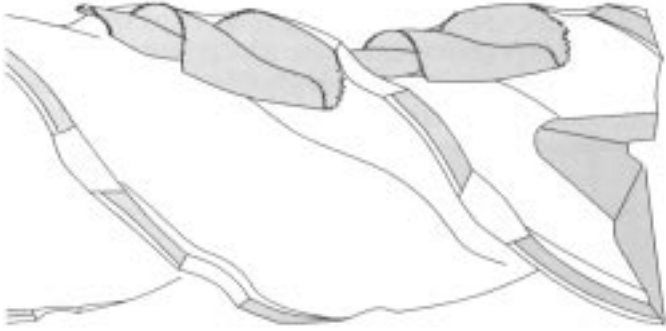


# CHIP FORMATION

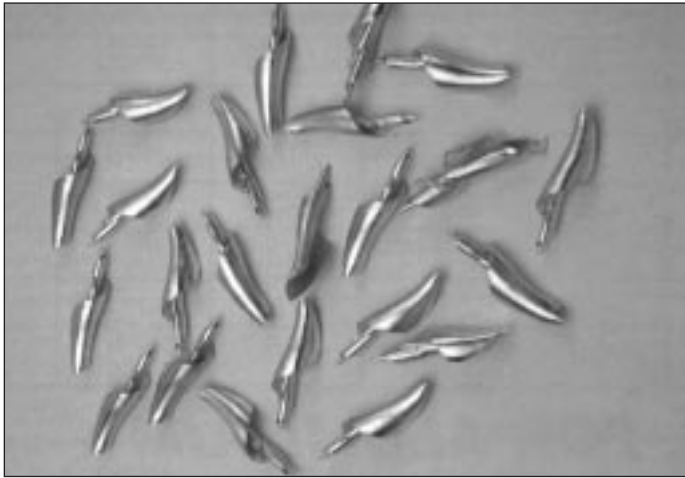


*THE EFFECT AND CONSEQUENCES OF THE SINUSOIDAL GULLET AND TRAILING FACES ON THE FORMATION OF CHIPS ARE EXPLAINED AS FOLLOWS:*

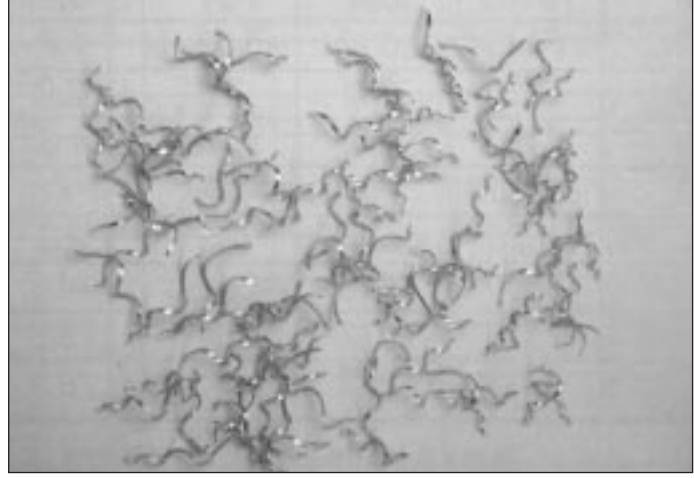
*DURING CHIP FORMATION, AS THE CHIP BEGINS TO CURL WITHIN THE GULLET SPACE, THIS GEOMETRY PROVIDES LESS SPACE IN WHICH TO CURL AT THE TWO EXTREMITIES OF THE INTERRUPTED CUTTING EDGE COMPARED TO THE CENTRAL PORTION. THE SINUSOIDAL GULLET IN FACT REACHES ITS MAXIMUM AMPLITUDE AT THE MIDDLE OF THE INTERRUPTED CUTTING EDGE.*

*THIS UNEVEN CURLING SPACE, CREATES A SPRINGING EFFECT ON THE CHIPS AND TOGETHER WITH THE SHEARING FORCE PRODUCE THE PHENOMENON OF CHIP EJECTION FROM THE WORK AREA AS OBSERVED BY THE MANY USERS OF "MINICUT" END MILLS.*

*MINICUT – ALUMINUM*



*ROUGHER – ALUMINUM*



*MINICUT – TITANIUM*



*ROUGHER – ALUMINUM*

