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tool to obtain the desired shape and size of the workpiece. The essence of the cutting process is that the workpiece cutting layer produces plastic deformation under the extrusion of the front edge of the cutter, and becomes a complicated process of cutting.

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Figure 21.10 - Forces in metal cutting: (b)

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in metal cutting. The essence of this method is to test the experimental results against the theoretical obtained by minimizing the following expression for the cutting force $F_c = \frac{1}{\sin \phi} (F_c \cos \phi + F_t \sin \phi)$ (33) where F_c is the force

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component arising from the inevitable flow of a thin layer of the work material below

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