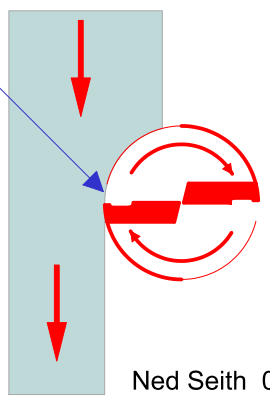


FINISH IS A RESULT OF EXIT CUT WHEN CHIP LOAD AND FORCES ARE MAXIMUM AND LESS STABLE

CONVENTIONAL MILLING

(UP CUT MILLING)

- UPWARD FORCE ON THE WORK PIECE
- CHIP STARTS THIN AND INCREASES IN THICKNESS
- CUTTER STARTS WITH MINIMUM CHIP LOAD

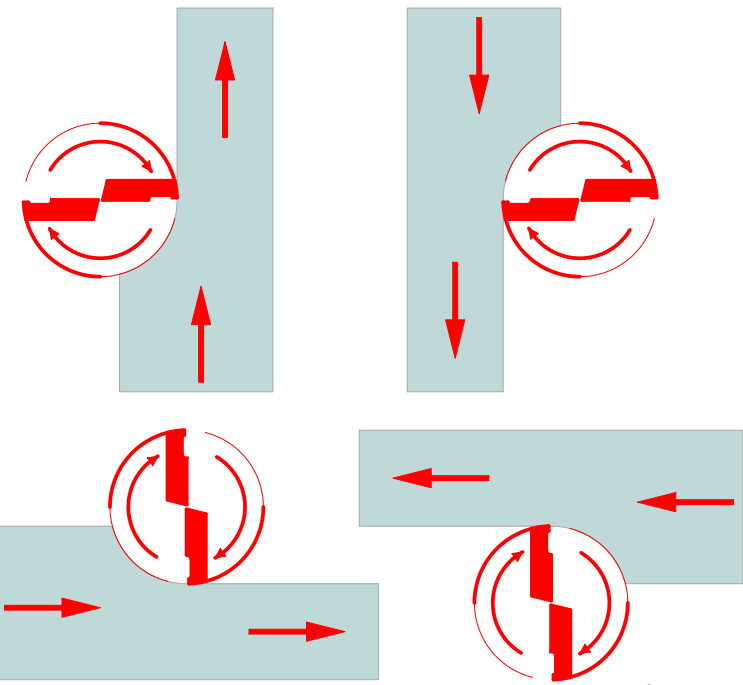


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Ned Seith 08/08

WORK PIECE TRAVELS IN OPPOSITE DIRECTION OF CUTTER ROTATION

CONVENTIONAL MILLING



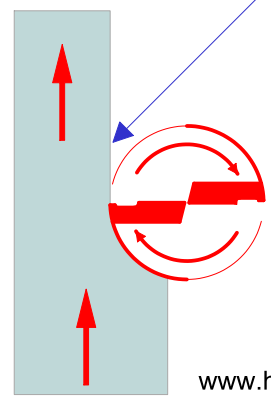
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CLIMB MILLING

(DOWN CUT MILLING)

FINISH IS A RESULT OF EXIT CUT WHEN CHIP LOAD AND FORCES ARE MINIMUM

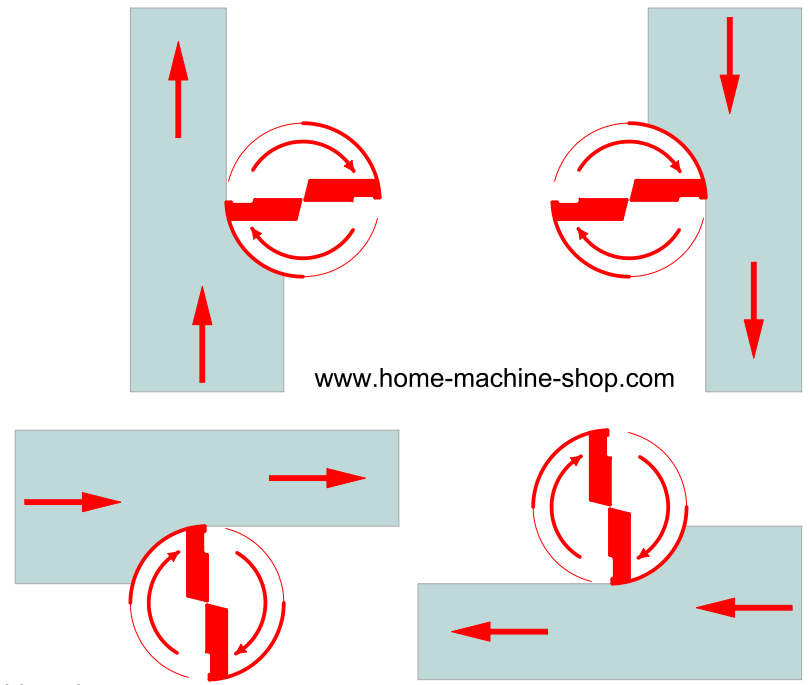
- DOWNWARD FORCE ON THE WORK PIECE
- CHIP STARTS THICK AND REDUCES IN THICKNESS
- CUTTER STARTS WITH MAXIMUM CHIP LOAD
- SUPERIOR FINISHES



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WORK PIECE TRAVELS IN SAME DIRECTION OF CUTTER ROTATION

CLIMB MILLING



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