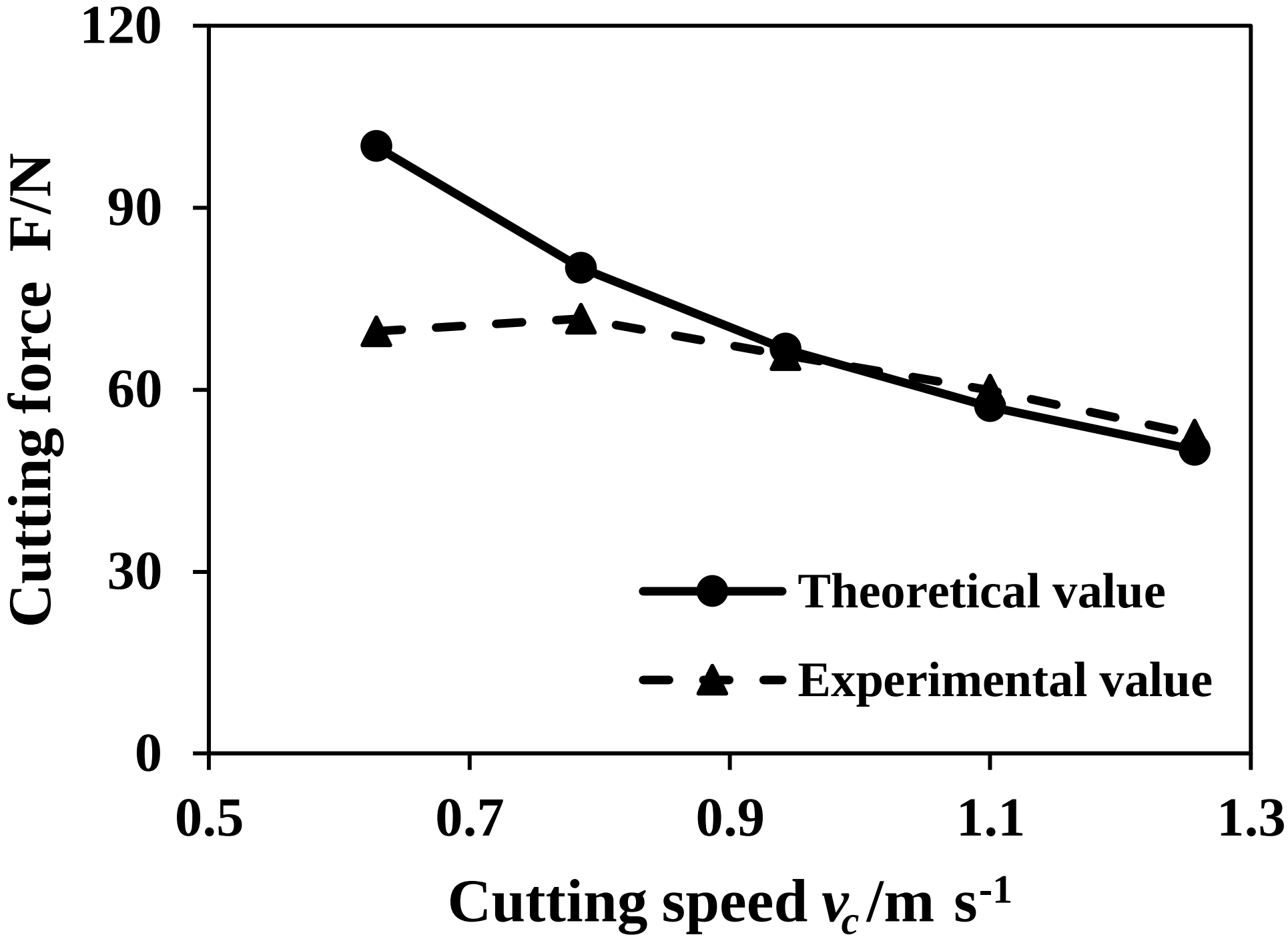
120
90
60
30
0
Cutting force F/N
0.5
0.7
0.9
1.1
1.3
Cutting speed v_c/m s^{-1}
Theoretical value
Experimental value