

## Accepted Manuscript

Title: Sensor-less On-line Chatter Detection in Turning process Based on Phase Monitoring using Power Factor Theory

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PII: S0141-6359(17)30437-3  
DOI: <http://dx.doi.org/doi:10.1016/j.precisioneng.2017.07.017>  
Reference: PRE 6627

To appear in: *Precision Engineering*

Received date: 23-4-2017  
Accepted date: 14-7-2017

Please cite this article as: Yamato Shuntaro, Hirano Takayuki, Yamada Yuki, Koike Ryo, Kakinuma Yasuhiro. Sensor-less On-line Chatter Detection in Turning process Based on Phase Monitoring using Power Factor Theory. *Precision Engineering* <http://dx.doi.org/10.1016/j.precisioneng.2017.07.017>

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**Sensor-less On-line Chatter Detection in Turning process Based on Phase Monitoring using Power Factor Theory**

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