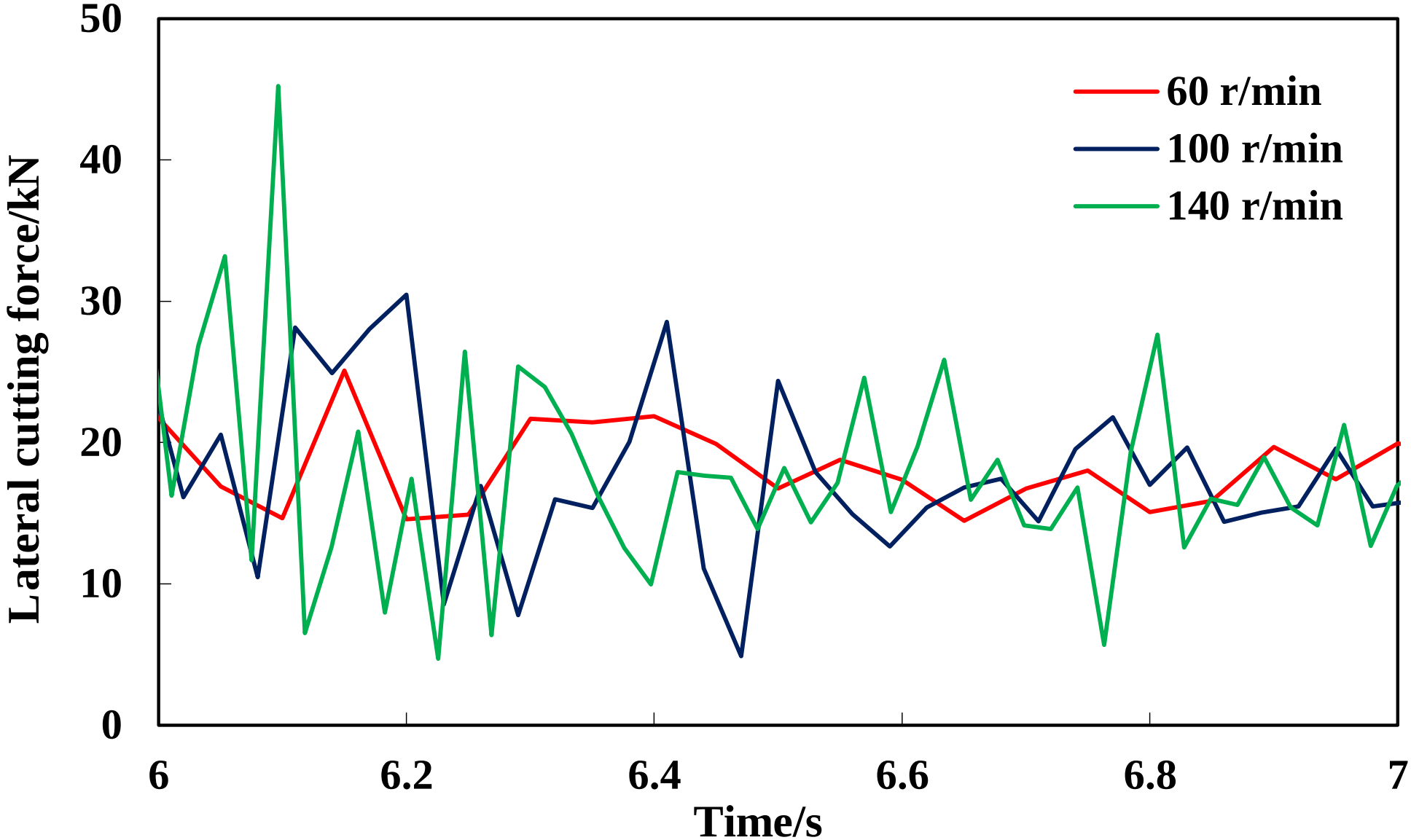
50
40
30
20
10
0
Lateral cutting force/kN
6
6.2
6.4
6.6
6.8
7
Time/s
60 r/min
100 r/min
140 r/min