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With updated information on machine tools, cutting tool material, and workholding technologies, this book provides selection criteria needed to identify the proper machine tool and tool materials for quality and cost effectiveness. The authors emphasize physical understanding of machining processes, including tool wear, forces, power, rigidity, and machining economics. The book explores the ways of extending tool life, diagnosing machining problems, and solving them using various technologies. This second edition includes new chapters on cutting fluids, agile and high-throughput machining, and design for machining as well as the addition of examples and end-of-chapter problems for textbook use.