

# Table of Contents

## Sponsors, Committees and Preface

## Mechanism

<b>Experimental Study and Modeling of Milling Force during High-Speed Milling of SiCp/Al Composites Using Regression Analysis</b>	
S.T. Huang, X.L. Yu and L. Zhou	3
<b>The Analysis of Saw-Tooth Chip Formation in High Speed Machining through Material Micro-Hardness Measurement</b>	
G.S. Su and Z.Q. Liu	9
<b>Study on the Cutting Force of Inconel 718 Machined by Different Cutting Tools</b>	
G.S. Geng, J.H. Xu, S.N. Galyshev, B. Yang and L.L. Su	15
<b>Research on Thermodynamic Characteristics in High-Speed Machining System</b>	
Y. Wan, Z.Q. Liu, X. Ai and Z.X. Wu	21
<b>Analysis on the Microstructure of Carbide Reamers after the Cryogenic Treatment</b>	
Q.L. Niu, Q.L. An, M. Chen, G. Liu and C.Y. Wang	26
<b>Progressive Tool Failure in High Speed End Milling of Inconel 718 with Coated Carbide Inserts</b>	
A.H. Li, J. Zhao, Z.Q. Pei and S.G. Guo	32
<b>Research on Wear Property of Tool Flank by Dry Cutting of Austempering Ductile Iron</b>	
D.D. Wan, X.H. Guo and C.H. Wang	38
<b>Combining Multiaxis Machining and Burnishing in Complex Parts</b>	
L.N. López de Lacalle, A. Rodríguez, A. Lamikiz and A. Celaya	43
<b>Friction and Wear Properties of WC-Co Cemented Carbide Sliding against Ti6Al4V Alloy in Nitrogen Gas</b>	
W. Zhao, N. He and L. Li	49
<b>Cutting Force, Cutting Temperature and Tool Wear in End Milling of Powder Metallurgy Nickel-Based Superalloy FGH95</b>	
J. Du and Z.Q. Liu	55
<b>Effect of Flow Field on Cutting Fluid Penetration during Minimum Quantity Lubrication (MQL) Machining</b>	
W.J. Zheng, H.J. Pei, G.C. Wang and C.G. Shen	61
<b>Determining Structural Modes of HSK Tool System and Influential Factors</b>	
C.G. Shen, G.C. Wang, S.L. Wang, W.W. Nie and G. Liu	67
<b>Incidence Analysis on Characteristic of High Speed Ball-End Milling Hardened Steel</b>	
B. Jiang, Y.J. Yang, X.L. Liu, C.X. Qi and X.F. Zhao	73
<b>An Experimental Study on Rough Ball-End Milling of T10A Steel</b>	
X.Q. Zhuang, C.Z. Huang, Z.Y. Liu, B. Zou, H.L. Liu and H.T. Zhu	78
<b>The Mechanical Behavior of Carbon Steel in the Super High-Speed Cutting State</b>	
Z.J. Zhang, J. Li and S.T. Huang	84
<b>An Experimental Study on Grinding of SiC/Al Composites</b>	
L.F. Xu, L. Zhou, X.L. Yu and S.T. Huang	90
<b>Experimental Study on the Staining Method for Measuring Acoustic Field for Ultrasonic Process</b>	
G.F. Wang, K.H. Zhang, S. Lu and C.L. Hong	94
<b>Experimental Study on the Dynamic Characteristics of High Speed Milling on Inclined Planes</b>	
Q.L. Zhang, C.Y. Wang, Y.N. Hu and Y.X. Song	99
<b>Module Partition and Application for Printed Circuit Board High Speed Drilling Machine</b>	
H.Q. Tang, C.Y. Wang, B. Wang, F. Su, P. Ma and Y.X. Song	104
<b>Experimental Study and Theory Prediction on Adiabatic Shear Critical Conditions of Fe-36Ni Invar Alloy</b>	
G.H. Li and M.J. Wang	110

<b>Critical Thickness and Dynamic Stiffness for Chatter Avoidance in Thin Floors Milling</b>	116
F.J. Campa, L.N. López de Lacalle, G. Urbicain, A. Lamikiz, S. Seguy and L. Arnaud	
<b>Cutting Performances of Diamond Coated Milling Tools in Machining Aluminum Alloy</b>	122
L. Wang, J.G. Zhang, B. Shen and F.H. Sun	
<b>Prediction of High Speed Machining Cutting Forces Using a Variable Flow Stress Machining Theory</b>	128
P. Mathew	
<b>Temperatures in High Speed Grinding of TC4 with a Vitrified CBN Wheel</b>	134
X.H. Yu, G.Q. Huang, C.F. Fang, H. Huang, H. Guo and X.P. Xu	
<b>Research on Cutting Performances of Tool Rounded Cutting Edge in High Speed Milling Hardened Steel</b>	139
S.C. Yang, M.L. Zheng, Y.H. Fan and W. Xu	
<b>Cluster Analysis on Vibration Characteristic in High Speed Ball-End Milling Hardened Steel</b>	145
B. Jiang, S.C. Yang, Y.J. Yang, M.L. Zheng and P. Sun	
<b>Research of Cutter Geometric Parameter Effect on Machining Stability Area in High Speed Milling Process</b>	150
S. Wu, D.K. Jia, X.L. Liu, Y.C. Jiang and Y.F. Li	
<b>Study of Exit Burr Formation of CFRP</b>	154
W. Ji, Y.W. Wang, Y.F. Li, F.G. Yan and X.L. Liu	
<b>Method of Recognizing of Chip Shape Based on Machine Vision Technology</b>	158
K.E. Qing, Y.W. Wang, L.J. Liu, Z.R. Zhang and Z.Q. Yu	
<b>The Identification of Vibration Characteristics for Hardened Steel Based on Wavelet Energy Spectrum in High-Speed Milling</b>	162
Y.X. Wang, X.L. Liu, C.X. Yue, F. Xiao and P. Sun	
<b>Cutting Force Model Prediction Considering Cutting Edge Parameters Base on Genetic Algorithm</b>	166
Y. Wang, L.Q. Wang, Y.F. Li, Y.S. Zhai and X.L. Liu	
<b>Temperature Variables Selection for Thermal Error Modeling of Heavy-Duty CNC Milling-Boring Machine Tools</b>	171
G.W. Cui, D. Gao, L. Wang and Y.X. Yao	
<b>A Viscometer Based on Velocity Attenuation of Rotary Cylinder</b>	175
H.B. Wang, Y.X. Yao and L. Zhou	
<b>The Study on Three-Dimensional Roughness of Machined Surface in High Speed Milling of SiCp/Al Composites</b>	179
Y.J. Wang, M. Zhou and Y.H. Zhao	
<b>Analysis of the Nanoscale Manipulation Using Near-Field Optical Tweezers Combined with AFM Probe</b>	184
B.H. Liu, L.J. Yang, J. Tang, Y. Wang and J.L. Yuan	
<b>Analysis on the Coupling Error of Laser and Water-Jet in Water-Jet Guided Laser Micromachining</b>	190
L.J. Yang, C.Q. Li, J. Tang, Y. Wang and Y.B. Chen	
<b>Experimental Study of Titanium Alloy Micro-Holes by EDM Fuzzy Control System</b>	195
Y.K. Wang, X.S. Geng, Z.L. Wang and D.B. Shan	
<b>Analysis of Elastic Deformation of Axial Foil Hydrodynamic Thrust Bearing Used in Turbine Generator</b>	199
Y.K. Wang, Z.Q. Zeng, Z.L. Wang and Y.S. Huang	
<b>Experimental Study on the Surface Roughness with Mill-Grinding SiC Particle Reinforced Aluminum Matrix Composites</b>	203
J.G. Li, J.G. Du and H. Zhao	
<b>A Steel Plate Correction Method of NC Flame Cutting Based on Edge Detection</b>	208
Y.C. Jiang, J.F. Wang, L.J. Zhang and B.S. Huang	
<b>Research on Compound Servo Drive Control of Heavy Loading Feed Table</b>	212
Z.M. Long, S.Q. Guo, G.J. Chen and F. Xiao	
<b>Study on Residual Stress for High-Speed Cutting Titanium Alloy Based on Finite Element Method</b>	216
M.H. Wang, Z.H. Liu and H.J. Wang	

<b>FEM Prediction of Chip Morphology during the Machining of Particulates Reinforced Al Matrix Composites</b>	220
H. Guo, D. Wang and L. Zhou	
<b>Research on Dynamic Constitutive Relation of Materials Taking Account of Damage Evolution and Fracture Law for High Speed Cutting</b>	224
J. Li, T.T. Dong and M.J. Wang	
<b>Analytical Method for Softness Abrasive Flow Field Based on Low Reynolds K-<math>\epsilon</math> Model</b>	230
Q.L. Yuan, S.M. Ji, D.P. Tan and L. Zhang	
<b>Software System Development of Measurement and Control System for a Nonlinear Absorber by Virtual Instrument</b>	236
C.L. Zhu, W.Z. Jin, D.R. Ci, Z.G. Ding and S.T. Wu	
<b>Control Algorithm Study for some Optical Tracking Measurement System with Low Mechanical Resonance Frequency</b>	241
Y.L. Bi and Z.X. Wang	
<b>The Experimental Research about the Influence of High Moisture Extrusion on Texture of Product</b>	246
P.L. Sun, Z.L. Sun, F.G. Jia, Y. Sun and Y. Cao	
<b>The Experimental Study about the Influence of Extrusion System Parameters on Textured Degree of High Moisture Content Fibriform Imitated Meat</b>	250
P.L. Sun, L.Z. Jiang, Y. Sun, Z.L. Sun, T.M. Xie and Y. Cao	
<b>Comparative Study on 2A70 Aluminum Alloy High-Speed Milling Cutting Force Model</b>	254
X.H. Wang, M.J. Feng and C. Zhao	
<b>Comparison of Multi-Frequency Phase Unwrapping Algorithm for Shape Measurement Using Digital Fringe Projection</b>	258
W.T. He, X.L. Meng, Y.Y. Guo and C. Zhao	
<b>Stability Research on High Speed Milling of Aviation Aluminum Alloy</b>	263
Y.Y. Guo, W.T. He and C. Zhao	
<b>Research on Dynamic Characteristics of High-Speed Machining Aluminum Alloy Blades</b>	268
Y.B. Liu, Y.D. Zhang and C. Zhao	
<b>Fuzzy Comprehensive Evaluation of Aluminum Alloy 7475 High-Speed Milling Parameter Optimization</b>	272
A.Q. Lin, M.L. Zheng, Y. Gu and C.G. Fan	
<b>Research on Instantaneous Cutting Force of High Speed Ball-End Milling Cutter</b>	277
C.X. Qi, B. Jiang, M.L. Zheng, Y.J. Yang and P. Sun	
<b>Remote Control of Servo Motor Based on ZigBee Module and PLC</b>	283
L. Zhou, Z.R. Liao, X.R. Liang, G.Q. Pan and Y.H. Ren	
<b>Research on Effects of Cutting Vibration on Surface Appearance</b>	288
D.K. Jia, S. Wu, Y.X. Wang, F.G. Yan and Y.F. Li	

## Processing

<b>Cutting Force and Processing Parameters Optimization of Plunge Milling for Die Steel</b>	295
Y.M. Zhou, C.Y. Wang, Q.Y. Yang and Y.X. Song	
<b>Parameters Optimization of Turning Free Cutting Steel Based on the Coupling Method of Response Surfaces</b>	301
Z.Q. Liu, X.J. Cai, S. Han, M. Chen and Q.L. An	
<b>Optimization of Cutting Parameters for Desirable Surface Roughness in End-Milling Hardened AISI H13 Steel under a Certain Metal Removal Rate</b>	307
T.C. Ding, S. Zhang, Z.M. Li and Y.W. Wang	
<b>Deformation Control and Chatter Suppression in 5-Axis Milling of Thin-Walled Blade</b>	314
B.H. Wu, M. Luo, D.H. Zhang and X. Zhou	
<b>Experimental Research on Dry Cutting 34CrNiMo6</b>	319
H. Yang, X.B. Wang, L.J. Xie, J.J. Pei and T. Wang	
<b>Tool Wear Prediction when Machining Ti6Al4V Using Different Tool Materials</b>	325
Y.H. Fan, M.L. Zheng, M.M. Cheng and D.Q. Zhang	
<b>Research on the Topography Features of the Densely Bonded Diamond Grinding Wheel Dressed by Elliptical Ultrasonic Vibration</b>	330
B. Zhao, C.Y. Zhao and G.F. Gao	

<b>Parametric Design of Face Milling Cutter Based on UG Template Model</b> S.Y. Ji, X.L. Liu, D.L. Ma, Y.P. Ding and J. Wu	336
<b>The Optimization on Case-Based Reasoning to Processing Piece Large Cylinders of Heavy Cutting Process</b> Y.H. Shen, Y.W. Wang, T. Chen, H.Y. Han and H. Zhang	340
<b>Tool with Heavy-Duty Machining Tube Section of the Fatigue Analysis</b> Z.G. Yu, X.L. Liu, Y.S. Zhai, G.H. He and M. Li	344
<b>Ball-End Milling Force Modeling and Simulation Based on Cutting Path Optimization Experiments</b> X.F. Zhao, X.L. Liu, D.K. Jia and K. Ding	348
<b>The Simulation of Cutting Force during High-Speed Milling of Die Steel Cr12MoV</b> Z.Y. Zhao, Y. Wang, K.Q. Li, C.X. Yue and W.T. Li	352
<b>Calculation of Indentation Hardness Based on Indentation Energy</b> L. Zhou, Y.Z. Guo, Z.R. Liao, X.R. Liang and G.Q. Pan	356
<b>Modeling of Thrust Force and Tool Wear and Optimization of Process Parameters in Drilling Nickel-Based Alloy GH536</b> M.H. Wang and S.T. Huang	360
<b>Influence of the Sharpening Methods for Drill Flank Surfaces on the Compressive Strength of PCD Inserts</b> L.F. Xu, J. Chen, S.T. Huang and L. Zhou	364
<b>Finite Element Method Modeling Approaches in Grinding</b> H.L. Zhang and H. Guo	368
<b>Finite Element Method Simulation of Drilling Process on Metal-Matrix Composites</b> H.L. Zhang and J. Chen	372
<b>Research on Fabrication Technology and Hydraulic Performance of Multi-Point Gear Flow Dividers</b> X.B. Li, X.L. Liu, Z.M. Shi, Q.M. Hu and S.G. Wang	376
<b>Simulation of Residual Stress in Ultrasonic Vibration Assisted Micro-Milling</b> H.J. Hu, Y.Z. Sun and Z.S. Lu	381

## Cutting Tool

<b>Fabrication and Cutting Performance of Ultrafine Grain Composite Diamond Coated Drills</b> Y.P. Ma, G.F. Yuan and M. Chen	387
<b>High Speed Machining of Particulate Reinforced Metal Matrix Composites with PCD Tools</b> Y.F. Ge, J.H. Xu and Y.C. Fu	392
<b>Aeroacoustic Performance Evaluation of Milling Cutters Based on the Flow Field on the Cutter Surface</b> C.H. Ji and Z.Q. Liu	398
<b>Cutting Force Prediction for Generalized Cornering Milling Process</b> X. Yan, H. Tao, D.H. Zhang and B.H. Wu	404
<b>Experimental Investigation on Tool Wear when End-Milling Inconel 718 with Coated Carbide Inserts</b> Y.W. Wang, J.F. Li, Z.M. Li, T.C. Ding and S. Zhang	410
<b>Rapid Selection of Milling Tools Based on the Initial Wear</b> H. Zhang and W.Y. Chen	416
<b>Research on New Helical-Conical Grinding Method for PCB Drill</b> X.H. Zheng, G.L. Zhang, C.A. Fu, M. Chen and C.Y. Wang	423
<b>Drilling Force and Chip Morphology in Drilling of PCB Supported Hole</b> L.P. Yang, L.X. Huang, C.Y. Wang, L.J. Zheng, P. Ma and Y.X. Song	429
<b>Cutting Forces of PCB Supported Hole</b> L.X. Huang, C.Y. Wang, L.P. Yang, L.J. Zheng and Y.X. Song	435
<b>A Review on Drilling Printed Circuit Boards</b> L.J. Zheng, C.Y. Wang, Y.X. Song, L.P. Yang, Y.P. Qu, P. Ma and L.Y. Fu	441
<b>Research on the Application and Design of Special Tools of the Hydrogenated Cylindrical Shell</b> G.H. He, X.L. Liu, F.G. Yan, Y.S.Z. Hai and M. Li	450

## **Machine Tool**

<b>The Performance of the Hydraulic Expansion Toolholder in High-Speed Rotation</b> S.L. Wang, W.Z. Zhang, Q. Zhang, G. Liu and Z.J. Yang	457
<b>Dynamic Analysis of Helical Milling Unit Based on Virtual Machine Tool</b> X.D. Qin, Q. Wang, H.Y. Wang and S. Hua	463
<b>Tools Optimization in Efficient Intermittent Cutting of 2.25Cr1Mo0.25V Steel</b> H.L. Liu, X. Lv, C.Z. Huang, Z.B. Yin, B. Zou and H.T. Zhu	469
<b>A Wireless System for Cutting Temperature Measurement</b> Z.J. Liu, Y.M. Quan and L. Liang	475
<b>Design and Strength Analysis of Ultra-High Speed Permanent Magnet DC Rotor</b> J.C. Xiao, S.H. Xiao and H. Wu	481
<b>Research on MFBD Modeling Method for a Gantry Machining Center Beam Components</b> Q.J. Yang, D.N. Li, L.L. Kong and K. Li	487
<b>Research on Kinematics of High Speed Linear Feed System</b> P. Ma, Y.B. Tang, Z.H. Chen and J.J. Huang	493
<b>The Study of Control System for Reconfigurable Machine Tool Model</b> L. Zhou, W.J. Nie, Z.R. Liao, X.R. Liang and G.Q. Pan	499
<b>Research on Ram Thermal Deformation Real-Time Compensation of Large Floor Type Boring-Milling Machine</b> Y. Lu, D. Gao, Y.L. Liu and Z. Sun	503
<b>A New 2D NC System of Thermal Cutting Machine</b> Y.C. Jiang, C.L. Zhang, Q.Y. Liang and C.H. Yang	507
<b>The Structural Design and Analysis of the Rock Hob Test-Bed</b> K.J. Zhao, Z.X. Cui, K. Zhang, D.H. Zhao and H. Sun	511
<b>Analysis on the Impact of the Error Mapping for Structural Parameters of Parallel Machine Tool</b> Y.G. Wei and Z.X. Wang	515

## **CAD/CAE/CAM**

<b>Study on the Thermal Contact Zone in the Surface Grinding</b> C.L. Hua, G.C. Wang, H.J. Pei and G. Liu	523
<b>Study on High-Speed Drilling of SUS304 Based on FEA</b> M.P. Yan and H. Shao	529
<b>Surface Roughness Prediction in Turning of Free Machining Steel 1215 by Artificial Neural Network</b> X.J. Cai, Z.Q. Liu, Q.C. Wang, S. Han, Q.L. An and M. Chen	535
<b>The Process Strategies of Mould High-Speed Machining and their Applications in the Environment of PowerMILL</b> J. Liu	542
<b>Simulation for Sinusoidal Spindle Speed Variation Cutting in Time Domain Based on Simulink</b> K.M. Mao, M. Zhang, M. Zhu and L. Yin	549
<b>3D Finite Element Simulation on the Orthogonal Cutting Processes with Different Commercial Codes</b> Z.Y. Mou, P.F. Gao, W.F. Wang and D.H. Wen	555
<b>Vibration Analysis on Ball End Milling Hardened Mould Assembled with Different Hardness Materials</b> Y.Y. Wang, S.M. Ji, X. Zhang, D.H. Wen and Y.J. Tang	561
<b>Finite Element Analysis and Calculation of Load Capacity on Aerostatic Thrust Bearing</b> P.C. Shu, S.H. Xiao and H. Wu	566
<b>Cutter/Work Interference and Surface Generation in Ball End Milling</b> T. Obikawa and T. Senoda	572
<b>High Speed Machining: A Review from a Viewpoint of Chip Formation</b> T. Obikawa, M. Anzai, T. Egawa, N. Narutaki, K. Shintani and E. Takeoka	578

<b>Robotic High Speed Machining of Aluminum Alloys</b>	584
I. Zaghbani, M. Lamraoui, V. Songmene, M. Thomas and M. El Badaoui	
<b>The Numerical Simulation of the Aluminum Alloy Processing</b>	590
B.J. Xiao, C.Y. Wang, Y.N. Hu and Y.X. Song	
<b>Thermal Analysis of High Speed Built-In Spindle by Finite Element Method</b>	596
P. Ma, B. Zhou, D.N. Li, S.H. Xiao and C.Y. Wang	
<b>Modal Analysis of Externally Pressurized Air Bearing Workbench Based on Spring-Mass System Method</b>	602
B. Zhang, P. Ma and J.J. Huang	
<b>The Establishment of Dynamic Model and Stability Research on High-Speed Precision Hard Turning</b>	608
G.J. Chen, X.L. Liu, Z.Y. Zhao, W.D. Li and F. Xiao	
<b>Large NC Machining Fast Knife Mould Based on Image Technology</b>	613
X.L. Liu, X.R. Song, L.J. Liu, Z.Y. Zhao and D.L. Ma	
<b>Finite Element Simulation of Heavy Cutting Process</b>	617
C.X. Yue, X.L. Liu, Z.Y. Zhao, K.Q. Li and T.Y. Ma	
<b>Cutting Parameters Optimization of the Matching of Lengthened Shrink-Fit Holder and Cutter in High Speed Milling</b>	622
H.M. Zhou, C.Y. Wang, J.X. Deng and Y.X. Song	
<b>Fault Diagnosis of Pump Based on a Hybrid HMM/SVM Model</b>	629
X. Yue, C.L. Zhang, J. Li and H.Y. Zhu	
<b>Study on the Machinability Characteristics of Superalloy K424 during High Speed Turning</b>	636
M.H. Xiao, N. He, L. Li, B.G. Qiu and Y. Su	
<b>Analysis and Research of the Vibration of the High-Speed Cutting Process</b>	642
A.M. Tang, Z.X. Zhou and W.W. Huang	
<b>An Experimental Study on the Impact on Vari-Speed Milling to the Capacity Machine Tool</b>	648
X.Q. Xue, N. He, L. Li, W. Zhao and Q. Wang	
<b>Process Information Parameterization of Camshaft Part for Virtual High-Speed Grinding</b>	652
D.F. Cao, Z.H. Deng, L.L. Wan and X.H. Zhang	
<b>3D Simulation and Analysis for Face Precision Milling of Aerospace Aluminum Alloy</b>	657
A.Q. Lin, M.L. Zheng and Y. Gu	
<b>The Application of Fuzzy Comprehensive Evaluation to Cutting Sequences' Optimization of Multi-Feature Part</b>	662
Z. Li, M.L. Zheng, J. He and J.J. Ming	
<b>Research on Comprehensive Quality Evaluation System for Computer Supported Cooperative Design of Mould</b>	667
Y.Z. Wang, M.L. Zheng, Z.Q. Man and W. Li	
<b>Design and Simulation of Ground Test Platform for Microsatellite Docking Mechanism</b>	671
Y.N. Lai, M.J. Zhao, Y. Dai, M.Z. Lai and X. Lai	
<b>Application of Continuous Wavelet Features and Multi-Class Sphere SVM to Chatter Prediction</b>	675
S. Wu, D.K. Jia, X.L. Liu, F.G. Yan and Y.F. Li	
<b>Modeling and Predicting Cutting Force in Precision Hard Turning</b>	681
T. Chen, F.G. Yan, J.S. Hu, Y.P. Ding and H.Y. Han	
<b>Process Simulation and Process Parameter Optimization of Large Automobile Cover Die Hard Milling</b>	685
K. Guo, X.L. Liu, C.X. Yue, J.C. Huang and W.T. Li	
<b>The Impeller Five-Axis NC Machining Simulation Based on UG NX 7.5</b>	689
J.C. Huang, X.L. Liu, D.K. Jia, W.D. Li and K. Guo	
<b>Vibration Modeling and Analysis of Large Thin-Walled Cylinder Workpiece in Turning Ring Groove of Inner Hole</b>	693
J.J. Zhang, X.L. Liu, Y.S. Zhai, G.H. He and J.L. Zhang	
<b>UG-Based Parametric Design of Copy Milling Cutters</b>	697
D.L. Ma, Y. Wang, S.Y. Ji, Y.P. Ding and W.T. Li	
<b>Curve Construction for Virtual Hand Modeling and Manipulation</b>	701
P. Chen, Y.X. Yao, L. Zhou and P.J. Xia	
<b>Study on CAD/CAM Software System of Machining Spatial Curved Surface by WEDM</b>	705
B.B. Yan, G.J. Chen, J.F. Shuai and D.C. Huang	

<b>Establishing of Constitutive Equation of ZGMn13 Steel and Cutting Simulation Test</b>	711
L. Xu, T. Teng, L. Yang and J. Fan	
<b>Numerical Investigation on Particle Velocity in Cold Spraying of Hydroxyapatite Coating</b>	717
L. Zhang and W.T. Zhang	
<b>Military Vehicle Start-Up Process Simulation and Analysis Based on Matlab</b>	723
Y.B. Zhou and W. Wei	
<b>Study on Unicursal Pseudo-Random Tool Path for Computer Controlled Polishing</b>	729
F.H. Zhang, X.B. Yu and Y. Zhang	
<b>The Development of Micro Abrasive Waterjet Machining Technology</b>	733
W.S. Luo, C.Y. Wang, J. Wang and Y.X. Song	
<b>Simulation of Drilling on the Copper of PCB with Ultra-High-Speed</b>	739
H.Q. Tang, J. Wen, C.Y. Wang, L.S. Wu and Y.X. Song	
<b>Optimization Design Based on Static and Dynamic Performance of Beam</b>	743
M. Cong, Q. Zhao, T. Han, D.D. Liu, Z.B. Duan and J.G. Yu	