

FIG.1

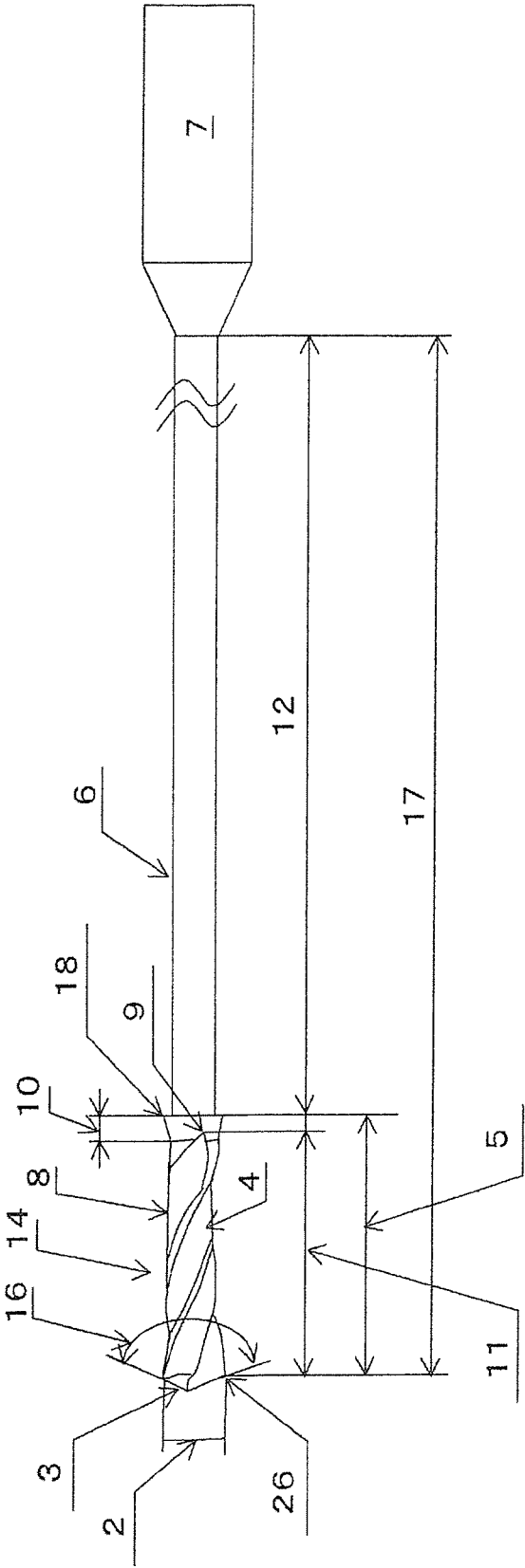


FIG.2

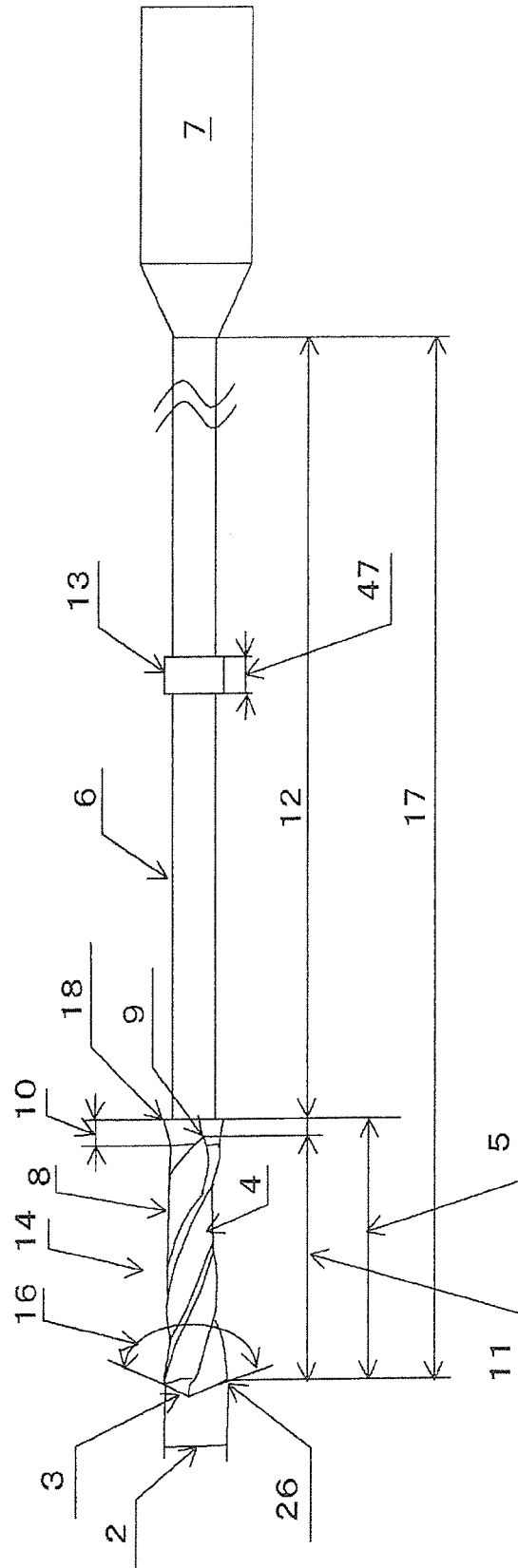


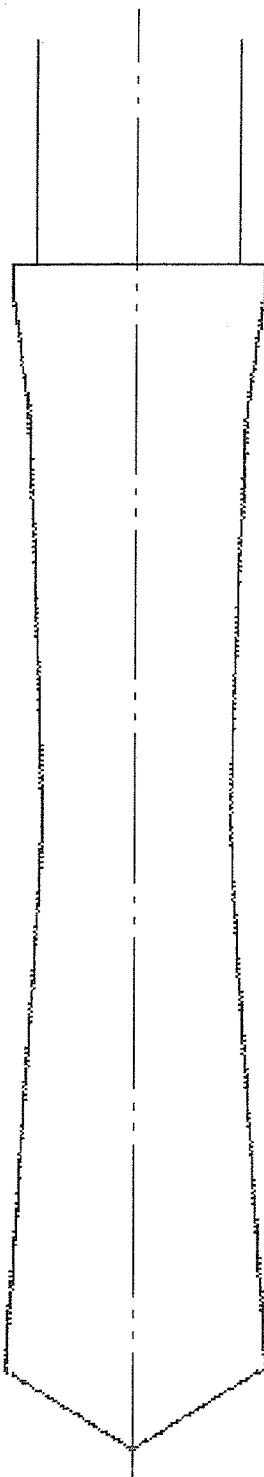
FIG.3

FIG.4

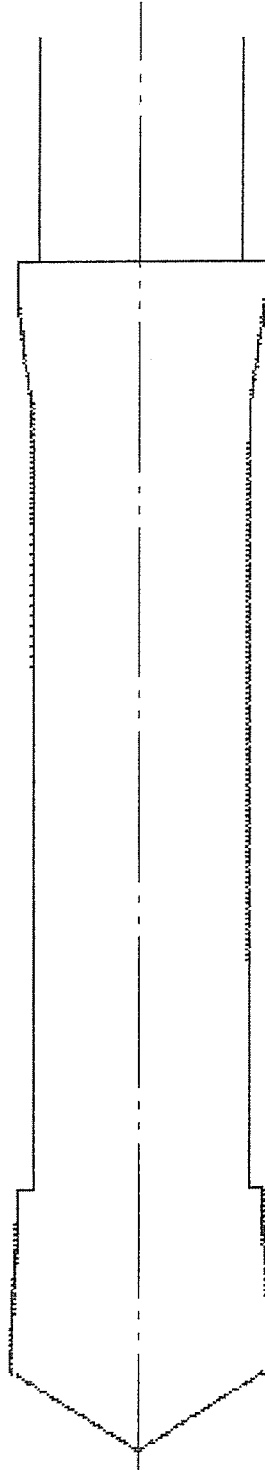


FIG.5

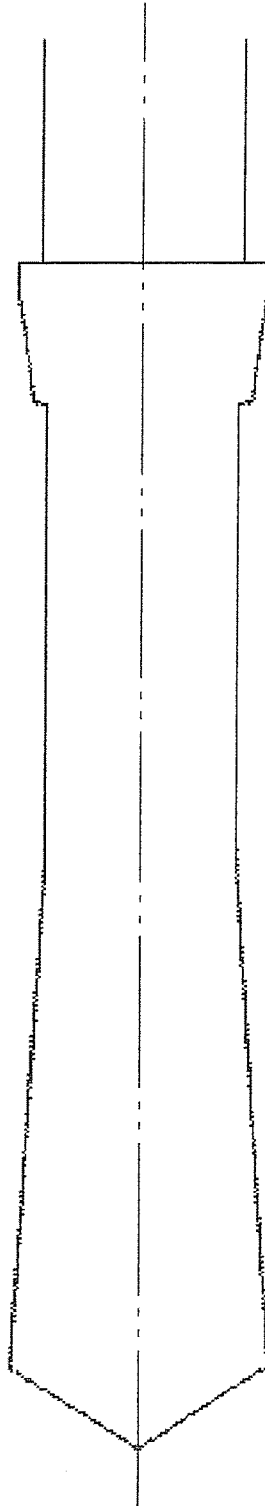


FIG.6

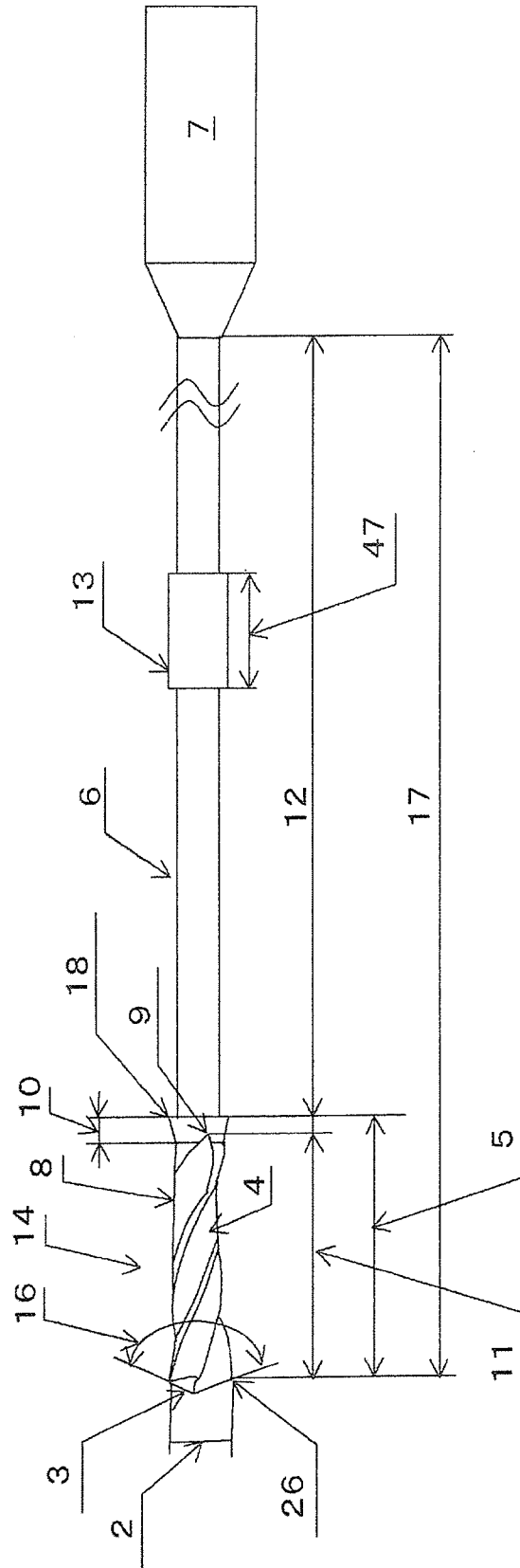


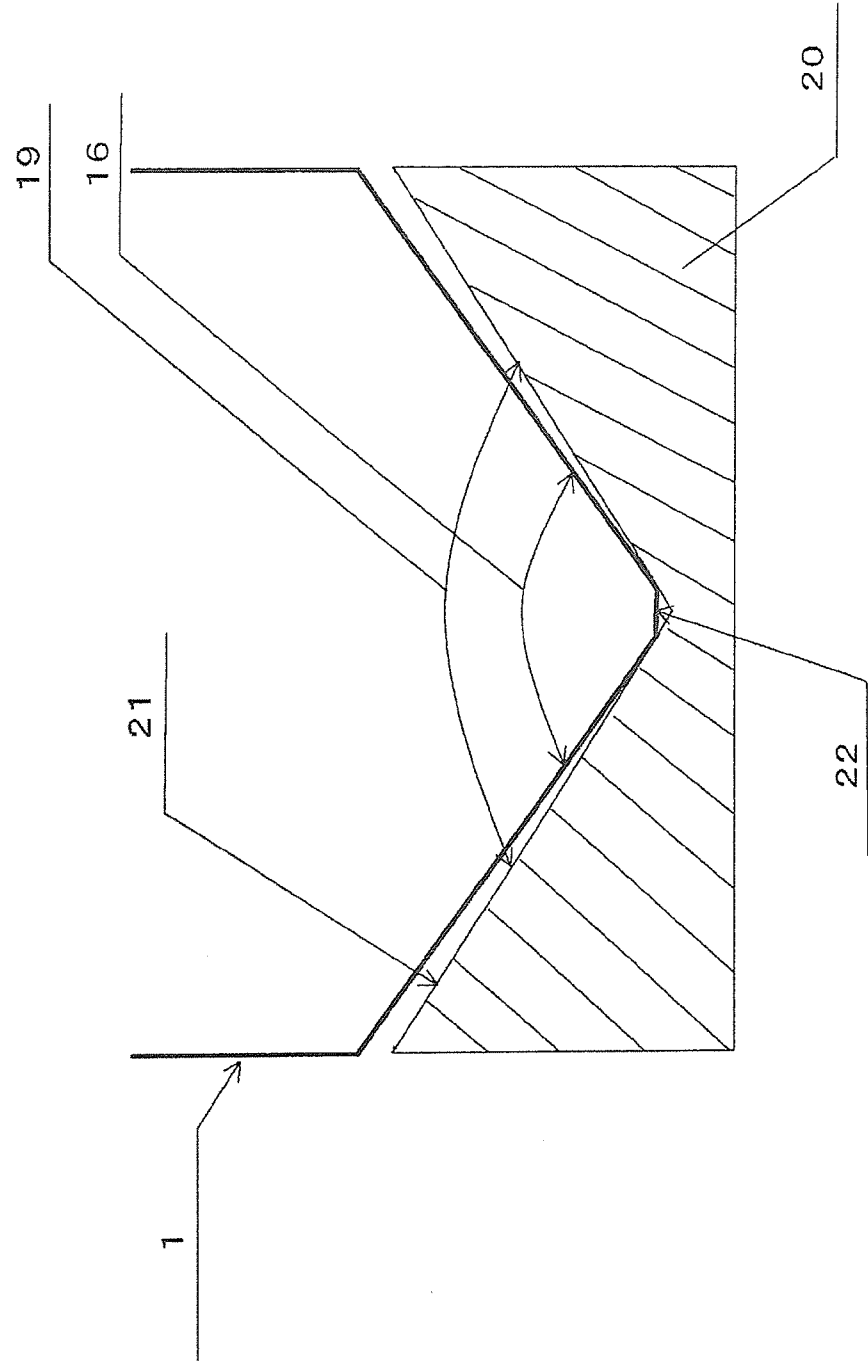
FIG. 8

FIG. 9

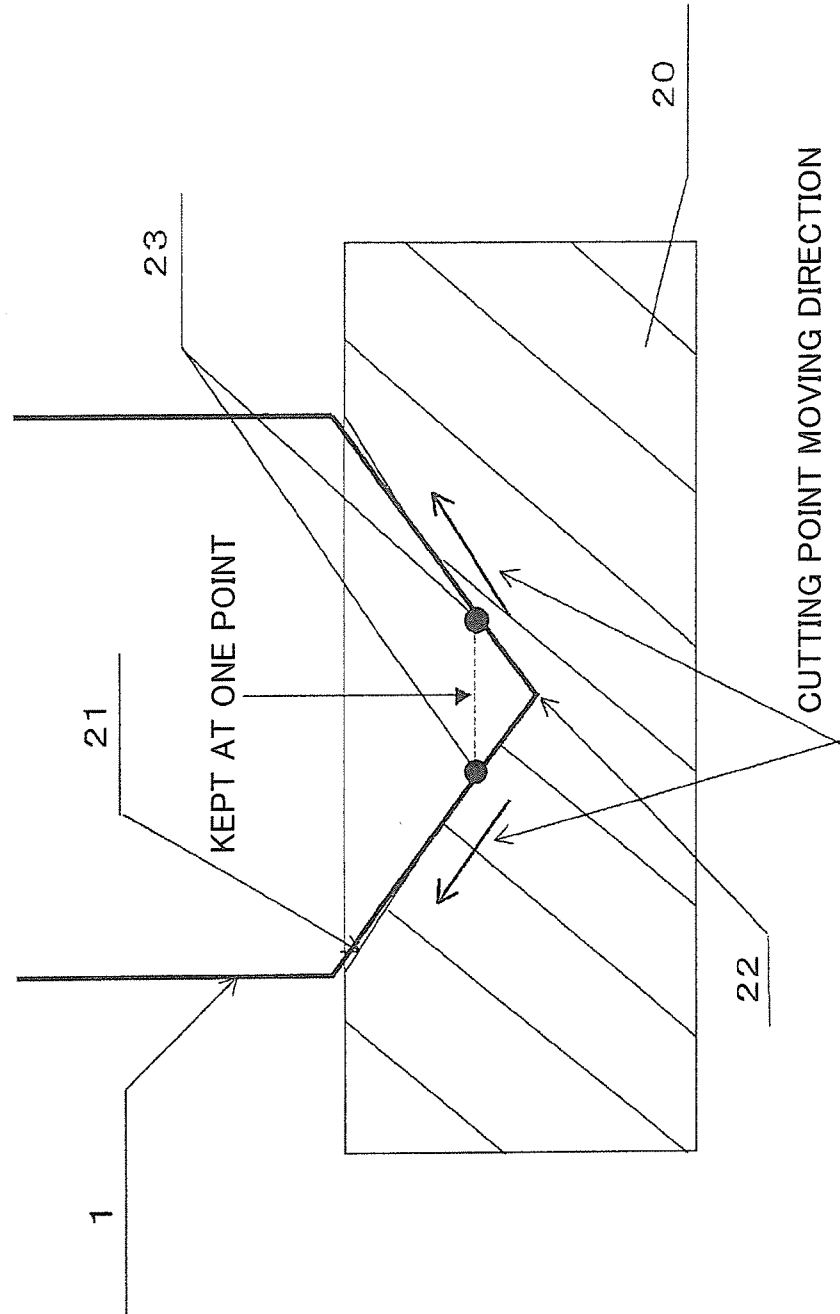


FIG.10

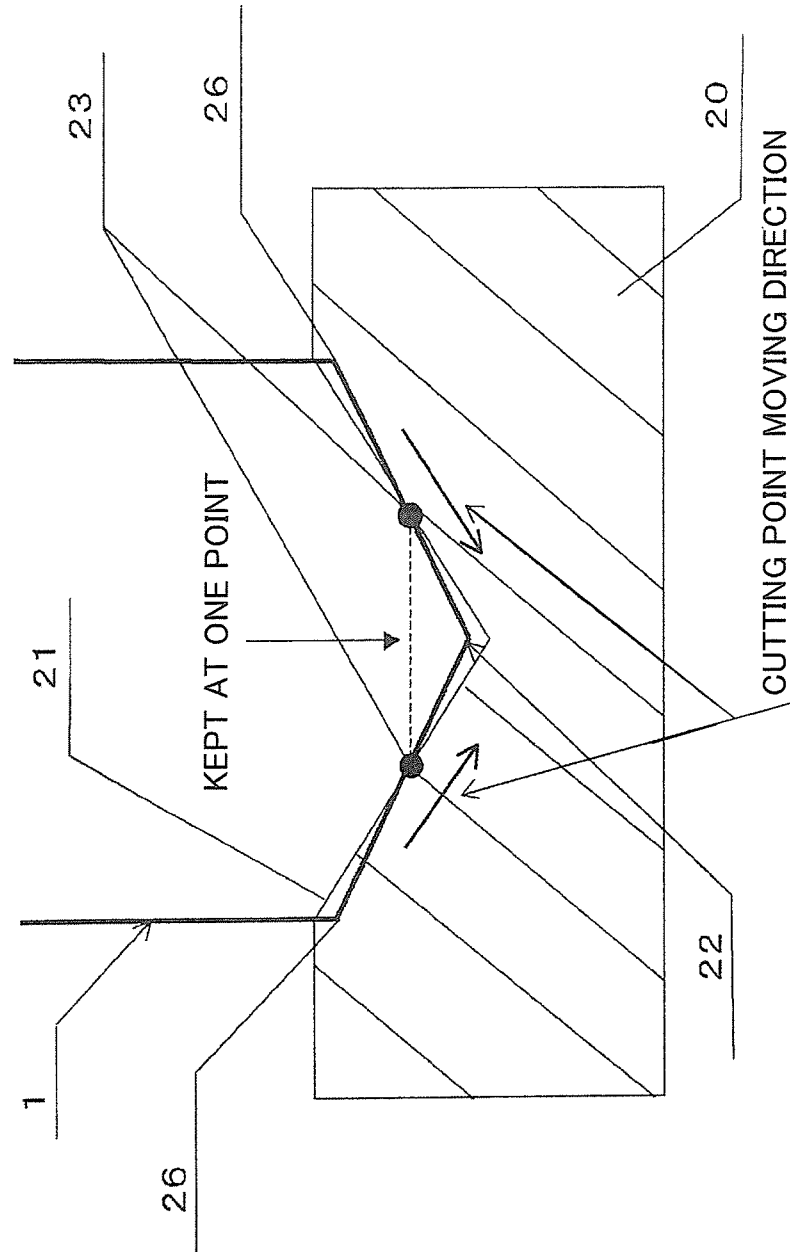


FIG.11

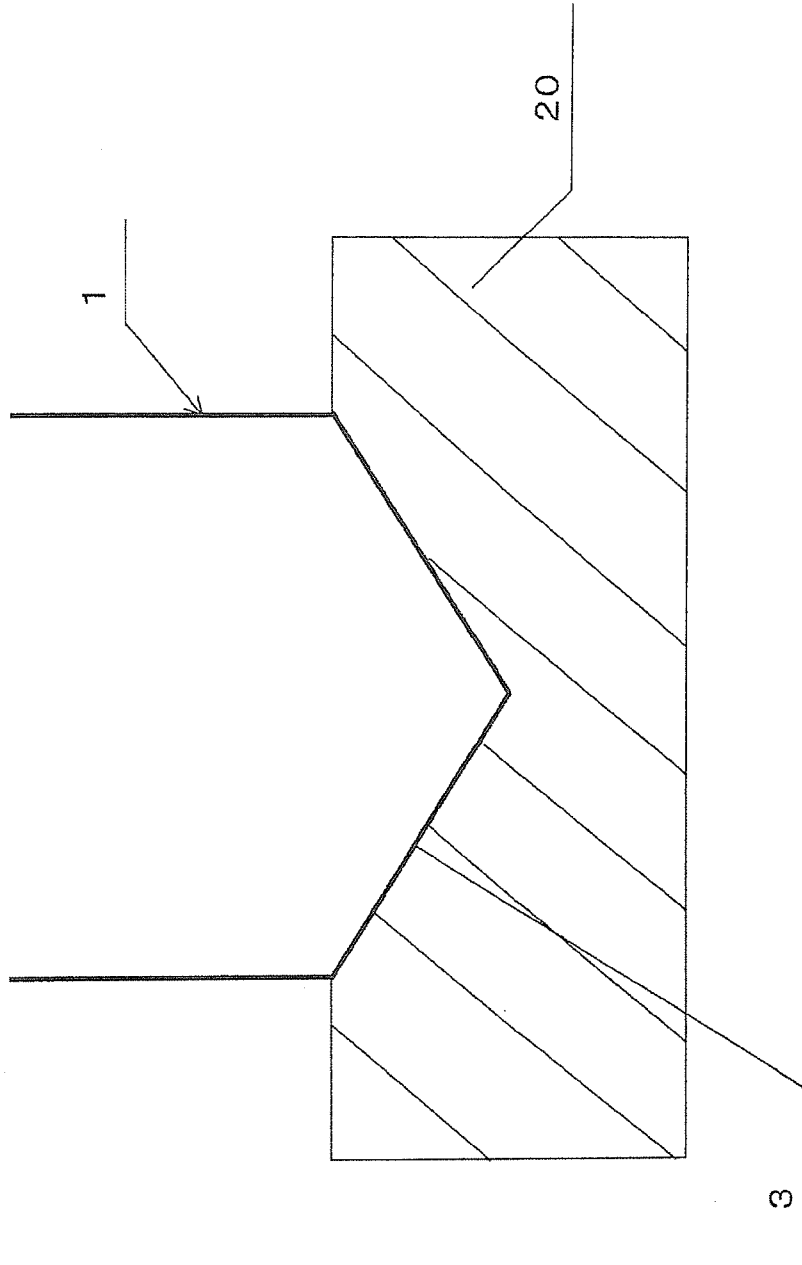


FIG.12

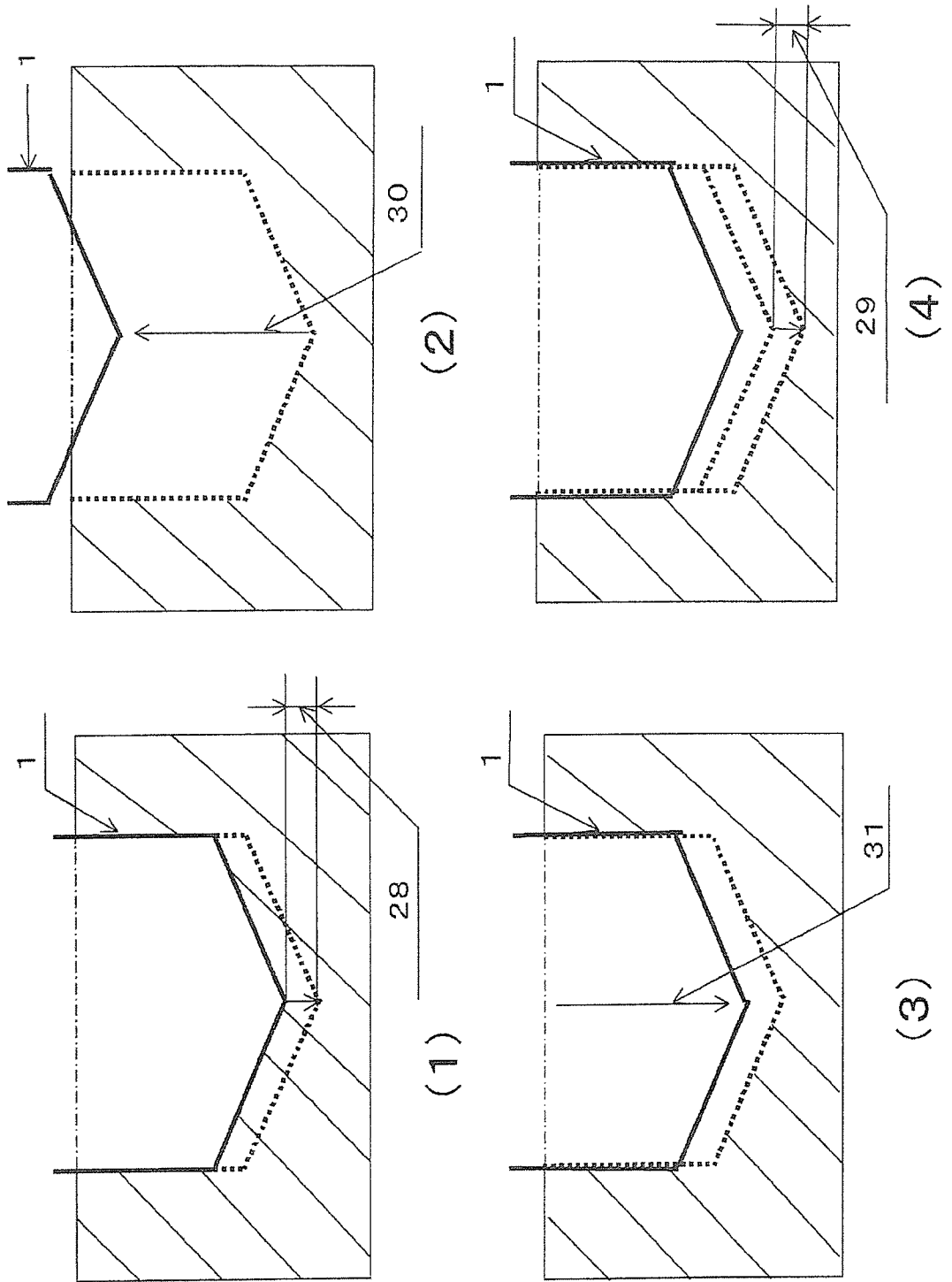


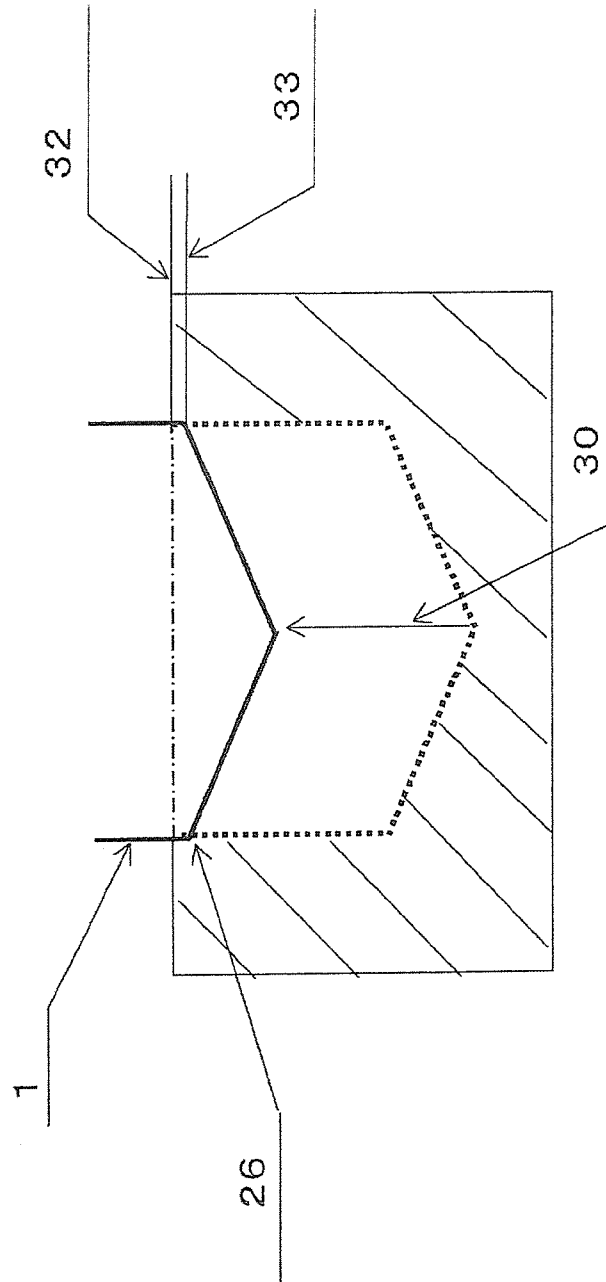
FIG.13

FIG.16

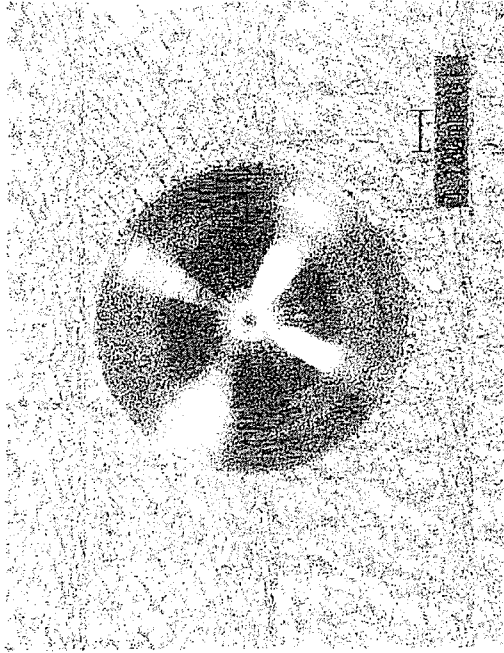
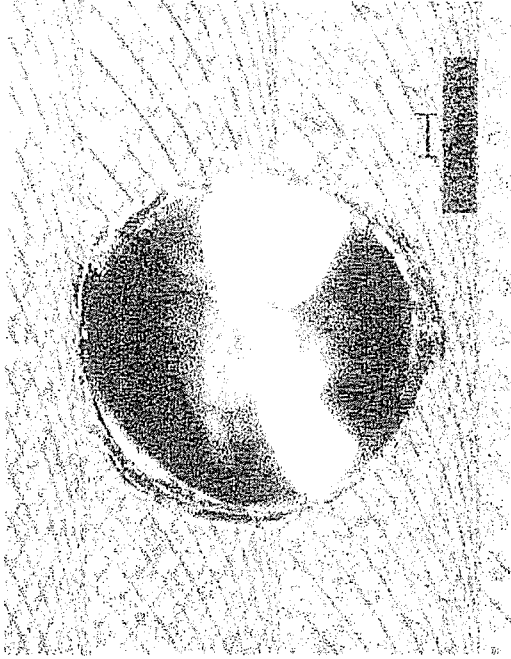
GUIDE HOLE DRILLING ($V_f=100\text{mm/min}$) USING A BALL END MILL ($\phi 0.8\text{mm}$) HAVING TWO CUTTING EDGES	GUIDE HOLE DRILLING ($V_f=100\text{mm/min}$) USING A SHORT DRILL ($\phi 0.8\text{mm}$)
HOLE DEPTH: 0.8mm HOLE DIAMETER: 0.799mm 	HOLE DEPTH: 0.8mm HOLE DIAMETER: 0.874mm 

FIG.17

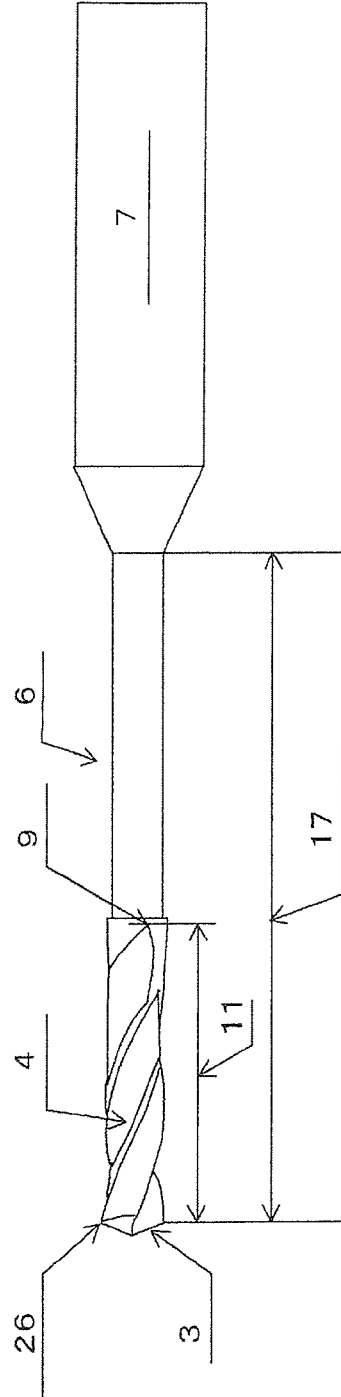


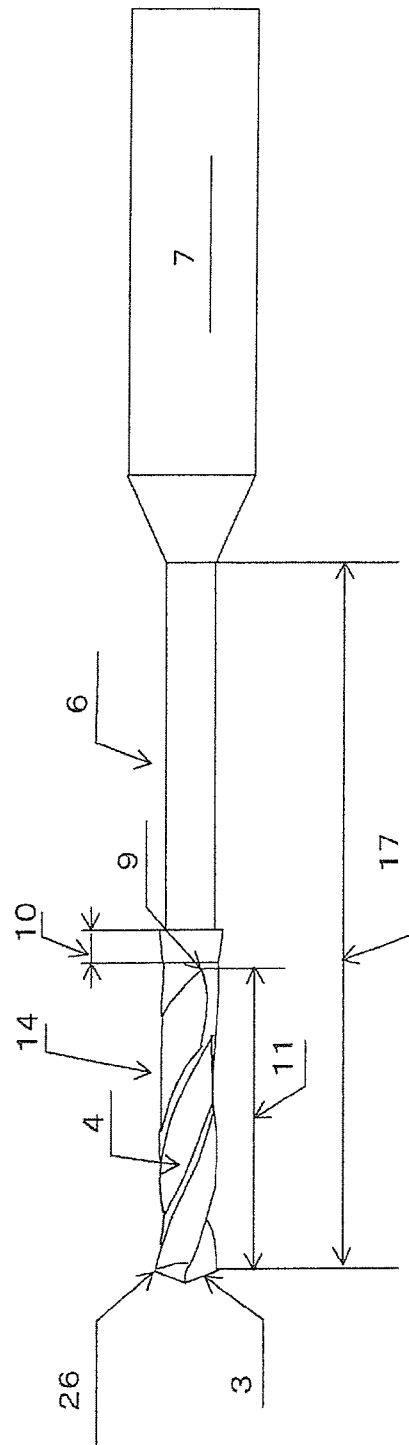
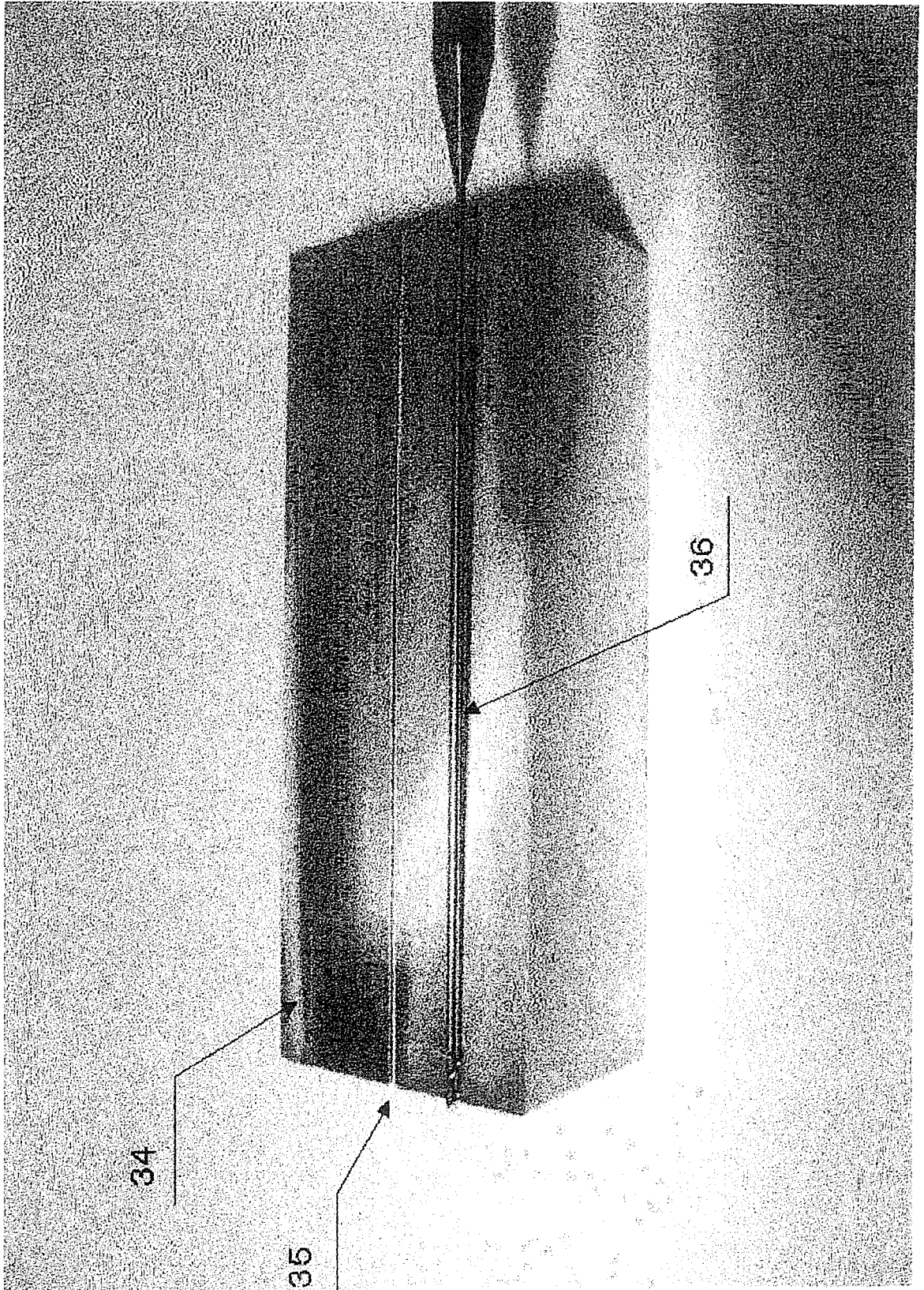
FIG.18

FIG.19



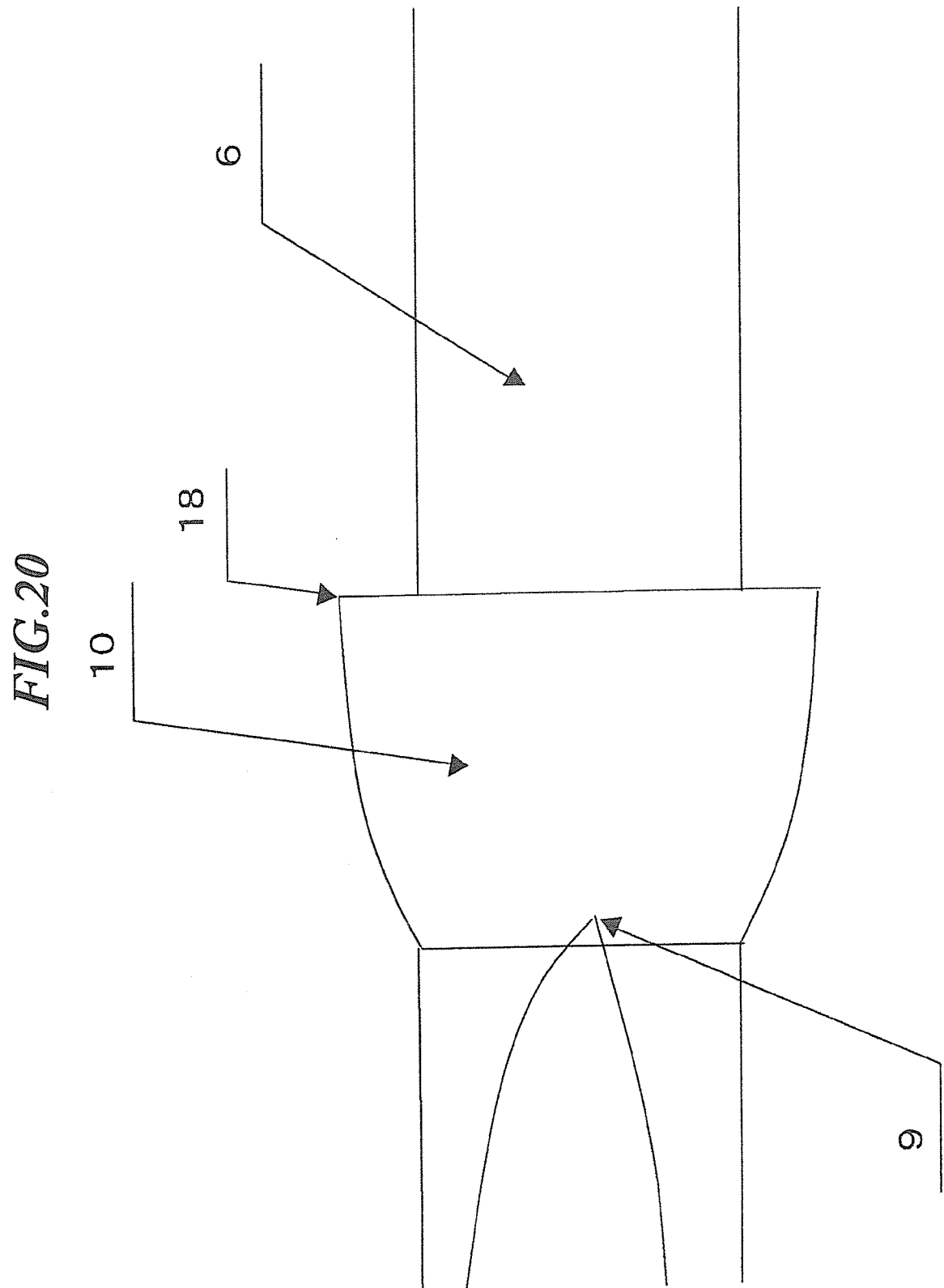
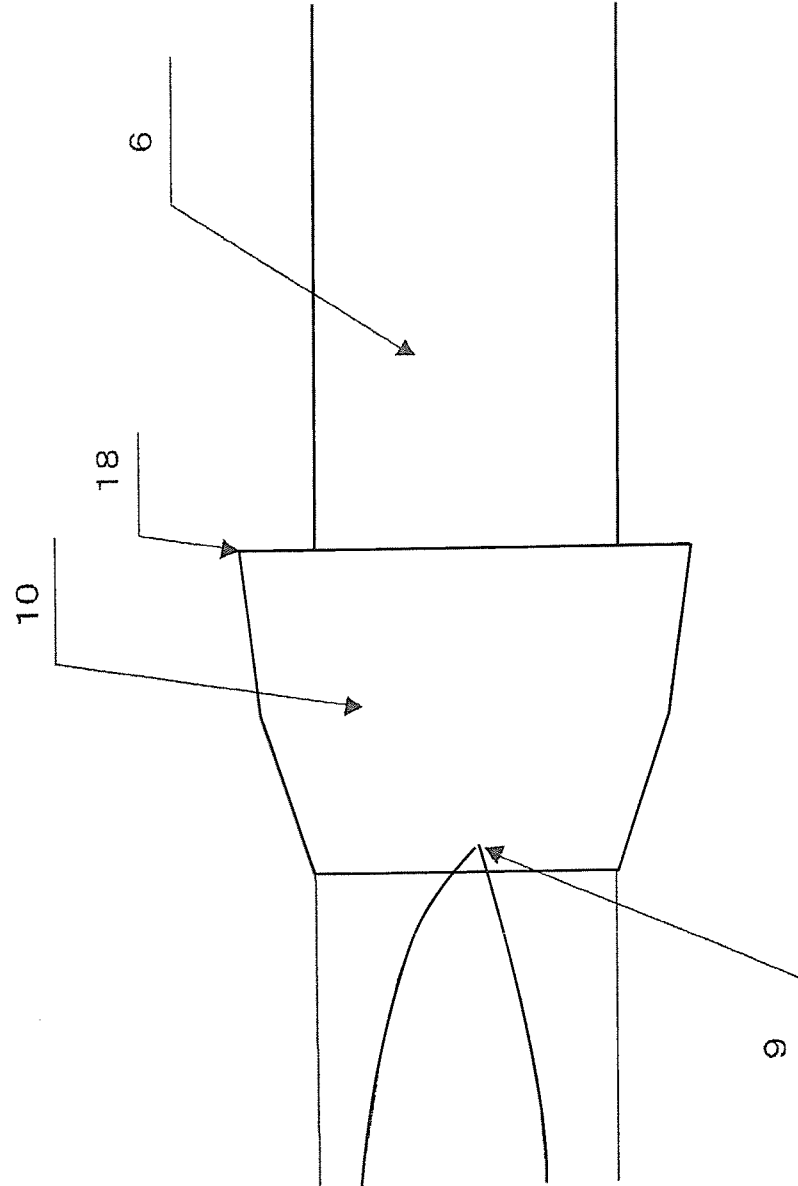


FIG.21



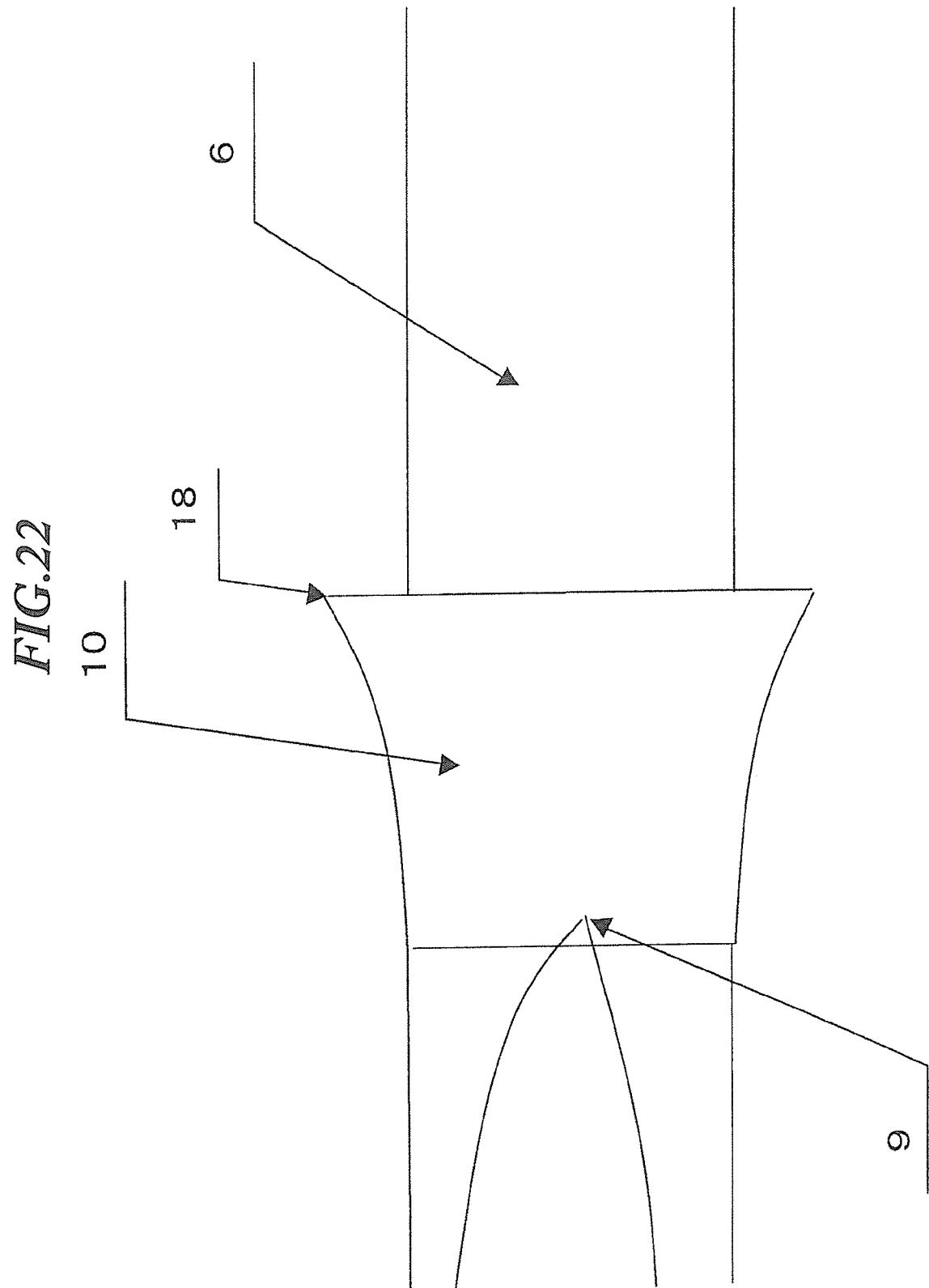


FIG.23

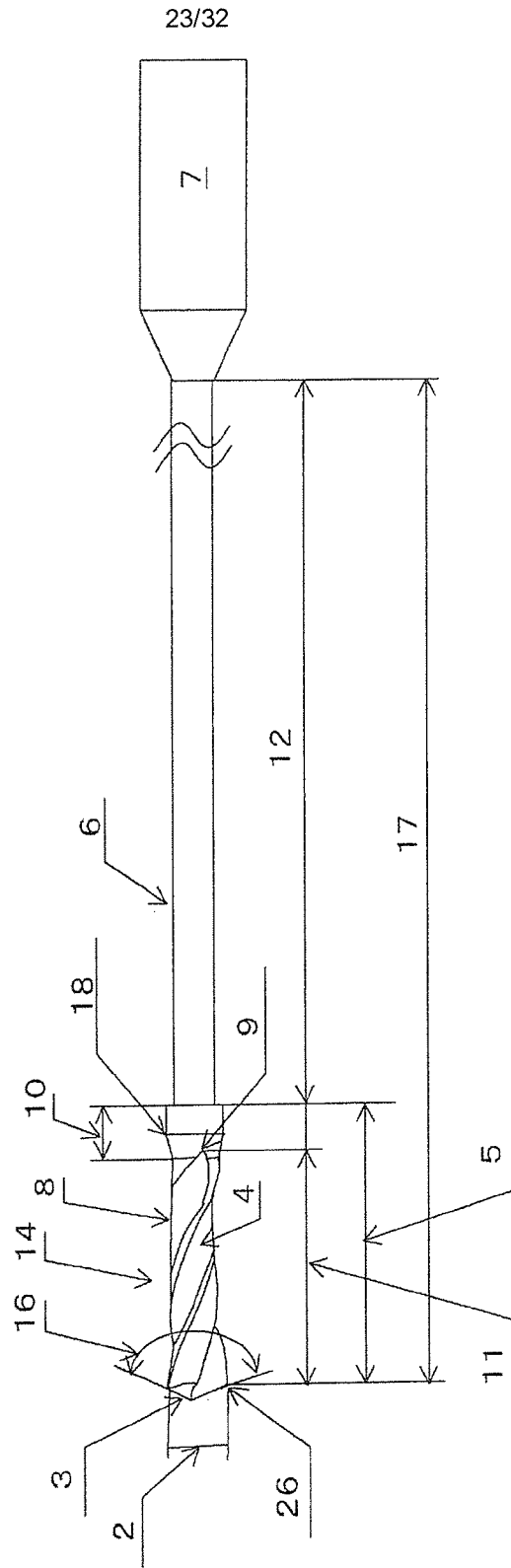


FIG. 24

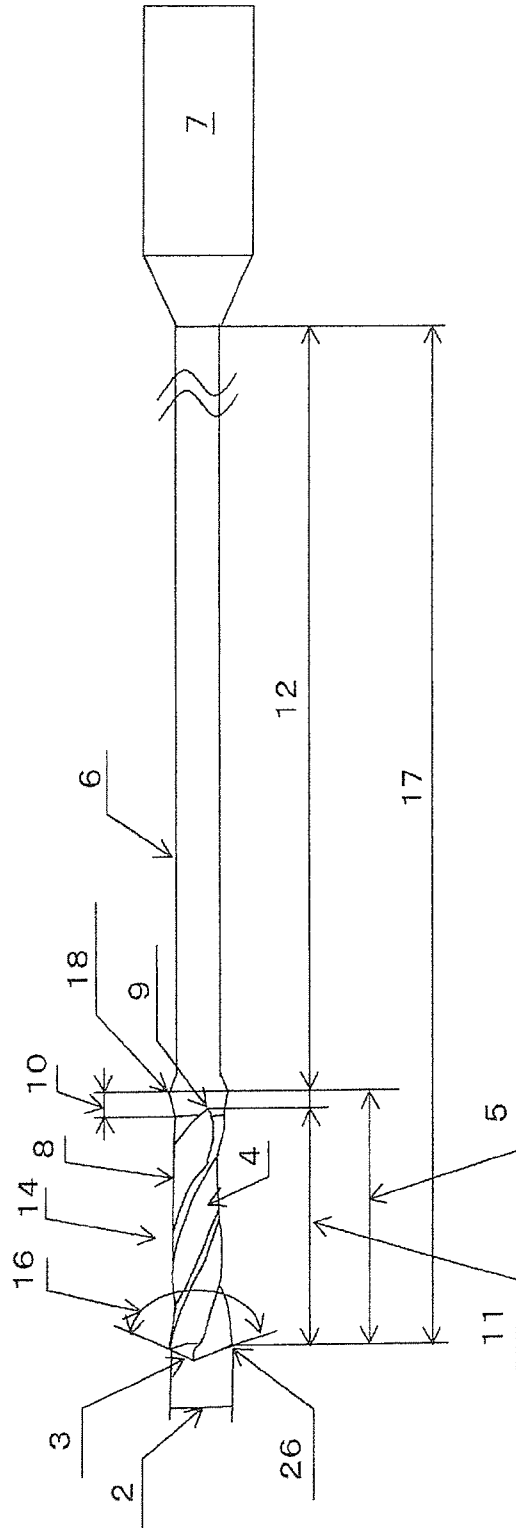


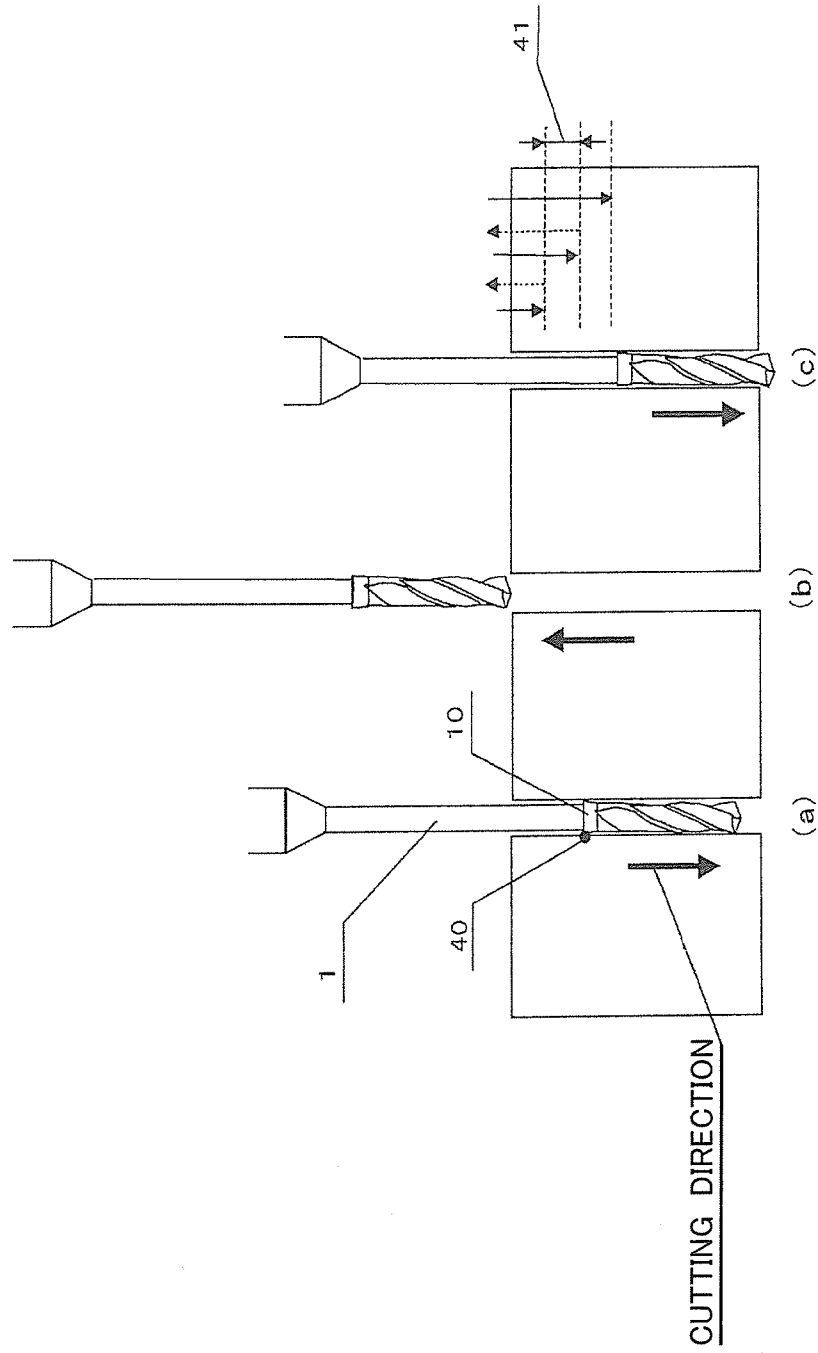
FIG.25

FIG.26(a)

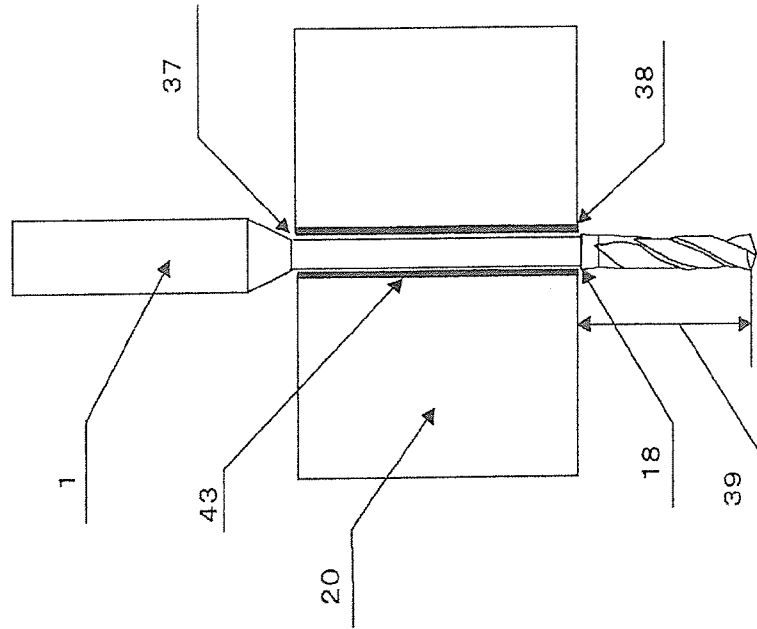


FIG.26(b)

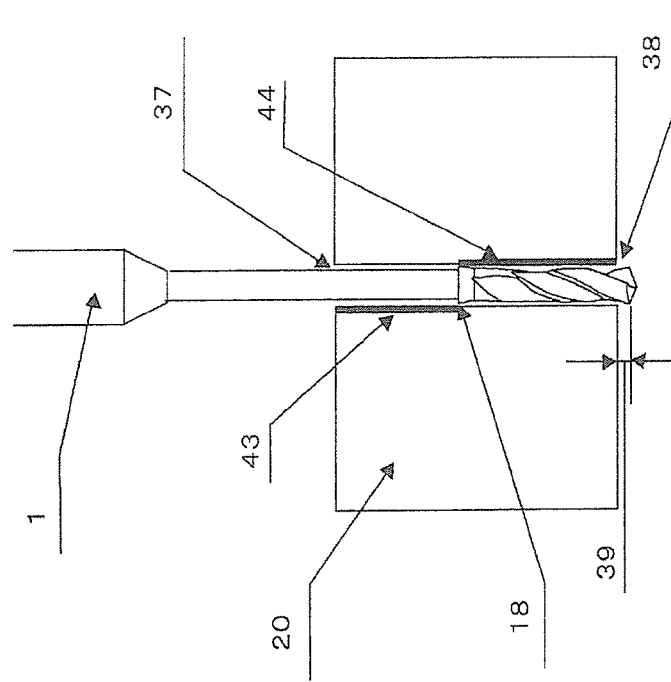


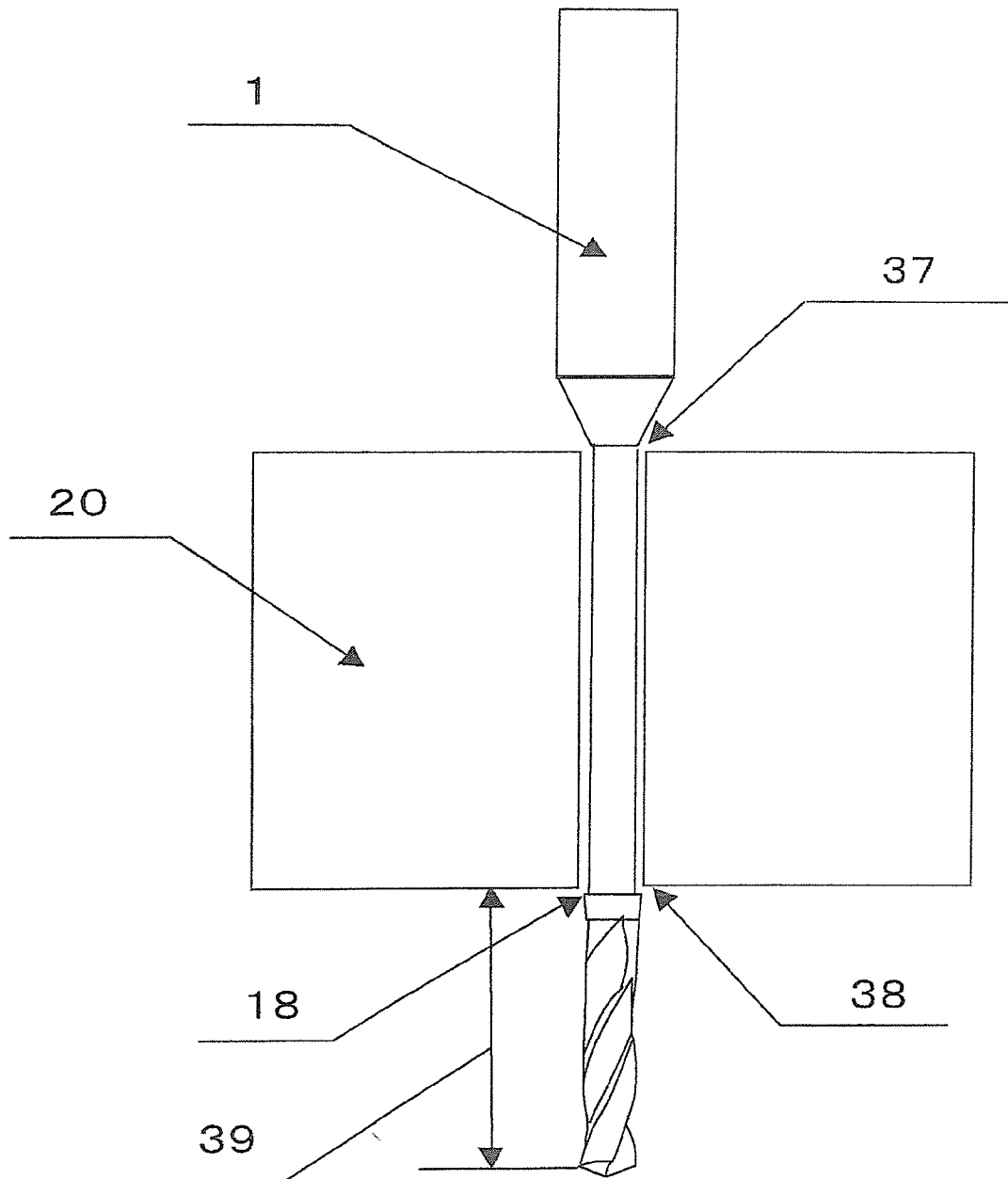
FIG.27

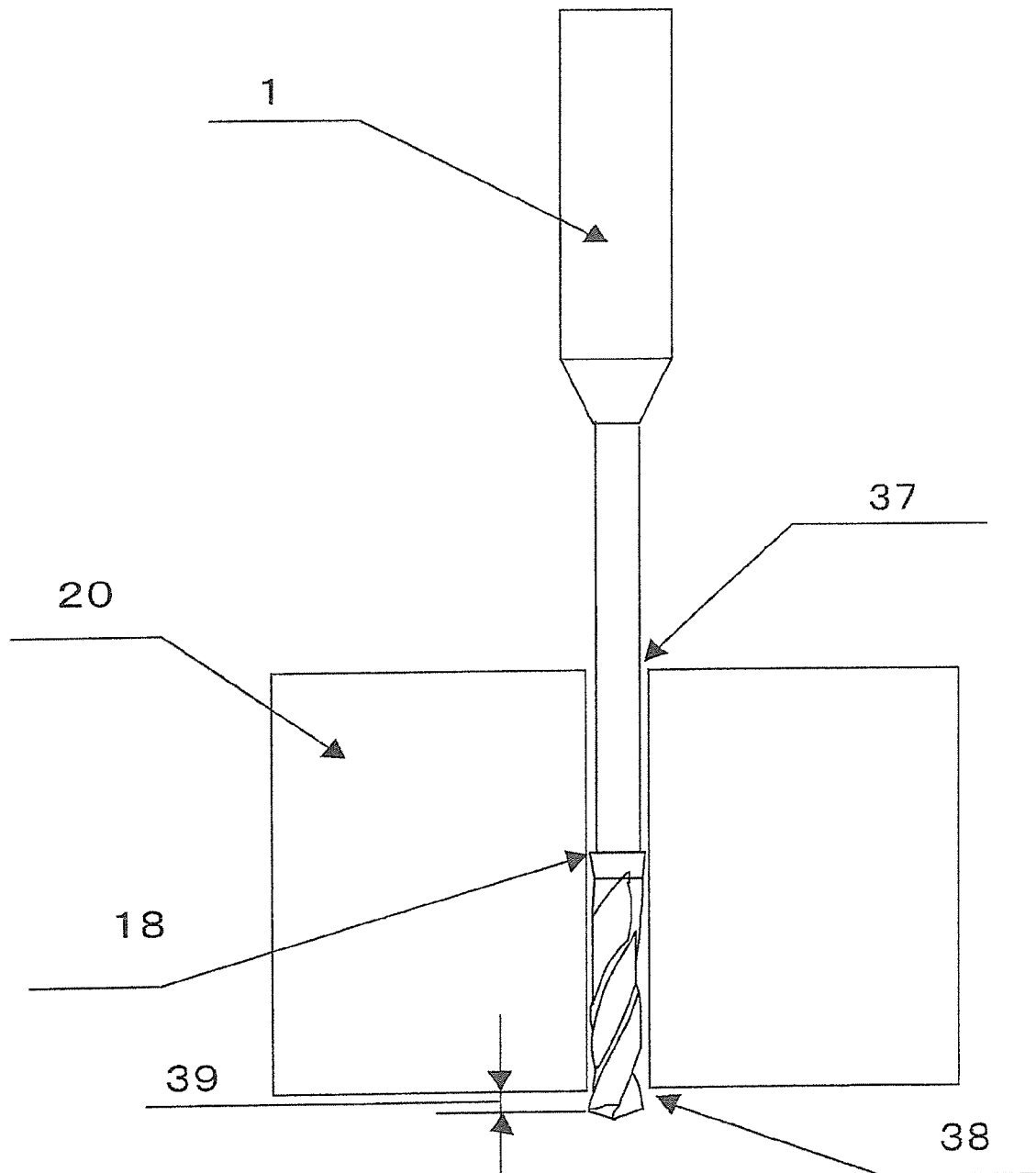
FIG.28

FIG.29

NEAR THE MIDDLE
OF HOLE

NEAR THE EXIT
OF HOLE

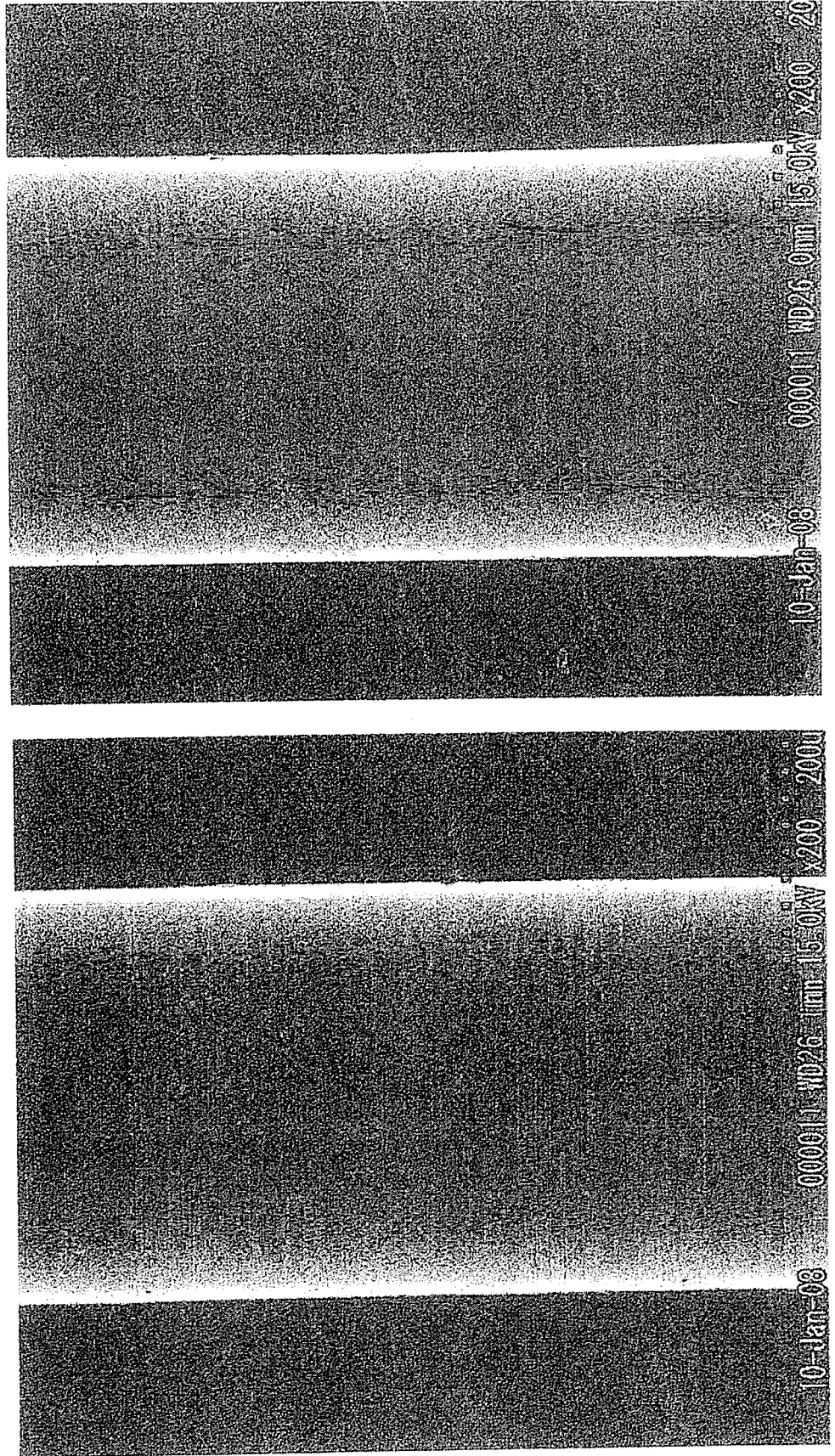


FIG.30

NEAR THE MIDDLE
OF HOLE

NEAR THE EXIT
OF HOLE

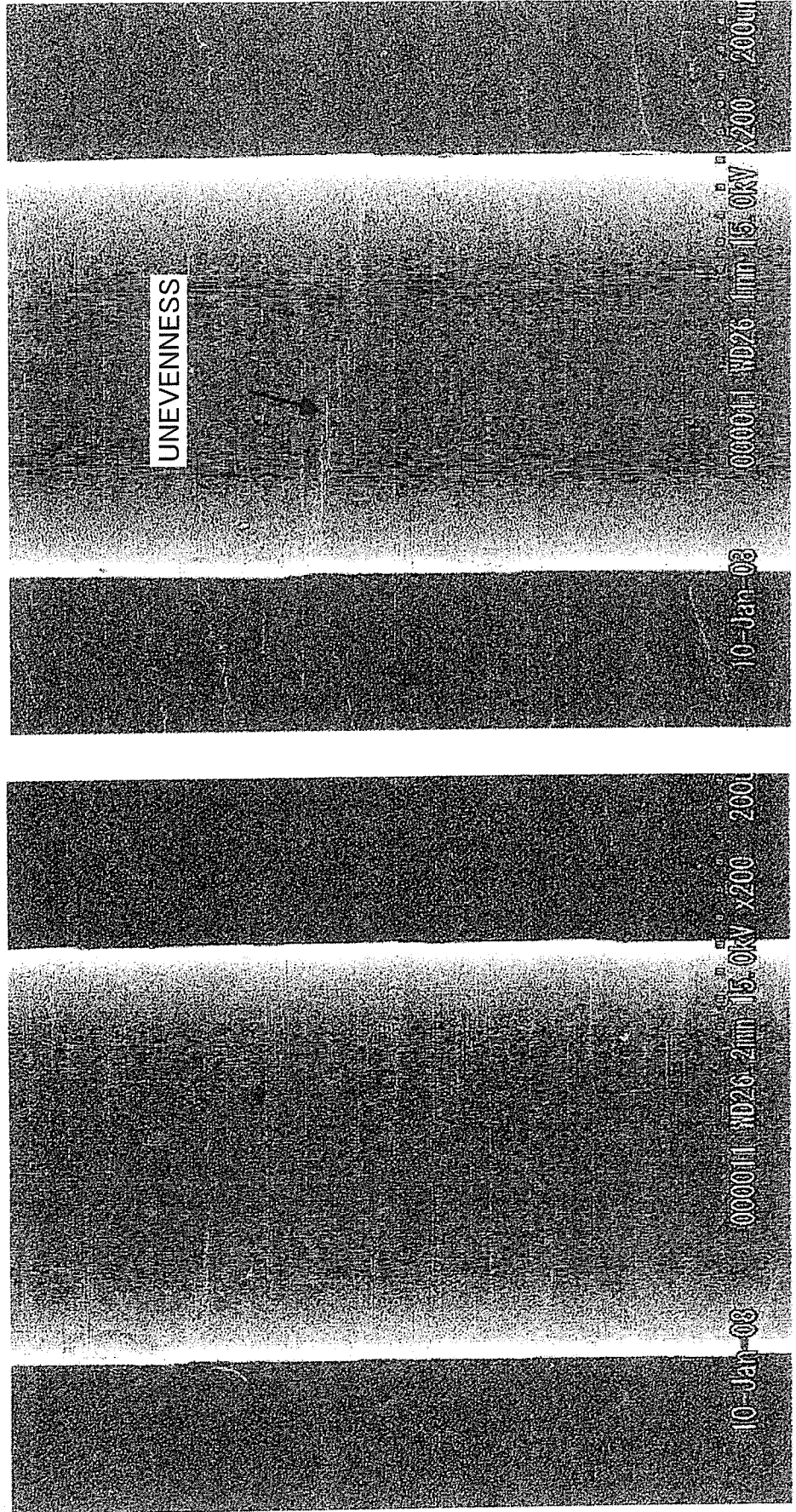


FIG.31

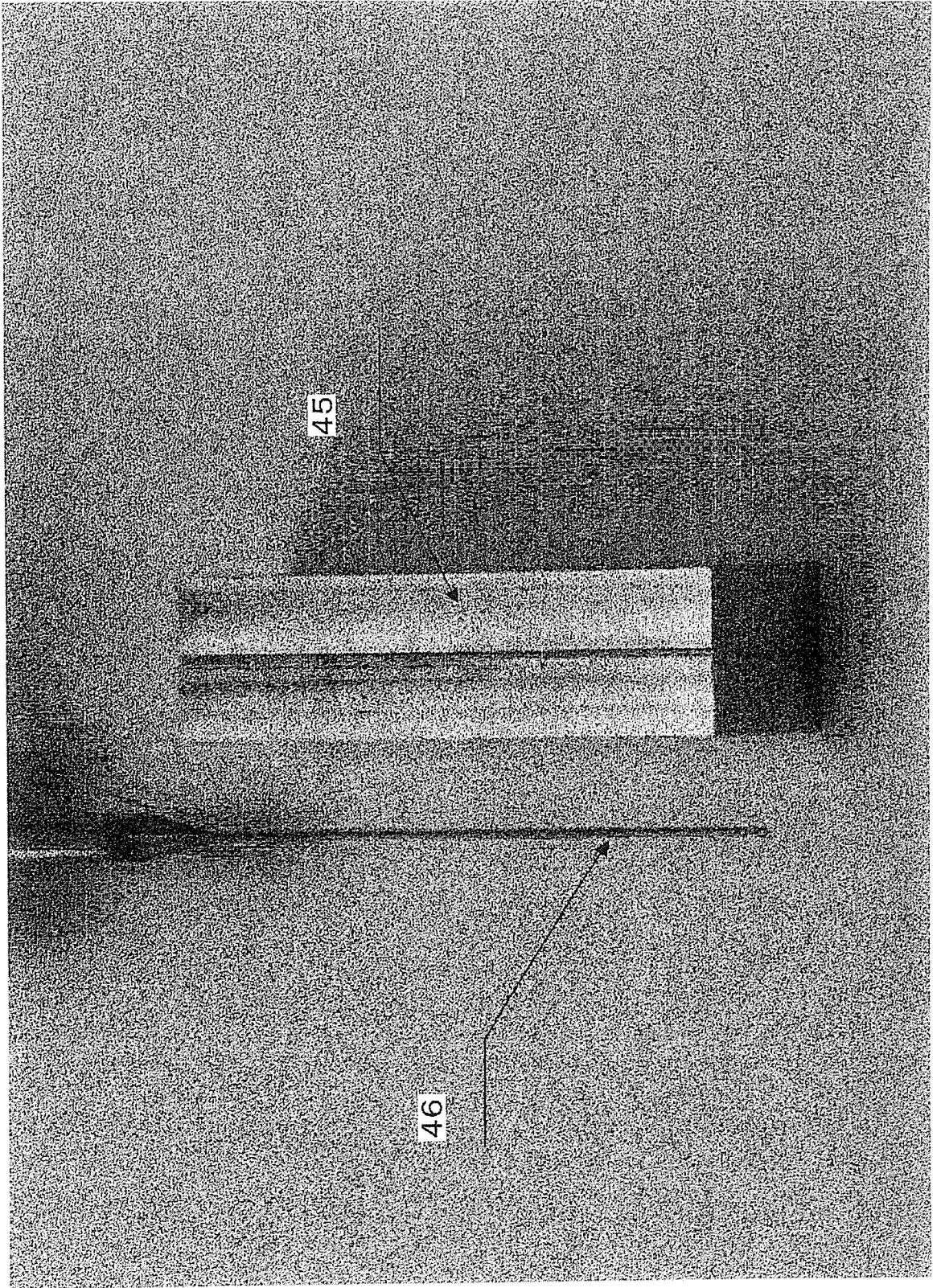
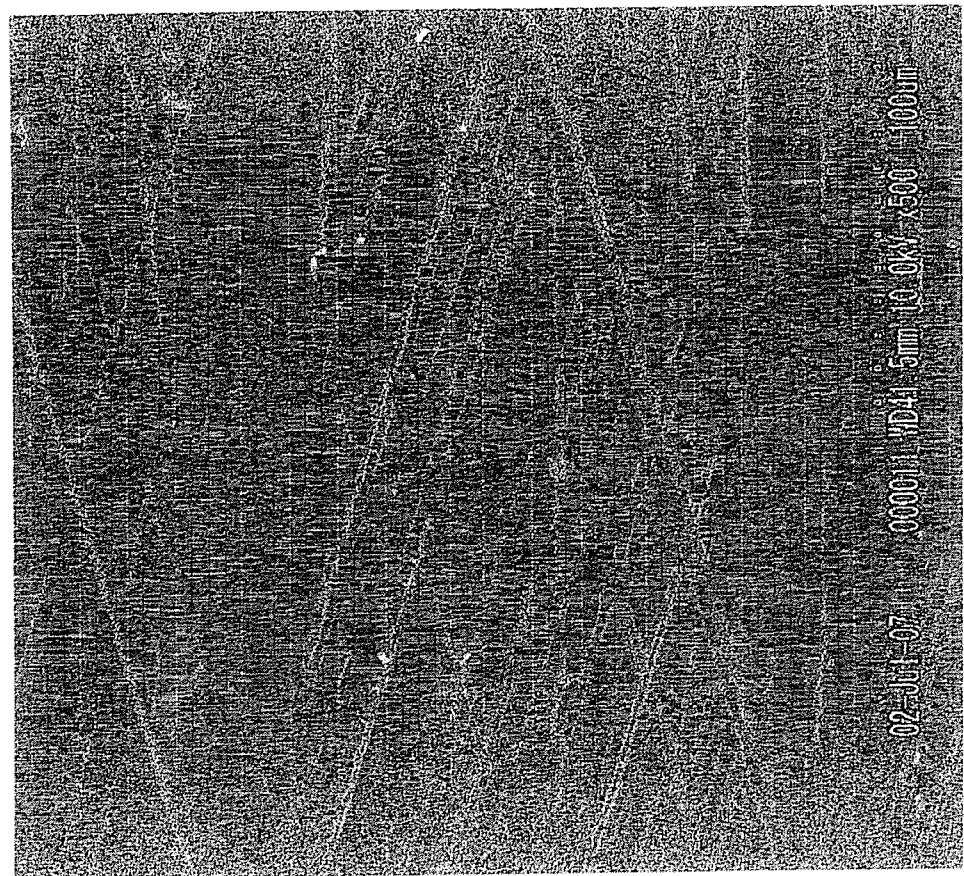


FIG.32(a)*FIG.32(b)*