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| **Table 3** Influence of cutting speed and MQL flow rate on chip shape |
| $V$ [$m/min$] | MQL1 | MQL2 | MQL3 |
| 145 | C:\Users\HP\Desktop\Dropbox\Morteza-Mahshad 2\Paper 4 - New version\M1-C12.jpg | C:\Users\HP\Desktop\Dropbox\Morteza-Mahshad 2\Paper 4 - New version\M2-C12.jpg | C:\Users\HP\Desktop\Dropbox\Morteza-Mahshad 2\Paper 4 - New version\M3-C12.jpg |
| 650 | C:\Users\HP\Desktop\Dropbox\Morteza-Mahshad 2\Paper 4 - New version\M1-C2.jpg | C:\Users\HP\Desktop\Dropbox\Morteza-Mahshad 2\Paper 4 - New version\M2-C2.jpg | C:\Users\HP\Desktop\Dropbox\Morteza-Mahshad 2\Paper 4 - New version\M3-C2.jpg |
| 1155 | C:\Users\HP\Desktop\Dropbox\Morteza-Mahshad 2\Paper 4 - New version\M1-C18.jpg | C:\Users\HP\Desktop\Dropbox\Morteza-Mahshad 2\Paper 4 - New version\M2-C18.jpg | C:\Users\HP\Desktop\Dropbox\Morteza-Mahshad 2\Paper 4 - New version\M3-C18.jpg |

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| **Table 4** Impact of feed rate and MQL flow rate on chip shape |
| $$f [mm/rev]$$ | MQL1 | MQL2 | MQL3 |
| 0.07 | C:\Users\HP\Desktop\Dropbox\Morteza-Mahshad 2\Paper 4 - New version\M1-C8.jpg | C:\Users\HP\Desktop\Dropbox\Morteza-Mahshad 2\Paper 4 - New version\M2-C8.jpg | C:\Users\HP\Desktop\Dropbox\Morteza-Mahshad 2\Paper 4 - New version\M3-C8.jpg |
| 0.19 | C:\Users\HP\Desktop\Dropbox\Morteza-Mahshad 2\Paper 4 - New version\M1-C2.jpg | C:\Users\HP\Desktop\Dropbox\Morteza-Mahshad 2\Paper 4 - New version\M2-C2.jpg | C:\Users\HP\Desktop\Dropbox\Morteza-Mahshad 2\Paper 4 - New version\M3-C2.jpg |
| 0.31 | C:\Users\HP\Desktop\Dropbox\Morteza-Mahshad 2\Paper 4 - New version\M1-C13.jpg | C:\Users\HP\Desktop\Dropbox\Morteza-Mahshad 2\Paper 4 - New version\M2-C13.jpg | C:\Users\HP\Desktop\Dropbox\Morteza-Mahshad 2\Paper 4 - New version\M3-C13.jpg |

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| **Table 5** Effect of cutting speed and MQL flow rate on chip shape |
| 𝐷 [mm] | MQL1 | MQL2 | MQL3 |
| 0.66 | C:\Users\HP\Desktop\Dropbox\Morteza-Mahshad 2\Paper 4 - New version\M1-C17.jpg | C:\Users\HP\Desktop\Dropbox\Morteza-Mahshad 2\Paper 4 - New version\M2-C17.jpg | C:\Users\HP\Desktop\Dropbox\Morteza-Mahshad 2\Paper 4 - New version\M3-C17.jpg |
| 1.5 | C:\Users\HP\Desktop\Dropbox\Morteza-Mahshad 2\Paper 4 - New version\M1-C2.jpg | C:\Users\HP\Desktop\Dropbox\Morteza-Mahshad 2\Paper 4 - New version\M2-C2.jpg | C:\Users\HP\Desktop\Dropbox\Morteza-Mahshad 2\Paper 4 - New version\M3-C2.jpg |
| 2.34 | C:\Users\HP\Desktop\Dropbox\Morteza-Mahshad 2\Paper 4 - New version\M1-C15.jpg | C:\Users\HP\Desktop\Dropbox\Morteza-Mahshad 2\Paper 4 - New version\M2-C15.jpg | C:\Users\HP\Desktop\Dropbox\Morteza-Mahshad 2\Paper 4 - New version\M3-C15.jpg |