

### Purpose

The main aim of the study was to measure the cutting forces and chip shapes based on different machining parameters.

### Design/methodology/approach

To get the best optimal machining conditions, it is essential to use the best combination of machining parameters. Although some machining parameters are not important for the process, there are machining parameters which are very important for the machining process.

### Findings

It is essential to determine which machining parameters are the most dominant to make the optimal machining conditions.

### Originality/value

Six different chip shapes are obtained according to ISO standardization. It was determined that the different cutting forces occurred for the different chip shapes.