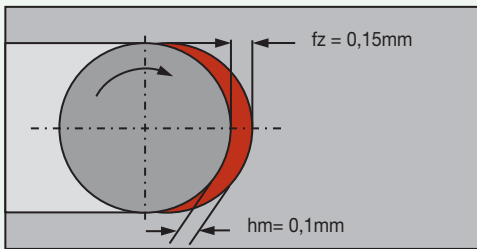


■ ae and Chip Thickness

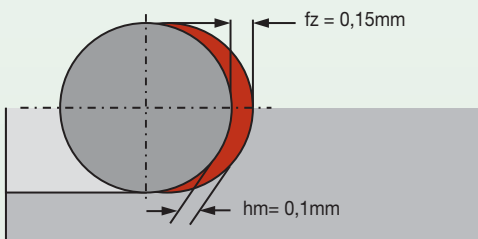
chip thinning effect		
ae	programmed feed (fz)	chip thickness (hm)
100%	0,15mm	0,1mm
50%	0,15mm	0,1mm
40%	0,15mm	0,09mm
20%	0,15mm	0,07mm
10%	0,15mm	0,046mm

The chip thickness needs to be compensated by feed.

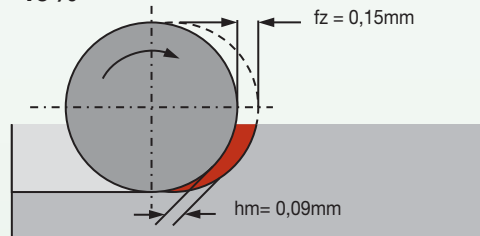
100%



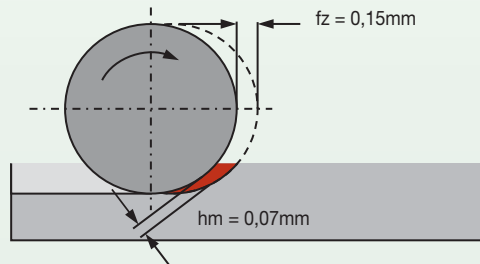
50%



40%



20%



10%

