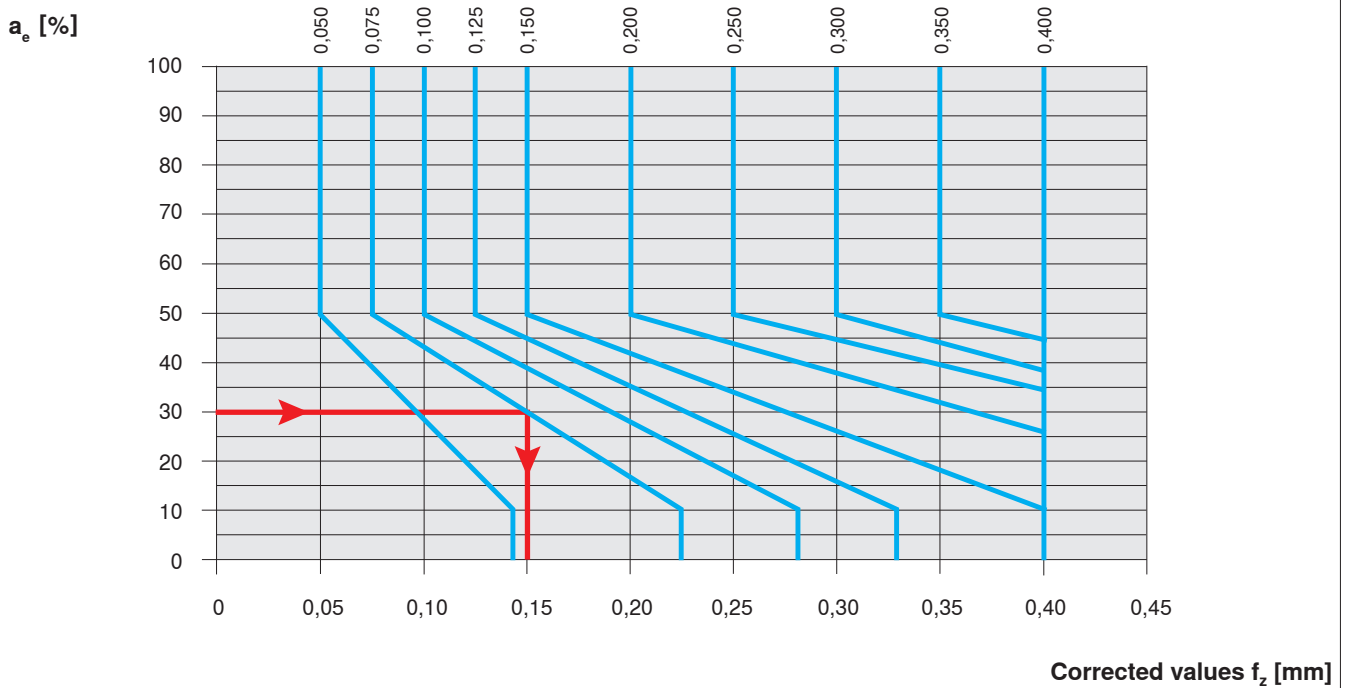


Starting values f_z [mm] from starting parameter diagram



These parameters apply for cutting width (a_e) below 50%

Example:

Starting value [f_z] = 0.075 mm

a_e = 30%

Corrected value [f_z] = 0.15 mm