















3). Observations on the screw surface profile indicated that the screw surface was damaged, including non-uniform screw height and the presence of welded chips. This is caused by the highly generated heat during the cutting process so that the chipped material sticks to the top of the thread. Damage in the form of sticking chips is also triggered by the titanium alloy having low thermal conductivity so that the cutting temperature accumulates at the top of the thread.

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