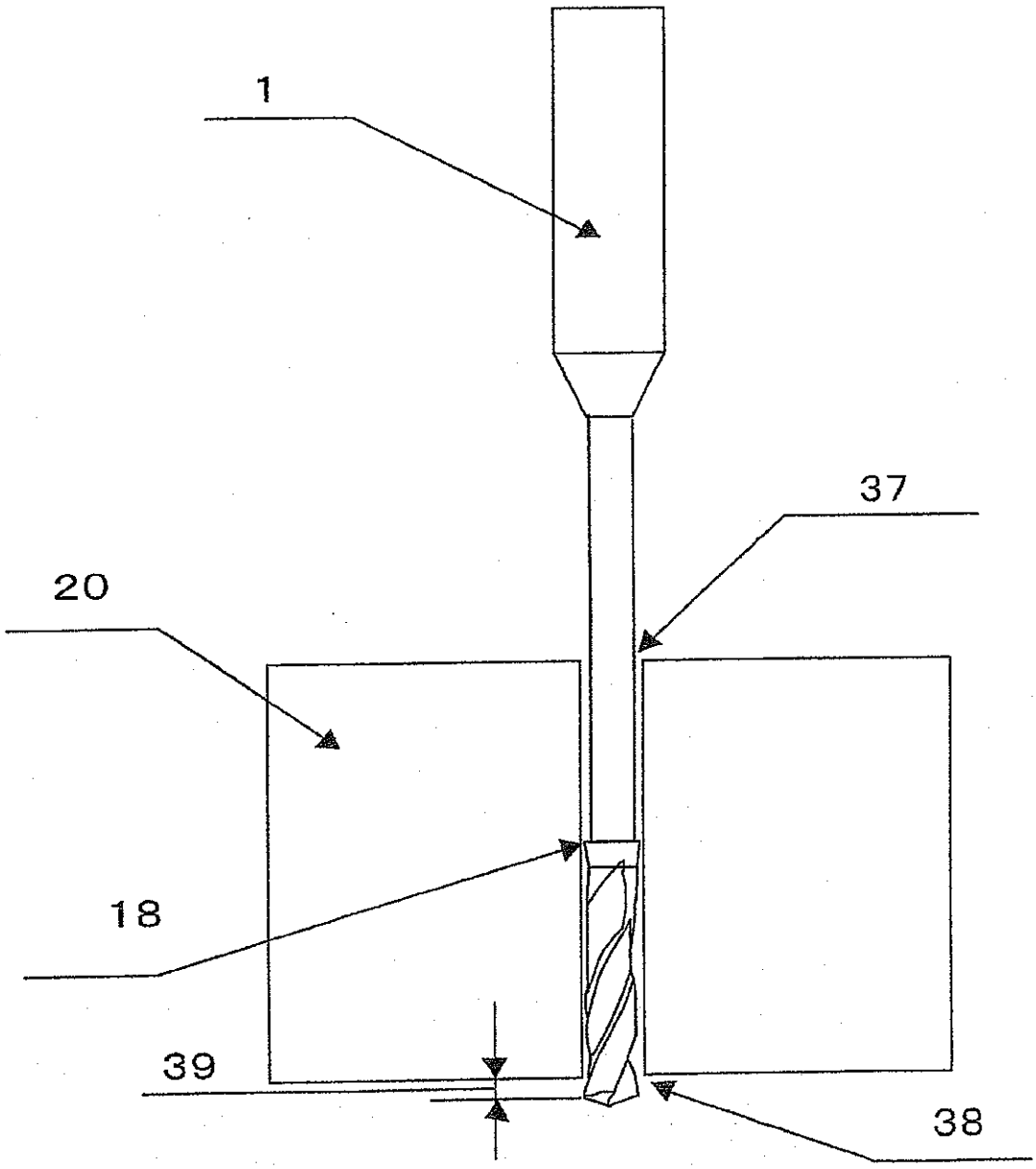
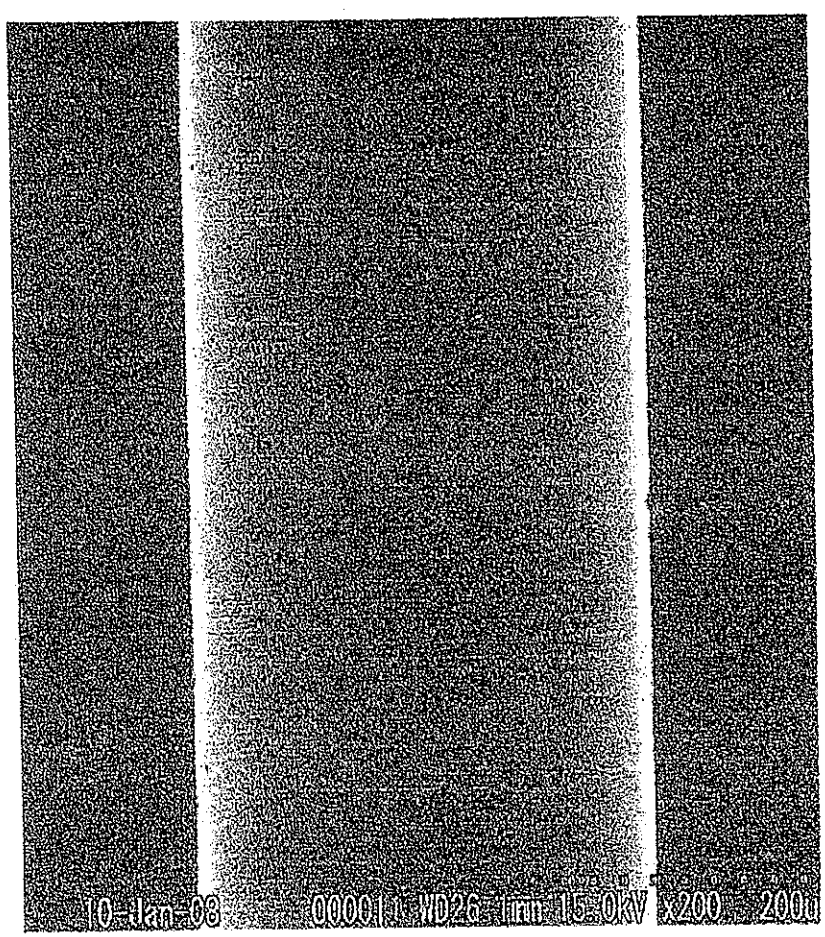


FIG.29

NEAR THE MIDDLE OF HOLE



NEAR THE EXIT OF HOLE

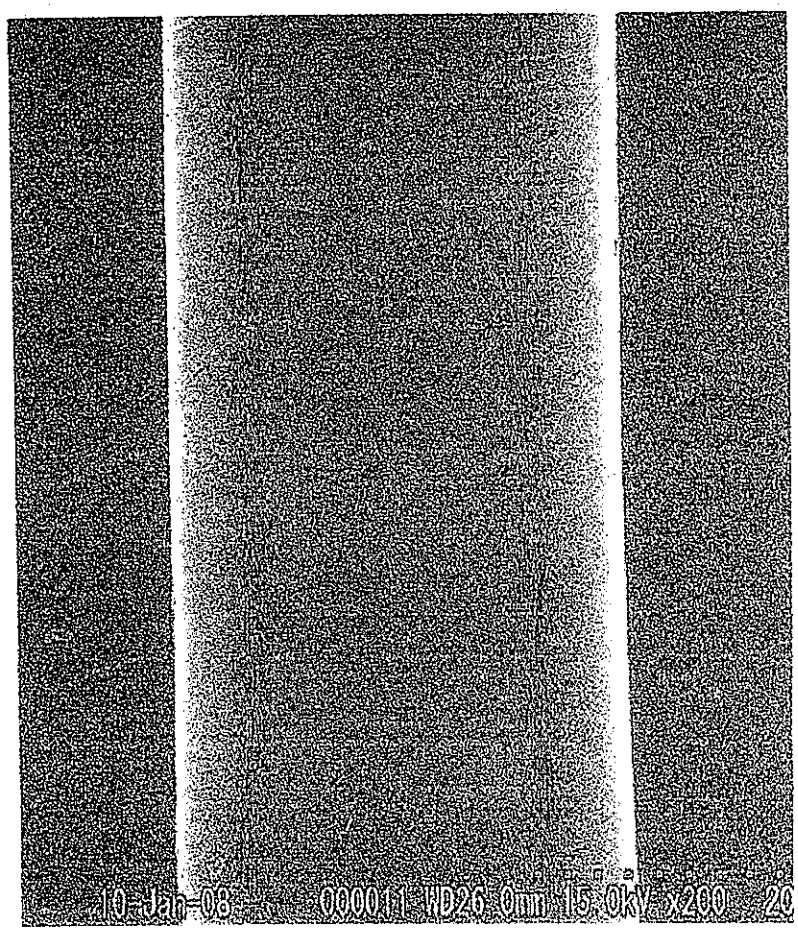


FIG.30

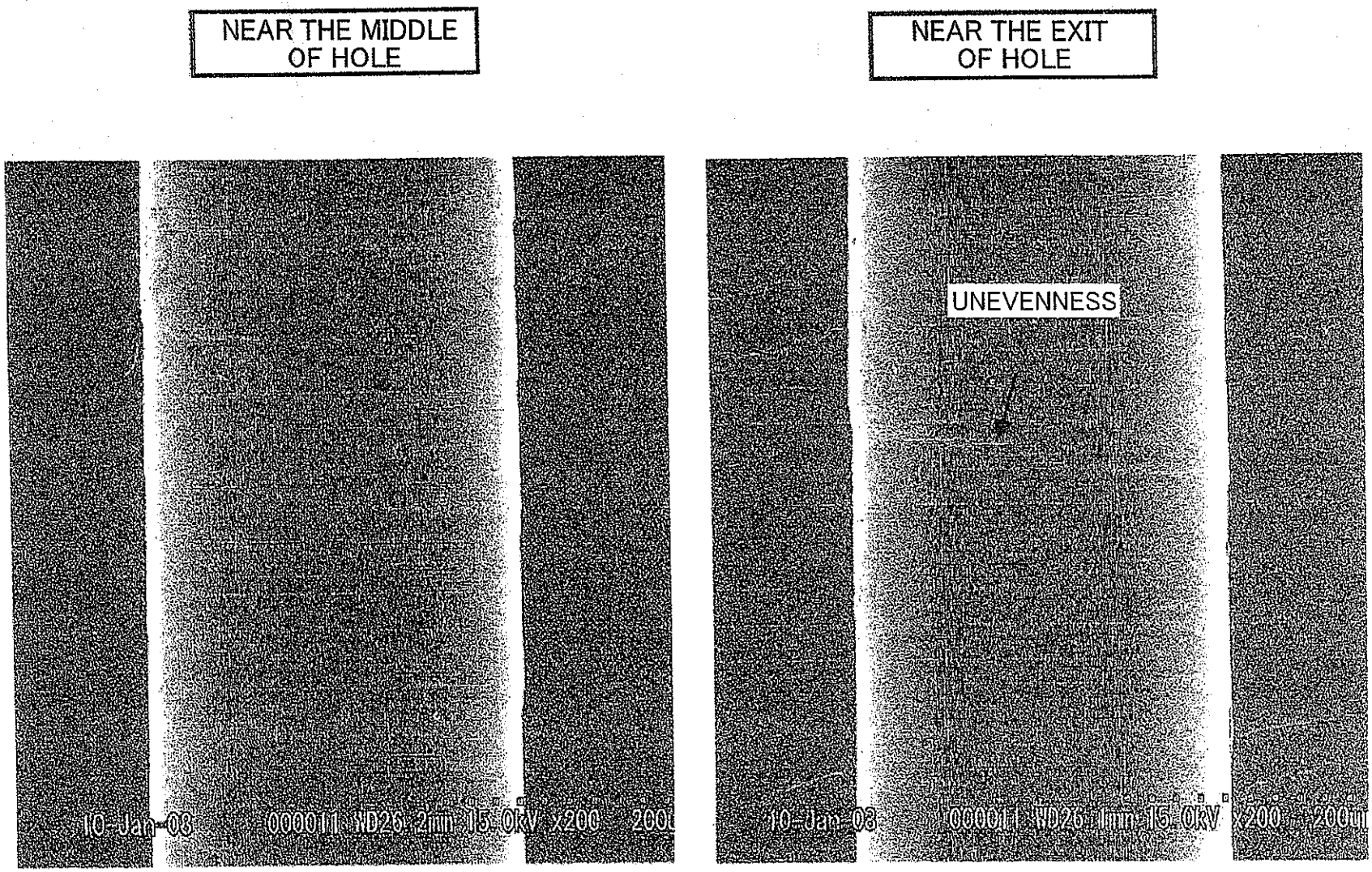

NEAR THE MIDDLE OF HOLE
NEAR THE EXIT OF HOLE
UNEVENNESS
10-Jan-08
10-Jan-08

FIG.31

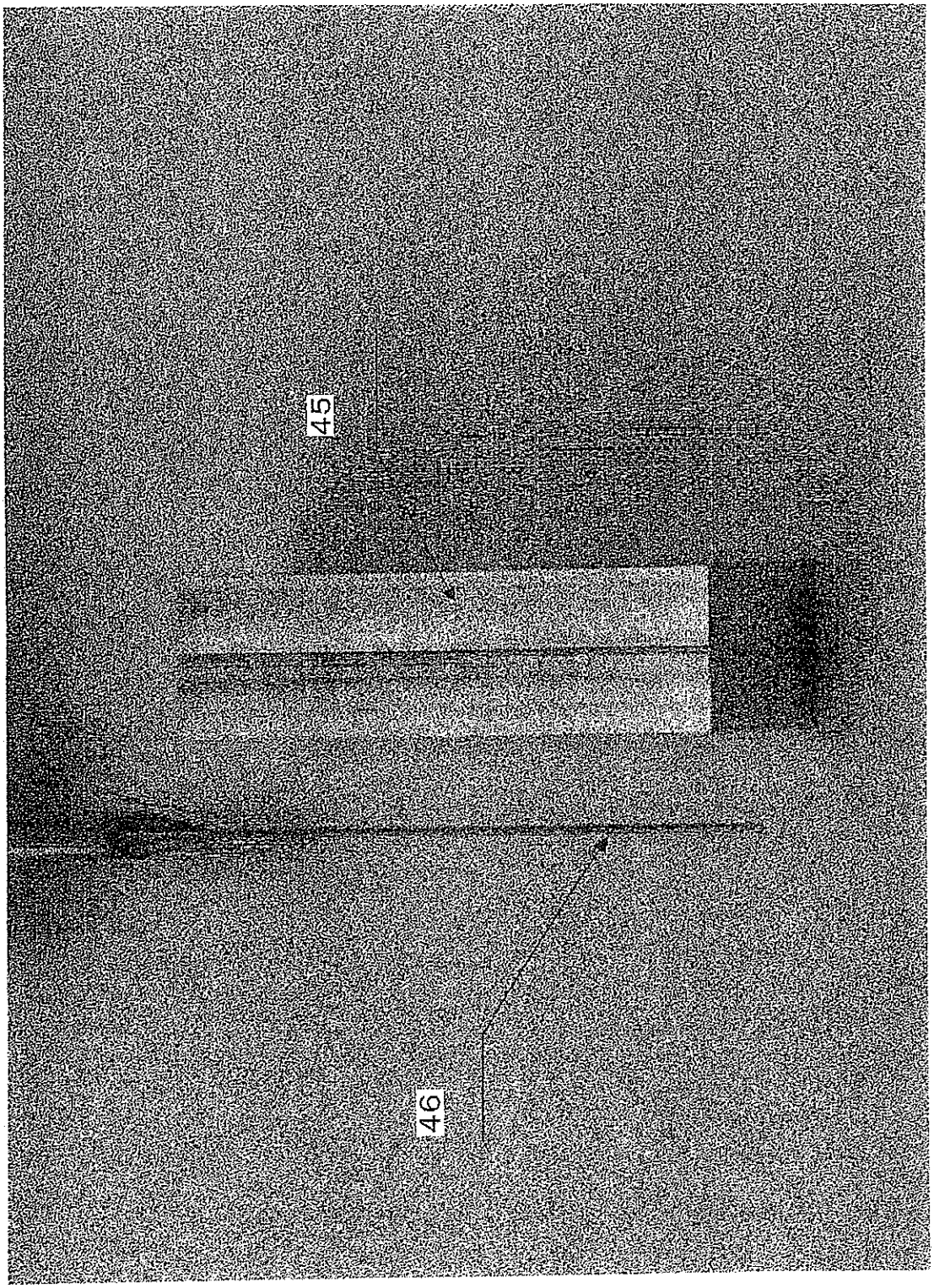


FIG.32(a)

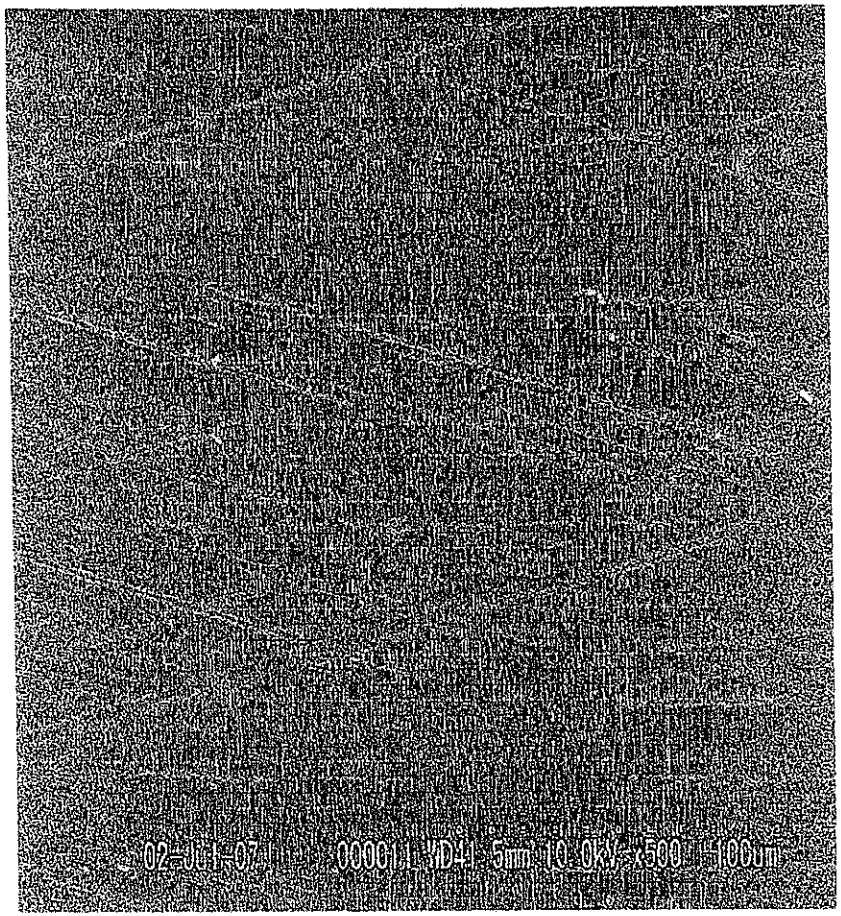


FIG.32(b)

