Accepted Manuscript

Title: Modeling dynamics and stability of variable pitch and helix milling tools for development of a design method to maximize chatter stability



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PII:	S0141-6359(16)30254-9
DOI:	http://dx.doi.org/doi:10.1016/j.precisioneng.2016.09.021
Reference:	PRE 6468
To appear in:	Precision Engineering
Received date:	15-5-2016
Revised date:	20-9-2016
Accepted date:	29-9-2016

Please cite this article as: Comak A, Budak E.Modeling dynamics and stability of variable pitch and helix milling tools for development of a design method to maximize chatter stability.*Precision Engineering* http://dx.doi.org/10.1016/j.precisioneng.2016.09.021

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Modeling Dynamics and Stability of Variable Pitch and Helix Milling Tools for Development of a Design Method to Maximize Chatter Stability

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