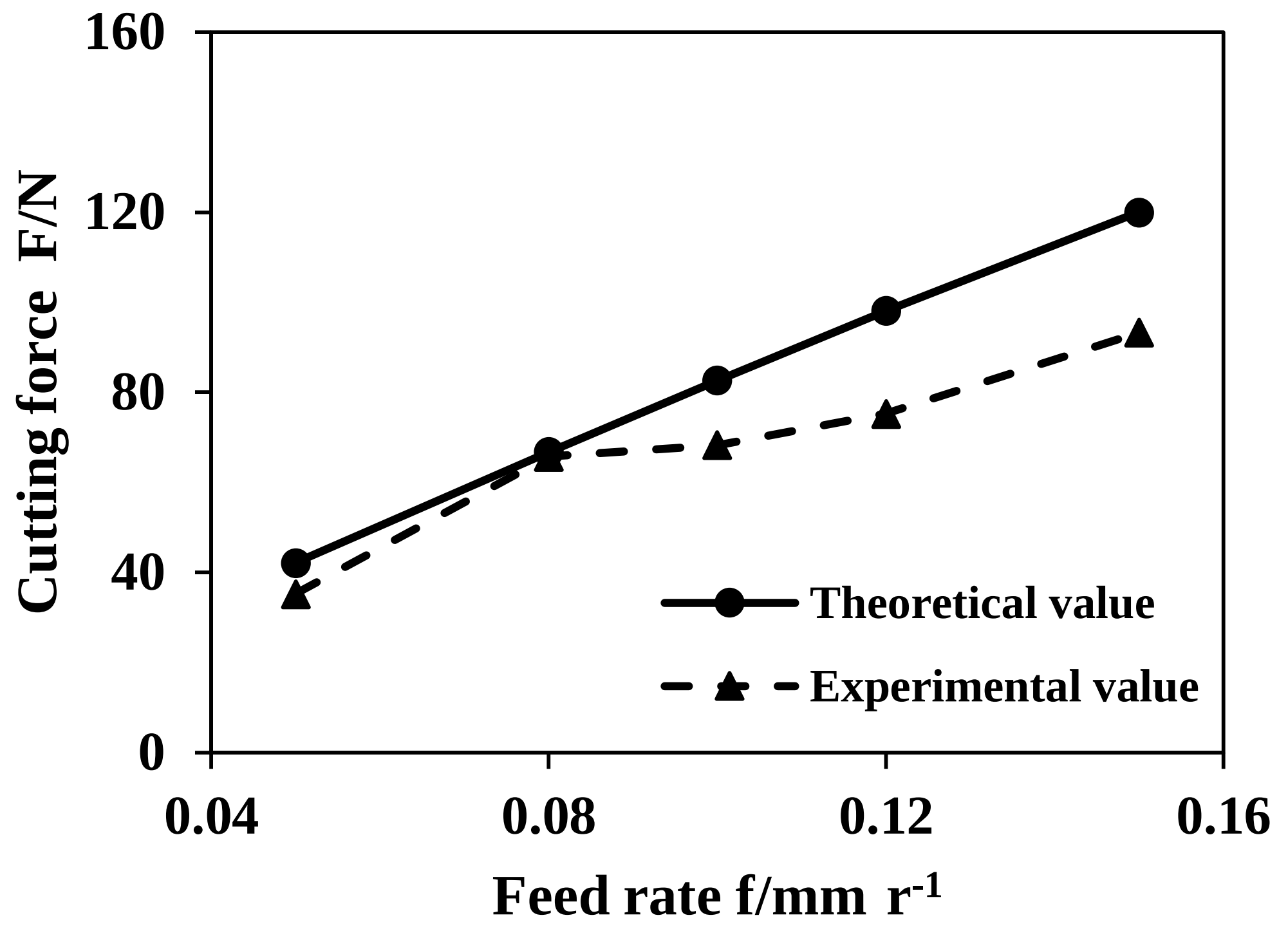
160
120
80
40
0
Cutting force F/N
0.04
0.08
0.12
0.16
Feed rate f/mm r-1
Theoretical value
Experimental value