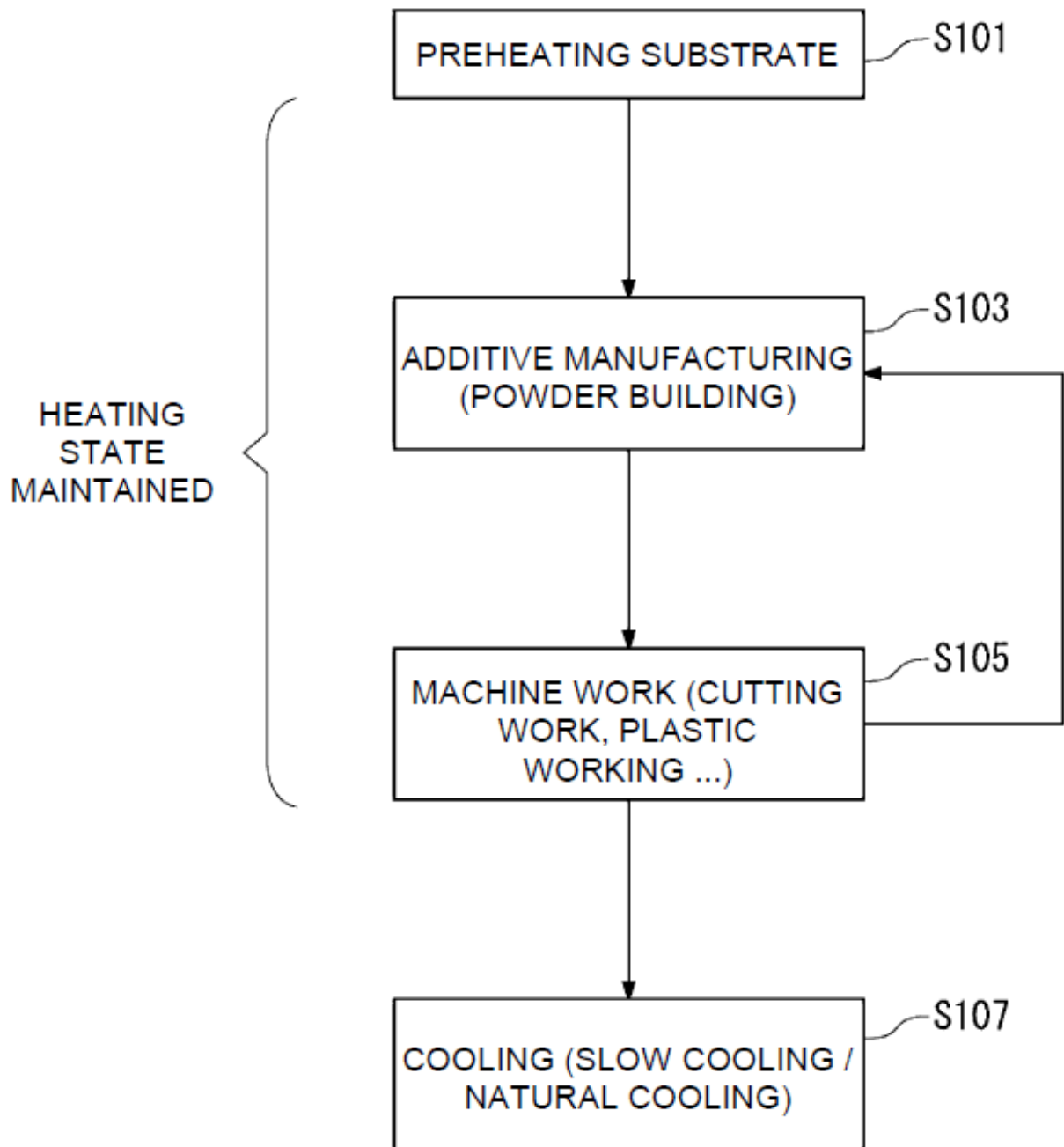


FIG. 1



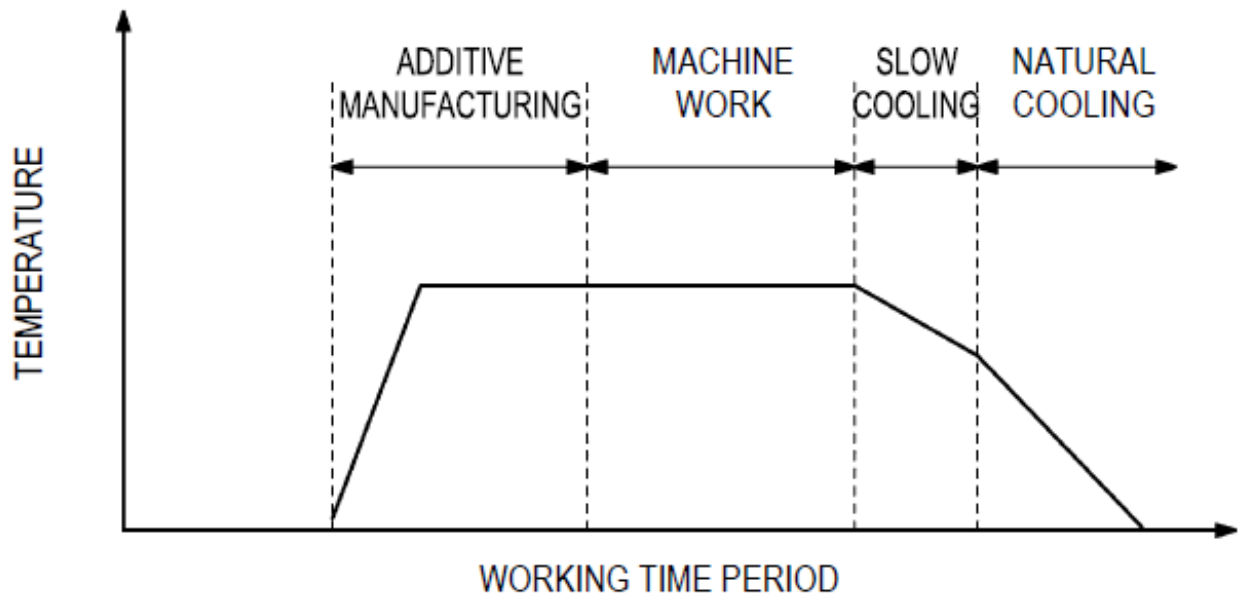


FIG. 2A

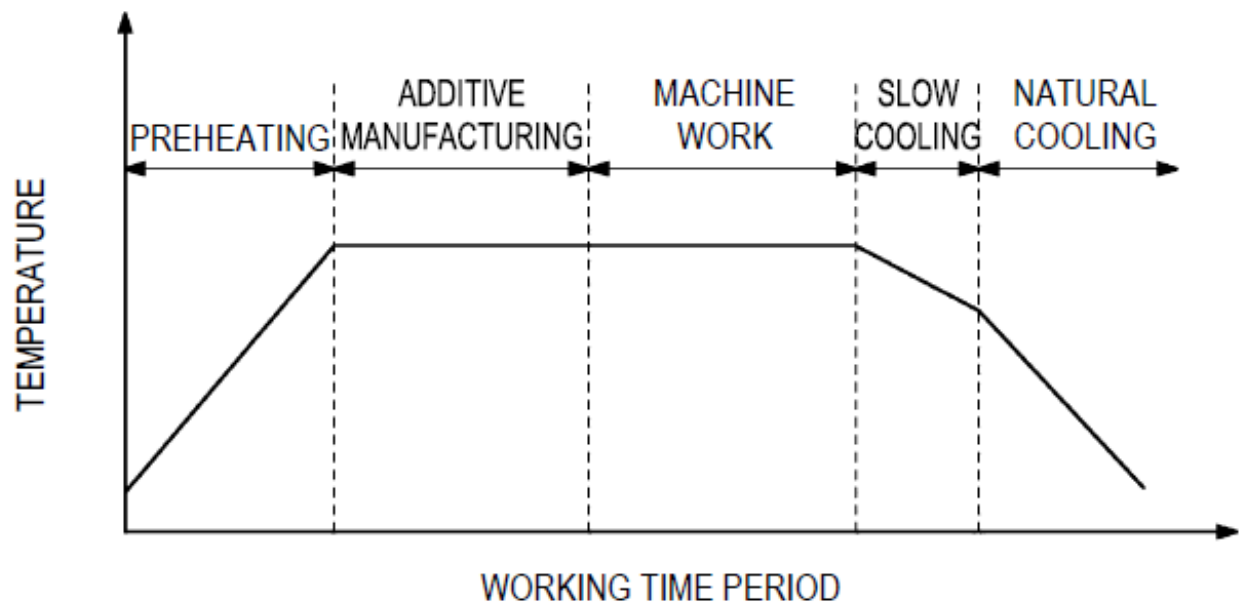


FIG. 2B

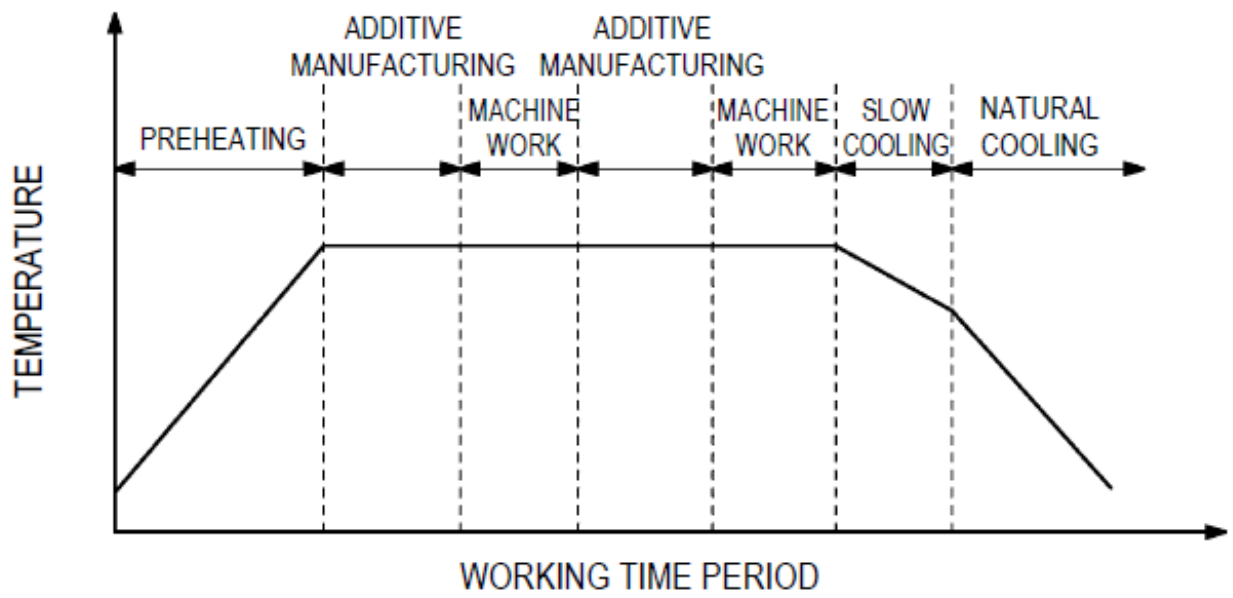


FIG. 2C

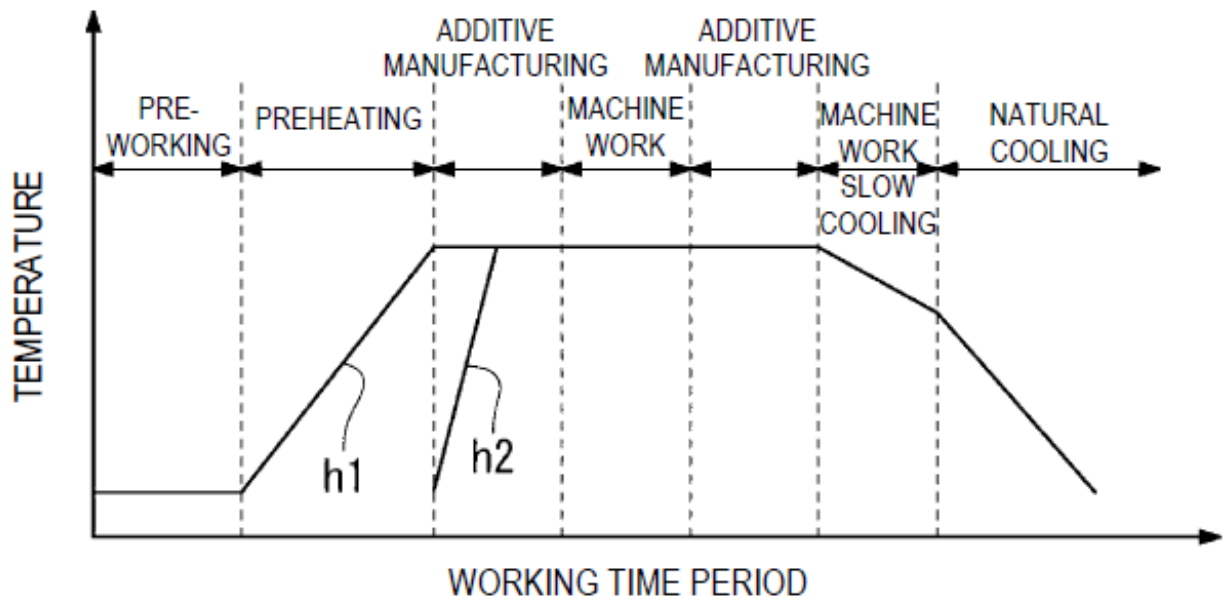


FIG. 3A

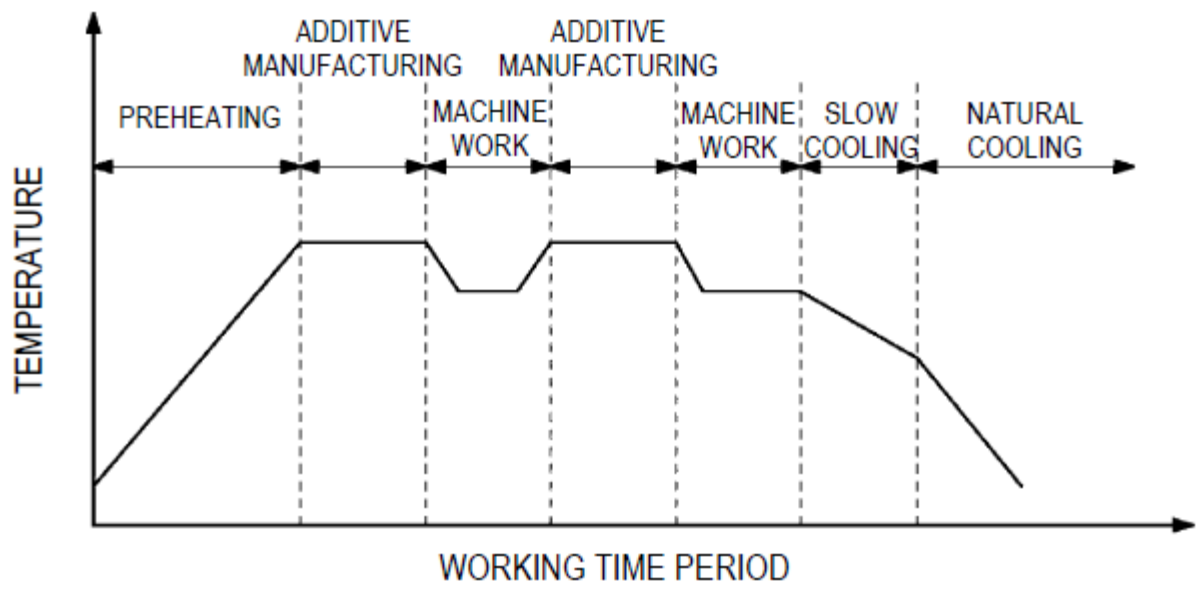


FIG. 3B

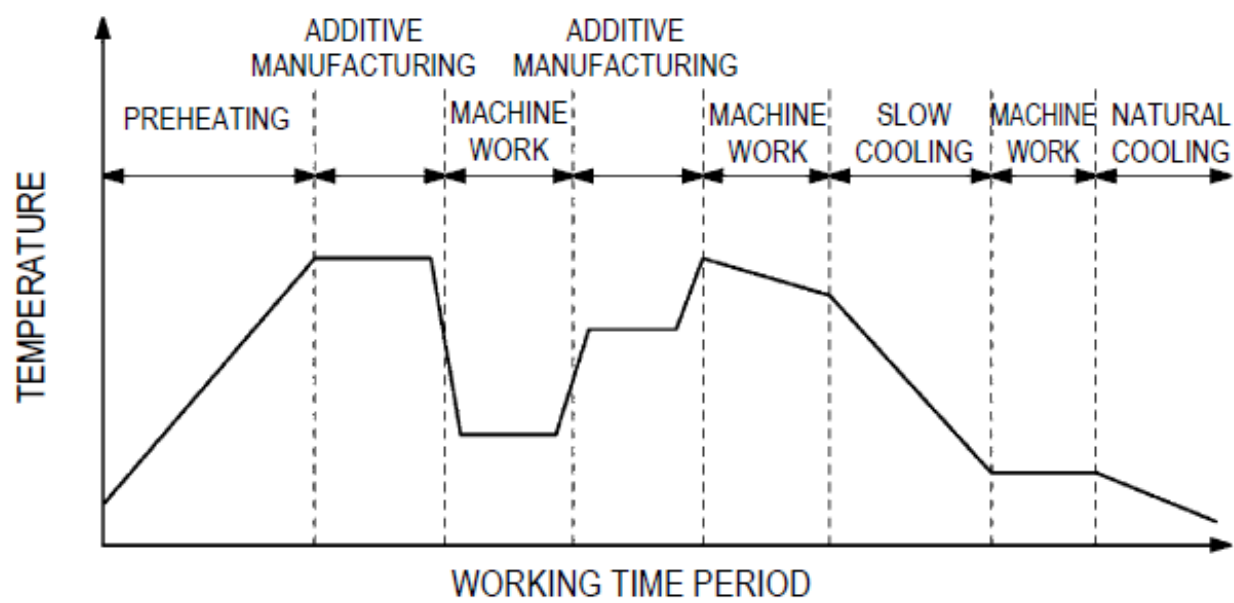


FIG. 3C

FIG. 4

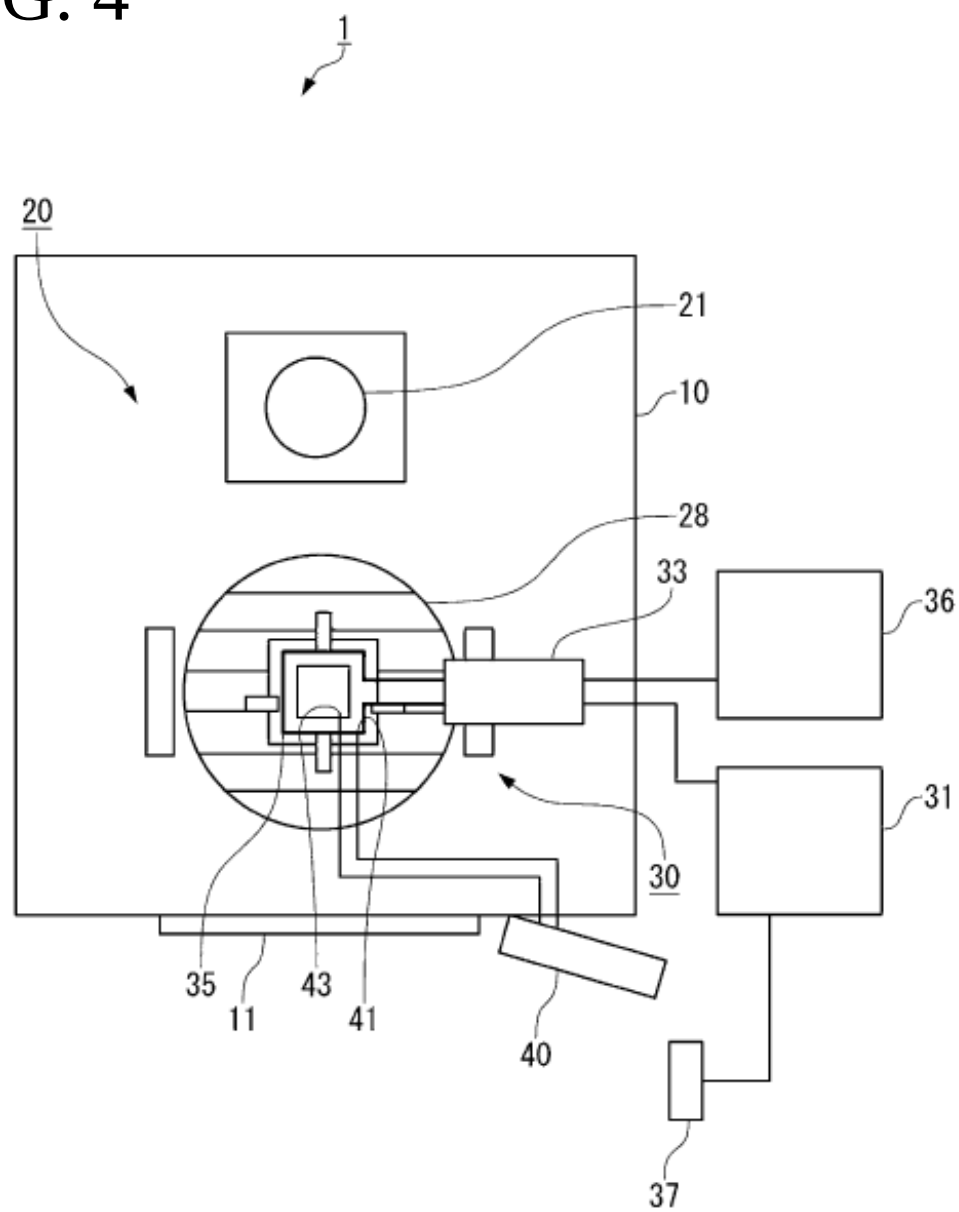


FIG. 5A

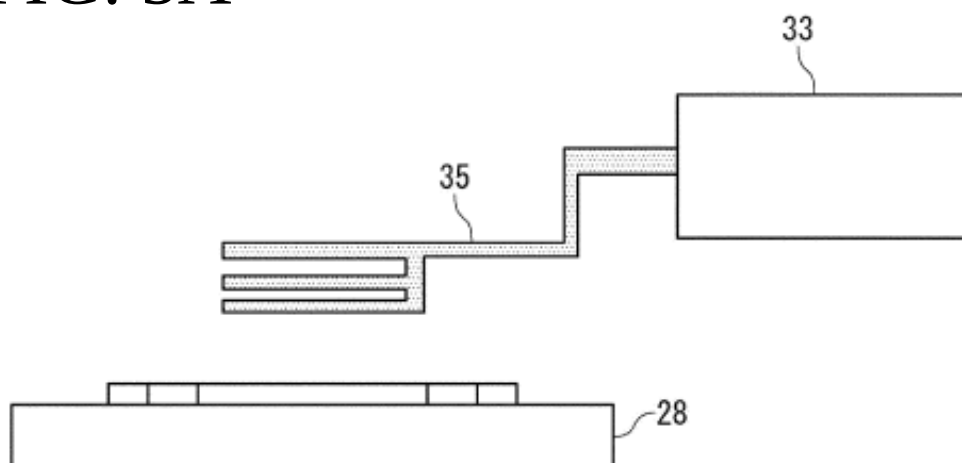


FIG. 5B

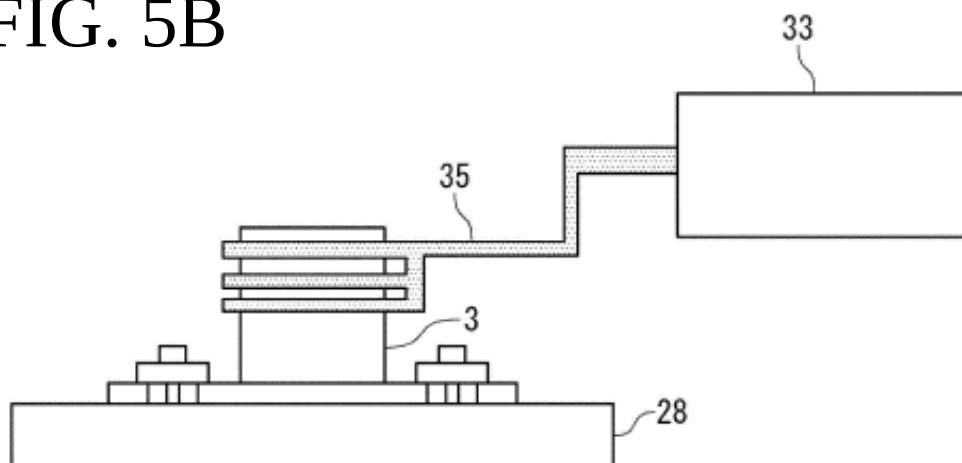


FIG. 6A

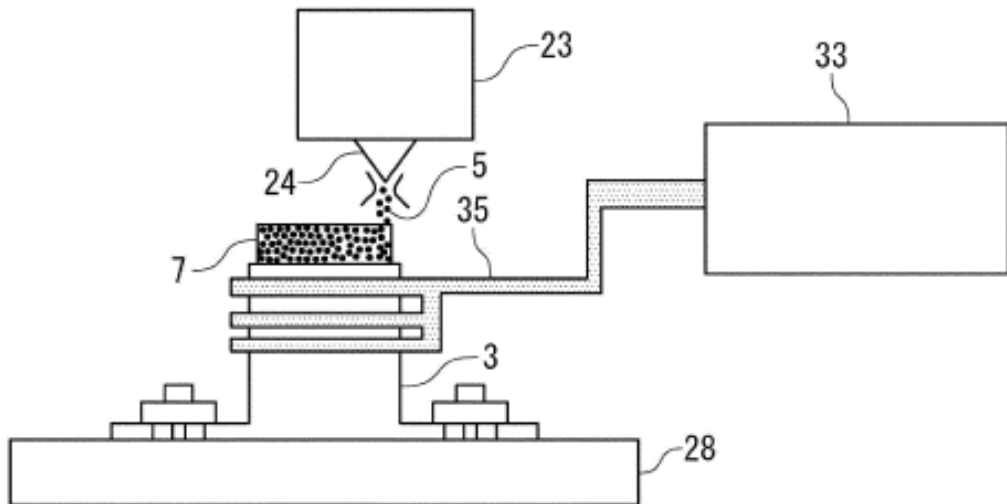


FIG. 6B

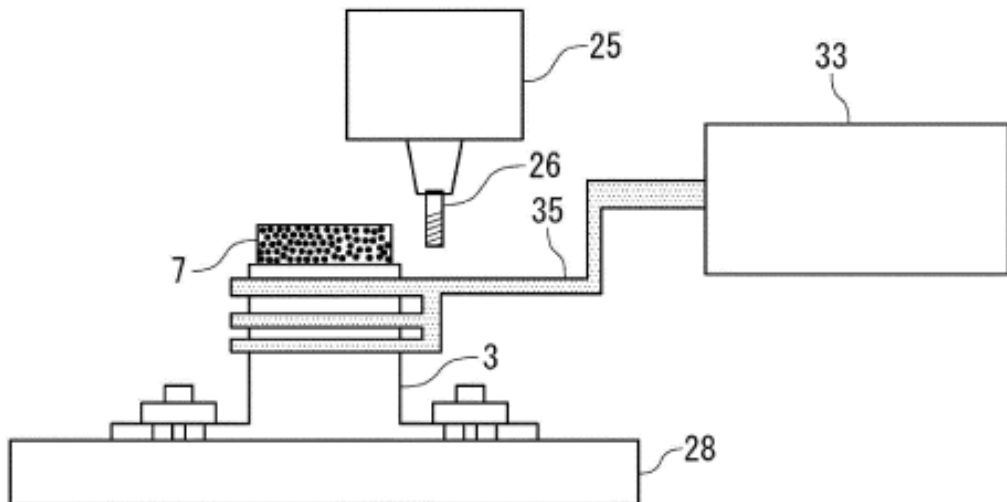
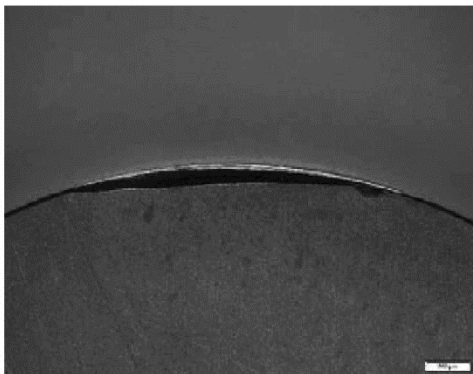


FIG. 7

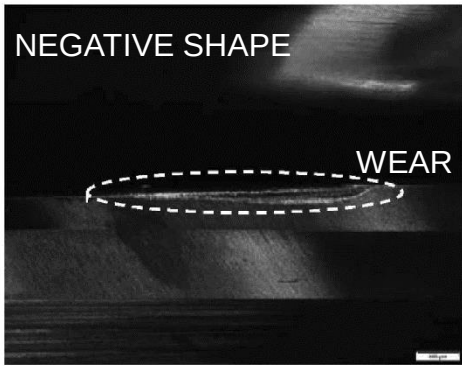


EXAMPLE 13
CUTTING SPEED $V=300$ m/min
WORK MATERIAL
TEMPERATURE: 500 TO 600°C

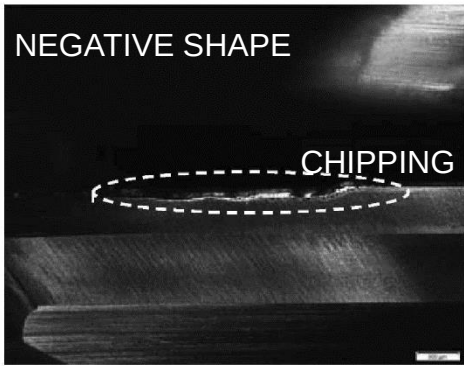


COMPARATIVE EXAMPLE 23
CUTTING SPEED $V=300$ m/min
WORK MATERIAL
TEMPERATURE: R. T. 25°C

FIG. 8



EXAMPLE 32
WORK MATERIAL
TEMPERATURE: 500 TO 600°C



COMPARATIVE EXAMPLE 41
WORK MATERIAL
TEMPERATURE: R. T. 25°C

1 mm

FIG. 9A

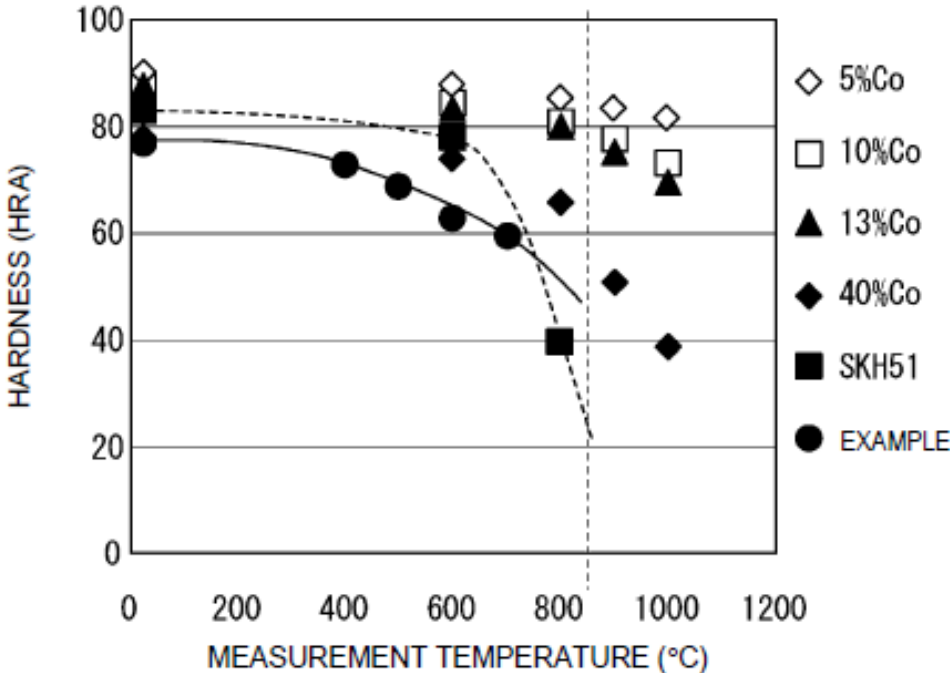
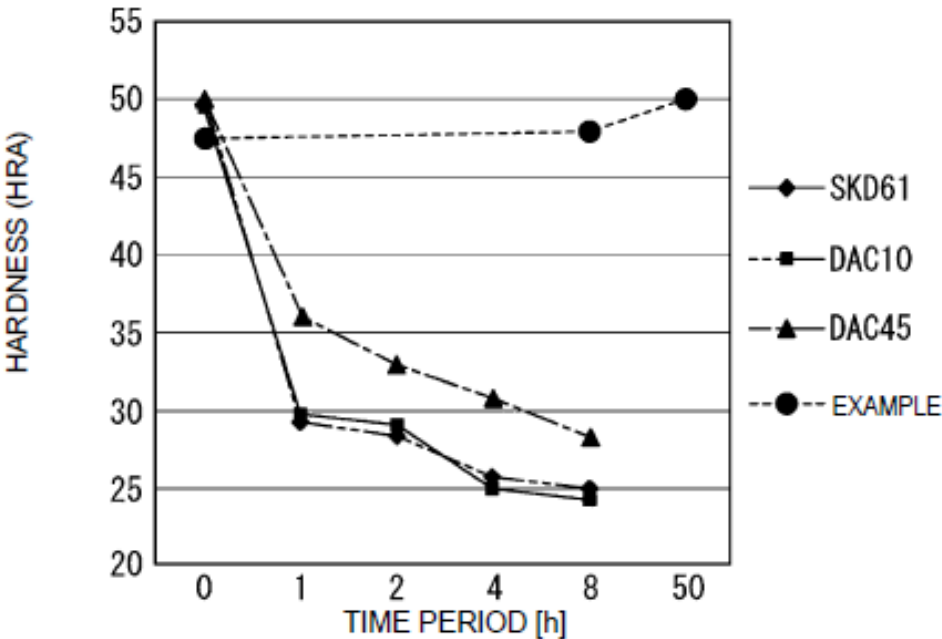


FIG. 9B



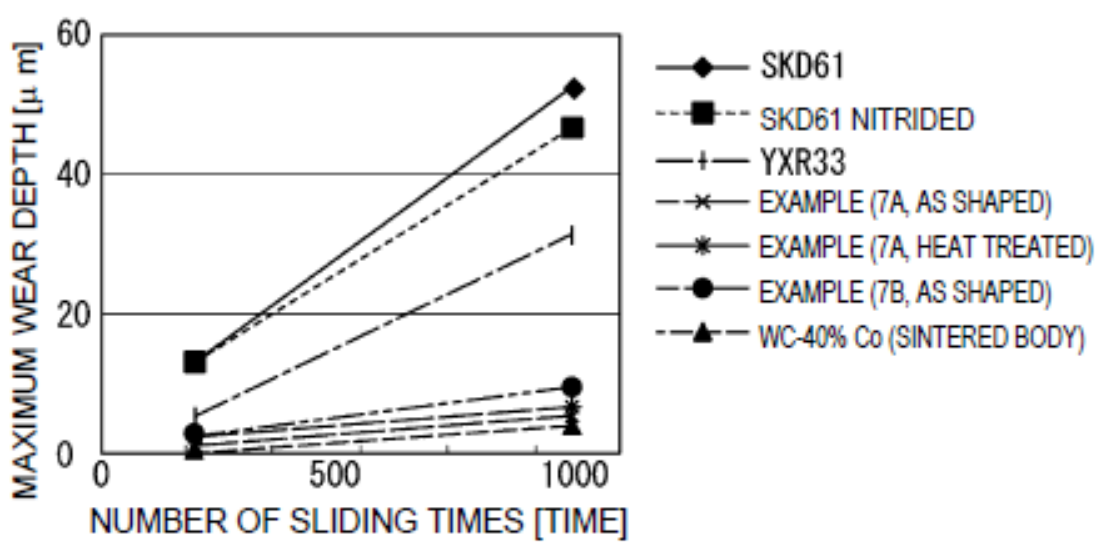


FIG. 10