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Authors: A.V. Filippov, A.Y. Nikonov, V.E. Rubtsov, A.I. Dmitriev, S.Yu. Tarasov



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**Vibration and Acoustic Emission Monitoring the Stability of Peakless Tool Turning:  
Experiment and Modeling**

**A.V. Filippov<sup>1,2\*</sup>, A.Y. Nikonov<sup>1,3</sup>, V.E. Rubtsov<sup>1,2</sup>, A.I. Dmitriev<sup>1,2,3</sup>, S.Yu. Tarasov<sup>1,2</sup>**

<sup>1</sup> Institute of Strength Physics and Materials Science SB RAS, Academicheskii av. 2/4, Tomsk, Russian Federation

<sup>2</sup> Tomsk Polytechnic University, Lenina av. 30, Tomsk, Russian Federation

<sup>3</sup> Tomsk State University, Lenina av. 36, Tomsk, Russian Federation

\* Corresponding author e-mail: avf@ispms.ru

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