

μ'' AA	500	250	125	63	32	16
$\mu m Ra$	12.5	6.3	3.2	1.6	0.8	0.4



HORIZONTAL MILLING	VERTICAL MILLING	TURNING
-----------------------	---------------------	---------

N10	N9	N8	N7	N6	N5
Δ		$\Delta \Delta$		$\Delta \Delta \Delta$	
$\nabla \nabla$		$\nabla \nabla \nabla$		$\nabla \nabla \nabla \nabla$	
N7	N6	N5	N4	N3	N2



PLAIN GRINDING	FLAT LAPPING EXTERNAL GRINDING
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$\mu m Ra$	1.6	0.8	0.4	0.2	0.1	0.05
μ'' AA	63	32	16	8	4	2

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Jicheng Xie



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Table of Contents Engineering Finishes Guide

1. Understanding the eBook Engineering Finishes Guide
 - The Rise of Digital Reading Engineering Finishes Guide
 - Advantages of eBooks Over Traditional Books
2. Identifying Engineering Finishes Guide
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Engineering Finishes Guide
 - User-Friendly Interface
4. Exploring eBook Recommendations from Engineering Finishes Guide
 - Personalized Recommendations

- Engineering Finishes Guide User Reviews and Ratings
- Engineering Finishes Guide and Bestseller Lists
- 5. Accessing Engineering Finishes Guide Free and Paid eBooks
 - Engineering Finishes Guide Public Domain eBooks
 - Engineering Finishes Guide eBook Subscription Services
 - Engineering Finishes Guide Budget-Friendly Options
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 - Engineering Finishes Guide Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Engineering Finishes Guide
 - Highlighting and Note-Taking Engineering Finishes Guide
 - Interactive Elements Engineering Finishes Guide
- 8. Staying Engaged with Engineering Finishes Guide
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Engineering Finishes Guide
- 9. Balancing eBooks and Physical Books Engineering Finishes Guide
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Engineering Finishes Guide
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Engineering Finishes Guide
 - Setting Reading Goals Engineering Finishes Guide
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Engineering Finishes Guide
 - Fact-Checking eBook Content of Engineering Finishes Guide

- Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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