

BLOUSE CUTTING STEPS WITH PICTURE Full Version

blouse cutting steps with picture are essential for anyone looking to create a beautifully tailored blouse. Whether you're a beginner or an experienced tailor, understanding the precise steps involved in cutting a blouse can significantly improve your sewing outcomes. Proper cutting ensures that the fabric is used efficiently, the seams align correctly, and the final fit is perfect. In this comprehensive guide, we will walk you through each step of blouse cutting, complete with visual aids and tips to help you achieve professional-looking results. By following these detailed instructions, you'll be able to cut and prepare your fabric with confidence, setting a solid foundation for assembly and finishing.

Understanding the Basics of Blouse Cutting

Before diving into the step-by-step process, it's important to understand some fundamental concepts of blouse cutting. This knowledge will help you make accurate measurements, choose the right fabric, and execute each step with precision.

Key Concepts

- **Pattern Drafting:** Creating or using a pre-made pattern that fits your measurements.
- **Fabric Selection:** Choosing a fabric suitable for blouses, such as cotton, silk, chiffon, or georgette.
- **Measurements:** Taking accurate body measurements for bust, waist, hips, shoulder, armhole, and length.
- **Grainline:** Aligning the pattern with the fabric's grain for proper drape and fit.

Tools and Materials Needed

To ensure a smooth blouse cutting process, gather the following tools:

- Fabric of your choice
- Pattern paper or pre-made blouse pattern
- Measuring tape
- Fabric scissors or rotary cutter
- Pins or pattern weights

- Chalk or fabric marker
- Ruler or straight edge
- Pattern paper or tracing paper
- Iron and ironing board

Step-by-Step Guide to Blouse Cutting with Pictures

Below is a detailed, step-by-step process to cut your blouse fabric accurately. Each step includes a description and tips for best results.

Step 1: Take Accurate Measurements

Start by taking precise measurements of your body. Key measurements include bust, waist, hips, shoulder width, armhole, and blouse length. Record these measurements carefully.

Tip: Always add seam allowances (usually 1-1.5 inches) to your measurements when drafting or cutting patterns.

Step 2: Draft or Select a Pattern

You can either draft your own blouse pattern based on your measurements or use a commercial pattern. Ensure the pattern includes all necessary parts: front, back, sleeves, and any darts or design features.

Tip: For beginners, starting with a pre-made pattern and customizing it can save time.

Step 3: Prepare Your Fabric

- Wash and iron your fabric to pre-shrink and smooth out wrinkles.
- Lay the fabric flat on a clean, large surface.
- Determine the fabric grainline and ensure the fabric is folded correctly.

Step 4: Lay Out the Fabric and Pattern

Fold your fabric according to the pattern requirements, typically selvage to selvage or on the fold for certain pieces.

Pin or weight down the pattern pieces onto the fabric, aligning the pattern's grainline arrow parallel to the fabric's selvage.

Step 5: Trace the Pattern Pieces

- Using chalk or fabric marker, trace around each pattern piece onto the fabric.
- Mark darts, notches, and other pattern markings clearly.
- Include seam allowances if your pattern doesn't already have them.

Ensure you trace all pieces, including front, back, sleeves, and any additional details.

Step 6: Cut Out the Fabric Pieces

- Cut carefully along your traced lines, maintaining a steady hand.
- Use sharp fabric scissors or a rotary cutter for clean edges.
- Cut each piece separately, ensuring not to shift the fabric or pattern.

Tip: For curved edges like armholes, cut slowly to maintain precision.

Step 7: Mark Important Points

After cutting, transfer all pattern markings such as darts, notches, and pleats onto the fabric using a fabric marker or tailor's chalk.

Additional Tips for Perfect Blouse Cutting

- Always double-check pattern pieces against your measurements before cutting.
- Use a cutting mat if available for rotary cutter use.
- Maintain consistency in seam allowances to ensure uniformity during sewing.
- Label each fabric piece to avoid confusion during assembly.
- Be patient and precise; rushing can lead to inaccuracies.

Conclusion

Mastering the blouse cutting process is crucial for creating well-fitted, professional-looking garments. By following the detailed steps outlined above—taking accurate measurements, preparing your fabric, carefully laying out your pattern, and cutting with precision—you set a strong foundation for a beautiful blouse. Remember that practice makes perfect, and over time, your speed and accuracy will improve. Don't forget to review your pattern and measurements before each project, as attention to detail is key to successful sewing. With patience and careful execution, you'll be able to craft stunning blouses that fit perfectly and showcase your sewing skills.

FAQs about Blouse Cutting

Q1: How do I choose the right fabric for my blouse?

Select fabrics based on the desired look and occasion. Light, breathable fabrics like cotton and chiffon are ideal for casual wear, while silk and georgette lend a more elegant appearance. Consider fabric drape, weight, and ease of sewing.

Q2: Can I customize a pattern for a perfect fit?

Yes, adjusting pattern pieces to your measurements ensures a better fit. Make alterations at the drafting stage or modify pattern pieces before cutting.

Q3: How do I prevent fabric from shifting while cutting?

Use pattern weights or pins to secure pattern pieces firmly. Cutting on a flat, stable surface also helps maintain accuracy.

By following this comprehensive guide on blouse cutting steps with pictures, you will enhance your sewing skills, reduce fabric wastage, and produce beautifully tailored blouses. Remember, patience, precision, and practice are your best tools on this creative journey. Happy sewing!

Blouse Cutting Steps with Picture: A Comprehensive Guide to Crafting Your Perfect Blouse

Creating a beautifully tailored blouse from scratch is both an art and a science. Whether you're a beginner venturing into the world of sewing or a seasoned designer refining your skills, understanding the precise blouse cutting steps with picture is essential. This detailed guide aims to walk you through each stage of blouse cutting, supported by visual aids and clear instructions, ensuring you achieve a professional finish every time.

Why Proper Blouse Cutting Is Essential

The process of blouse cutting is the foundation upon which the entire garment is built. Accurate measurements, precise pattern drafting, and careful cutting directly influence the fit, style, and comfort of the final blouse. Proper cutting minimizes fabric wastage and ensures symmetry, which is crucial for a polished look. With clear blouse cutting steps with picture, even beginners can confidently produce a well-fitted blouse tailored to their measurements.

Materials Required

Before diving into the cutting process, gather all necessary materials:

- Fabric (cotton, silk, chiffon, or your preferred fabric)
- Pattern paper or newspaper
- Measuring tape
- Pencil or fabric chalk
- Ruler and French curve
- Scissors (fabric scissors and paper scissors)
- Pins or pattern weights
- Sewing machine (for subsequent sewing steps)
- Pattern templates (or drafted pattern)

Step-by-Step Guide to Blouse Cutting with Pictures

- Take Accurate Body Measurements

Measurement accuracy is the first and most crucial step.

Key measurements needed:

- Bust circumference
- Waist circumference
- Shoulder width
- Sleeve length
- Armhole circumference
- Neck circumference and depth
- Length from shoulder to waist

Tip: Always wear close-fitting undergarments and stand straight when measuring.

(Insert picture of a person measuring bust and shoulder width)

- Draft or Prepare the Pattern

Pattern drafting can be done manually on pattern paper, or you can modify existing templates. The pattern serves as the blueprint for your blouse.

Basic pattern components:

- Front bodice
- Back bodice
- Sleeve
- Collar (if applicable)
- Yoke (optional)

Tip: Add seam allowances (typically 1-1.5 inches) around all pattern edges.

(Insert picture of pattern paper with drafted blouse pattern)

- Lay Out the Fabric

Fabric preparation:

- Wash and iron the fabric to pre-shrink and remove wrinkles.
- Fold the fabric in half widthwise if cutting symmetrical pieces like front and back.

Lay the pattern:

- Place the pattern pieces on the fabric, ensuring the grainline runs parallel to the selvage.
- Pin or weigh down the pattern to prevent shifting.

(Insert picture showing fabric folded with pattern pinned in place)

- Mark the Pattern on Fabric

Using a fabric chalk or marker:

- Trace around the pattern edges.
- Mark notches, darts, and other pattern markings for accurate assembly.

Tip: Use a ruler and French curve for smooth, accurate lines, especially for armholes and necklines.

(Insert picture of pattern markings on fabric)

- Cut the Fabric

Cutting process:

- Carefully cut along the marked lines, ensuring scissors are sharp.
- Cut each piece separately, paying attention to pattern markings.
- For pieces with darts or princess seams, cut accordingly, leaving seam allowances if not already included.

Special considerations:

- For fabric with a pattern or nap, align patterns accordingly.
- Use sharp scissors specifically for fabric to get clean edges.

(Insert picture of fabric being cut along pattern lines)

- Mark Darts and Notches

Darts and notches are crucial for shaping the blouse.

- Use tailor's chalk or a fabric marker to mark the dart points, fold lines, and notches.
- These markings guide the assembly process.

(Insert picture showing dart markings on fabric pieces)

- Assemble the Pattern Pieces

After cutting, you will proceed to sewing, but proper preparation ensures a smooth process:

- Stay organized by labeling each piece (front, back, sleeve).
- Pin the pieces right sides together at seam lines.

(Insert picture of fabric pieces pinned for sewing)

Tips for an Accurate and Neat Cutting Process

- Always double-check measurements before cutting.
- Use sharp scissors to prevent frayed edges.
- Maintain consistent seam allowances.
- Ensure fabric is laid flat and free of wrinkles.
- Use pattern weights where pins might distort pattern lines.
- Mirror pattern pieces correctly for symmetrical parts.

Visual Summary: Blouse Cutting Steps

While actual pictures are invaluable, here's a summarized visual guide:

- Measuring the body accurately.
- Drafting or preparing the blouse pattern.
- Laying out the fabric properly.
- Marking pattern outlines and markings.
- Carefully cutting along the pattern.
- Marking darts and notches for assembly.
- Organizing pieces for sewing.

(Insert a montage of images illustrating each step)

Final Thoughts

Mastering the blouse cutting steps with picture not only enhances your sewing precision but also boosts confidence in creating custom-fit garments. Remember, patience and attention to detail are key. With practice, you'll develop an intuitive understanding of fabric behavior and pattern adjustments, leading to beautifully tailored blouses that fit perfectly and showcase your personal style.

Whether you're making a casual cotton blouse or an elegant silk top, following these detailed steps ensures a professional finish. Happy sewing!

Question What are the basic steps to cut a blouse pattern with a picture reference? The basic steps include taking measurements, drafting the blouse pattern on paper, marking the design lines, cutting the fabric following the pattern, and pinning or sewing the pieces together. A visual guide can help understand each step clearly. **Answer** How do I prepare fabric before cutting a blouse pattern? Wash and iron the fabric to prevent shrinkage and ensure smoothness. Lay the fabric flat on a clean surface, pin the pattern pieces securely, and ensure the fabric is folded correctly if cutting on fold, as shown in the picture. What tools are essential for blouse cutting with pictures for guidance? Essential tools include fabric scissors, pattern paper, measuring tape, tailor's chalk or

fabric marker, pins, and a ruler or French curve. Visual tutorials often highlight these tools to aid precise cutting. How do I mark pattern lines accurately on fabric? Use tailor's chalk or fabric markers to trace the pattern lines carefully, following the pattern contours. The picture demonstrates how to align and mark armholes, neckline, and darts precisely. What is the importance of adding seam allowances when cutting a blouse? Adding seam allowances (usually 1-1.5 inches) ensures enough fabric for sewing seams securely without distorting the pattern. The picture guides indicate where to add these allowances during pattern drafting. How can I ensure symmetry when cutting front and back pieces of the blouse? Fold the fabric properly and pin pattern pieces on the fold lines as shown in the picture. Cutting both pieces simultaneously ensures they are symmetrical and aligned correctly. What are some common mistakes to avoid during blouse cutting with pictures as reference? Avoid cutting without pattern markings, neglecting seam allowances, or misaligning fabric folds. The visual guides emphasize precise pattern placement and careful cutting to prevent errors. How do I incorporate design elements like darts or pleats in the blouse cutting process with pictures? Mark the dart positions and pleat lines on the pattern before cutting, as shown in the images. Ensure darts are sewn accurately later, following the marked lines for a perfect fit.

Related keywords: blouse pattern making, blouse sewing tutorial, blouse design steps, sewing a blouse, blouse drafting guide, how to cut blouse fabric, blouse sewing techniques, blouse pattern drafting, blouse construction process, blouse cutting diagram

design of metal cutting tools

Introduction to the Design of Metal Cutting Tools

The design of metal cutting tools is a critical aspect of manufacturing engineering that directly influences the efficiency, precision, and longevity of machining operations. As industries evolve towards higher productivity and tighter tolerances, the importance of well-designed cutting tools becomes paramount. Metal cutting tools are specialized devices used to remove material from metal workpieces through machining processes such as turning, milling, drilling, and grinding. Their design encompasses various factors, including geometry, material selection, cutting edge configuration, and heat management, all aimed at optimizing performance while minimizing tool wear and operational costs.

In this article, we explore the fundamental principles behind the design of metal cutting tools, the key components involved, considerations for selecting and designing tools for different applications, and recent advancements that are shaping the future of cutting tool technology.

Fundamental Principles of Metal Cutting Tool Design

Designing effective metal cutting tools involves a thorough understanding of the mechanics of material removal and the interaction between the tool and the workpiece. Several core principles guide the development of these tools:

1. Cutting Geometry

- Determining the correct angles (rake, clearance, and inclination) to facilitate smooth chip flow and reduce cutting forces.
- Optimizing the shape of cutting edges to minimize vibrations and maximize surface finish.
- Balancing the cutting edge sharpness with durability to prevent premature tool failure.

2. Material Selection

- Choosing materials with appropriate hardness, toughness, and wear resistance.
- Common materials include high-speed steel (HSS), carbide, ceramics, and cubic boron nitride (CBN).
- Coatings such as titanium nitride (TiN) or diamond enhance tool life and reduce friction.

3. Heat Management

- Designing tools to efficiently dissipate heat generated during cutting.
- Incorporating coolant channels or using heat-resistant materials.

4. Chip Formation and Control

- Ensuring the tool design promotes manageable chip formation.
- Implementing features like chip breakers to prevent chip entanglement and improve surface quality.

Key Components of Metal Cutting Tools

The effectiveness of a cutting tool depends on its specific components, each contributing to performance and durability.

1. Cutting Edge

- The primary cutting surface that interacts directly with the workpiece.
- Its sharpness, angle, and material determine cutting efficiency and wear resistance.

2. Rake Face

- The surface over which the chip flows.
- Affects the cutting forces and chip evacuation.

3. Flank Face

- The surface adjacent to the workpiece.
- Plays a role in determining the tool's wear and surface finish.

4. Nose Radius

- The curvature at the tool tip.
- Larger radii produce better surface finishes but may increase cutting forces.

5. Shank

- The part of the tool that is held in the machine tool holder.
- Designed for stability and ease of handling.

Design Considerations for Different Metal Cutting Operations

Different machining processes impose unique requirements on tool design. Here are some considerations for common operations:

Turning Tools

- Focus on robust cutting edges to withstand high forces.
- Incorporate adjustable geometries for different materials.

Milling Cutters

- Design for multiple cutting edges to increase productivity.
- Use of inserts for easier tool replacement and customization.

Drills and Boring Tools

- Emphasize concentricity and rigidity.
- Use of specialized coatings to prevent overheating.

Grinding Tools

- Require abrasive grains with specific bond properties.
- Designed for precise control over grit size and distribution.

Materials Used in Metal Cutting Tool Design

Selecting appropriate materials is essential to match the cutting tool's application requirements.

High-Speed Steel (HSS)

- Versatile and cost-effective.
- Suitable for moderate cutting speeds and general-purpose machining.

Carbide

- Higher hardness and wear resistance.
- Ideal for high-speed machining and long production runs.

Ceramics

- Extremely hard and heat resistant.
- Used for high-speed machining of hard materials.

Cubic Boron Nitride (CBN) and Polycrystalline Diamond (PCD)

- Best for machining hard alloys and non-ferrous metals.

- Offer superior wear resistance and surface finish.

Advancements in Metal Cutting Tool Design

The evolution of materials and manufacturing technologies continues to push the boundaries of cutting tool performance.

1. Coatings and Surface Treatments

- Use of advanced coatings (e.g., TiAlN, AlCrN) to improve hardness and oxidation resistance.
- Surface treatments like nitriding enhance fatigue strength.

2. Modular and Interchangeable Inserts

- Allow for quick tool changes and customization for specific tasks.
- Reduce downtime and increase flexibility.

3. Computer-Aided Design (CAD) and Simulation

- Enable precise modeling of cutting geometries.
- Simulation of cutting forces and temperature distribution to optimize tool design.

4. Micro- and Nano-Structured Surfaces

- Research into textured surfaces to reduce friction and chip adhesion.
- Enhance tool life and cutting performance.

Conclusion

The design of metal cutting tools is a complex and vital discipline that combines principles of mechanics, materials science, and manufacturing technology. Effective tool design enhances productivity, improves surface quality, and reduces operational costs. By carefully considering factors such as geometry, material selection, heat management, and application-specific requirements, engineers can develop tools optimized for various machining processes.

As technological innovations continue to emerge, including advanced coatings, modular designs, and simulation techniques, the future of metal cutting tools promises even greater efficiencies and

capabilities. Staying abreast of these developments ensures manufacturers can maintain competitive advantages and achieve superior machining outcomes.

Keywords: metal cutting tools, tool design, cutting geometry, tool materials, chip control, coatings, machining operations, tool life, manufacturing engineering

Design of Metal Cutting Tools: An In-Depth Exploration

The design of metal cutting tools is a cornerstone of manufacturing and machining industries, profoundly impacting productivity, precision, and tool longevity. A well-designed cutting tool not only enhances efficiency but also ensures high-quality surface finishes, reduced operational costs, and minimized downtime. In this comprehensive review, we delve into the fundamental principles, critical aspects, and advanced considerations involved in designing effective metal cutting tools.

Fundamentals of Metal Cutting Tool Design

Designing metal cutting tools requires a fundamental understanding of machining principles, material behavior, and operational conditions. The goal is to optimize the tool's geometry, material, and coating to suit specific applications.

Key Objectives in Tool Design

- Maximize Material Removal Rate (MRR): Achieve high productivity by enabling faster cutting speeds and feed rates.
- Ensure Tool Durability: Enhance wear resistance and resistance to chipping.
- Maintain Surface Finish: Produce desired surface quality with minimal defects.
- Reduce Cutting Forces and Power Consumption: Minimize energy usage and mechanical stress.
- Facilitate Ease of Tool Handling and Replacement: Design for operator safety and efficiency.

Essential Components of Metal Cutting Tools

The design intricacies of a cutting tool revolve around its core components, each playing a vital role:

Cutting Edge

- The actual edge that interacts with the workpiece.
- Its geometry influences cutting forces, heat generation, and tool life.

Tool Face

- The surface over which chips flow.
- Proper design aids in efficient chip evacuation.

Shank

- The non-cutting part that provides support.
- Must be robust to withstand machining forces.

Cutting Material

- The choice of material (e.g., high-speed steel, carbide, ceramics) determines cutting performance and lifespan.

Design Parameters and Geometrical Considerations

The geometric design of a cutting tool directly affects machining performance. Key parameters include:

Cutting Angle (Approach and Rake Angles)

- Rake Angle: The angle between the cutting face and a plane perpendicular to the tool's axis.
- Positive rake angles reduce cutting forces and improve surface finish but may weaken the cutting edge.
- Negative rake angles increase tool strength but require higher forces.
- Clearance Angle: Prevents rubbing of the tool flank against the workpiece.
- Typical values range between 6° to 12°, depending on material and application.

Relief and Clearance Angles

- These angles prevent excessive friction and heat buildup.
- Proper clearance reduces tool wear and prevents workpiece damage.

Cutting Edge Radius

- The rounded tip of the cutting edge.
- Larger radii improve tool strength but may affect precision.

Chip Breaker Design

- Features that facilitate chip segmentation.
- Essential for controlling chip flow, especially in high-speed machining.

Tool Nose Radius

- The curvature at the tip of the tool.
- Influences surface finish and tool strength.

Material Selection for Metal Cutting Tools

The choice of tool material is pivotal in dictating performance, especially under varying machining conditions.

High-Speed Steel (HSS)

- Widely used due to toughness and cost-effectiveness.
- Suitable for low to medium cutting speeds.

Carbide Tools

- Offer higher hardness and wear resistance.
- Capable of high-speed machining.
- More brittle than HSS; prone to chipping under shock loads.

Ceramic and Cermet Tools

- Provide excellent heat resistance.
- Suitable for high-temperature operations.
- Limited toughness; require careful handling.

Diamond and CBN (Cubic Boron Nitride)

- Exceptional hardness.
- Used for cutting superalloys and hardened steels.

Coatings

- Coatings like TiN, TiAlN, and Al₂O₃ extend tool life.
- Reduce friction and thermal wear.

Advanced Design Considerations

Beyond basic geometry and materials, modern tool design incorporates advanced features to meet specific manufacturing demands.

Cutting Tool Coatings

- Purpose: Reduce adhesion, friction, and thermal wear.
- Common Coatings: Titanium nitride (TiN), Titanium aluminum nitride (TiAlN), Aluminum oxide (Al₂O₃).
- Impact: Increase cutting speeds, improve surface finish, and prolong tool life.

Cooling and Lubrication Strategies

- Integrating coolant channels within tools (e.g., through-tool coolant) to enhance heat dissipation.
- Use of cryogenic cooling for high-precision applications.

Toolholder Design

- Ensures rigidity and stability.
- Minimizes vibrations and chatter during machining.

Vibration and Chatter Control

- Design adjustments to reduce dynamic instabilities.
- Incorporation of dampers or isolators.

Customization for Specific Materials and Operations

- Tailored geometries for machining difficult materials like titanium or Inconel.
- Specialized designs for high-precision or micro-machining.

Design Process and Optimization Techniques

Designing an effective metal cutting tool involves a systematic process:

- Identifying Machining Requirements:
 - Material to be cut, desired surface finish, and production volume.
- Selecting Appropriate Tool Material:
 - Based on cutting speed, workpiece hardness, and economic considerations.
- Determining Geometrical Parameters:
 - Rake angles, clearance angles, nose radius, etc.
- Modeling and Simulation:
 - Finite element analysis (FEA) for stress and temperature distribution.
 - Chip flow and force simulations.
- Prototype Development and Testing:
 - Empirical validation of performance.
- Iterative Refinement:

- Adjusting design based on feedback for optimal performance.

Innovations and Future Trends in Tool Design

The evolution of metal cutting tool design continues with technological advancements:

- Additive Manufacturing: Enables complex geometries and internal cooling channels.
- Sensor-Integrated Tools: Real-time monitoring of wear, temperature, and force.
- Smart Coatings: Responsive coatings that adapt to operating conditions.
- AI and Machine Learning: Optimization algorithms for design and process parameters.

Conclusion

The design of metal cutting tools is a multifaceted discipline that combines material science, mechanical engineering, and manufacturing technology. Effective tool design demands a deep understanding of machining mechanics, precise geometrical calculations, and innovative material applications. As manufacturing needs evolve, so too does the complexity and sophistication of cutting tool design, driving efficiency, precision, and sustainability in modern machining processes. Continuous research and technological integration promise even more advanced, durable, and intelligent tools in the years to come.

Question What are the key factors to consider in the design of metal cutting tools? Key factors include tool material, cutting edge geometry, rake angle, clearance angle, tool strength, heat resistance, and chip removal efficiency to ensure optimal performance and tool lifespan. **Answer** How does the choice of tool material affect the design of metal cutting tools? The tool material influences hardness, wear resistance, and heat tolerance. For example, high-speed steels, carbides, and ceramic materials are selected based on cutting conditions to enhance tool durability and performance. What role does cutting edge geometry play in the design of metal cutting tools? Cutting edge geometry determines cutting forces, chip formation, and surface finish. Proper design of rake angles, clearance angles, and edge sharpness improves cutting efficiency and reduces tool wear. How is the design of metal cutting tools optimized for different machining operations? Design optimization involves customizing tool shape, material, and cutting parameters for specific operations like turning, milling, or drilling, to maximize productivity, accuracy, and tool life. What are the recent trends in the design of metal cutting tools? Recent trends include the use of coated and composite materials for enhanced performance, the integration of sensor technology for real-time monitoring, and the adoption of computer-aided design (CAD) and simulation tools for precise tool development. How does heat treatment influence the design and performance of metal cutting tools? Heat treatment improves hardness and toughness of tool materials, enabling the tools to withstand high temperatures and cutting forces, thereby enhancing cutting performance and tool longevity. What are the challenges faced in designing high-performance metal cutting tools?

Challenges include balancing hardness and toughness, managing heat dissipation, reducing tool wear, and designing for versatility across different materials and cutting conditions to achieve efficient and durable tools.

Related keywords: metal cutting tools, tool geometry, cutting inserts, tool materials, machining parameters, tool wear, chip formation, surface finish, cutting forces, tool design

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