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Types of Chips □ Four Types: -Continuous -Built-up edge -Serrated or Segmented -Discontinuous □ Tool side of chip is shiny or burnished (a) continuous chip with narrow, straight primary shear zone; (b)

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secondary shear

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In recent years, the machining of wood products has acquired great importance due the short supply of wood and increasing environmental awareness among users and manufacturers. The optimization of the machining process centers around the mechanism of chip formation, tool wear, workpiece surface quality, crack initiation and propagation of different types of wood.

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