

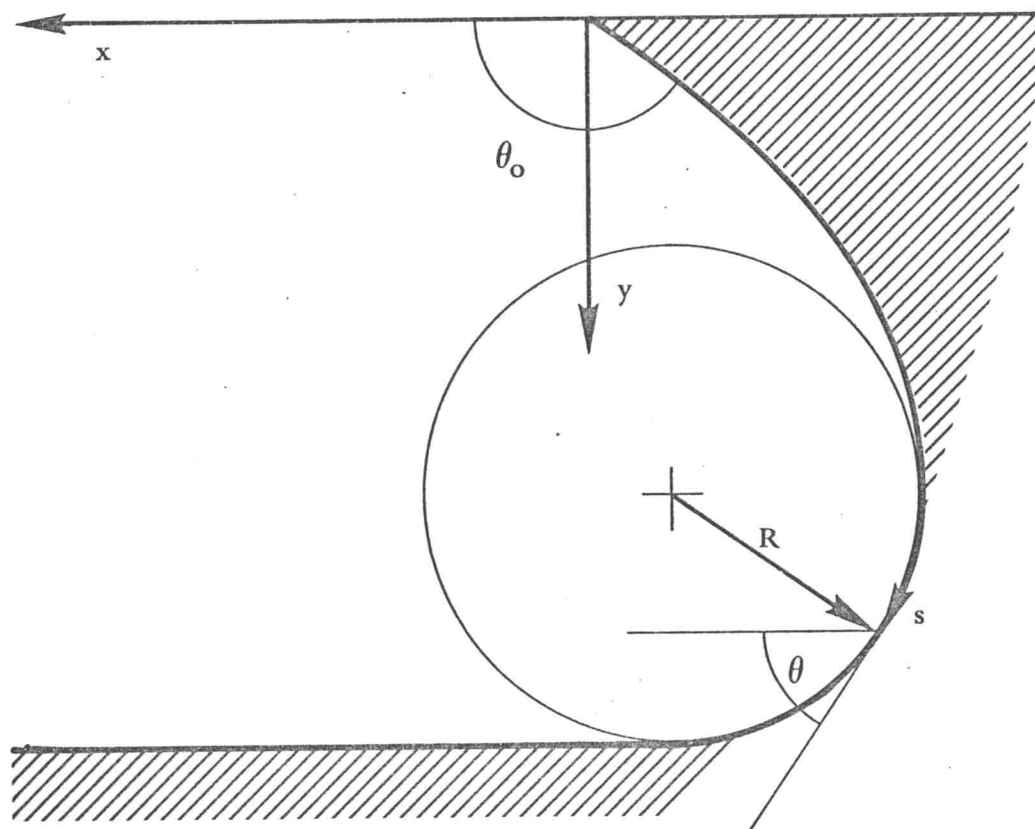


Figure 3. Geometry of the cutting surface. The jet enters with a positive rake (cf. Section 8).