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ABSTRACT

ANALYSIS OF SURFACE TEXTURE PARAMETERS AND CUTTING FORCES IN MILLING OPERATIONS.

by Preetesh U. Munshi

It has been known and understood that milling is quite a complicated process being a multi-point cutting tool operation. Each Surface texture is complex and requires different functions of forces to get the optimized Surface Texture. The challenge faced here is to devise any form of relation between the Surface Texture and the Milling Operating parameters (Spindle Speed, Feed rate, Depth of Cut), Cutting forces and the Milling Operating parameters and also between the Surface Texture and the Cutting Forces.

This Research study was conducted to determine the effect of the Operating Parameters on Surface Texture and Cutting forces and empirical relationships have been established between the Surface Texture and Operating parameters, The Cutting forces and Operating parameters and Surface Texture and Operating parameters.

Thus, the outcome of the research is to determine the optimal cutting conditions and by controlling the operating parameters, accordingly, better surface quality in milling operations can be attained.

ANALYSIS OF SURFACE TEXTURE PARAMETERS AND CUTTING FORCES IN MILLING OPERATIONS

by Preetesh U. Munshi

A Master's Thesis Submitted to the Faculty of New Jersey Institute of Technology in Partial Fulfillment of the Requirements for the Degree of Master of Science in Industrial Engineering

Department of Industrial and Manufacturing Engineering

May 1997

APPROVAL PAGE

ANALYSIS OF SURFACE TEXTURE PARAMETERS AND CUTTING FORCES IN MILLING OPERATIONS

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To my dear parents, brother and wife

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TABLE OF CONTENTS

Chapter Pa			Page
1			
	1.1	Background Information	1
2	LITE	RATURE REVIEW	3
3	PROPOSED METHOD AND METHODOLOGY		9
	3.1	Methodology	9
	3.2	Variations in Cutting Forces and Surface Finish	9
	3.3	Design of Experiments	10
	3.4	Methods, Setup and Procedures	12
	3.5	Data Collection	15
	3.6	Statistical Techniques using Microsoft Excel	16
	3.7	Mathematical Models.	17
	3.8	Multiple Linear Regression Analysis Technique	17
	3.9	Analysis of Variances.	19
	3.10	Curve Fitting Techniques	19
4	CAS	E STUDY AND RESULTS	20
	4.1	Method of Experiment, Set Up and Procedure	24
	4.2	Design of Experiments	26
	4.3	Total Time for 4 Experiments	27
	4.4	Data Organization	28
	4.5	Multiple Linear Regression Analysis	37
	4.6	Results of Multiple Linear Regression Analysis - X Direction	38

TABLE OF CONTENTS (Continued)

Chapter Pag			Page
	4.7	Results of Multiple Linear Regression Analysis - XY Direction	39
	4.8	Results of Multiple Linear Regression Analysis - Y Direction .	. 39
	4.9	Table Curve Software	40
	4.10	Comparison of Different Operating Parameters	. 46
	4.11	Variation in Surface Texture Parameters and Cutting	54
5	ANAI	LYSIS OF RESULTS	62
	5.1	Analysis of Results	62
	5.2	Cutting in X Direction	76
	5.3	Cutting in XY Direction	76
	5.4	Cutting in Y Direction	76
	5.5	Analysis of the Different Comparisons	79
6 CON		CLUSIONS AND RECOMMENDATIONS	80
	6.1	Conclusions	80
	6.2	Recommendations	81
APPENDIX A TABLE CURVE SOFTWARE RESULTS		82	
APPENDIX B		X B PLOTTINGS OF THE DIFFERENT OPERATING PARAMETERS	88
APP	'ENDI)	X C PLOTTINGS OF THE VARIATIONS OF THE SURFACE TEXTURE AND CUTTING FORCES	94
REF	EREN	ICES	98

LIST OF TABLES

Table		Page
3.1	List of Formulae from Microsoft Excel	22
4.1	Operating Parameters and Levels of Cutting	26
4.2	Cutting in X Direction - Surface Texture	31
4.3	Cutting in XY Direction - Surface Texture.	32
4.4	Cutting in Y Direction - Surface Texture	33
4.5	Cutting in X Direction - Cutting Force	34
4.6	Cutting in XY Direction - Cutting Force	35
4.7	Cutting in Y Direction - Cutting Force	36
5.1	Analysis of Results of Probability Plottings	77

LIST OF FIGURES

Figure		Page
3.1	Profile of the surface quality parameters	15
4.1	Workpiece and feedrates in the order as the component was cut .	24

CHAPTER 1

INTRODUCTION

1.1 Background Information

It is well known that milling is quite a complicated process being a multi-point cutting tool operation. The process of cutting metals by milling operation develops stochastic cutting forces which ultimately result into variable surface roughness. In the machining industry it is of great importance to have the knowledge of Surface Texture or the Surface Finish that would be obtained by using a particular cutting operation.

Due to the stochastic nature of the cutting forces and Surface Texture it would be difficult to choose a machining operation for a particular component. This may result into unexpected and undesired tool failure which obviously needs to be avoided. In order to ensure system reliability and improve the productivity in an automated manufacturing environment it is necessary to implement sensing and corrective devices that can detect and correct the system malfunctions.

Over the last decade, researchers have put their efforts into on-line monitoring of the machining process, especially the recognition of tool breakage, because of the rapid development of computer integrated manufacturing systems and sensor based machining processes. One of the most important requirements is to obtain a relationship between the Surface Texture and Operating Parameters in the Milling operation. This would lead to developing a relationship between the cutting process parameters (spindle speed, feed rate,

1

depth of cut) and the Surface texture parameters. These relationships are important in developing analytical models for cutting process monitoring. At the same time this research also develops a relation between the Cutting Forces and Operating parameters and thereby determine the relationship between the Surface Texture and Cutting Forces.

CHAPTER 2

LITERATURE REVIEW

In the interest of maximizing the metal removal rate and preventing tool breakage L.K.Lauderbaugh and U.G.Ulsoy [1] have conducted Research work on Fixed Gain Feedback Controllers which manipulate the feed rate to maintain a constant cutting force. These process controllers have resulted in substantial improvements in the metal removal rate but may have poor performance when the process parameters deviate from the design conditions. They have also presented an empirical second order model of force response for a milling system to feed rate changes along with experimental results. These results show that the parameters of the model vary significantly with cutting conditions.

In their paper by **Y** Atlintas and Yelloley [4], the authors have shown that by force averaging over a tooth period and then differentiating twice, tool damage may be identified and normal transients may be ignored. The authors have shown that force averaging and normalized differencing form a suitable base for practical tool breakage detection algorithm.

In their paper L.K. Lauderbaugh and A.G. Ulsoy [8] describe the design and implementation of a model reference adaptive controller for force controlling in milling, the adaptive controller was found to be performing more effectively than the fixed gain controller but it is difficult to implement and tune because of the unmodelled dynamics or measurement noise resulting from runout on the milling cutter.

3

The researchers, **Ismail and F. Albestawi** [7] generated a mechanic model for Surface generation in peripheral milling that includes the effect of cutter runout and flank wear. The surface roughness parameters and characteristic features of the Surface Profile were examined by using Computer Simulation. The trend towards unattended manufacturing emphasized the need for sensing the variables in process that could affect the state of cutting force and Surface finish. The new trend brought the usage of Adaptive Control Technology and On -Line monitoring. The adaptive control denotes whereas the Numerical Control determines the proper speeds and/or the proper feed rates during the milling process as a function of , factors such as work material hardness, depth of cut, spindle speed. With increasing focus on the development of the sensing techniques many researchers demonstrated their findings by using sensing and adaptive control technology.

Bobe [10] employed a method which describes the method for determining the natural frequencies and vibration modes of milling machine's. the model combined a finite element model and an asymmetric stiffness matrix system.

According to Fussel and Srinivas [11], Varying machining conditions are encountered in adaptively controlled machining situations where operating conditions such as feed rate and spindle speed are adjusted continuously to achieve desired objectives. The authors have evaluated the adequacy of the models available of the milling process mechanics for many cases of varying machining conditions including the change of depth of cut and feed rate (axial and radial)They have also evaluated the significance of dynamic effects in the milling process of effects such as run out for constraint type adaptive control system.

G.Chryssolouris and M.Guillot [12] presented an approach for the selection of a set of process parameters for use in machining control. The approach is aimed at providing a range of parameters within which machining operations can be optimized. Because of the complexity and somewhat unpredictable nature of the machining process the approach combines process modeling with rule based techniques. Modeling correlates process state variables such as surface roughness or chip merit mark to process parameters such as feed rate, cutting speed and tool rake angle. The modeling techniques considered in the paper include multiple regression analysis, group method of data handling and neural network. The authors concluded that a rule based system added the flexibility necessary to treat various cases of the machining process and considered the accuracy of the model. Even though this model has been developed with a particular intelligent controller scheme it is general enough to apply as a complement to other machining controllers (e.g. adaptive control constraint or optimization) or to standard machinability databases.

S.Smith and J.Tlusty [14] claim that it has been shown for many milling operations that it is desirable to set the tooth frequency equal to the natural frequency. At this spindle speed, the development of resonant forced vibration is actually inhibited by regeneration of waviness. The authors have presented an algorithm for automatically selecting the optimum spindle speed based on the

cutting force signal. It was concluded by the authors that the optimum spindle speed for a milling operation is that speed where the tooth frequency is equal to the natural frequency.

N.K.Jha [15] claims that the production planning of milling operations in an important problem. It has been observed that if discrete settings of speed and feed are taken into account, production planning becomes more complex. A procedure has been suggested in the paper for such cases. The approach suggested looks most promising for adaptive control optimization. The objective of the adaptive controller is to optimize the index of performance such as cost per piece, material removal rate by manipulating the speed or feed to maintain the measured variables at or below their constraint limit values. Especially sensors will be developed to a level at which true process performance can be measured on-line.

In conclusion a considerable amount of research has been done in the area of unattended machining, milling operations and a lot of means have been devised to get the desired cutting forces and Surface Finish on the Milled Products. During the course of the literature survey it was observed that there was no work that showed the optimal cutting conditions in which the desired cutting force and the desired Surface Texture could be obtained using typical combinations of speed, feed and depth of cut. There was hardly any work done to determine the values of spindle speed, feed rate, depth of cut using which a particular surface finish or a particular cutting force could be obtained.

Therefore, the main objective of the Research work is to improve the surface Quality of any component that is being machined on an automated Milling Machine. In order to improve the Surface quality of the machined component it would be of great benefit if the expected Surface Quality that could be obtained by the machine would be known prior to the machining operation. In an open machining system it is very difficult to improve the surface quality, and hence the need of a system which would give the feedback to the Milling machine. It is necessary to derive models that would establish empirical relations giving us the values of the expected Surface Quality. This expected value can then be compared with the actual surface quality value obtained and then depending on the need corrective measures could be incorporated to obtain the desired Surface Quality Results. As mentioned earlier in the introduction and the limitations of the literature review the interest and the focus of the research being done is to develop empirical relations between

1) Surface Texture and Operating parameters (spindle speed, feed rate and depth of cut)

2) Cutting Forces and Operating parameters (spindle speed, feed rate and depth of cut)

3) Surface Texture Parameters and Cutting Force

By establishing these results it would be possible to predict the Surface Texture or the Cutting force that would be developed by using a particular combination of spindle speed, feed rate and depth of cut. Thus, we shall have the expected value of the Cutting Force and/or Surface Texture which could serve as a reference for the actual values that would be obtained after the machining is done.

Hence, by knowing prior to machining the combination of spindle speed, feed rate and depth of cut it would be possible to set the machining system at those particular values and obtain a Surface Texture that would be desirable. in addition to that, it would also be possible to develop an Adaptive Control system which would be capable of detecting the Surface texture and the Cutting force during the process of operation and be capable of taking preventive and/or corrective measures.

This research work would greatly contribute towards improving the quality and the productivity of the components being machined using an automated milling machining and it can also be extended to other similar machining operations.

CHAPTER 3

PROPOSED METHOD AND METHODOLOGY

3.1 Methodology

In order to achieve the goals of the research Work it is necessary to conduct a number of experiments so that enough data can be collected to derive mathematical relations and models. It is necessary to conduct experiments on the milling machine so that data can be collected on the different milling operating parameters. After these experiments have been performed and data collected it would be possible to formulate mathematical models. The results obtained from these mathematical models would be then used to analyze the data collected and present the findings, give suggestions and improvements.

3.2 Variations in Cutting Forces and Surface Finish

Milling is a process in which the material is cut using a multi point cutting tool, thus ,making the milling process a complicated process. This complicated process is controlled by various operating parameters like spindle speed, feed rate and depth of cut. This complicated milling process results in stochastic forces, which also result in stochastic surface finish. The milling process can generate a wide range of shapes and obtain different surface texture results. It can also give a high material removal rate. All these properties of a milling process give rise to variations in the cutting forces which ultimately vary the final surface quality result. The problems mentioned above are critical to study the behavior of the milling process. There are also many other factors that affect the

9

cutting process. Hence, the surface finish, cutting forces and for that matter even tool wear are stochastic making it very difficult to predict the accuracy of these measures. Hence, the output of the cutting force varies from point to point and from one machine to another, even under the same operating conditions. It is of interest to examine the two applications that result from the stochastic milling process. One being, to identify the cutting conditions under different operating conditions and the other being able to examine the surface quality results due to the stochastic nature of the cutting force.

3.3 Design of Experiments

Experimental design is necessary to obtain reliable results. In this research, the validation of the models depends on the way the experiments were designed since the mathematical models of cutting force and Surface Texture will be formulated according to the experimental collected data.

In a milling process there are 3 control parameters that is the spindle speed, feed rate and depth of cut. These three variables can be selected to be the independent variables of the mathematical models of cutting force and surface roughness. A factorial design can be introduced for the formulation of the mathematical model. In a factorial design a fixed number of levels are selected for each of the number of variables and then experiments are run with all the possible combinations. If there are L1 variables for the first variable , L2 variables for the second variable , Lk variables for the Kth variable , the experimental run is called an L1 x L2 x x Lk factorial design. These designs

are of importance for a number of reasons. they require relatively few runs per factor studied and although they are unable to explore fully a wide region in the factor space, they can indicate major trends and so determine a promising direction for further experimentation. these designs and the corresponding fractional designs may be used as building blocks so that the degree of the complexity of the finally constructed design can match the sophistication of the problem. The interpretation of the observations produced by the design can proceed largely by using common sense and elementary arithmetic.

LEVEL	Cutting Speed	Feed rate	Depth of cut
High	S _h	F _h	D _h
Central	S _c	F _{c1} , F _{c2}	D _c
Low	SI	Fı	D

The advantages of the factorial experimentation naturally depend on the purpose that is to investigate the effects of each factor over some pre assigned range that is covered by the levels of that factors which are used in the experiment. If all the factors are independent in their effect the factorial effect will save a considerable time and material devoted to the experiment. When the factors are not independent the purpose then is to still investigate each factor over the range represented by its levels. When the factors are not independent, the simple effects of a factor vary according to the particular combination of other factors with which these are produced.

3.4 Methods, Set Up and Procedures

It is necessary to come up with a method and the procedure in which the experiments would be conducted to obtain the desirable results. Explained as follows is the proposed procedure to obtain the desired models and results. First of all an appropriate workpiece has to be selected on which the experiments could be performed. The workpiece can be placed on the load cell and fixed with the aid of a vice. The data acquisition board is kept ready and all the necessary information is entered to a proper software. After that the amplifier is set up after a warm up of a fixed amount of time. The CNC milling machine and the NC part program are kept ready. The data acquisition program is then actuated and the process is performed. If there is no overload signal the data is saved. The Surface finish of the workpiece is measured by the necessary instrument and the collected data is transferred to the Surface Finish software.

The cutting force varies due to the stochastic nature of the process at each moment of time and thereby it leads to the variation in the surface roughness every time. Thus the cutting forces were also to be recorded at the same time. In this research, a transducer was used for converting the vibrations of the cutting force to analog signals. A transducer is a device that converts one type of physical quantity such as temperature, force, velocity into another type, commonly an electrical voltage. The reason for making this conversion is that the converted signal can be used or evaluated more conveniently. Basically, there are two types of transducers, analog and digital. The analog transducers produce a continuos analog signal for e.g. an electrical voltage. in the research the transducer can be used to measure each separate component of the force at the same time. A force transducer will be used to measure the three orthogonal components of the cutting forces in arbitrary directions. The workpiece can be connected with 4 screws to the fixture and after every 4 experiments the workpiece can be changed to another one. The transducer has to be calibrated with the fixture as a perload.

A CNC machine can be used to perform the milling process. The machine that would be selected should have the three X, Y and Z axes and should be able to rotate in both the directions of rotation. A high speed processor would be required to increase the machine capability to use faster feedrates. These higher feedrates may be attained without emptying the machine buffer. There are also additional G and M code capabilities. The macro capabilities provides a programmer with full mathematical calculations within a program.

A mill can be used to perform the cutting operation. The cutters used should be constructed from a high speed steel matr. (HSS). First, the roughing operation is performed and then the finishing operation and the data has to be collected. For these experiments appropriate material of the workpiece should be selected so that it can be cut by the HSS cutter. Each experiment would consist of cutting in different directions. The total time for cutting should also be recorded for different combinations of the operating parameters which would help towards the analysis of all the data collected.

3.5 Data Collection

The most important part of the research work was the data collection. The data collection was divided into two parts. The first was the data collected for the different surface quality parameters and the second part was the data collected for the cutting forces.

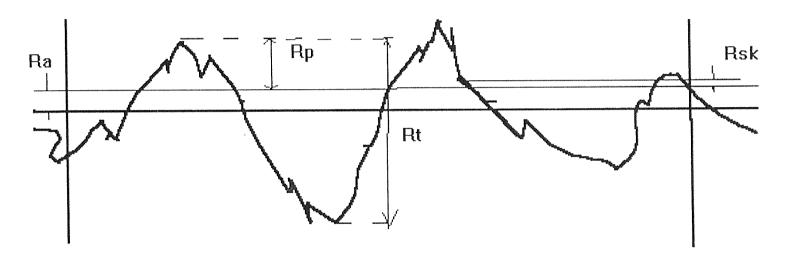
The data that was collected for the Surface Quality had five different parameters: Rku, Ra, Rq, Rp and Rt. Fig. 3.1 shows the rough sketch of the profile of the Surface Quality parameters. The explanation of those parameters is as given below.

1) Rku - Kurtois provides a measure of the sharpness of the Surface Profile, a spiky surface has a high Rku and a bumpy surface has a low Rku value. Rsk which is the skew value cannot detect if the spikes on the profile are evenly distributed or not where as the Kurtois can, hence the Kurtois value is to be used.

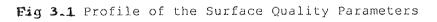
Std K - The standard deviation of the sharpness of the surface profile.

S/N Rku - This is the Signal to noise ratio for the Rku value.

- 2) Ra Ra is the parameter for roughness. It is the arithmetic mean of the departures of the roughness profile from the mean line.
- 3) Rq Rq is the RMS parameter corresponding to Ra.
 4) Rp Rp is the maximum height of the profile above the mean line within the assessment length.
- 5) Rt Rt is the maximum peak to valley height of the profile in the assessment length.



Rq is the RMS value of Ra



Each of the above parameters have their standard deviations and Signal to Noise Ratios.

The second part that is the cutting forces were just in the form of values of the cutting forces. These cutting forces were directly imported into the excel spreadsheet. These values were in the form of data files and there is a special feature in the excel spreadsheet that allows the user to convert data files into Excel spreadsheets. The data that will be obtained from the CNC machine software will be in the form of thousands of numbers. This data needed to be organized so that mathematical models could be derived.

3.6 Statistical Techniques Using Microsoft Excel

There was a large amount of data collected in the form of Surface Texture parameters and also cutting forces by directly reading it from the CNC machine. This data was stored as data files and was imported into the Microsoft Excel Software for its analysis. The cutting was done in three directions, the X, XY, and the Y. For each of the axis the data was sorted in the ascending order of the speed, feed and the depth of cut. The average, maximum, and the minimum of each of the parameters of the Surface Texture and the Cutting Forces were found out by using the inbuilt Statistical Formulae. For eg. the maximum of a particular range was found by the formula = max (range) , Similarly the minimum = min (range), and for the average = average (range). For the ease of use of Multiple Regression Analysis Technique the In values for each of the Operating parameters, Surface Texture Parameters and the Cutting forces were

found using In (number). Their log std. deviations was also calculated to see how much do they deviate from the average value. These calculations were done for both the Surface Texture Parameters and Cutting Forces. The Signal to noise ratios were also found out using the appropriate formula from the formulae mentioned earlier. A list of the formulae that could be used from Microsoft Excel are shown in table 3.1.

3.7 Mathematical Models

After all the data was collected and now organized there were 36 values for each operating parameter for cutting in each of the directions X, XY, and Y. This data was now to be converted into a Mathematical model giving relationship between the Surface Texture and the Operating parameters of speed, feed and depth of cut and also between the cutting force and the operating parameter of speed, feed and depth of cut. The Multiple Linear Regression Software written in QBASIC was used for this purpose. Then relationship was also established between the Surface Texture parameter and the Cutting Force and a more advanced software called the Table Curve Software was used for the same.

3.8 Multiple Linear Regression Analysis Technique

The Multi-Linear Regression analysis was selected as it was the most adequate statistical technique. This statistical technique was used to establish the relationship between

1) Surface Texture (Rku, Ra, Rq, Rp, Rt) and Milling Operating

17

Parameters (Spindle speed, feed rate, depth of cut).

Cutting Forces (Fmax, Favg) and Milling Operating Parameter
 (Spindle speed, feed rate, depth of cut).

An explanation as to why the above model was used is as follows.

In any statistical model there are dependent variables and independent variables. In the Surface Texture model, the Rku value for e.g. is the dependent variable and the operating parameters of speed, feed and depth of cut are the independent variables. In the Cutting Force model, the Fmax value for e.g. is the dependent variable and the operating parameters of speed, feed and depth of cut are the independent variables.

The relationship between the dependent and the independent variables can be mathematically represented as follows:

$$Y_i = X_0 * X_1^{n1} * X_2^{n2} * X_3^{n3}$$

This non-linear relationship can then be written linearly as :

$$\ln(Y_i) = \ln(X_0) + n1 + \ln(X_1) + n2 + \ln(X_2) + n3 + \ln(X_3)$$

Using the Multiple Regression technique it becomes possible to determine the values of X_0 , n1, n2, and n3. This is the statistical technique that is used to determine the equation of the line or the curve which minimizes the deviations between the observed data and the regression equation values. Since, there is more than one independent variable the Multiple Regression technique has been applied.

3.9 Analysis of Variances

After using the Multiple Regression Technique the models were established and the ANOVA i.e. Analysis of Variance has been performed to determine the adequacy of the models. The correlation coefficient and the F value are the main output of the ANOVA. The Correlation Coefficient is a measure of how well a specific regression equation explains the observed variation. Hence, Higher the R value better is the regression model, the F test is used to examine the adequacy of the model. The F value is the ratio of the regression sum of squares and the sum of squares error. Residual analysis is necessary to draw a conclusion about the regression model. Since all the above measures are based on the assumption of normality, the residual analysis is the tool to confirm this assumption. In this Research Standardized Residuals were calculated, the assumption of normality thus being confirmed. Thus using the above guidelines the model was developed and the relationships were established. It was now required to further establish a relationship between the Surface Texture and the Cutting Forces.

3.10 Curve Fitting Techniques

The table Curve software has been developed by Jandel Scientific. This software is ideally used when one has to determine the relation between two parameters, in which one is the dependent variable and the other is the independent variable. In the Research work this software has been used to develop relationship between the Surface Texture parameters and the Cutting Force parameters for cutting in the 3 directions of X, XY and Y. This software has a File Menu which allows us to import data from Excel and Lotus spreadsheets. The data can be imported directly, it can be imported after digital filtration or it can also be imported from a Clipboard which has been previously saved. Next it has the Edit Menu. This software has an Ascii Editor and also a table editor in which we can directly type in the numbers to obtain the relations. This software has a Table and the Calculate Menu which calculates the integral, differential, Bessels function and various other desired mathematical and algebraic calculations. Next it has a Process menu in which the selected data gets processed and the software comes up with a graph listing the equations and the graph that was desired, it has a variety of options for the type of fit desired.

For this purpose the Table Curve Software was utilized. In this research work the software imports the data from the clipboard of a spread sheet, reads it, analyzes the same and comes up with a graph for Best Fit and also gives the Best Fit Equation. It calculates the Correlation Coefficient and thus we can determine the adequacy of the model. This software has a limitation that it can take just two variables and establish the relation between the two of them. This is the reason why this software was not used for determining the relation between the Surface Texture, Cutting Forces and the milling Operating Parameters. To use the table curve software the entire data was put on the spread sheet, then the table curve software was made to import the Surface Texture and the Cutting Force values, one at a time and the graphs and the relations were established

for each of the 36 values in each of the three directions for cutting (X, XY andY)

The data so transformed into mathematical models has to be analyzed and thereby conclusions can be made. With the help of the empirical relations obtained from these various softwares it would be possible to predict the nature of the cutting force and the value of the Surface Texture parameters before the cutting process would actually take place.

Statistical Functions	
AVEDEV	Returns the average of the absolute deviations of data points from their mean
AVERAGE	Returns the average of its arguments
BETADIST	Returns the cumulative beta probability density function
BETAINV	Returns the inverse of the cumulative beta probability density function
BINOMDIST	Returns the individual term binomial distribution probability
CHIDIST	Returns the one-tailed probability of the chi-squared distribution
CHIINV	Returns the inverse of the one-tailed probability of the chi-squared distribution
CHITEST	Returns the test for independence
CONFIDENCE	Returns the confidence interval for a population mean
CORREL	Returns the correlation coefficient between two data sets
COUNT	Counts how many numbers are in the list of arguments
<u>COUNTA</u>	Counts how many values are in the list of arguments
COVAR	Returns covariance, the average of the products of paired deviations
CRITBINOM	Returns the smallest value for which the cumulative binomial distribution is less than or equal to a criterion value
DEVSQ	Returns the sum of squares of deviations
EXPONDIST	Returns the exponential distribution
FDIST	Returns the F probability distribution
FINV	Returns the inverse of the F probability distribution
FISHER	Returns the Fisher transformation
FISHERINV	Returns the inverse of the Fisher transformation
FORECAST	Returns a value along a linear trend
FREQUENCY	Returns a frequency distribution as a vertical array
FTEST	Returns the result of an F-test
GAMMADIST	Returns the gamma distribution
<u>GAMMAINV</u>	Returns the inverse of the gamma cumulative distribution
GAMMALN	Returns the natural logarithm of the gamma function, $\Gamma(x)$
GEOMEAN	Returns the geometric mean
GROWTH	Returns values along an exponential trend
HARMEAN	Returns the harmonic mean
HYPGEOMDIST	Returns the hypergeometric distribution
INTERCEPT	Returns the intercept of the linear regression line
KURT	Returns the kurtosis of a data set
LARGE	Returns the k-th largest value in a data set
LINEST	Returns the parameters of a linear trend
LOGEST	Returns the parameters of an exponential trend
LOGINV	Returns the inverse of the lognormal distribution
LOGNORMDIST	Returns the cumulative lognormal distribution
MAX	Returns the maximum value in a list of arguments
MEDIAN	Returns the median of the given numbers
MIN	Returns the minimum value in a list of arguments
MODE	Returns the most common value in a data set
NEGBINOMDIST	Returns the negative binomial distribution

Table 3.1

(Continued)

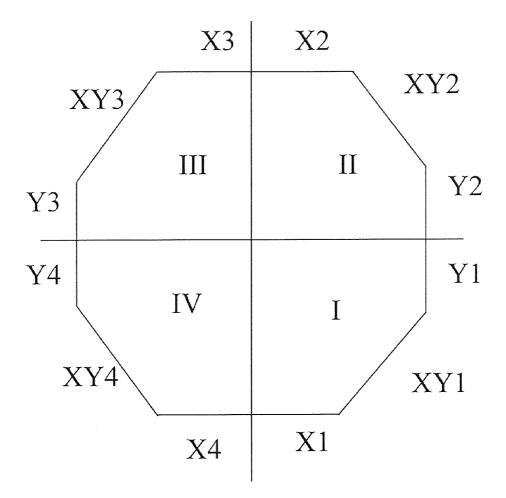
NORMDIST	Returns the normal cumulative distribution
NORMINV	Returns the inverse of the normal cumulative distribution
NORMSDIST	Returns the standard normal cumulative distribution
NORMSINV	Returns the inverse of the standard normal cumulative distribution
PEARSON	Returns the Pearson product moment correlation coefficient
PERCENTILE	Returns the k-th percentile of values in a range
PERCENTRANK	Returns the percentage rank of a value in a data set
PERMUT	Returns the number of permutations for a given number of objects
POISSON	Returns the Poisson distribution
PROB	Returns the probability that values in a range are between two limits
QUARTILE	Returns the quartile of a data set
RANK	Returns the rank of a number in a list of numbers
RSQ	Returns the square of the Pearson product moment correlatin coefficient
<u>SKEW</u>	Returns the skewness of a distribution
SLOPE	Returns the slope of the linear regression line
SMALL	Returns the k-th smallest value in a data set
STANDARDIZE	Returns a normalized value
STDEV	Estimates standard deviation based on a sample
STDEVP	Calculates standard deviation based on the entire population
<u>STEYX</u>	Returns the standard error of the predicted y-value for each x in the regression
TDIST	Returns the Student's t-distribution
TINV	Returns the inverse of the Student's t-distribution
TREND	Returns values along a linear trend
TRIMMEAN	Returns the mean of the interior of a data set
TTEST	Returns the probability associated with a Student's t-Test
VAR	Estimates variance based on a sample
VARP	Calculates variance based on the entire population
WEIBULL	Returns the Weibull distribution
ZTEST	Returns the two-tailed P-value of a z-test

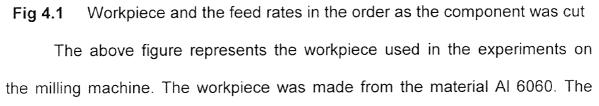
CHAPTER 4

CASE STUDY AND RESULTS

4.1 Method of Experiment, Set Up and Procedure

The workpiece (3 in x 3 in) is placed on the load cell and it is fixed with the aid of a vice.





cutter that was used for the milling operation was made out of high speed steel. The workpiece was cut in the order as represented by the number in the figure.

The data acquisition board is kept ready and all the necessary information is entered to the UEI-Win 30. After that the amplifier is set up after a warm up of 1 hr. The CNC milling machine and the NC part program are kept ready. The data acquisition program is then actuated and the process is performed. If there is no overload signal the data is saved. The surface finish of the workpiece is measured by the Surtronic 3 + and the collected data is transferred to the Surface Finish software.

The cutting force varies due to the stochastic nature of the process at each moment of time and thereby it leads to the variation in the surface roughness every time. Thus the cutting forces were also to be recorded at the same time. In this research, a transducer was used for converting the vibrations of the cutting force to analog signals. The transducer measured each separate component of the force at the same time. A Kistler 9067 force transducer was used to measure the three orthogonal components of the cutting forces in arbitrary directions. The workpiece was an eight sided polygon that was connected with 4 screws to the fixture and after every 4 experiments the workpiece was changed to another one. The transducer was calibrated with the fixture as a perload.

The Fadal CNC machine was used to perform the milling process. The Fadal CNC machine is a 5 axis milling machine. It moves on the X,Y, and Z axis and rotates to both directions of rotations. The high speed processor increases

the machine capability to use faster feedrates. These higher feedrates may be attained without emptying the machine buffer. There are also additional G and M code capabilities. The macro capabilities provides a programmer with full mathematical calculations within a program.

Four 1/2 in. size flute side mills were used to perform the cutting operation. All the cutters were constructed from a high speed steel matr. (HSS). First, the roughing operation was performed and then the finishing operation was performed and the data was collected. For these experiments the workpiece was made from the AL 6060. Each experiment consisted of three different paths as follows X direction, XY direction and the Y direction under the same conditions.

4.2 Design of Experiments

In this research the factorial design of 2⁻³ was adopted and the selected experimental points created the vertices of the cube. Based on the capacity of the milling machine used three levels (lower, central, and upper) were selected for each cutting condition. The table below shows the combination of the different parameters involved in the machining of the component.

 Table 4.1
 Operating Parameters and levels of cutting

SPEED	FEED	DEPTH OF CUT
1500 RPM	0.001 in/min	0.001 in
3000 RPM	0.005 in/min	0.02 in
4500 RPM	0.01 in/min	0.05 in
	0.02 in/min	

The above table shows the different operating parameters involved in the machining operation and the different levels of cutting. After the machining was carried out the data was collected and transferred to excel spreadsheet.

4.3 Total Time for 4 Experiments

There was a total of 4 experiments performed per combination of the operating parameters. These 4 experiments represent the cutting if the workpiece was divided into 4 quadrants. The milling process of each of the workpiece took as follows :

When the spindle speed = 1500 RPM, total time = 304.2 secs.

When the spindle speed = 3000 RPM, total time = 153.6 secs.

When the spindle speed = 4500 RPM, total time = 76.8 secs.

When the spindle speed was increased the milling process was shorter. The total sampling rate that was collected is as follows :

For a total time of 307.2 secs. the signals per channel were 1024. For a total time of 153.6 secs. the signals per channel were 512 and when the total time was 76.8 secs. the signals per channel were 256.

There were 4 experiments performed on each workpiece. The workpiece was divided into 4 quadrants and each feedrate was used in each quadrant and the readings were recorded from the software. The Surface Quality results and the Cutting force results were all recorded from the software. Initially this data was in the form of .dat file from the software. It was imported into the Excel

Spreadsheet so that there could be ease of calculation. For this conversion a special feature in excel was used that allows us to convert each .dat file into a .xls format. Once the .xls format was obtained all the calculations could be performed like a normal excel spreadsheet. Given below are the results from the excel spreadsheet for the Surface Quality and Cutting Forces. The formulae that were described in the previous chapter were utilized to obtain the Signal to noise ratio for all the parameters.

4.4 Data Organization

The data that was obtained from the CNC machine software was in the form of thousands of numbers. This data needed to be organized so that mathematical models could be derived. The Surface texture data was first imported in the Excel Spreadsheet. It is to be noted that there were 3 spindle speeds, 4 feed rates and 3 depths of cut. Thus if we have a single value for a single combination for cutting in each direction we should end with 3 x 4 x 3 = 36 values for cutting in each direction. Thus each of the surface texture parameter was averaged or maximized or minimized to obtain the 36 values for cutting in each direction. Rku, Ra and Rq values were averaged as the average value would give optimum results. The Rp and Rt values which are the peak values were minimized because of the fact that minimum the distance between peaks the better it is. These values were calculated using the Excel spreadsheet. The cutting force data was split into the Fmax value and the Favg. value to obtain optimum results.

For this purpose also Excel spread sheet was used. Before performing these functions the data files had to be converted from the .dat format to the .xls format and this feature was available through a software in Excel.

Taguchi's method was used to calculate the S/N Ratios. The following formulae are available and they were used according to the conditions.

a. When nominal is the best

 $(S/N) = 20 * \log (Y/S)$

where Y is the average of a number of readings = S

 $(S/N) = -10 * \log (1/n (\Sigma Y^{2}))$

where Y is the reading and n is the number of readings.

 $(S/N) = -10 * \log (1/n (\Sigma 1/Y^2))$

where Y is the reading and n is the total number of readings.

Thus using the above formulae the Signal to noise ratios were calculated using either min. the better or max. the better.

Similar results were also obtained for the cutting forces. In this case there were only two parameters

Fmax - The maximum cutting force.

Favg - The average cutting force.

The standard deviations and the signal to noise ratios were calculated for the Fmax. in a similar manner as for the Surface texture Results. The cutting was carried out in three directions X, XY and the Y Directions. Therefore, a set of readings was obtained for each of the three directions.

There were thousands of numbers involved and to develop a mathematical model it was necessary that the data be organized so that sense could be made out of it after feeding it to the various softwares. Since there are three spindle speeds, four feed rates and three depths of cut 3 x 4 x 3 = 36 values of each operating parameter was obtained for cutting in each of the X, XY and the Y direction. The entire data which was consolidated and organized is shown in the tables 4.2, 4.3, 4.4, 4.5, 4.6, and 4.7. Tables 4.2, 4.3 and 4.4 show the surface quality parameter values of Rku, Ra, Rq, Rp and Rt, their In values, the standard deviations and the signal to noise ratios for cutting in each of the three directions X, XY and Y respectively. The tables 4.5, 4.6 and 4.7 show the maximum cutting force and the average cutting force, their In values, standard deviations and the signal to noise ratios for cutting in all the three directions X, XY and Y respectively.

The tables were created by using excel functions. On the Microsoft Excel screen there are lots of icons. There is an icon for "Function Wizard "which comes up with the numerous statistical formulae that can be used for mathematical and algebraic calculations. Not all of these functions were utilized during the course of the data organization.

Table 4.2 Cutting in X Direction

5	peed	In speed	leed	In feed	depth	In depth	Rku(avg)	Ln Rku	std k	kogstd k	S/N Rku	Avg R	ln Ra	std Ra	logstd Ra	S/N Ra
		2.0.000							1							L
		7.31322		-6.90776		-6.90776		1.087439					33 2.817403			
	1500			-6.90776		-3.91202		1.335001					67 3.217542			
I	1500		0.001	-6.90776	0,05	-2.99573		1.243194					33 3.128221			
	1500			-5.29832		-6 90776		1,734601					33 3.078847			
	1500 1500							1.740466	2,946184				33 2.703596			
	1500				0.05								33 2.77457			
	1500								0.288675				33 3.158418	2 3/55/	0.375768	-27 463
	1500		0.01	-4 60517	0.02	-2.99573	2.966667	0,993252	0.305505				33 3.319023 67 3.474035			
	1500			-3 91202	0.001	-6.90776		1.173514				32 200	33 3 630544	5.503/34	0.329033	-30 2065
	1500			-3 91202		-3.91202	2 166667		0 305505		-6.77303		33 3 630344			
	1500		0 02			-2.99573		0.741937			-6.56737		1 3 78646			
		8.006368	0 001					1 394593			-12 1387		67 2.854553			
1		8 006368			0.02	-3 91202		1.596015					33 2.823361			
		8.006368				-2.99573		1 575536					.8 2.879198			
		8 006368			0.001	-6.90776	3 133333	1.142097	0 503322	-0.29815	9.99421		2 509599	1 216553	0.085131	-21 8263
		8.006368			0.02	-3.91202		1 193922		-0.2159		10.837	33 2.382626	1 350300	0 130433	-20 74
		8 006368			0.05	-2.99573		1.262242					4 2 74071	13	0.113943	.10 5176
		8 006368		-4.60517	0.001	-6.90776		1.299283	0.85049	-0.07033	-11.4385	15.833	1.4 2.24071 33 2.762117	3.855299	0.586058	24 1598
		8.006368				-3.91202	4 766667	1.561647	1 795364	0.254153	-13.9568	1	2.60269	1 410674	0.149427	-72 6387
		8.006368	0.01	-4.60517		-2.99573		1 7 16796				2	.4 3.015535	2 821347	0.450457	-26.2476
E	3000	8 006368		-3.91202		-6.90776		0,77319					33 3.584444			
	3000	8 006368	0.02	-3.91202	0.02	-3.91202	2.033333	0.709576					3 4.012773			
	3000	8.006368	0.02	-3.91202	0.05	-2.99573	2.8	1.029619	1,053565	0.022661	-9 33487	3	3 3 505557	5.940539	0 773826	-30 5401
-	4500	8 411833	0.001	-6.90776	0 001	-6.90776	3,4	1.223775	0.5	-0.30103	-10.6917	1	7 2,753661	3.109662	0.492713	-24 0301
-		8 411833		-6.90776	0.02	-3,91202	7 933333	2.071073	5.006329	0.699519	-19.0117	19 333	33 2 961831	14.73001	1 168203	-27 1469
		8 411833		-6.90776				1.290151			-11 3704	13.666	57 2.61496	3.3545991	0 525641	-22.8843
		8 411833	0.005	-5.29832	0 001			1.163151	0,458258	-0.33889	-10 162	15.533	33 2 742988	1.258306	0.099786	-23 8443
		8 411833		-5 29832	0.02			1.410987					33 2.575154	1.93477	0 286629	-22 4299
		8 411833	0.005	-5.29832	0.05			1.252763				12.166		2.050203		-21 7849
		8 411833	0 0 1	-4.60517	0.001			1.504077				21 166		4.350096		
		8.411833		-4.60517	0.02			1.386294					33 3.212187			
· · · · ·		8 411833	0 0 1		0.05			1.369487			-12.5123		57 2.888518			
		8.411833	0.02	-3.91202	0.001			1.005522			-8.73514	29.433	33 3 382128			
		8.411833	0.02		0.02		4.8	1.568616	3.477068	0.541213	-14.9276		4 3.815512			-33 584
	4500	8 411833	0.02	-3.91202	0.05	-2.99573	2.033333	0,709676	0.152753	-0.81601	-6.18048	54 766	57 4.003082	2 050203	0 311797	-34 7744
			1.5	0									-			
		Avg Rq	In Rq	Starq	logstd Rg	SIN RQ	Avg Rp	In Rp	Std Rp	logstd Rp	S/N Rp	Avg Rt	In Ri	Std Rt	logstd Rt	S/N Rt
1		20 96667	3.038153	2 750462	0 430357	-26.4391	65.66667	4 19/501	8.621678	0.036600	-36.3965		1 1 770505	10.35750	1 000040	
			3,485334					4.618415	45 64495	1.659430			18 4.770585 24 5.267858		1.203815	41 5072
			3 361532					4.477337		1 113943			33 5 160969			-45 991 -44 8688
-			3.410047					4.907741			-45.0309		33 5 37682			
			3 044522					4.321923			-38 5447		57 4.946393			
1			3 020425												1000403	
		29 53333			0 146128	-26.2486						1 1		20 80865	1 318244	
			3.38552		0.146128					0 745681				20.80865		
	1	34 46667		2.542309	0 405228	-29.4277	92 33333	4.525405	9.291573	0 968089	-39.3364	1	5.09375	20.80865 6 557439	0 8 16734	-44 2484
1			3.38552 3.539993 3.681351	2.542309 7 600877	0 405228	-29.4277 -30,8866	92 33333 89 66667		9.291573 14 57166	0 968089		1 180.66	53 5.09375 57 5.196654	20 80865 6 557439 27 46513	0816734	-44 2484 -45 204
1		39 7 45 7	3 539993 3 681351 3 822098	2.542309 7 600877 10 95628 9.26013	0 405228 0 880864 1 039663 0 966617	-29 4277 -30,8866 -32 009 -33 3156	92 33333 89 66667 101 6667 171.3333	4 525405 4 496099 4 621699 5 143611	9 291573 14 57166 18.00926 108.8592	0 968089 1 163509 1 255496 2 036865	-39.3364 -39 1284	1 180.66 197.66 253.33	5 09375 5 196654 5 286582 5 5 534706	20 80865 6 557439 27 46513 23 35237 130 6688	0 816734 1 438782 1 368331 2 116172	-44 2484
		39 7 45 7	3 539993 3 681351	2.542309 7 600877 10 95628 9.26013	0 405228 0 880864 1 039663 0 966617	-29 4277 -30,8866 -32 009 -33 3156	92 33333 89 66667 101 6667 171.3333	4 525405 4 496099 4 621699	9 291573 14 57166 18.00926 108.8592	0 968089 1 163509 1 255496 2 036865	-39.3364 -39 1284 -40.2335	1 180.66 197.66 253.33	5 09375 5 196654 5 286582 5 5 534706	20 80865 6 557439 27 46513 23 35237 130 6688	0 816734 1 438782 1 368331 2 116172	-44 2484 -45 204 -45 9589 -48 783
		39 7 45 7 51 83333 51	3 539993 3 681351 3 822098 3 948033 3 931826	2.542309 7.600877 10.95628 9.26013 6.115826 7.218726	0 405228 0.880864 1.039663 0.966617 0.786455 0.858461	-29 4277 -30,8866 -32 009 -33 3156 -34,3323 -34,209	92 33333 89 66667 101 6667 171.3333 128.3333	4 525405 4 496099 4 621699 5 143611	9 291573 14 57166 18.00926 108.8592 12 50333	0 968089 1 163509 1 255496 2 036865 1 097026	-39.3364 -39 1284 -40 2335 -45 7119	1 180.66 197.66 253.33 214.33	53 5.09375 57 5.196654 57 5.286582	20 80865 6 557439 27 46513 23 35237 130 6688 19 75686	0 816734 1 438782 1 368331 2 116172 1 295718	-44 2484 -45 204 -45 9589
		39 7 45 7 51 83333 51 22 36667	3 539993 3 681351 3 822098 3 948033 3 931826 3 107572	2.542309 7 600877 10 95628 9.26013 6.115826 7.218726 3.865661	0 405228 0 880864 1 039663 0 966617 0 786455 0 858461 0 587224	-29 4277 -30.8866 -32 009 -33 3156 -34.3323 -34.209 -27.0777	92 33333 89 66667 101 6667 171.3333 128 3333 128 3333 122 87.66667	4.525405 4.496099 4.621699 5.143611 4.854631 4.804021 4.473542	9.291573 14.57166 18.00926 108.8592 12.50333 9.192388 31.39002	0 968089 1 163509 1 255496 2 036865 1 097026 0 963428 1 496792	-39.3364 -39 1284 -40.2335 -45 7119 -42 1942	1 180.66 197.66 253.33 214.33 216.66	53 5.09375 57 5.196654 57 5.286582 33 5.534706 33 5.367532	20 80865 6 557439 27 46513 23 35237 130 6688 19 75686 16 77299	0 816734 1 438782 1 368331 2 116172 1 295718 1.224611	-44 2484 -45 204 -45 9589 -48 783 -46 6463
		39 7 45 7 51 83333 51 22 36667 23 16667	3 539993 3 681351 3 822098 3 948033 3 931826 3 107572 3 142714	2.542309 7 600877 10 95628 9 26013 6.115826 7.218726 3.865661 5.493026	0 405228 0 880864 1 039663 0 966617 0 786455 0 858461 0 587224 0 739812	-29 4277 -30.8866 -32 009 -33 3156 -34.3323 -34.209 -27.0777 -27.4571	92 33333 89 66667 101 6667 171 3333 128 3333 128 3333 122 87 66667 87 66667	4.525405 4.496099 4.621699 5.143611 4.854631 4.804021 4.473542 4.473542	9.291573 14.57166 18.00926 108.8592 12.50333 9.192388 31.39002 29.36551	0 968089 1 163509 1 255496 2 036865 1 097026 0 963428 1 496792 1 467838	-39.3364 -39 1284 -40.2335 -45 7119 -42 1942 -41.7356 -39 2129 -39 17	1 180.66 197.66 253.33 214.33 216.66 153.66 153.66 162.33	50 5 09375 57 5 196654 57 5 286582 53 5 534706 53 5 367532 57 5 37836 57 5 034786 53 5 089652	20 80865 6 557439 27 46513 23 35237 130 6688 19 75686 16 77299 32 39341 54 19717	0 816734 1 438782 1 368331 2 116172 1 295718 1,224611 1,510457 1 733977	-44 2484 -45 204 -45 9589 -46 783 -46 6463 -46 7332 -43 8584
		39 7 45 7 51 83333 51 22 36667 23 16667 25 03333	3 539993 3 681351 3 822098 3 948033 3 931826 3 107572 3 142714 3 220208	2.542309 7 600877 10 95628 9 26013 6.115826 7.218726 3.865661 5.493026 13.37174	0 405228 0 880864 1 039663 0 966617 0 786455 0 858461 0 587224 0 739812 1 126188	-29 4277 -30,8866 -32 009 -33 3156 -34 3323 -34 209 -27,0777 -27,4571 -28,7266	92 3333 89 66667 101 6667 171.3333 128 3333 122 87.66667 87.66667 88.66667	4.525405 4.496099 4.621699 5.143611 4.854631 4.804021 4.473542 4.473542 4.484884	9.291573 14.57166 18.00926 108.8592 12.50333 9.192388 31.39002 29.36551 47.35328	0 968089 1 163509 1 255496 2 036865 1 097026 0 963428 1 496792 1 467838 1 67535	-39.3364 -39 1284 -40.2335 -45 7119 -42 1942 -41 7356 -39 2129 -39 17 -39 7112	1 180.66 197.66 253.33 214.33 216.66 153.66 153.66 162.33 161.66	50 509375 51 196654 57 5286582 33 5.534706 33 5.367532 37 5.37836 37 5.034766 33 5.034786 33 5.034786 33 5.034786 33 5.085537	20.80865 6 557439 27.46513 23.35237 130.6688 19.75686 16.77299 32.39341 54.19717 87.75154	0 816734 1 438782 1 368331 2 116172 1 295718 1,224611 1,510457 1 733977 1 943255	-44 2484 -45 204 -45 9589 -48 783 -46 6463 -46 7332 -43 8584 -44 5194 -44 9512
· · · · · · · · · · ·		39 7 45 7 51 83333 51 22 36667 23 16667 25 03333 15 4	3 539993 3 681351 3 822098 3 948033 3 931826 3 107572 3 142714 3 220208 2 734368	2.542309 7.600877 10.95628 9.26013 6.115826 7.218726 3.865661 5.493026 13.37174 1.509967	0 405228 0 880864 1 039663 0 966617 0 786455 0 858461 0 587224 0 739812 1 126188 0 178967	-29 4277 -30,8866 -32,009 -33 3156 -34,3323 -34,209 -27,0777 -27,4571 -28,7266 -23,7782	923333 896667 1016667 171,333 128333 128333 122 87,66667 87,66667 88,66667 49,3333	4 525405 4 496099 4 621699 5 143611 4 854631 4 804021 4 473542 4 473542 4 484884 3 8986	9.291573 14.57166 18.00926 108.8592 12.50333 9.192388 31.39002 29.36551 47.35328 8.521678	0 968089 1 163509 1 255496 2 036865 1 097026 0 963428 1 496792 1 467838 1.67535 0 935592	-39.3364 -39 1284 -40 2335 -45 7119 -42 1942 -41 7356 -39 2129 -39 17 -39 7112 -33 9504	1 180.66 197.66 253.33 214.33 216.66 153.66 162.33 161.66	53 5.09375 57 5.196654 57 5.286582 33 5.534706 33 5.367532 37 5.37836 37 5.37836 37 5.367532 37 5.36858 33 5.034766 33 5.089652 37 5.085537 30 4.49981	20 80855 6 557439 27 46513 23 35237 130 6688 19 75686 16 77299 32 39341 54 19717 87 75154 9 165151	0 816734 1 436782 1 368331 2 116172 1 295718 1,224611 1,510457 1 733977 1,943255 0,96214	-44 2484 -45 204 -45 9589 -48 783 -46 6463 -46 7332 -43 8584 -44 5194 -44 9512 -39 1148
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295418 1 295418 1 295418 1 295418 1 295418 1 205952 1 2059519 1 295418 1 295418 1 295418 1 295418 1 295418 1 295418 1 295418 1 295418 1 295518 1 295418 1 295418 1 295418 1 295418 1 295418 1 295418 1 295518 1 295418 1 295418 1 295418 1 295418 1 295418 1 295418 1 2059518 1 295418 1 295418 1 295418 1 295518 1 295418 1 295418 1 295518 1 295518 1</td> <td>44 2484 45 204 45 2589 48 783 46 5463 46 5463 49 7332 44 5194 44 5194 44 9512 39 1148 38 4511 37 3899 42 2352 40 9887 45 5351 45 6577 45 9342 45 9368 45 9368</td>	2080665 2030667 2146513 2335237 1306688 1975686 1677299 2339341 5419717 8775154 9185151 1867679 2116601 4073082 41585151 1867679 4073082 4073082 4073082 4073082 4073082 4050103 2067519 4235957 1594783 2557944 1594783 2557944 1594783 2657994 1594783 2657994 1594783 2657994 1594783 2657994 1594783 2657994 1594783 2657994 1594783 2657994 1594783 2657994 1594783 2657994 1594783 2657994 1594783 2657994 1594785 2015978 20159778 20159778 2015977778 201597778 20159777777777	0 816734 1 368331 2 116172 1 295718 1 204592 1 205923 1 205923 1 205923 1 205923 1 205923 1 205923 1 205923 1 205952 1 205952 1 205952 1 205952 1 205955 1 2059519 1 295418 1 295418 1 2059519 1 295418 1 295418 1 295418 1 295418 1 295418 1 295418 1 205952 1 2059519 1 295418 1 295418 1 295418 1 295418 1 295418 1 295418 1 295418 1 295418 1 295518 1 295418 1 295418 1 295418 1 295418 1 295418 1 295418 1 295518 1 295418 1 295418 1 295418 1 295418 1 295418 1 295418 1 2059518 1 295418 1 295418 1 295418 1 295518 1 295418 1 295418 1 295518 1	44 2484 45 204 45 2589 48 783 46 5463 46 5463 49 7332 44 5194 44 5194 44 9512 39 1148 38 4511 37 3899 42 2352 40 9887 45 5351 45 6577 45 9342 45 9368 45 9368
		39 7 45 7 51 83333 51 22 36867 23 16667 25 03333 15 4 11 83333 19 73333 17 36667 42 1 63.8 40 36667 42 1 63.8 40 36667 42 1 63.8 40 36667 42 1 63.8 40 36667 20 1 30 63333 17 46667 20 1 30 63333 17 46667 20 1 5 28 3333 33 13333 22 53333	3 339993 3 68 1351 3 822098 3 948033 9 931826 3 107572 3 142714 3 220208 2 733388 2 617396 2 47092 2 882308 2 854553 3 55921 3 740048 4 155753 3 5698004 4 155753 3 5698004 2 892292 2 882292 2 8820291 2 882292 2 882292 2 8820294 3 420089 3 340039 3 114996	2,542309 7,600877 10,95628 9,26013 6,115826 1,827 4,93026 13,37174 1,509867 1,30747 1,8685661 1,450287 3,098925 4,728636 4,728636 4,728636 4,728636 3,732292 9,176237 4,784349 26,73955 4,298148 1,03056 1,057735 1,05775 1,	0 405228 0 880864 1 039663 0 966617 0 786455 0 858461 0 739612 1 126188 0 739612 1 126188 0 739612 1 126188 0 688319 0 617454 0 303906 0 491211 0 671976 0 962865 0 679923 1 427154 0 869411 0 4291211 0 4291211 0 429234 0 491211 0 491212 0 491211 0 491212 0 491212 0 491212 0 491212 0 491212 0 491212 0 491212 0 49121 0 49129 0 49121 0 49124 0 4	29 4277 30 8866 30 8866 31 30 8866 32 009 33 3156 34 3323 34 209 27 4571 28 7266 27 4571 28 7266 27 4571 28 7266 27 4571 28 7266 29 7215 26 0775 24 8145 29 215 25 226 26 0775 24 8145 29 215 25 225 26 0775 32 2576 33 22 557 36 105 32 2576 31 5078 32 5075 32 5075 35 50	92 33333 89 66867 101 6667 171,3333 128 3333 128 3333 128 3333 128 3333 128 358 87 66667 88 66687 49 33333 42 66667 38 8 11 6667 113 3333 104 6667 51 53333 104 6667 56 53333 59 33333 104 6667 57 666 48 118 6667 67 33333 112	4 425405 4 496099 4 621699 4 621699 4 621699 4 6854631 4 6854631 4 4854631 4 485463 3 753412 4 473542 4 473542 4 473542 4 473542 4 473542 4 473542 4 473542 4 473542 4 473542 4 473641 7 5030438 4 083171 1 74367 5 030438 4 083171 4 743051 4 1380655 3 8 71201 4 775359 4 775559 4 775559 4 775559 4 775559 4 775559 4 7755559	9 291573 14 57166 108 6592 12 50335 9 192388 31 39002 29 38551 14 57166 11 36782 24 02776 9 291573 15 30795 49 69239 172 5022 20 42874 8 660254 20 42875 10.81665 81.6272 67.85207 49.1272883 3.605551	0 968089 1 63509 2 036865 1 097026 0 963428 1 496792 1 496792 1 496792 1 496792 1 495792 1 495792 1 495792 1 495792 1 495792 1 380713 0 968089 1 184917 1 59629 1 3027531 1 302622 1 302622 1 3034093 1 911835 1 43183 1 43185 1 43185	39.384 -39 1284 -40 2335 -45 7119 -42 1942 -41 7356 -39 2129 -39 17 -39 7112 -39 7112 -39 7112 -33 35504 -33 2527 -31 8469 -32 728 -41 1086 -42 7284 -41 1086 -42 7284 -41 1086 -5504 -41 1086 -5504 -41 0042 -5504 -42 528 -42 3438 -33 7943 -42 528 -42 3438 -33 6546 -42 528 -42 3438 -33 6546 -42 528 -42 3438 -33 6546 -42 528 -42 3438 -33 6546 -42 528 -42 3438 -42 548 -42 548 -44 555 -44 55 -54 -54 -54 -54 -54 -54 -54 -54 -54 -	1 10, 55 100, 56 197, 66 197, 66 197, 66 197, 66 197, 66 197, 66 102, 33 101, 66 102, 33 101, 66 102, 33 101, 66 102, 33 115, 66 102, 33 115, 66 102, 33 115, 66 104, 35 105, 66 105, 35 105, 35 105, 66 105, 35 105, 35 10	31 5.069375 32 5.069375 33 5.069375 31 5.069375 32 5.069375 33 5.34766 33 5.34766 33 5.34766 33 5.34766 33 5.34766 33 5.34766 33 5.34766 33 5.34766 33 5.34766 33 5.34766 33 5.34766 33 5.34766 33 5.34766 33 5.34766 34 4.9981 34 4.9991 35 2.09962 35 2.1777 35 5.570866 35 5.570866 35 5.570866 36 4.56761 36 4.567614 37 7.753186 36 4.569346 36 4.569346 37 4.589346 </td <td>2080665 2030665 2746513 2335237 1306886 1975686 1677299 2339341 5419717 8419717 8419717 8419717 8419717 8419717 8419717 8419717 1887879 2116601 4073062 4073052 1201388 6337961 159478 1</td> <td>0 816734 1 436782 1 368331 2 116172 1 265718 1,224611 1,214611 1,214611 1,21425 0,98214 1,275928 1,0942255 0,98214 1,275928 1,094255 1,094255 1,095821 1,095853 1,097853 1,0978553 1,097853 1,0978553 1,0978555 1,0978555555 1,0978555555555555555555555555555555555555</td> <td>44 2484 45 2954 45 2954 46 5455 46 5455 46 7352 43 8584 44 5194 38 4611 37 3899 44 5194 38 4611 37 3899 42 2352 40 9887 45 5351 45 5351 45 6377 48 3942 41 6361 49 9088 41 6191 39 7536 41 6193 42 5401 45 61653</td>	2080665 2030665 2746513 2335237 1306886 1975686 1677299 2339341 5419717 8419717 8419717 8419717 8419717 8419717 8419717 8419717 1887879 2116601 4073062 4073052 1201388 6337961 159478 1	0 816734 1 436782 1 368331 2 116172 1 265718 1,224611 1,214611 1,214611 1,21425 0,98214 1,275928 1,0942255 0,98214 1,275928 1,094255 1,094255 1,095821 1,095853 1,097853 1,0978553 1,097853 1,0978553 1,0978555 1,0978555555 1,0978555555555555555555555555555555555555	44 2484 45 2954 45 2954 46 5455 46 5455 46 7352 43 8584 44 5194 38 4611 37 3899 44 5194 38 4611 37 3899 42 2352 40 9887 45 5351 45 5351 45 6377 48 3942 41 6361 49 9088 41 6191 39 7536 41 6193 42 5401 45 61653
		39 7 45 7 51 83333 51 23 36667 23 16667 25 03333 15 4 13 7 11 83333 19 73333 19 73333 19 73333 19 73333 19 73333 19 73333 19 73333 19 6667 20 1 30 6637 20 1 30 6637 20 1 30 6637 20 1 31 30333 31 3333 33 13333 33 13333 35 86667 25 26667	3 539993 3 68 1351 3 822098 3 948033 3 948033 3 9431826 3 107572 3 142214 3 122214 3 142214 3 142214 3 142214 3 142214 3 142214 2 73366 2 47092 2 86355 3 359217 3 359204 4 155753 3 3 74004 4 155753 3 422089 2 852552 3 422089 2 852522 2 992393 3 422089 2 892224 2 992393 3 422089 2 892224 2 992393 3 422089 2 892224 2 74084 3 3 44039 3 3 50054	2,542309 7,600877 10,95628 9,26013 6,115826 1,15826 1,15826 1,15826 1,15826 1,150967 1,188154 2,013288 1,150987	0 405228 0 450228 1 039663 0 966617 0 786455 0 858461 0 786455 0 858461 0 786455 0 858724 0 739612 1 126188 0 738612 0 74736 0 962665 0 96265 0	29 4277 30 8866 32 009 33 3156 34 3323 34 3209 27,0777 27,4571 28,7652 23,7762 23,7762 23,7762 24,8165 24,8165 24,8165 29,2115 32,2676 32,2676 32,2676 32,2676 32,2676 32,2676 32,2676 33,2676 24,9344 25,295 30,6766 31,108 36,7109 10,005 10,0	92 3333 89 6567 101 5667 171 3333 122 87 66667 87 66667 88 66667 49 3333 42 66667 38 81 59 33333 104 6667 113 3333 104 6667 153 59 33333 59 33333 57 66 48 118 6667 67 33333 118 6667 67 33333 118 267 118 267 118 267 118 27 118 27 11	4 425405 4 496099 4 621699 5 143611 4.654631 4.654631 4.473542 4.473542 4.473542 4.473542 4.473542 4.473542 4.473542 4.473542 4.473541 4.98475 4.98476 4.98371 4.715518 4.93331 4.935781 4.73559 4.725318 4.208655 3.871201 4.208655 3.871201 4.208655 3.871201 4.208655 3.871201 4.208655 3.871201 4.208655 3.871201 4.208655 3.871201 4.208655 3.871201 4.208655 3.871201 4.208655 3.871201 4.208655 4	9 291573 14 57166 18 00926 108.8592 12 50333 9 192388 31.39002 9 36551 47 35328 8 521678 47 35328 8 521678 14 57166 11 35782 37 511 4 041452 37 51 4 041452 9 291573 15 30795 49 69239 211 172 5022 20.42874 8 660254 20.2375 10.81665 81 6272 67.89207 49.9328551 261.421 0.8165551 0.8165551 0.8165551 0.8165551 0.8165551 0.8165551 0.8165551 0.81655551 0.81655551 0.81655551 0.81655551 0.81655551 0.81655551 0.81655551 0.81655551 0.81655551 0.816555555555555555555555555555555555555	0 960089 1 63500 1 255496 2 036865 1 097026 0.963428 1.496792 1.496792 1.496792 1.496792 1.496792 1.496792 1.495295 1.574147 0.606537 1.302713 0.966089 1.302713 0.936629 1.302420 0.935531 1.302420 0.935531 1.302420 0.935531 1.302420 0.935531 1.302420 0.935531 1.302420 0.935531 1.302420 0.935531 1.302420 0.935531 1.302420 0.935531 1.302420 0.935531 1.302420 0.935531 1.302420 0.935531 1.302420 0.935531 1.302420 0.935531 1.302420 0.935531 1.302420 0.935531 1.302420 0.935531 1.302420 0.935531 1.302420 0.935531 1.302420 0.9355972 2.417341 0.556972 2.417341 0.556972 2.417341 0.556972 2.417341 0.556972 2.417341 0.556972 2.417341 0.556972 2.417341 0.556972 2.417341 0.556972 2.417341 0.556972 2.417341 0.556972 2.417341 0.556972 2.417341 0.556972 2.417341 0.556972 2.417341 0.556972 2.417341 0.556972 0.5755 0.575	39.3364 39 1284 40 2335 45 7119 42.1642 39 2129 39 2129 39 917 39 712 33 5504 41 0905 41 0042 36 5504 41 0042 36 5504 41 0042 36 5504 41 0042 35 1836 5963 35 1836 5963 35 1836 5963 35 6396 36 5546 35 7653 36 5546 33 7694 42 2288 42 336 500 45 506 35 1635 50 7555 50 75555 50 7555 50 75555 50 7555 50 75555 50 75555 50 75555 50 75555 50 75555 50 75555 50 75555 50 75555 50 75555 50 755555 50 755555 50 75555555555	1 190 66 197 66 253 33 214 33 216 66 153 66 152 33 161 66 162 33 161 66 162 33 161 66 191 66 262 66 191 66 262 66 191 66 262 66 191 66 32 4 33 115 69 110 66 116 66 96 333 115 66 96 333	31 5 509375 32 5 509375 33 5 509376 31 5 266582 33 5 534706 33 5 367533 34 509376 5034766 33 5 0934766 34 509952 57836 35 509952 5034766 36 509952 75 37 5 50986 38 509952 75 39 4 49891 31 4 49891 31 4 49891 31 4 49891 31 4 49894 31 4 498542 37 5 50986 30 5 54764 30 5 54764 30 5 54764 30 5 54764 30 5 54764 <td>2080655 2352439 2746513 2335237 1306688 1975686 1677299 2339341 5419717 8775154 9185167 1887679 1887679 1887679 1887679 1897679 1997312 1201888 120188899 12018973 120188899 12018973 12018899 12018973 12018957 12018957 12018957 12018957 1594783 2557994 1594783 2557994 1594783 2067519 19971459 997159 997159715</td> <td>0 816734 1 3368331 2 116172 1 295716 1 295716 1 225716 1 225716 1 23977 1 943255 0 639277 1 203926 1 205923 1 204923 1 204923 1 204923 1 204923 1 204923 1 205922 1 205922 1 205922 1 205923 1 205923 1 205923 1 205923 1 205923 1 205923 1 205923 1 205923 1 205925 1 205955 1 205955 1 205955 1 205955 1 205955 1 205555 1 2055</td> <td>44 2484 45 204 45 2589 48 783 46 5463 46 5463 49 7332 44 5194 44 5194 44 9512 39 1148 38 4511 37 3899 42 2352 40 9887 45 5351 45 6577 45 9342 45 9368 45 9368</td>	2080655 2352439 2746513 2335237 1306688 1975686 1677299 2339341 5419717 8775154 9185167 1887679 1887679 1887679 1887679 1897679 1997312 1201888 120188899 12018973 120188899 12018973 12018899 12018973 12018957 12018957 12018957 12018957 1594783 2557994 1594783 2557994 1594783 2067519 19971459 997159 997159715	0 816734 1 3368331 2 116172 1 295716 1 295716 1 225716 1 225716 1 23977 1 943255 0 639277 1 203926 1 205923 1 204923 1 204923 1 204923 1 204923 1 204923 1 205922 1 205922 1 205922 1 205923 1 205923 1 205923 1 205923 1 205923 1 205923 1 205923 1 205923 1 205925 1 205955 1 205955 1 205955 1 205955 1 205955 1 205555 1 2055	44 2484 45 204 45 2589 48 783 46 5463 46 5463 49 7332 44 5194 44 5194 44 9512 39 1148 38 4511 37 3899 42 2352 40 9887 45 5351 45 6577 45 9342 45 9368 45 9368

Table 4.3	Cutting	in X	Y Direct	ion
Table 4.5	Culling			1011

| | eed | In speed | feed | In feed | depth
 | In depth | | Rku

 | In Rku | std Rk
 | logstd R | S/N R | ku | Ra | In Ra | std Ra
 | logstd Ra | SAN R |
|---|------|--|---|--
---|---|---
--
--
---|--|--|--
--|--|---|---|--
---|--|
| | | 1 24200 | 0.001 | 00770 | 0.001
 | -6.90776 | |

 | 0.0000070 |
 | 0.70000 | 0.00007 | | | 0.0070.43 | 2.55+050
 | 0.00000 | 20.5424 | | | |
| | 1500 | 7 31322 | | -6.90776
-6.90776 |
 | -3.91202 | |

 | 0.993252 |
 | -0.52288 | | | | |
 | 0 550358 | |
| | 1500 | 7 31322 | | |
 | | |

 | |
 | 0.428968 | | | | 3.38439 | 21,31267
 | 1.328638 | -30,6932 | | | |
| | 1500 | | | -6,90776 |
 | -2.99573 | |

 | 1.098612 |
 | | | | | 2,884801 |
 | | -25.118 |
| | 1500 | | | -5.29832 |
 | -6.90776 | |

 | |
 | 0.558027 | | | | 3,169686 |
 | 0.608874 | -27.6151 |
| | 1500 | | | -5.29832 |
 | -3,91202 | | 333333

 | 1.109662 | 0,416333
 | -0 38056 | -9.69261 | | 20.8 | 3,034953 | 5,36/495
 | 0.729772 | -26.5499 |
| | 1500 | | | | 0.001
 | | |

 | |
 | 0.572909 | | | 25.0 | 3.230374 | 2.304310
 | 0.373706 | -28.2566 |
| | | | | |
 | | | 5.9

 | 3.774952 | 3,551055
 | 0.550358 | -16,3565 | | 53333 | 3.351073 | 19, 165/6
 | 1,282979 | -30.2512 |
| | 1500 | | | | 0.02
 | -3.91202 | |

 | |
 | 0.431463 | | | | |
 | 0.423478 | -27.4213 |
| | 1500 | | 0.01 | -4 60517 |
 | -2.99573 | | 566567

 | 1.271631 | 1.069268
 | 0.029086 | -11.298 | | 22.8 | 3,126761 | 7.107742
 | 0.851732 | -27.4313 |
| | 1500 | 7 31322 | | |
 | -6.90776 | | 433333

 | 0.889262 | 0.305505
 | -0.51498 | -7.76943 | | | |
 | -0.07033 | -29.6216 |
| | 1500 | | | |
 | -3.91202 | |

 | |
 | -0.04221 | | | | 3.664416 |
 | | -32,0651 |
| | 1500 | | | |
 | -2.99573 | |

 | |
 | -0.17663 | | | | 3.596399 |
 | | -31.242 |
| | | 8 006368 | | -6.90776 |
 | -6,90776 | |

 | |
 | 0.341223 | | | 20.6 | 3.025291 | 10.64378
 | 1.027095 | -26 9887 |
| | | 8 006368 | | -6.90776 | 0.02
 | -3.91202 | 3.9 | 933333

 | 1.369487 | 1 069268
 | 0.029086 | -12.1041 | 15 | 13333 | 2.7169 | 0.152753
 | -0.81601 | 23.596 |
| | 3000 | 8 006358 | 0.001 | -6.90776 | 0.05
 | -2.99573 | 35 | \$33333

 | 1.262242 | 0.321455
 | -0.49288 | -10.9876 | 7.8 | 366667 | 2.062634 | 0.950438
 | -0.02205 | -17.9579 | | | |
| | 3000 | 8 006368 | 0 005 | |
 | -6.90776 | 6.0 |

 | |
 | 0.673209 | | | 63333 | 3 074235 | 7.550717
 | 0 877988 | -27.0416 |
| | 3000 | 8 006368 | 0 005 | -5 29832 | 0.02
 | -3.91202 | 6.0 | 666667

 | 1,802809 | 4.101626
 | 0.612956 | -16.8142 | 15 | 86667 | 2,76422 | 4,808673
 | 0 682025 | -24 2678 |
| | | 8 006368 | | -5.29832 | 0,05
 | | | 3.8

 | 1.335001 | 1 57 1623
 | 0.196348 | -12.0647 | | 112 | 2,415914 | 0.6245
 | -0 20447
0 211896 | -20.9934 |
| | | 8 006368 | 0.01 | -4 60517 |
 | | 29 | 933333

 | 1.076139 | 0.351188
 | -0.45446 | -9.38853 | 1 16 | 03333 | 2 77467 | 1.628906
 | 0 211896 | -24,1303 |
| | | 8 006368 | 0.01 | -4 60517 | 0.02
 | -3.91202 | 3.4 | 465667

 | 1,243194 | 0.723418
 | -0.14061 | -10.9225 | 18 | 03333 | 2 892222 | 1,962991
 | 0,292918 | -25,1557 |
| | | 8 006368 | | -4.60517 |
 | -2.99573 | 1 10 | 666667

 | 1.377926 | 2,193931
 | 0.341223 | -12.7746 | 15 | 23333 | 2.723488 | 1.686719
 | 0.226914 | -23.6912 |
| | | 8 006368 | | -3 91202 |
 | -6.90776 | 21 | 133332

 | 0 757686 | 0.152753
 | 0.81601 | -6.59599 | 10 | 56667 | 3.483289 | 2 186071
 | 0.377683 | -23.0312 | | | |
| | | 8 006368 | | |
 | -3 91202 | |

 | 0.587787 |
 | | -5.11438 | | | |
 | 0 752665 | -35,0466 |
| | | 8 006368 | | |
 | -2.99573 | |

 | | 0.404145
 | | -5.85085 | | | |
 | 0 779134 | -32,2616 |
| | | 8 411833 | | |
 | | |

 | |
 | | | | 10003 | 7 660900 | 0 702702
 | 0 11701 | |
| | | 8 411833 | | |
 | | | 22222

 | 1.142097 | 0.20010/
 | -0.68159 | -9.93289 | 14 | 10001 | 2.000082 | 0.103/03
 | -0.11704 | |
| | | | | |
 | | | 222223

 | 1.703389 | 3.01385/
 | 0 479123 | -16.0296 | 12 | 10000 | 2.302362 | 2.993883
 | 0.476235 | -22.4082 | | | |
| | | 8.411833 | | |
 | | |

 | 1.700586 | 4.128357
 | 0.615777 | -16,6808 | 14 | 63333 | 2.683302 | 3.390114
 | 0 131598 | -23 6829 | | | |
| | | 8 411833 | | |
 | | |

 | |
 | 0.006419 | | 16 | 40067 | 2.801338 | 2.003331
 | 0.301/53 | -24,3748 | | | |
| | | 8 41 1833 | | |
 | 3 91202 | |

 | | 0.776745
 | | | 19 | 06657 | 2 947942 | 2./46513
 | 0.438782 | -25 6652 | | | |
| | | 8.411833 | | |
 | | |

 | |
 | -0.59918 | | L | | 2.850707 |
 | | -24,7838 |
| | | 8 411833 | | |
 | | |

 | | 0.251661
 | | -9 36849 | ····· | | 2.917771 |
 | | -25,3789 |
| | | 8 411833 | | -4 60517 | 0.02
 | | |

 | |
 | -0.81601 | | 23 | 96667 | 3.176564 | 5.749203
 | 0 759608 | -27 7556 |
| | | 8.411833 | | -4 60517 | 0.05
 | | |

 | 1.029619 |
 | -0.39794 | | 21. | 36667 | 3 06 18 32 | 2.569695
 | 0.409882 | -26.6364 |
| | | 8 411833 | | | 0,001
 | -6.90776 | | 26

 | 0.955511 | 0.173205
 | -0,76144 | -8.3123 | 30 : | 26667 | 3.410047 | 1.101514
 | 0.04199 | -29.6231 |
| | 4500 | 8.411833 | 0 02 | -3 91202 | 0.02
 | -3.91202 | 3.8 | SEEET

 | 1 352303 | 0 101001
 | 0.0070.00 | 13 0103 | 20.1 | 222221 | 3.669527 | 0 048534
 | 0 007750 | -32.0554 | | | |
| | 4500 | | | |
 | | |

 | | 2.494001
 | 0.397012 | -12.0103 | | 200001 | |
 | | |
| | | 8 411833 | 0.02 | -3 91202 | 0.05
 | -2.99573 | |

 | 0.624154 |
 | 0.397012 | | | | |
 | | |
| | 1000 | 8 411833 | 0.02 | -3 91202 | 0.05
 | -2.99573 | |

 | |
 | | | | | 3 985893 |
 | | -34 6544 |
| | | | 0.02
In Rg | |
 | -2.99573
S/N Ro | 1.8 | 366667

 | 0.624154 | 0.11547
 | -0.93753 | | 53. | 83333 | 3 985893 | 5.787343
 | 0.762479 | -34 6544 |
| | | 8 411833
Rq | | | 0.05
logstd Rq
 | | 1.8 |

 | |
 | -0.93753 | -5,4324 | 53. | | |
 | | -34 6544 |
| | | Rq | In Rg | std Rq | logstd Rq
 | S/N Ro | 1.8 | 866667
Rp

 | 0.624154
In Rp | 0.11547
std Rp
 | -0.93753
logsto Rj | -5.4324
S/N Rs | 53. | 83333
Rt | 3 985893
In Rt | 5.787343
std Rt
 | 0.762479
logstd Rt | -34 6544
S/N Ri |
| | | <u>Rq</u>
18 06667 | In Rg
2.894069 | std Rq
4 135618 | 0.61654
 | S/N Ro
-22,8998 | 1.8 | 866667
Rp
52

 | 0.624154
In Rp
3.951244 | 0.11547
std Rp
12.12436
 | -0.93753
logsto Rj
1.083659 | -5.4324
S/N Rg
-34.4747 | 53 | 83333
Rt
93 | 3 985893
In Rt
4,532599 | 5.787343
std Rt
19
 | 0,762479
logstd Ri
1,278754 | -34 6544
S/N Rt
-39,4889 |
| | | Rq
18 06667
41 96667 | In Rq
2.894069
3.736876 | std Rq
4 135618
33 38298 | logstd Rq
0.61654
1 523525
 | S/N Ro
-22,8998
-33.6521 | 1.8 | 866667
Rp
52
184

 | 0.624154
In Rp
3.951244
5.214936 | 0.11547
std Rp
12.12436
178.404
 | -0.93753
logstd Rj
1.083659
2.251405 | -5.4324
S/N Rs
-34.4747
-47.4095 | 270 | 83333
Rt
93
0.6667 | 3 985893
In Rt
4,532599
5 600888 | 5.787343
std Rt
19
196.6223
 | 0.762479
logstd Rt
1.278754
2.293633 | -34.6544
S/N Rt
-39,4889
-49,9578 |
| | | Rq
18 06667
41 96667
22 53333 | In Rq
2.894069
3.736876
3.114996 | std Rq
4 135618
33.38298
3 239341 | logstd Rq
0.61654
1 523525
0.510457
 | S/N Ro
-22,8998
-33.6521
-24.9558 | 1.8 | 866667
Rp
52
184
33333

 | 0.624154
In Rp
3.951244
5.214936
4.179502 | 0.11547
std Rp
12.12436
178.404
15.14376
 | -0.93753
logstd Rj
1.083659
2.251405
1.180234 | -5,4324
S/N Rg
-34,4747
-47,4095
-38,4555 | 270 | 83333
Rt
93
0 6667
126 | 3 985893
In Rt
4 532599
5 600888
4 836282 | 5.787343
std Rt
19
196.6223
17.4356
 | 0.762479
logstd Ri
1.278754
2.293633
1.241437 | -34 6544
S/N Rt
-39,4889
-49,9578
-42,0625 |
| | | Rq
18 06667
41 96667
22 53333
33 16667 | In Rq
2.894069
3.736876
3.114996
3.501545 | std Rq
4 135618
33.38298
3 239341
10.37368 | logstd Rq
0.61654
1 523525
0 510457
1 015933
 | S/N Ro
-22,8998
-33.6521
-24.9558
-29.5836 | 65 | 866667
Rp
52
184
33333
134

 | 0.624154
In Rp
3.951244
5.214936
4.179502
4.89784 | 0.11547
std Rp
12.12436
178.404
15.14376
97.8928
 | -0.93753
logsto Rj
1.083659
2.251405
1.180234
1.990751 | -5,4324
S/N Rg
-34,4747
-47,4095
-38,4555
-43,864 | 270 | 83333
Rt
93
0 6667
126
250 | 3 985893
In Rt
4 532599
5 600888
4 836282
5 521461 | 5.787343
std Rt
19
196.6223
17.4356
171.7091
 | 0.762479
logstd Rt
1.276754
2.293633
1.241437
2.234793 | -34.6544
S/N Rt
-39.4889
-49.9578
-42.0625
-49.1464 |
| | | Rq
18 06667
41 96667
22 53333
33 16667
26 16667 | In Rq
2 894069
3 736876
3 114996
3 501545
3 264486 | std Rq
4 135618
33.38298
3 239341
10.37368
6.85298 | 0.61654
1 523525
0.510457
1.015933
0.835879
 | S/N Ro
-22,8998
-33.6521
-24.9558
-29.5836
-25.5047 | 18
65
75 | 866667
Rp
52
184
33333
134
66667

 | 0.624154
In Rp
3.951244
5.214936
4.179502
4.89784
4.326338 | 0.11547
std Rp
12.12436
178.404
15.14376
97.8928
35,10461
 | -0.93753
logstd Ry
1.083659
2.251405
1.180234
1.990751
1.545364 | -5.4324
S/N Rg
-34.4747
-47.4095
-38.4555
-43.864
-38.1604 | 270 | 83333
Rt
93
0 6667
126
250
4 3333 | 3 985893
In Rt
4,532599
5 600888
4 836282
5.521461
4.972125 | 5.787343
std Rt
19
196.6223
17.4356
171.7091
47.07795
 | 0.762479
logstd R(
1.276754
2.293633
1.241437
2.234793
1.672818 | -34,6544
S/N Rt
-39,4889
-49,9578
-42,0625
-49,1464
-43,4849 |
| | | Rq
18 06667
41 96667
22 53333
33 16667
26 16667
35 46667 | In Rq
2.894069
3.736876
3.114996
3.501545
3.264486
3.568593 | std Rq
4 135618
33.38298
3 239341
10.37368
6.85298
8 451233 | 0.61654
1 523525
0.510457
1.015933
0.835879
0.92692
 | S/N Rc
-22,8998
-33.6521
-24.9558
-29.5836
-25.5047
-29.8415 | 1 8
65
75
133 | 866667
Rp
52
184
33333
134
66667
5.6667

 | 0.624154
In Rp
3.951244
5.214936
4.179502
4.89784
4.326338
4.910201 | 0.11547
std Rp
12.12436
178.404
15.14376
97.8928
35,10461
97.04295
 | -0.93753
logstd Rj
1.083659
2.251405
1.180234
1.990751
1.545364
1.986964 | -5.4324
S/N Rg
-34.4747
-47.4095
-36.4555
-43.864
-38.1604
-43.9241 | 270 | 83333
Rt
93
0 6667
126
250
4 3333 | 3 985893
In Rt
4,532599
5 600888
4 836282
5.521461
4.972125 | 5.787343
std Rt
19
196.6223
17.4356
171.7091
47.07795
 | 0.762479
logstd R(
1.276754
2.293633
1.241437
2.234793
1.672818 | -34,6544
S/N Rt
-39,4889
-49,9578
-42,0625
-49,1464
-43,4849
-49,2984 |
| | | Rq
18 06667
41 96667
22 53333
33 16667
26 16667
35 46667
40 6 | In Rq
2.894069
3.736876
3.114996
3.501545
3.264486
3.568593
3.703768 | std Rq
4 135618
33.38298
3 239341
10.37368
6.85298
8 451233
30.51278 | logstd Rq
0.61654
1 523525
0.510457
1 015933
0.835879
0.92692
1.484482
 | S/N R
-22,8998
-33,6521
-24,9558
-29,5836
-25,5047
-29,8415
-25,5495 | 1 8
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133 | 866667
Rp
52
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 | 0.624154
In Rp
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5.214936
4.179502
4.89784
4.326338
4.910201
5.28151 | 0.11547
std Rp
12.12436
178.404
15.14376
97.8928
35.10461
97.04295
200.8291
 | -0.93753
logstd Rj
2.251405
1.180234
1.990751
1.545364
1.986964
2.302827 | -5.4324
S/N Rg
-34.4747
-47.4095
-36.4555
-43.864
-38.1604
-43.9241
-48.1668 | 53.1
270
270
144
307 | 83333
Rt
93
0 6667
126
250
4 3333
259
7 6667 | 3 985893
In Rt
4,532599
5 600888
4 836282
5.521461
4.972125
5.556828
5.729017 | 5.787343
std Rt
19
196.6223
17.4356
171.7091
47.07795
164.3158
259.7197
 | 0,762479
logstd R(
2,293633
1,241437
2,234793
1,672818
2,21569
2,414505 | -34,6544
S/N Rt
-39,4889
-49,9578
-42,0625
-49,1464
-43,4849
-49,2984
-51,4497 |
| | | Rq
18 06667
41 96667
22 53333
33 16667
26 16667
35 46667
40 6
31 76667 | In Rq
2 894069
3 736876
3 114996
3 501545
3 264486
3 568593
3 703768
3 458418 | std Rq
4 135618
3338298
3 239341
10.37368
6.85298
6 451233
30.51278
6 724086 | logstd Rq
0.61654
1 523525
0 510457
1 015933
0.835879
0.92692
1.484482
0.827633
 | S/N R
-22,8998
-33,6521
-24,9558
-29,5836
-25,5047
-29,8415
-25,5495
-28,8565 | 1 8
65
75
133 | 866667
Rp
52
184
33333
134
66667
5.6667
6.6667
103

 | 0.624154
In Rp
3.951244
5.214936
4.179502
4.89784
4.326338
4.910201
5.28151
4.634729 | 0.11547
std Rp
12.12436
178.404
15.14376
97.8928
35.10461
97.04295
200.8291
69.63476
 | -0.93753
logstd Rj
2.251405
1.180234
1.990751
1.545364
1.986964
2.302827
1.842826 | -5.4324
S/N Rg
-34.4747
-47.4095
-36.4555
-43.864
-38.1604
-43.9241
-48.1668
-41.4119 | 270
270
144
307 | 83333
Rt
93
0 6667
126
250
4 3333
259
7 6667
187 | 3 985893
In Rt
4,532599
5 600888
4 836282
5 521461
4 972125
5 556828
5 5729017
5.231109 | 5.787343
std Rt
19
196.6223
17.4356
171.7091
47.07795
164.3198
259.77348
 | 0,762479
logstd R(
2,293633
1,241437
2,234793
1,672818
2,21569
2,414505
1,775053 | -34,6544
S/N Rt
-39,4889
-49,9578
-42,0625
-49,1464
-43,4849
-49,2984
-51,4497
-45,7212 |
| | | Rq
18 06667
41 96667
22 53333
33 16667
26 16667
35 46667
40 6
31 76667
30 63333 | In Rq
2.894069
3.736876
3.114996
3.501545
3.264486
3.568593
3.703768
3.458418
3.422089 | std Rq
4 135618
33 38298
3 239341
10.37368
6 85298
6 451233
30 51278
6 724086
12.3553 | logstd Rq
0.61654
1 523525
0.510457
1 015933
0.835879
0.92692
1.484482
0.827633
1.091853
 | S/N Rc
-22,8998
-33,6521
-24,9558
-29,5836
-25,5047
-29,8415
-25,5495
-25,5495
-25,5495
-25,6604 | 1 8
65
75
133 | 866667
Rp
52
184
33333
134
66667
5 6667
5 6667
6 6667
103
76

 | 0.624154
In Rp
3.951244
5.214936
4.179502
4.89784
4.326338
4.910201
5.28151
4.634729
4.330733 | 0.11547
std Rp
12.12436
178.404
15.14376
97.8928
35.10461
97.04295
200.8291
69.63476
30.34798
 | 0.93753
logstd Ri
1.083659
2.251405
1.180234
1.990751
1.545364
1.986964
2.302827
1.842826
1.48213 | -5.4324
S/N Rg
-34.4747
-47.4095
-36.4555
-43.864
-38.1604
-43.9241
-48.1668
-41.4119
-38.055 | 270
270
144
307
180 | 83333
Rl
93
0 6667
126
250
4 3333
259
7 6667
187
0 3333 | 3 985893
In Rt
4 532599
5 600888
4 836282
5 521461
4 972125
5 556828
5 729017
5 231109
5 194807 | 5.787343
std Rt
19
196.6223
17.4356
171.7091
47.07795
164.3198
259.71348
88.93443
 | 0.762479
logstd Rt
1.278754
2.293633
1.241437
2.234793
1.672818
2.21569
2.414505
1.775053
1.94907 | -34,6544
S/N Rt
-39,4889
-49,9578
-42,0625
-49,1464
-43,4849
-49,2984
-51,4497
-45,7212
-45,7212 |
| | | Rq
18 06667
41 96867
22 53333
33 16667
26 16667
35 46667
40 6
31 76667
30 63333
36 03333 | In Rq
2 894069
3 736876
3 114996
3 501545
3 264486
3 568593
3 703768
3 458418
3 422089
3 584444 | std Rq
4 135618
33 38298
3 239341
10.37368
6.85298
6.451233
30.51278
6.724086
12.3553
1.750238 | 0.61654
1.523525
0.510457
1.015933
0.835879
0.92692
1.484482
0.827633
1.091853
0.243097
 | S/N Rc
-22,8998
-33,6521
-24,9558
-29,5836
-25,5047
-29,8415
-25,5495
-28,8565
-28,8565
-25,6604
-29,5822 | 1.8
1.8
5
75
132
192 | 866667
Rp
52
184
33333
134
66667
5 6667
5 6667
6 6667
103
76
110

 | 0.624154
In Rp
3 951244
5 214936
4 179502
4.89784
4 326338
4 910201
5 28151
4.634729
4.330733
4.70048 | 0.11547
std Rp
12.12436
178.404
15.14376
97.8928
35.10461
97.04295
200.8291
69.63476
69.63476
63.34798
6.557439
 | 0.93753
logstd Ri
1.083659
2.251405
1.180234
1.990751
1.545364
1.986964
2.302827
1.842826
1.48213
0.816734 | -5.4324
S/N Rg
-34.4747
-47.4095
-38.4555
-43.864
-38.1604
-43.9241
-48.1688
-41.4119
-38.055
-40.8381 | 270
270
144
307
180
177 | 83333
Rl
93
0 6667
126
250
4 3333
259
7 6667
187
0 3333
7 6667 | 3 985893
In Rt
4 532599
5 600888
4 836282
5 521461
4 972125
5 556828
5 729017
5 231109
5 194807
5 194807
5 19909 | 5.787343
std Rt
19
196.6223
17.4356
171.7091
47.07795
164.3188
259.7197
59.57348
88.93443
15.37314
 | 0.762479
logstd Rt
1 276754
2.293633
1.241437
2.234793
1.672818
2.21569
2.414505
1.775053
1.94907
1.186762 | -34 6544
S/N Ri
-39,4889
-49,9578
-42,0625
-49,1464
-43,4849
-49,2984
-51,4497
-45,7212
-45,7741
-45,0137 |
| | | Rq
18 06667
41 96667
22 5333
33 16667
26 16667
35 46667
40 6
31 76667
30 63333
36 03333
46 63333 | In Rq
2 894069
3 736876
3 501545
3 264486
3 568593
3 703768
3 422089
3 584444
3 842316 | std Rq
4 135618
33.38298
3 239341
10.37368
6.85298
6.451233
30.51278
6.724086
12.3553
1.750238
11.82765 | logstd Rq
0.61654
1.523525
0.510457
1.015933
0.835879
0.92692
1.484482
0.827633
1.091853
0.243097
1.072899
 | S/N Rc
-22,8998
-33.6521
-24.9558
-29.5836
-25.5047
-29.8415
-25.5495
-25.6604
-29.5822
-30.7508 | 1.8
1.8
5
75
132
192 | 866667
Rp
52
184
33333
134
65667
5 6667
6 6667
103
76
110
9 6667

 | 0.624154
In Rp
3.951244
5.214936
4.179502
4.89784
4.326338
4.910201
5.28151
4.634729
4.330733
4.70048
4.78471 | 0.11547
std Rp
12.12436
178.404
15.14376
97.8928
35.10461
97.04295
200.8291
69.63476
30.34798
36.557439
35.07611
 | 0.93753
logstd Rj
2.251405
1.180234
1.990751
1.545364
1.986964
2.302827
1.842826
1.48213
0.816734
1.545011 | -5.4324
S/N Rg
-34.4747
-47.4095
-38.4555
-43.864
-38.1604
-43.9241
-48.1668
-41.4119
-38.055
-38.051
-40.8381
-41.8014 | 53.
270
270
144
307
180
177
217 | 83333
Rt
93
0 6667
126
250
4 3333
259
7 6667
187
0 3333
7 6667
7 6667 | 3 985893
In Rt
4,532599
5 600888
4 836282
5 521461
4,972125
5 556828
5 729017
5 231109
5 179099
5 1382965 | 5.787343
stid Rt
19
196.6223
17.4356
171,7091
164.3188
259.7197
59.57348
88.93443
15.37314
28.0238
 | 0.752479
logstd R(
1.276754
2.293633
1.241437
2.234793
1.672818
2.21569
2.414505
1.775053
1.94907
1.186762
1.447527 | -34 6544
S/N R
-39,4689
-49,9578
-42,0625
-49,1464
-43,4649
-49,2084
-51,4497
-45,7212
-45,7712
-45,7713
-46,8038 |
| | | Rq
18 06667
41 96667
22 53333
33 16667
26 16667
35 46667
40 6
31 76667
30 63333
36 03333
36 03333
46 63333
46 1 | In Rq
2.894069
3.736876
3.114996
3.501545
3.264486
3.568593
3.703768
3.458418
3.422089
3.584444
3.842316
3.830813 | std Rq
4 135618
33 38298
3 239341
10.37368
6 451233
30.51278
6 724086
12.3553
1.750238
11.82765
0.9 | 109std Rq
0.61654
1 523525
0.510457
1 015933
0.836879
0.92692
1.484482
0.827633
1.091853
0.243097
1 072899
-0.04576
 | S/N Rc
-22,8998
-33,6521
-24,9558
-29,5836
-25,5047
-29,8415
-25,5495
-28,8565
-25,6604
-29,5822
-30,7508
-31,5979 | 1.8
65
75
133
19
19 | 866667
Rp
52
184
33333
134
66667
56667
103
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 | 0.624154
 | 0.11547
std Rp
12.12436
178.404
15.14376
97.8928
35.10461
97.04295
200.8291
69.63476
30.34798
6.557439
35.07611
 | 0.93753
logstd Rj
1.083659
2.251405
1.180234
1.990751
1.545364
1.986964
2.302827
1.842826
1.48213
0.816734
1.545011
0.784101 | -5.4324
S/N Rg
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1		1500	7 31322	0 001	-6 90776	0 001	-6 90776	3 666667	1 299283	0 832666	-0.07953	-11.4322	15.5	2,74084	3.214032	0.50705	-23 9294
		1500			-6.90776		-3 91202		1.955389						11 92323		
		1500	7 31322		-6.90776	0.05			1.386294			-12.4204	15.46667	2.738687	3,056687	0.485251	-23 8996
		1500	7 31322	0.005	-5.29832	0 001	-6.90776	3,433333	1.233532	1.101514	0.04199	-11.0026	21.46667	3.066501	1.861003	0.269747	-26 657
		1500	7 31322	0.005					1.064711	0,1	.1	-9.2514	21 23333		2.203026		
		1500	7 31322			0.05			1.087439			-9.44976	23,4	3.152736	0.173205	-0.76144	-27.3845
1.		1500	7 31322	0.01	-4.60517	0 001			1.243194			-10.9038	17.83333	2.851069	5.085601	0.706342	-25 2539
		1500	7 31322	0.01	-4 60517 -4 60517	0.02	-3 91202 -2 99573	3 222027	1.098612	0.34641	-0.46041	-9.58086 -18.6285			2 809508		
		1500	7 31322 7 31322	0.01		0.001		7.200007	0.980829	0.493020	-0.39346				2.95973		
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		1500	7 31322			0.05			0.861482			-7.5868	45.2	3.811097	5.6	0.748188	-33 147
		3000	8 006368	0 001			-6.90776	3.033333	1,109662	0.321455	-0.49288	-9.6708	16.23333	2.787067	5.331354	0.726838	-24 5097
		3000			-6.90776	0.02		8 233333	2 108191	7.43931	0 871533		12,96667	2 562382	6 703979	0 826333	-22.9688
		3000			-6.90776	0.05	-2.99573		1.317301						0 757188	-0.1208	-15 5129
1.						0.001			1.223775				12-8	2.549445	1.74356	0 241437	-22 1976
			8 006368			0.02		5.200007	1.661398	1.858315	0.209119	-14.777	18.3333	2.557227	12.30523	0.592488	-20 4000
			8 006368			0.001			0.96825			-8.42817			2.354428		
-			8.006368			0.02			2.147879				20.6	3.025291	2.330236	0.3674	-26.3142
1			8 006368		-4 60517	0 05			1.131402						7.557998		
1		3000	8 006368		-3 91202		-6.90776	2,533333	0,929536	0.404145	-0.39346	-8.14691	27.56667	3.316607	3.073001	0,487563	-28 8435
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1.			8 006368			0.05			0.606136						4 966219		
			8 411833	0.001					1.629241	3.204684	0.505785	-15.1662			3,797806		-24 312
			8 411833 8 411833					5.633333	1,728701	0.251525	-0 59918				1.800926		
			8 411833						1.076139				16 86567	2 825330	3 415162	0.533411	-24 6577
			8 411833	0 005		0.02	-3 91202		2.128232				20 96667	3.042934	7 276217	0.861906	-26.766
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		4000	0411033	0,02	-3.91202	0.03	-2 99313	2 000007	0.900029	1.50111	0.170413	18.55171	30,80007	4 042400	5000141	0 004270	-33 1041
			Rq	In Rg	std Rq	log std Rq	S/N Rq	Rp	In Rp	std Rp	logstd	S/N Rp	Rt	In Rt	std Rt	log std Rt	S/N Rt
			10 00007	0.050070													
-		. 1												1 4 660000	17 200301	1 242002	
1.						1,181844			3.951244	179 4461	0.69897	-34.3468			17.50238		
			27 46667	3 312973	25 06 199	1 130334	-30 6935	144	4.969813		2 251507	-46.2288	201 6567	5.306616	209.0223	2.320193	-48 4383
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5241547 5 189246 5 1	3536948 2247962, 247962, 286751 3318132, 781025, 7410128, 74312, 761025, 74312, 761025, 773174, 7007466, 7007466, 7007466, 7007466, 7007466, 7007466, 7007466, 7007466, 7007466, 7007466, 7007466, 7007466, 7007466, 7007466, 7007466, 700746, 700746, 700746, 700746, 700746, 8077247, 710411, 710411, 712041, 712041, 712041, 712041, 712041, 712041, 712041, 712041, 712041, 712041, 712041,	2 251507 1 548629 1 548629 1 52054 0 460409 1 520894 0 682065 1 869826 1 067301 1 574869 1 16823 1 067301 1 574869 1 16823 2 321259 1 302653 2 321259 1 45826 0 477121 2 036609 1 725202 0 619441 1 725202 0 619441 1 594635 1 04159 1 20449 1 151598 2 114512 1 378318 1 419529 1 46822 1 48626 1 49056 1 490566 1 490566 1 4	46 2288 37 5846 39 3845 39 3845 39 3845 39 3845 34 3849 41 6067 41 0413 41 6067 41 0413 41 6067 41 0413 41 6067 41 0413 41 6062 27 8438 35 8111 45 9628 27 8438 35 8111 35 8111 35 8111 35 8111 35 812 35 812 46 257 38 8675 40 2186 36 1841 33 8051 33 8051 34 8051 35 8051555555555555555555	201 667 128 157 3333 153 333 165 3333 106 3333 106 687 204 6667 212 6667 237 6667 96 33333 244 6667 123 6667 123 6667 123 6667 123 6667 123 6667 123 6667 124 6667 124 6667 122 6667 123 333 174 3333 174 335 174 374 374 175 774 175 77	5.306616 4.85203 5.058367 5.010635 5.113994 4.915103 4.915103 4.921509 5.31812 5.31812 5.31812 5.31812 5.31812 5.359726 5.470489 4.724932 5.4710469 4.724932 4.724932 4.724932 4.724932 4.724932 4.726989 4.557814 5.699896 5.821072 5.109896 5.821072 5.109896 5.821072 5.009896 5.821072 5.009896 5.821072 5.009896 5.821072 5.009896 5.821072 5.009896 5.821072 5.009896 5.821072 5.009896 5.821072 5.009896 5.507211 5.008411 5.008411 5.008411 5.008411 5.008411 5.008411 5.008411 5.008411 5.008411	209 0223 44 91102 21 38535 16 46208 3785039 47 07795 17 80786 28 63776 34 07834 40 45162 23 35237 33 71943 251 2449 11 37248 253 2594 58 07753 10 167 8164 64 08527 7 81025 122 7694 41 25934 98 89557 7 81025 122 7694 41 25934 98 89557 7 81025 122 7694 122 7694 122 7694 125 76909 13 12623 126 6957 7 81025 127 7890 127 7800 127 78000 127 78000 127 7800000000000000000000000000000000000	2 320193 1 652353 1 652353 1 330116 2 16485 0 578174 1 216485 0 578174 1 252801 1 917179 1 532478 1 362331 1 362331 1 362356 1 362356 1 92472 0 932655 1 92472 0 932655 1 92472 0 932655 1 92472 0 932655 1 92472 0 932655 1 92472 0 932655 2 08909 1 155221 1 995177 1 470099 1 344655 2 217562 1 97562 1 975762 1 97562 1 97562 1 975762 1 97562 1 975762 1 976762 1 97676 1 976767 1 976767 1 976767 1 97676 1 976767 1	$\begin{array}{c} 46 & 4363\\ 42 & 4869\\ 43 & 5566\\ 43 & 5566\\ 44 & 2011\\ 43 & 0242\\ 40 & 2324\\ 40 & 2324\\ 40 & 2324\\ 40 & 2324\\ 40 & 2324\\ 40 & 2324\\ 40 & 2324\\ 40 & 2324\\ 40 & 2324\\ 40 & 2324\\ 40 & 2324\\ 40 & 2324\\ 40 & 2324\\ 40 & 2324\\ 40 & 2324\\ 41 & 4365\\ 41 & 3665\\ 41 & 3655\\ 41 & 3024\\ 41 & 3665\\ 41 & 3024\\ 43 & 0156\\ 43 & 0156\\ 43 & 0156\\ 43 & 0156\\ 43 & 0156\\ 44 & 186\\ 43 & 0156\\ 44 & 186\\ 44 & 186\\ 43 & 05562\\ 44 & 967\\ 44 &$

Table 4.4 Cutting in Y Direction

speed	feed	depth		In speed				In Favg	stdev	logstdev	S/N Ratio	Favg
1500	0.001	0.001	64.11	7.31	-6.91	-6.91	4.16	2.93	8.933	0.950997	-26.355	18.78
3000	0.001	0.001	64.96	8.01	-6.91	-6.91	4.17	3.38	10.07	1.003029	-29.82	29.31
4500	0.001	0.001	80.22	8.41	-6.91	-6.91	4.38	3.55	14.06	1.147985	-31.44	34.65
1500	0.001	0.02	93.34	7.31	-6.91	-3.91	4.54	3.59	20.67	1.31534	-32.42	36.34
3000	0.001	0.02	177.01	8.01	-6.91	-3.91	5.18	4.10	26.41	1.421768	-36.36	60.34
4500	0.001	0.02	122.45	8.41	-6.91	-3.91		4.65	5.7	0.755875	-40.38	104.37
1500	0.001	0.05	71.6	7.31	-6.91	-3.00	4.27	3.36	8.15	0.911158	-29.49	28.71
3000	0.001	0.05	36.76	8.01	-6.91	-3.00	3.60	3.16	9.62	0.983175	-28.09	23.5
4500	0.001	0.05	23.36	8.41	-6.91	-3.00	3.15	2.69	2.13	0.32838	-23.46	14.75
1500	0.005	0.001	108.39	7.31	-5.30	-6.91	4.69	4.32	8.94	0.951338	-37.62	75.51
3000	0.005	0.001	138.46	8.01	-5.30	-6.91	4.93	4.33	16.6	1.220108	-37.84	76.22
4500	0.005	0.001	118.94	8.41		-6.91	4.78	4.52	11.25		-39.33	91.97
1500	0.005	0.02	84.46	7.31		-3.91	4.44	3.67	16.81	1.225568	-32.6	39.31
3000	0.005	0.02	134.87	8.01	-5.30	-3.91	4.90	4.45	23.66	1.374015	-38.98	85.77
4500	0.005	0.02	149.6	8.41	-5.30	-3.91	5.01	4.71	8.82	0.945469	-40.96	111.5
1500	0.005	0.05	70.18	7,31	-5.30	-3.00	4.25	3.68	8.16	0.91169	-32.12	39.55
3000	0.005	0.05	68.57	8.01	-5.30	-3.00	4.23	3.31	13.89	1.142702	-29.76	27.49
4500	0.005	0.05	31.84	8.41	-5.30	-3.00	3.46	2.71	6.89	0.838219	-24.36	15.06
1500	0.01	0.001	110.92	7.31	-4.61	-6.91	4.71	4.34	8.61	0.935003	-37.71	76.38
3000	0.01	0.001	130.12	8.01	-4.61	-6.91	4.87	4.37	17.47	1.242293	-38.14	78.91
4500	0.01	0.001	109.57	8.41	-4.61	-6.91	4.70	4.55	9.88	0.994757	-39.6	95.01
1500	0.01	0.02	90.97	7.31	-4.61	-3.91	4.51	3.78	18.16	1.259116	-33.48	43.62
3000	0.01	0.02	129.25	8.01	-4.61	-3.91	4.86	4.46	24.07	1.381476	-39.08	86.77
4500	0.01	0.02	133.06	8.41	-4.61	-3.91	4.89	4.70	5.22	0.717671	-40.87	110.48
1500	0.01	0.05	71.45	7.31	-4.61	-3.00	4.27	3.71	8.67	0.938019	-32.45	41.04
3000	0.01	0.05	64.64	8.01	-4.61	-3.00	4.17	3.36	12.21	1.086716	-29.92	28.9
4500	0.01	0.05	43.47	8.41	-4.61	-3.00	3.77	2.63	7.95	0.900367	-24.04	13.85
1500	0.02	0.001	75.07	7.31	-3.91	-6.91	4.32	4.23	5.385	0.731186	-36.8	68.57
3000	0.02	0.001	95.45	8.01	-3.91	-6.91	4.56	4.33	16.09	1.206556	-37.8	75.98
4500	0.02	0.001	134.85	8.41	-3.91	-6.91	4.90	4.66	10.34	1.014521	-40.5	105.45
1500	0.02	0.02	61.22	7.31	-3.91	-3.91	4.11	3.74	22.06	1.343606	-33.55	42.23
3000			90.57	8.01	-3.91	-3.91	4.51	4.21	25.32	1.403464	-37.17	67.65
4500	0.02	0.02	129.39	8.41	-3.91	-3.91	4.86	4.57	8.2	0.913814	-39.7	96.33
1500	0.02	0.05	22.56	7.31	-3.91	-3.00	3.12	2.75	1.21	0.082785	-23.93	15.68
3000	0.02	0.05	22.81	8.01	-3.91	-3.00	3.13	2.72	4.04	0.606381	-24.1	15.2
4500	0.02	0.05	60.84	8.41	-3.91	-3.00	4.11	3.25	9.97	0.998695	-28.79	25.8

Table 4.6	Cutting	in XY	Direction

speed	feed	depth	Fmax	In speed	In feed	In depth	In Fmax	In Favg			S/N Ratio	and the second sec
1500	0.001	0.001	92.31	7.31	-6.91	-6.91	4.53	3.46	13.39	1.13	-30.78	31.92
1500	0.001	0.02	118.08	7.31	-6.91	-3.91	4.77		and the second sec		-32.30	A
1500	0.001	0.05	58.85	7.31	-6.91	-3.00	4.07	3.44	7.05	0.85	-30.10	31.21
1500	0.005	0.001	111.44	7.31	-5.30	-6.91	4.71	4.26	9.22	0.96	-37.08	70.93
1500	0.005	0.02	107.603	7.31	-5.30	-3.91	4.68	3.62	16.67	1.22	-32.21	37.25
1500	0.005	0.05	82.58	7.31	-5.30	-3.00	4.41	3.64	7.71		-31.79	38.09
1500	0.01	0.001	112.99	7.31	-4.61	-6.91	4.73	4.36	7.32	0.86	-37.93	78.46
1500	0.01	0.02	137.62	7.31	-4.61	-3.91	4.92	3.83	19.07	1.28	-33.95	
1500	0.01	0.05	95.8	7.31	-4.61	-3.00	4.56	3.63	12.23	1.09	-31.95	37.63
1500	0.02	0.001	81.42	7.31	-3.91	-6.91	4.40	4.28	5.61	0.75	-37.19	72.14
1500	0.02	0.02	119.88	7.31	-3.91	-3.91	4.79	3.80	27.54	1.44	-34.41	44.77
1500	0.02	0.05	31.14	7.31	-3.91	-3.00	3.44	2.98	5.79	0.76	-26.26	19.74
3000	0.001	0.001	84.19	8.01	-6.91	-6.91	4.43	3.59	15.74	1.20	-31.00	36.38
3000	0.001	0.02	105.59	8.01	-6.91	-3.91	4.66	4.11	25.28	1.40	-36.42	· · · · · · · · · · · · · · · · · · ·
3000	0.001	0.05	64.18	8.01	-6.91	-3.00	4.16	3.18	12.00	1.08	-28.61	24.16
3000	0.005	0.001	137.26	8.01	-5.30	-6.91	4.92	4.26	17.77	1.25	-31.98	70.85
3000	0.005	0.02	143.67	8.01	-5.30	-3.91	4.97	4.36	25.03	1.40	-38.28	78.22
3000	0.005	0.05	76.26	8.01	-5.30	-3.00	4.33	3.21	15.60	1.19	-29.31	24.75
3000	0.01	0.001	126.67	8.01	-4.61	-6.91	4.84	4.39	17.32	1.24	-38.32	80.59
3000	0.01	0.02	173.81	8.01	-4.61	-3.91	5.16	4.48	24.21	1.38	-39.20	87.97
3000			73.91	8.01	-4.61	-3.00	4.30	3.48	14.50	1.16	-30.98	32.33
3000	0.02	0.001	99.39	8.01	-3.91	-6.91	4.60	4.31	16.55	1.22	-37.68	74.76
3000	0.02	0.02	89.81	8.01	-3.91	-3.91	4.50	4.16	23.05	1.36	-36.66	64.07
3000	0.02	0.05	20.37	8.01	-3.91	-3.00	3.01	2.81	2.17	0.34	-24.52	16.69
4500	0.001	0.001	68.69	8.41	-6.91	-6.91	4.23	3.77	15.07	1.18	-33.22	43.28
4500	0.001	0.02	115.23	8.41	-6.91	-3.91	4.75	4.66	5.37	0.73	-40.46	105.39
4500	0.001	0.05	62.49	8.41	-6.91	-3.00	4.14	2.78	8.69	0.94	-25.26	16.176
4500	0.005	0.001	121.475	8.41	-5.30	-6.91	4.80	4.40	15.16	1.18	-38.37	81.55
4500	0.005	0.02	150.67	8.41	-5.30	-3.91	5.02	4.72	9.49	0.98	-40.98	111.68
4500	0.005	0.05	66.61	8.41	-5.30	-3.00	4.20	2.80	12.13	1.08	-26.21	16.52
4500	0.01	0.001	132.22	8.41	-4.61	-6.91	4.88	4.62	11.24	1.05	-40.16	101.33
4500	0.01	0.02	152.01	8.41	-4.61	-3.91	5.02	4.75	8.82	0.95	-41.28	115.69
4500	0.01	0.05	53.88	8.41	-4.61	-3.00	3.99	2.88	13.05	1.12	-26.87	17.81
4500	0.02	0.001	126.12	8.41	-3.91	-6.91	4.84	4.67	10.31	1.01	-40.59	106.55
4500	0.02	0.02	141.03	8.41	-3.91	-3.91	4.95	4.74	8.50	0.93	-41.22	114.88
4500	0.02	0.05	61.28	8.41	-3.91	-3.00	4.12	3.21	13.94	1.14	-28.91	24.76

speed		depth		In speed	In feed	In depth	In Fmax	In Favg	stdev	logstdev	S/N Ratio	Favg
1500	0.001	0.001	111.37	7.31	-6.91	-6.91	4.71	4.01	13.76	1.138618	-35.12	55.38
3000	0.001	0.001	121.19	8.01	-6.91	-6.91	4.80	3.93	18.76	1.273233	-34.65	50.7
4500	0.001	0.001	77.83	8.41	-6.91	-6.91	4.35	4.00	14.12	1.149835	-35.01	54.54
1500	0.001	0.02	114.34	7.31	-6.91	-3.91	4.74	3.61	22.17	1.345766	-32.66	36.83
3000	0.001	0.02	138.34	8.01	-6.91	-3.91	4.93	4.30	27.66	1.441852	-37.9	73.61
4500	0.001	0.02	110.85	8.41	-6.91	-3.91	4.71	4.63	4.88	0.68842	-40.24	102.78
1500	0.001	0.05	75.14	7.31	-6.91	-3.00	4.32	3.60	8.33	0.920645	-31.51	36.74
3000	0.001	0.05	69.32	8.01	-6.91	-3.00	4.24	3.18	14.59	1.164055	-28.96	24.021
4500	0.001	0.05	60.27	8.41	-6.91	-3.00	4.10	2.77	7.58	0.879669	-24.91	15.93
1500	0.005	0.001	114.38	7.31	-5.30	-6.91	4.74	4.18	11.73	1.069298	-36.47	65.58
3000	0.005	0.001		8.01	-5.30	-6.91	4.80	4.13	17.99	1.255031	-36.18	61.95
4500	0.005	0.001	115.51	8.41	-5.30	-6.91	4.75	4.23	18.83	1.27485	-37.08	69
1500	0.005	0.02	109.26	7.31	-5.30	-3.91	4.69	3.72	25.54	1.407221	-33.71	41.24
3000	0.005	0.02	144.33	8.01	-5.30	-3.91	4.97	4.35	26.86	1.429106	-38.28	77.58
4500	0.005	0.02	141.9	8.41	-5.30	-3.91	4.96	4.68	9.01	0.954725	-40.68	107.83
1500	0.005	0.05	79.46	7.31	-5.30	-3.00	4.38	3.62	9.77	0.989895	-31.76	37.49
3000	0.005	0.05	80.31	8.01	-5.30	-3.00	4.39	3.25	17.4	1.240549	-29.82	25.68
4500	0.005	0.05	60.77	8.41	-5.30	-3.00	4.11	2.70	11.5	1.060698	-25.47	14.92
1500	0.01	0.001	106.35	7.31	-4.61	-6.91	4.67	4.38	6.936	0.841109	-38.05	79.6
3000	0.01	0.001	114.23	8.01	-4.61	-6.91	4.74	4.41	16.98	1.229938	-38.46	82.1
4500	0.01	0.001	126.05	8.41	-4.61	-6.91	4.84	4.64	10.73	1.0306	-40.36	103.715
1500	0.01	0.02	61.59	7.31		-3.91	4.12	3.51	18.65	1.270679	-31.68	33.6
3000	0.01	0.02	160.15	8.01			5.08	4.21	27.99	1.447003	-37.22	67.12
4500	0.01	0.02	131.83	8.41	-4.61	-3.91	4.88	4.76	6.25	0.79588	-41.36	116.805
1500	0.01	0.05	123.13	7.31	-4.61	-3.00	4.81	2.99	13.68	1.136086	-27.67	19.97
3000	0.01	0.05	90.98	8.01	-4.61	-3.00	4.51	3.47	17.92	1.253338	-31.32	32.21
4500	0.01	0.05	55.34	8.41	-4.61	-3.00	4.01	3.09	13.8	1.139879	-28.23	21.89
1500	0.02	0.001	83.53	7.31	-3.91	-6.91	4.43	4.34	5.83	0.765669	-37.7	76.59
3000	0.02	0.001	116.68	8.01	-3.91	-6.91	4.76	4.37	18.95	1.277609	-38.23	79.43
4500	0.02	0.001	130.49	8.41	-3.91	-6.91	4.87	4.64		Presente a la recepción terre de la construcción de		n 🛊 earrinn an ann an t-tha ann an t-tha ann an t-tha
1500	0.02	0.02	119.94	7.31	-3.91	-3.91	4.79	. 3.61	19.58			
3000	0.02	0.02	76.79	8.01	-3.91	-3.91	4.34	4.07	22.04			· · · · · · · · · · · · · · · · · · ·
4500	0.02	0.02	142.28	8.41	-3.91	-3.91	4.96	- All Annual	7.04	÷		and and the Party of Without Manager I and an I among the same states
1500	0.02	0.05	29.62	7.31	distance strategies and strategies and		3.39	• · · · · · · · · · · · · · · · · · · ·		• 1.11		
3000	0.02	0.05	24.08	8.01		-3.00				· · · · · · · · · · · · · · · · · · ·		· · · · · · · · · · · · · · · · · · ·
4500	0.02	0.05	50.15	8.41	· · · · · · · · · · · · · · · · · · ·	-3.00	•	• · · · · · · · · · · · · · · · · · · ·	-	1.011993		

 Table 4.7
 Cutting in Y Direction

4.5 Multiple Linear Regression Analysis

After all the data was consolidated and organized there was one value for a particular combination for speed, feed and depth of cut as can be observed from the tables showing the data. Now, It was required to convert these values into models which would have equations giving us the empirical releion between the operating parameters. For this purpose the Linear regression Software was chosen. This software has been written in QBASIC. It can take any number of dependent and independent variables and then on running the program the output comes in the form of equation giving the relation between the dependent and the independent variable. It also performs the ANOVA test and gives the Correlation coefficient. These values for cutting in all three directions were fed to the Qbasic program and the program was run.

As an eg. consider the Rku value for cutting in the X direction. The program asks for the number of dependent and independent variables first. For all the calculations the number of dependent variables is 1 and the number of independent variables is 3. In this example the dependent variable is the Rku value. For ease of developing the model the Ln values for each of the parameters were calculated and then they were fed into the software. After the dependent variable it asks for the independent variable. The independent variables are the three operating parameters of speed, feed and depth of cut. then it asks for the number of experiments. In all the calculations the number of experiments are 36 as there are 36 values for cutting in each direction. Then the software one by one asks for each of these values for the dependent and

independent variables and after inputting all these required values it comes out with the Regression equation and also performs all the ANOVA tests and correlation coefficients.

The final equations for cutting in all the three directions are shown below. Thus a model was developed for cutting in each of the three directions.

1) In Rku = (0.136077) * In speed + (-0.1330632) * In feed + (1.213256E-02) * In depth + (-0.4251051).

3) In Rq = (-0.17784) * In speed + (0.2054301) * In feed + (1.873142E-02) * In depth + 5.87079

- 5) In Rt = (-0.0680707) * In speed + (8.135596E-02) * In feed + (-1.5319E-03) * In depth + (-0.4251051).
- 6) In Fmax = (0.1186844) * In speed + (7.133371E-03) * In feed +
 (-0.1441128) * In depth + 2.804687

4.7 Regression Equations for Cutting in XY Direction

4.8 Regression Equations for Cutting in Y Direction

- 4) In Rp = (6.484896E-02) * In speed + (0.1049619) * In feed + (0.0548048) * In depth + 5.093226
- 5) In Rt = (0.1523802) * In speed + (0.1158374) * In feed + (7.026348E-02) * In depth + 5.097253
- 6) In Fmax = (0.0577496) * In speed + (-5.724295E-02) * In feed + (-0.1086182) * In depth + 3.273687
- 7) In Favg = (0.2608871) * In speed + (3.964887E-02) * In feed +

(-0.2237481) * In depth + 0.9777973

The above equations give the relationship between the various Surface Quality parameters, Cutting Forces and the operating parameters of speed, feed and depth of cut. Thus, by plugging in numbers it is now possible to predict the Surface Quality and the Cutting force before the actual machining could be carried out. This gives the operator an idea as to what the Surface Finish could be after the machining would be done. Due to this, the operator could actually be able to select before hand the almost accurate speed, feed and depth of cut that he would need to obtain the desired surface finish. Thus, the Multiple Regression Analysis Software was used to develop these models.

4.9 Table Curve Software

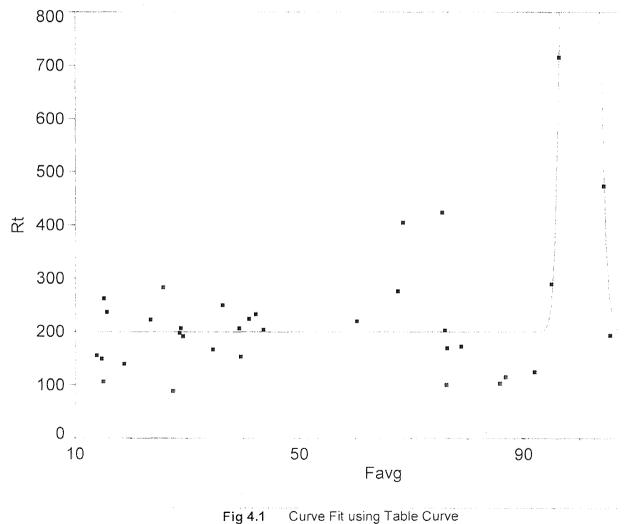
The table Curve Software was used to develop the relation between the Surface Quality parameters and the Cutting force parameters. This software is much more sophisticated than the Multiple Linear Regression Software. This software has been developed by Jindel Scientific. The working of this software was described in bried in the earlier chapter. In this software there is a FILE Menu which enables us to import data from excel or Lotus spreadsheet into the software. The data that was consolidated was saved on excel spreadsheet and the columns which had this data were saved onto a clipboard. This clipboard was imported from the excel spreadsheet into the Jandel Scientific Table Curve Software. After the import was carried out, the processing of the data was done by selecting the process menu. the best fit curve was selected. This software gives the output of only 2 different parameters, one is the dependent and the other is the independent. The interest of the research was to develop a relation between the Surface Quality parameter and the Cutting force parameter. Here. the Surface texture parameter was highlighted as the X value and the cutting force as the Y. The equation was in the form of Y = constant x X, thus giving the relation between the Surface Quality parameter and the Cutting force parameter. In this research work there are 5 Surface Texture parameters, the maximum cutting force and the avg. cutting force. Hence, this software gave 10 graphs taking into consideration all the combinations. Since there are 3 directions of cutting, it gave these 10 graphs for each of the three directions, thus resulting into 30 graphs, which took care of all the combinations.

Plottings in figures 4.1, 4.2, 4.3, 4.4 are some of the core graphs which give the relationship between the cutting force and the surface quality parameters. The remaining graphs are attached in the appendix.

Cutting in X Direction Rank 1 Eqn 8005 y=a+bexp(-0.5(ln(x/c)/d)²) [Log-Normal] r²=0.624464705 DF Adj r²=0.576008538 FitStdErr=77.9327765 Fstat=17.7372326

a=199.24202 b=6334.9412

c=100.02607 d=0.016840752



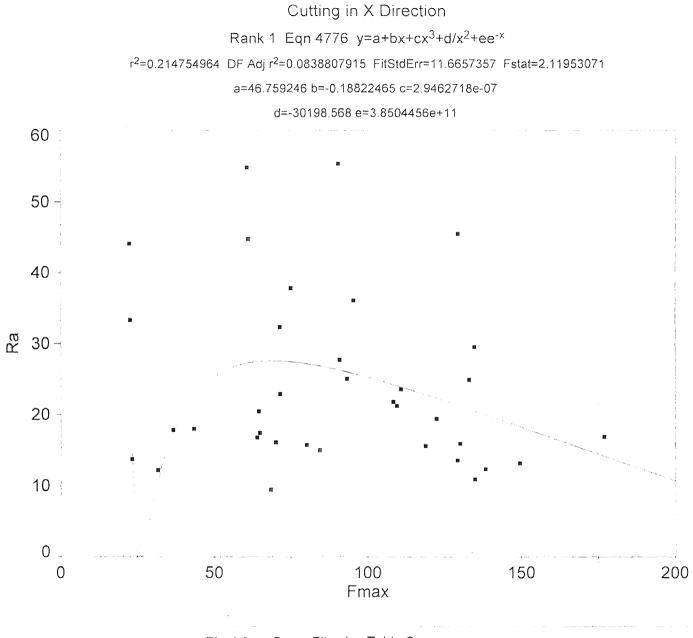
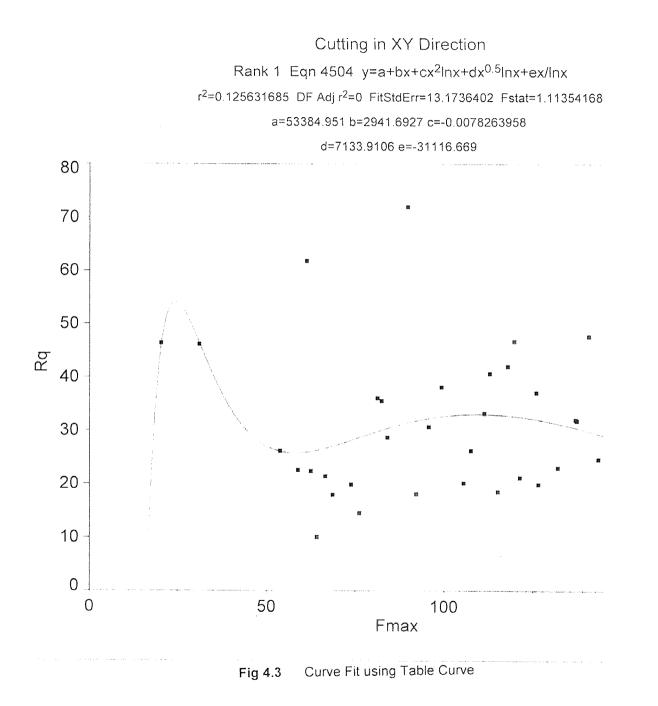


Fig 4.2 Curve Fit using Table Curve



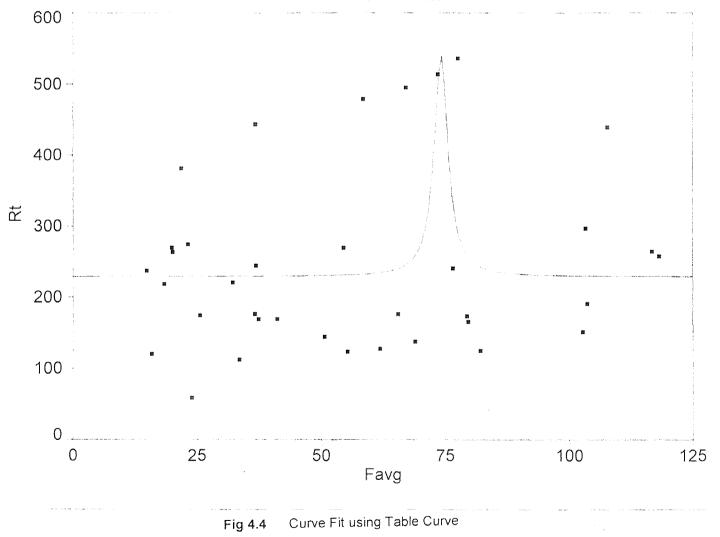
Cutting in Y Direction

Rank 1 Eqn 8004 $y=a+b/(1+((x-c)/d)^2)$ [Lorentzian]

r²=0.155728759 DF Adj r²=0.0467905344 FitStdErr=121.473646 Fstat=1.96750367

a=228.50377 b=313.90878

c=74.166438 d=1.6762655

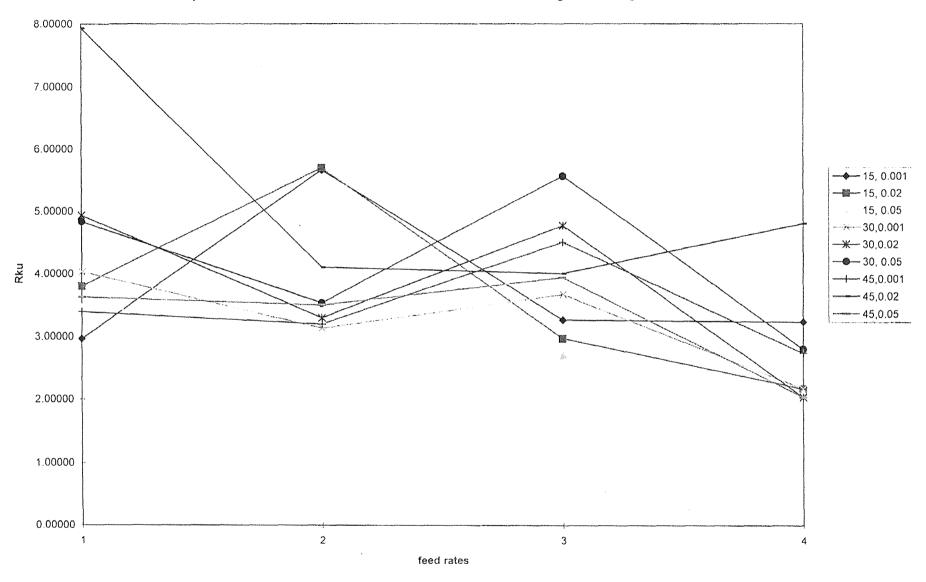


4.10 Comparison of Different Operating Parameters at Different Levels of Cutting

Once these relations were established it was further of interest of the research work to compare the different operating parameters at different levels of cutting. The entire data was sorted in the ascending order of speed, feed and depth of cut and then graphs were plotted with the Surface Quality parameter on the Y axis and the feedrates on the X axis. Each graph would have 9 lines on it and this would help to compare visually between the different operating parameters at the different levels of cutting.

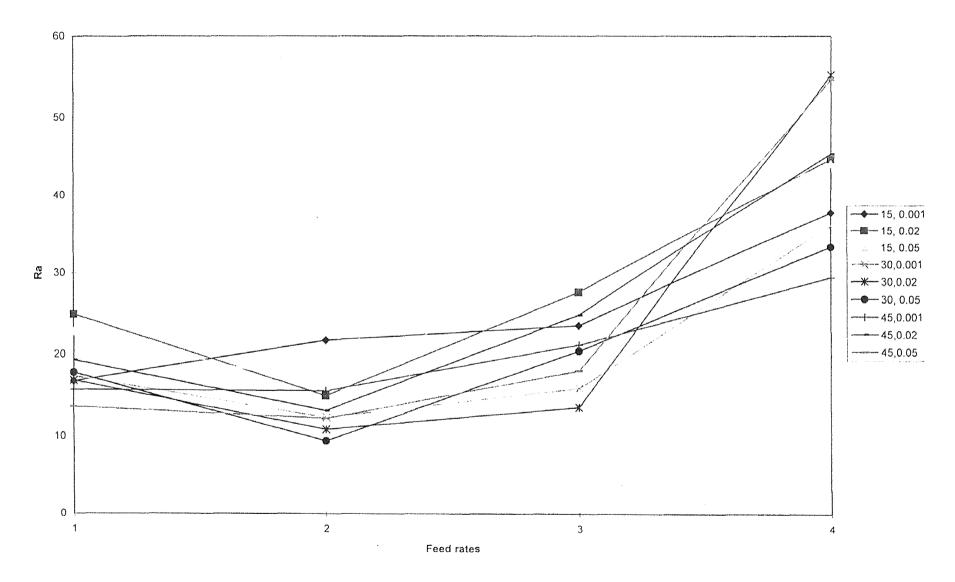
The graphs 4.5, 4.6, 4.7, 4.8, 4.9, 4.10, and 4.11 show the core comparisons for cutting in the three different directions. The remaining graphs are attached in the appendix.

For e.g. a graph with the Rku values on the Y axis and the feedrates on the X axis gives the comparison between the Rku values at different levels of cutting in the X direction. Similarly graphs were obtained for analysis for all other Surface Texture parameters and Cutting forces for cutting in the X, XY and Y direction.



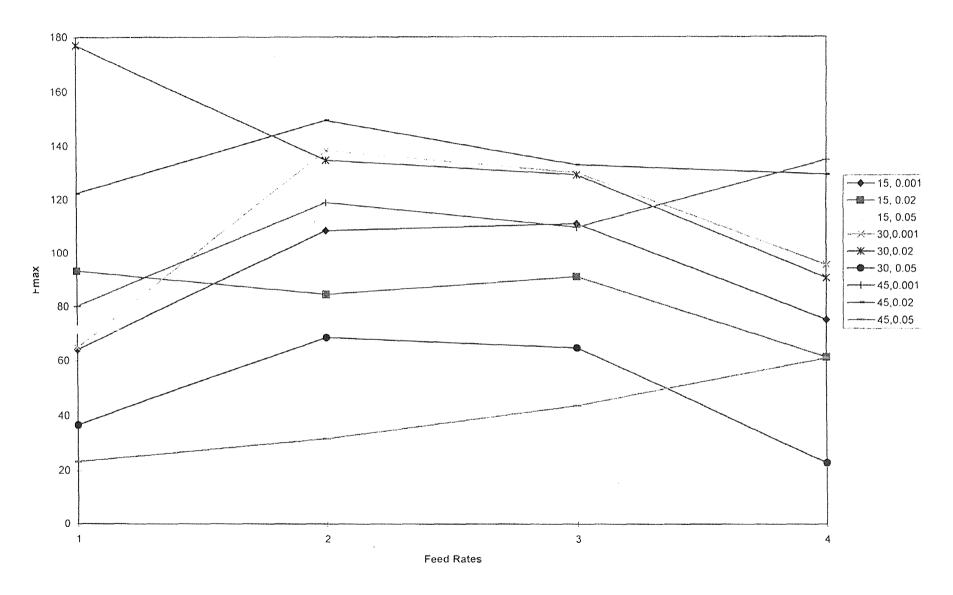
Comparison of the Rku values at the different levels of cutting for cutting in the X Direction

Fig 4.5 Comparison graph



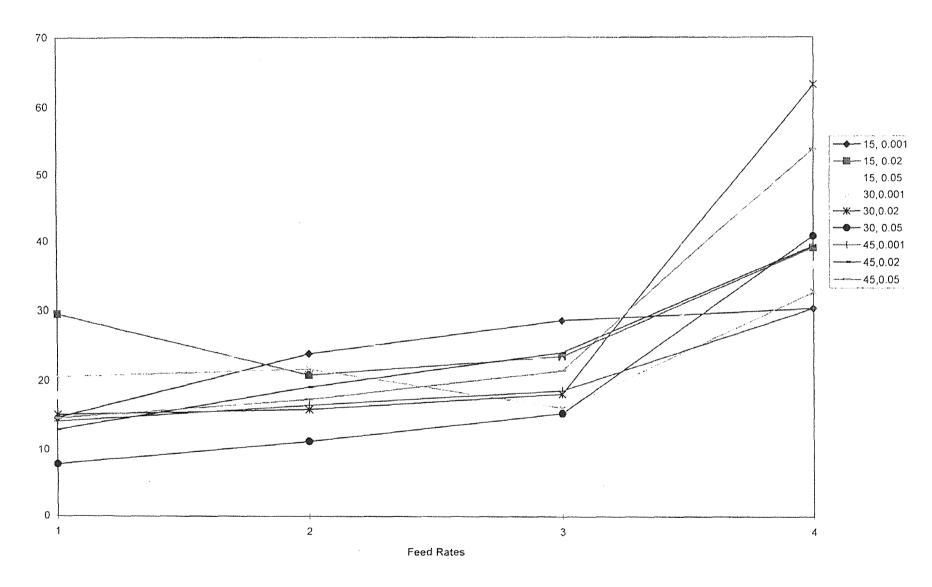
Comparison of the Ra values at different levels of cutting for cutting in the X Direction

Fig 4.6 Comparison graph



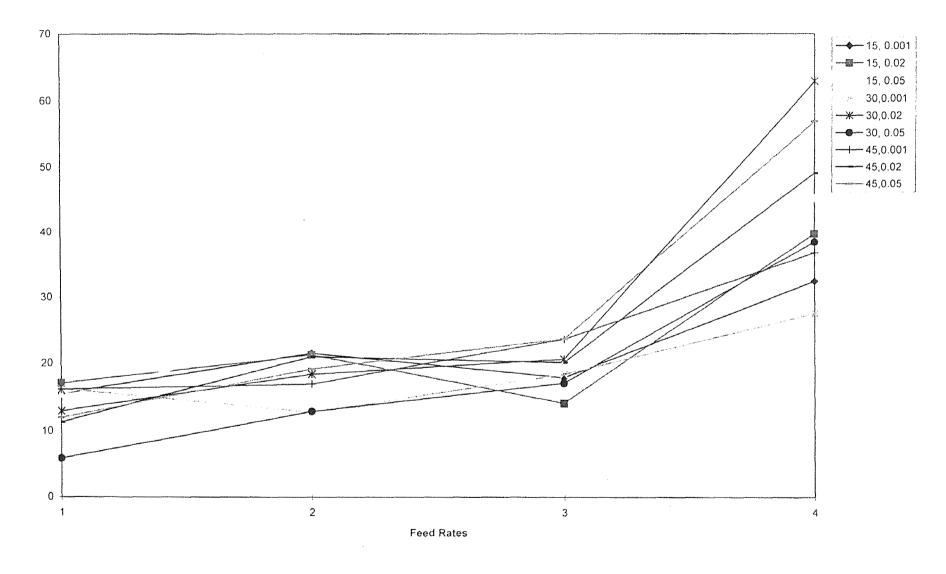
comparison of the Fmax values at different levels of cutting for cutting in the X Direction

Fig 4.7 Comparison graph



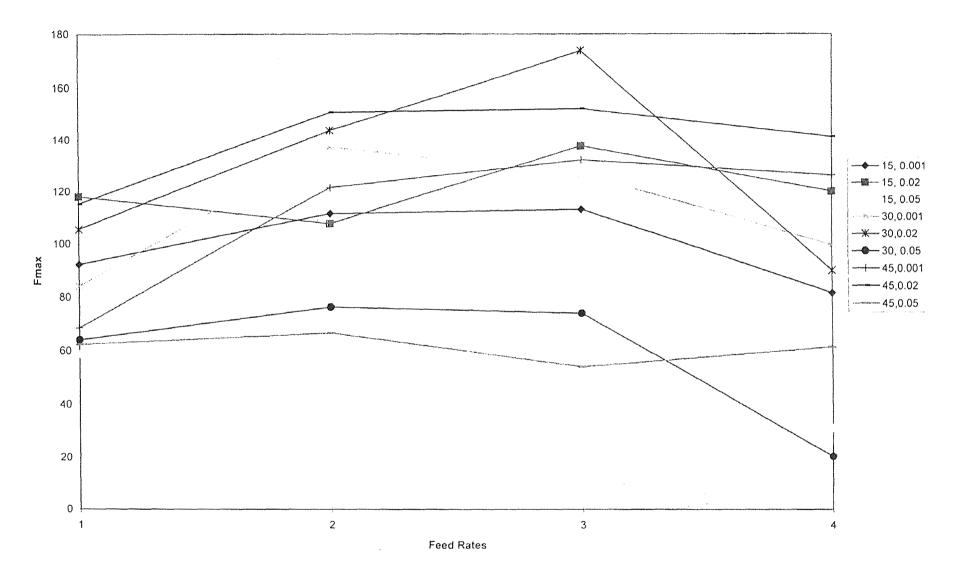
Comparison of the Ra values at different levels of cutting for cutting in the XY Direction

Fig 4.8 Comparison graph



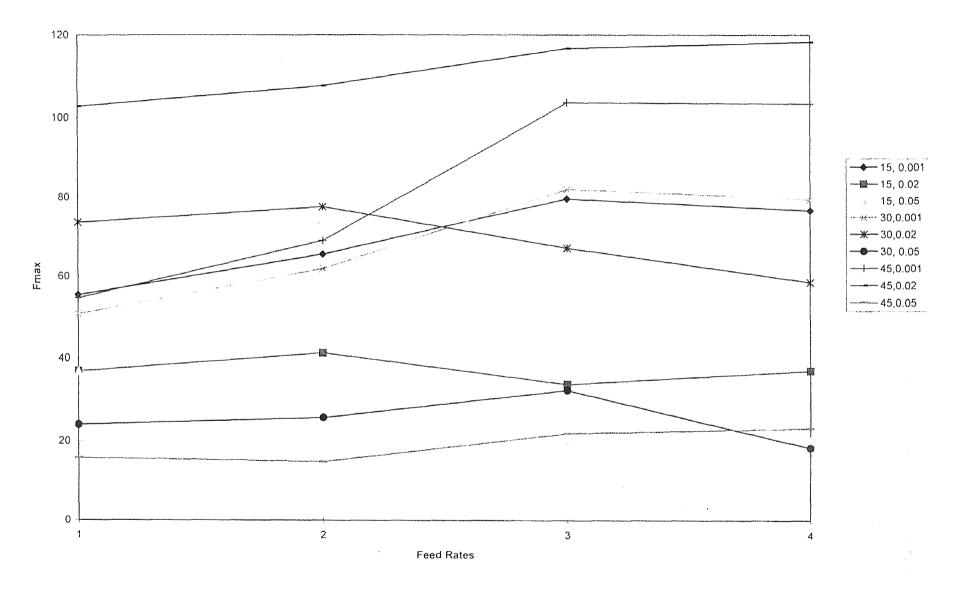
Comparison of the Ra values at different levels of cutting for cutting in the Y Direction

Fig 4.9 Comparison graph



Comparison of the Fmax values at different levels of cutting for Cutting in the XY Direction

Fig 4.10 Comparison graph



Comparison of the Fmax values at different levels of cutting for cutting in the Y Direction

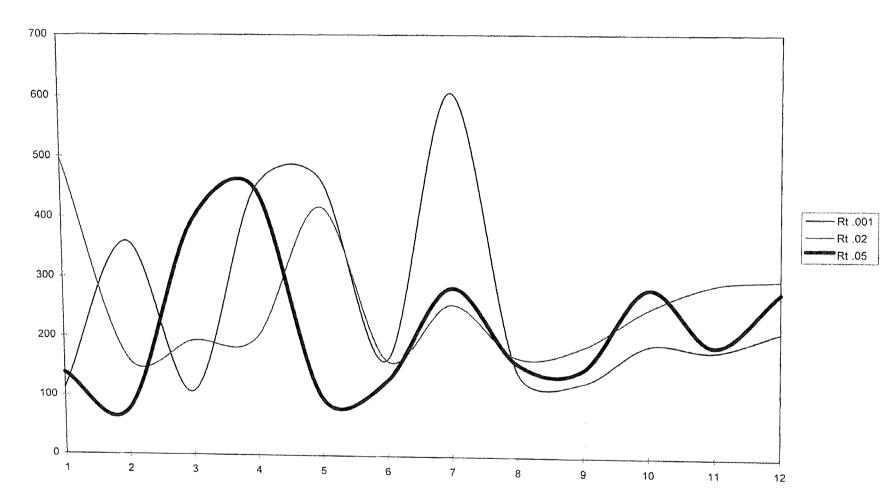
Fig 4.11 Comparison graph

4.11 Variation in the Surface Texture Parameters and the Cutting forces

Proceeding towards the final stage of the case study, graphs were plotted which show the variation of the Surface Texture parameter / cutting force parameter at the different feedrates. In these graphs the Y axis is the Surface Texture / Cutting force parameter and the X axis is the number of points for the corresponding operating parameter under consideration.

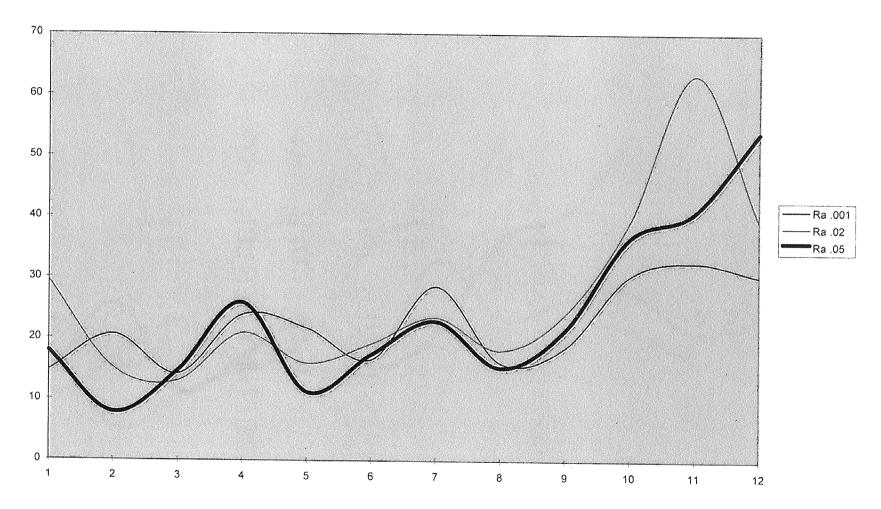
There are 36 values for each of the cutting directions. There are 3 speeds 4 feeds and 3 depths of cuts. If the variation of Rku for eg. has to be studied with respect to the different spindle speeds then the Y axis will have all the Rku values and the X axis will have the 12 points for each spindle speed. The graph will show 3 curves, one for each spindle speed , thus making it very simple to visually analyze the variation of the parameter under consideration.

Similarly the variation graphs for other parameters and directions of cutting were plotted. It was observed that the Ra and Rq showed a similar variation pattern for cutting in all the three directions. Similarities were also observed between the Rp and the Rt values. That consistency supports the fact that Rp and Rt are the peak value measurements and that Rq is the RMS parameter for Ra. Some of the important graphs are shown below and the rest are attached in the appendix.

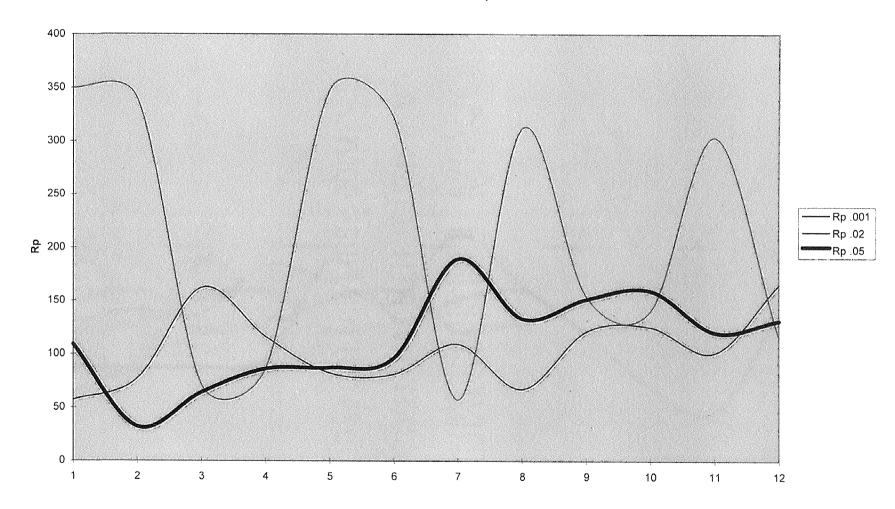


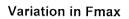
Variation in Rt

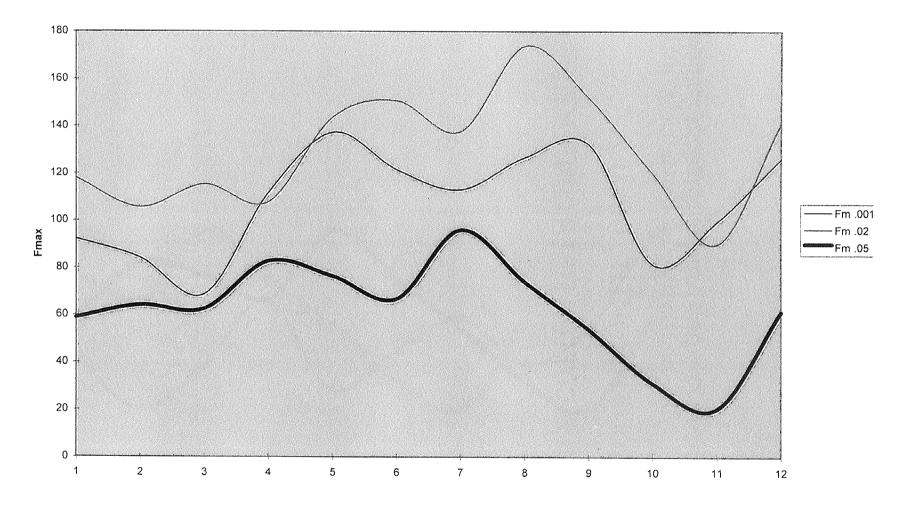




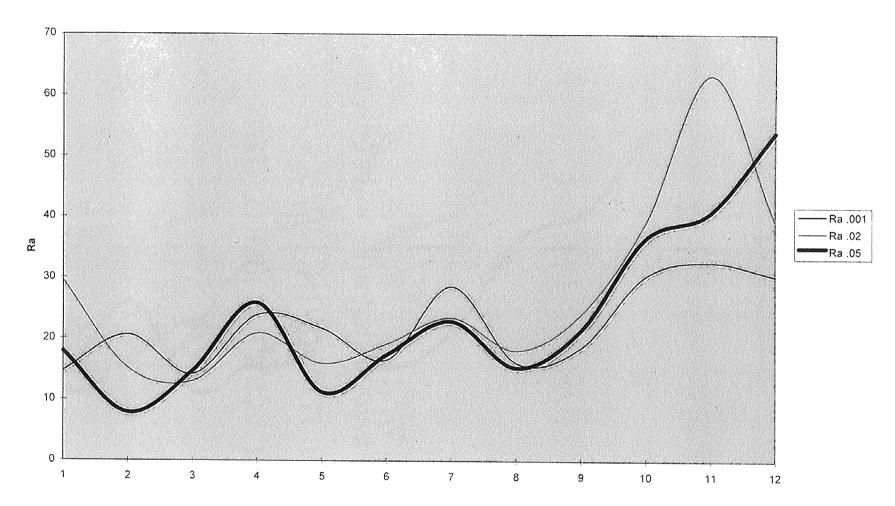




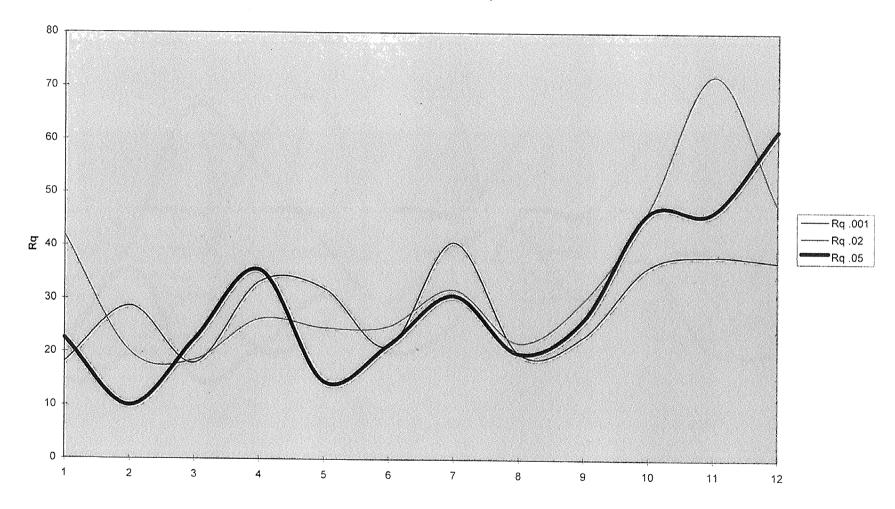


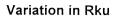


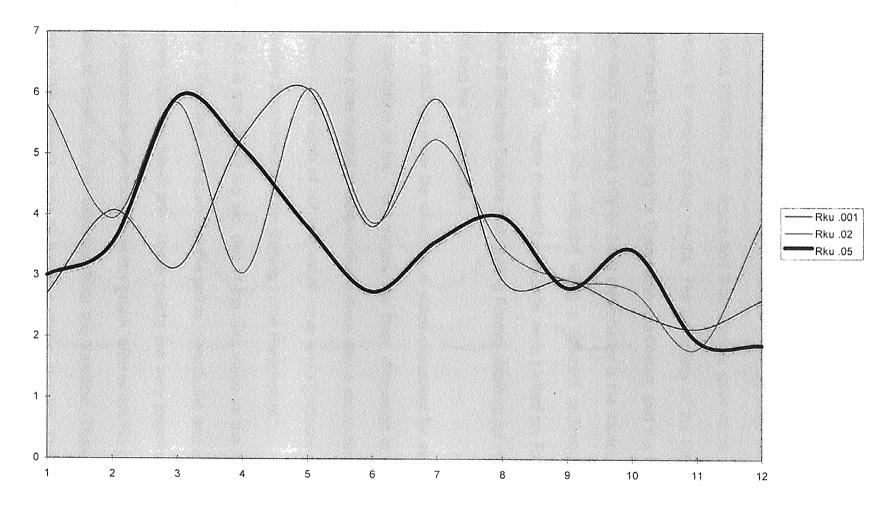












ANALYSIS OF RESULTS 5.1

The results that were obtained from the number of experiments performed were analyzed using statistical techniques and thus models were come up with. It is now necessary to analyze these results. The adequacy of the models can be easily determined by checking the Correlation coefficients and the F values and they can be readily analyzed. Higher the R value better is the model.

The results were also analyzed using a different technique called the Probability Plottings. These probability plottings were plotted on Excel by using the 36 values of Surface Texture and Cutting Forces obtained for cutting in each of the X, XY and the Y Directions.

These plottings show the effect vs vi value calculated for each plot. The method of calculation of the "vi "values has been discussed in the previous chapter. These plots helped in determining if there was a particular combination of speed, feed, and depth of cut that would have any significant effect on the Surface Texture parameters and the Cutting Force Parameters.

Fig. 5.1 is the plot of log std. dev of the Rku value vs the "Vi" value for cutting in the X Direction. It is seen that the points towards the end of the plotting deviate largely from the trend line. These points are very important and they have to be separated and removed from the graph, after which the graph can be plotted again to check for any deviation from the trendline. These points are summarized in the analysis table at the end of the chapter. The figures 5.2

62

through 5.11 are the plottings for the effects of the different surface quality and cutting force parameters.

These are the possible combinations and any of the above combinations may have a significant effect on the Surface Texture parameter or/and the Cutting force parameter. Thus for a particular parameter, e.g. Rku, the effect was calculated for the Rku value for cutting in the X Direction. The effect is calculated as the difference between the maximum and the minimum of the Rku value for that particular combination. Similarly the effects were calculated for Ra, Rq, Rp, Rt, Fmax, their log standard deviations and the Signal to noise ratios. These effects were arranged in the ascending order and then vi was calculated.

$$vi = (n - 0.5)/n * 100$$

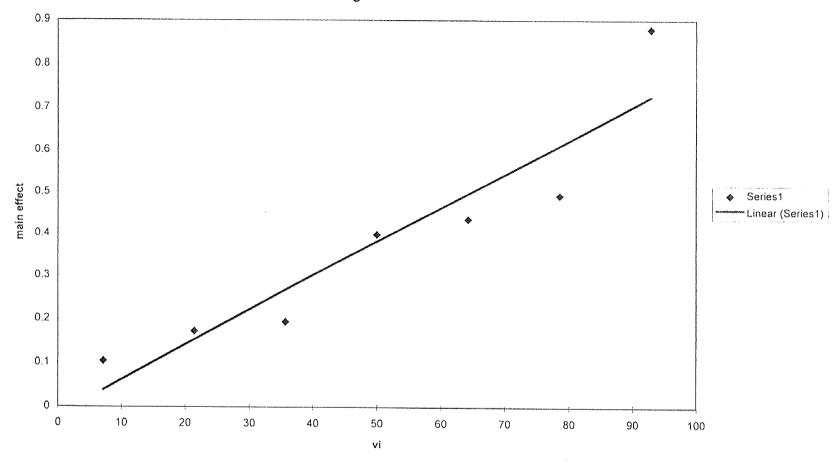
where n is the number of combinations into consideration for that particular probability plot.

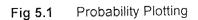
Thus, the vi values and the effects are calculated and then the graph of effect versus the vi is plotted. After the graph is plotted a linear trendline is established to check whether all the points follow the trend or not. If any point does not seem to follow the trend it is separated and the graph is plot again. This procedure is carried out until a linear trend is observed. These probability plottings determine any significance of any particular operating parameter as main effect, or the two interaction effect or the triple interaction effect.

Some of the important probability plots are as shown below and the remaining are attached in the appendix. The analysis of these probability plottings for the Surface Texture parameters are shown in the excel spreadsheet which has been imported from Microsoft Excel after summarizing the entire data from the probability plottings.

ia: Solution	27.389 1	00sid R. Sin Ri	38.2	SNR	7 -34.07
logstd Ri	0.817	logstd R	0.6931	logstd Rt	0.57
RA RA RA RA RA RA RA RA RA RA RA RA RA R	5 	basid Rp SN Rp Ri	0 	bgstd Rp SN Rp Rt •	-1766
logsid Rp	99 92 92	logstd Rp		logstd Rp	0.46
legeta Rq SN Rq. Rp.	38	logsid Rg SN Rg RP	-0.577 -0.577 -16.39 -141	logstd Rg S/N Rg Rp *	-17.66
5	0.14	log std Ra StN Ra -0 3161		log sid Ra SN Ra	
It was observed after the analysis that the operating parameters of speed. feed and depth of cut by themselves had no significant teffect on the various R values. Even the two interaction effect did not have any significant influence on the R values. But it was observed that the triple interaction effect of speed. feed and depth of cut did have a significant influence in some cases. They are mentioned below. The analysis for X Axis speed feed feed RRu logstd Rk SIN RKu Ra log sid Ra SIN Ra	2.033 2.033 1.233 1.233 -1.233 -1.233 -0.18	Icostd Rk, SJN Rku Ra 7,866		logsid Rk S/N Rku Ra	
It was observed after the analysis that the cut by themseives had no significant effect diffect did not have any significant influence inferaction effect of speed, feed and depth. They are mentioned below.	3000 0.02 0.05 2 4500 0.02 0.05 2 1500 0.021 0.061 2 1500 0.021 0.001 2 4500 0.021 0.055 2 4500 0.021 0.051 205 4500 0.021 0.055 0.055 3000 0.021 0.055 0.055 3000 0.005 0.005 0.055 3000 0.005 0.055 0.055 3000 0.005 0.055 0.055 3000 0.005 0.055 0.055	feed dep	3000 0.001 0.05 3000 0.001 0.05 3000 0.005 0.05 3000 0.001 0.05 3000 0.001 0.05 3000 0.001 0.05 3000 0.001 0.05 3000 0.001 0.05 3000 0.001 0.05 3000 0.01 0.05 3000 0.01 0.05 3000 0.01 0.05	Bysis for Y Axis leed dep	3000 0.02 0.02 1 1500 0.005 0.02 0.02 1500 0.005 0.02 0.02 1500 0.001 0.01 0.01 1500 0.005 0.05 0.05 3000 0.001 0.05 0.05 3000 0.001 0.05 0.05 3000 0.001 0.05 0.05 3000 0.001 0.05 0.05 3000 0.001 0.05 0.05 3000 0.001 0.05 0.05 3000 0.001 0.05 0.05
It was observed after the arcut by theorem and no s cut by theorem any sign effect of a not have any sign interaction effect of speed. They are mentioned below. The <u>enalysis</u> for X A		Speed		The an speed	

Cutting in Y Direction Log Std. Dev.





Cutting in XY Direction Log Std Dev.

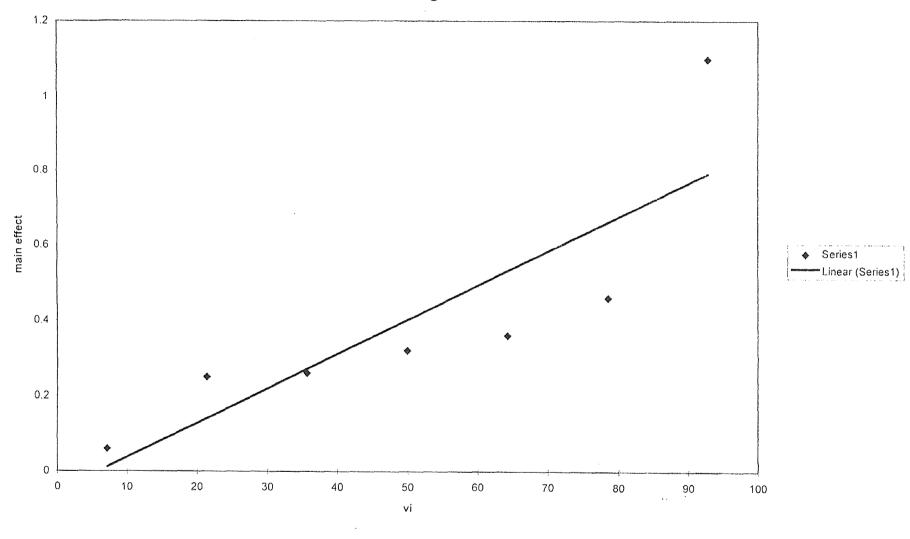


Fig 5.2 Probability Plotting

Cutting in X Direction Log Std Dev.

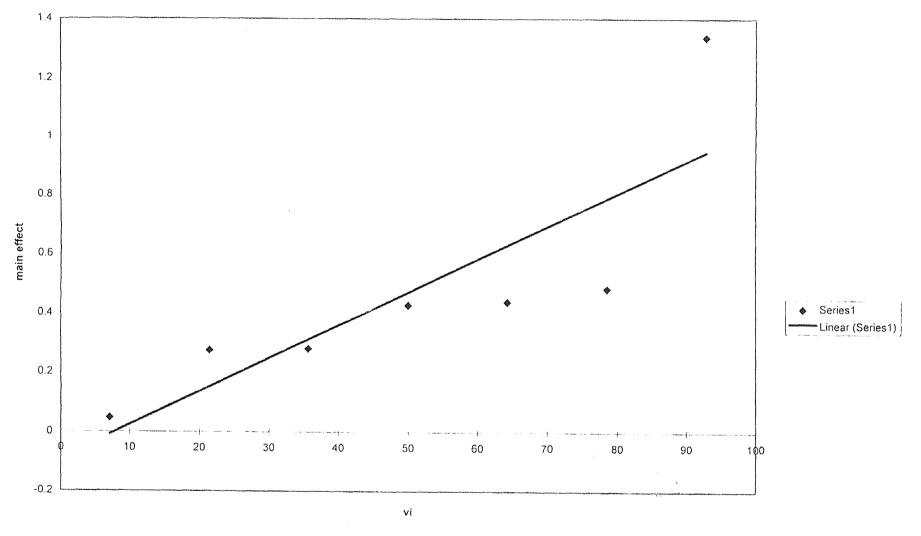


Fig 5.3 Probability Plotting



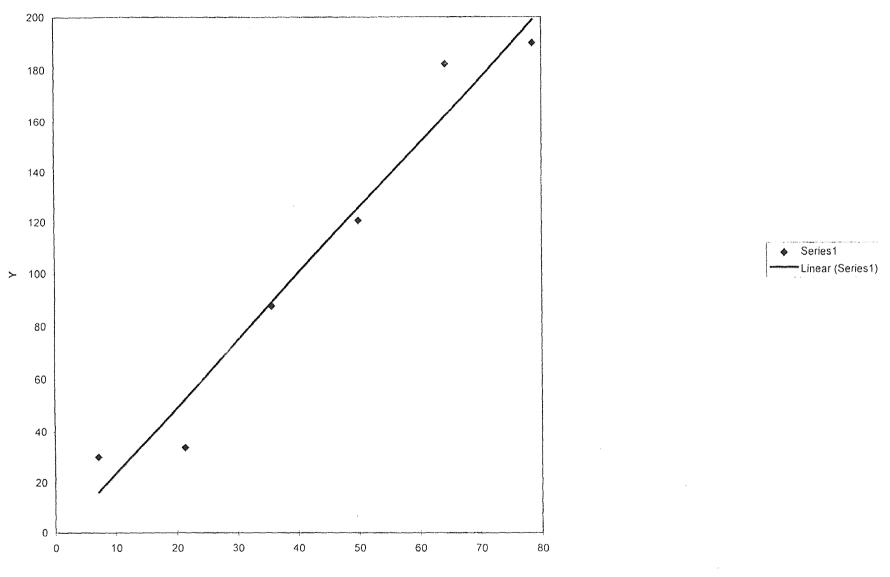


Fig 5.4 Probability Plotting

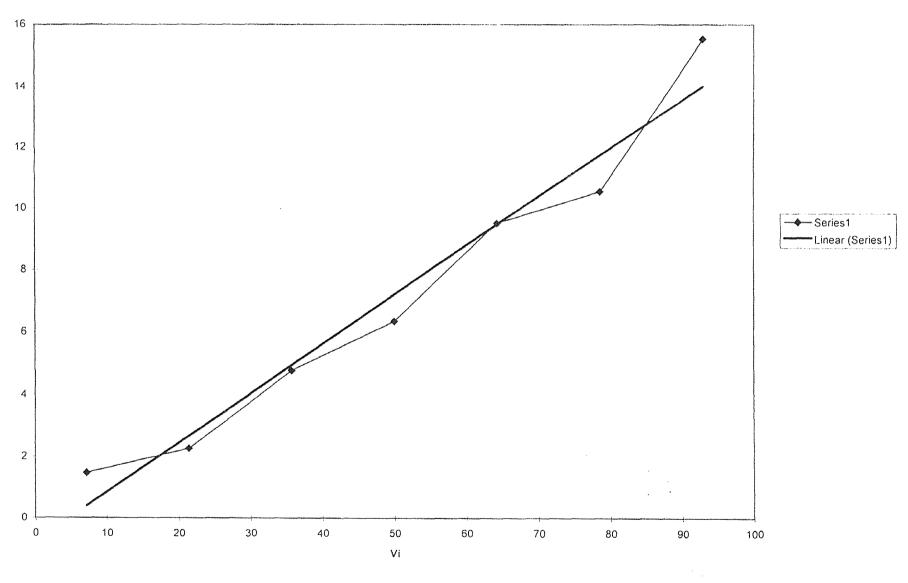


Fig 5.5 Probability Plotting

S/N Rt

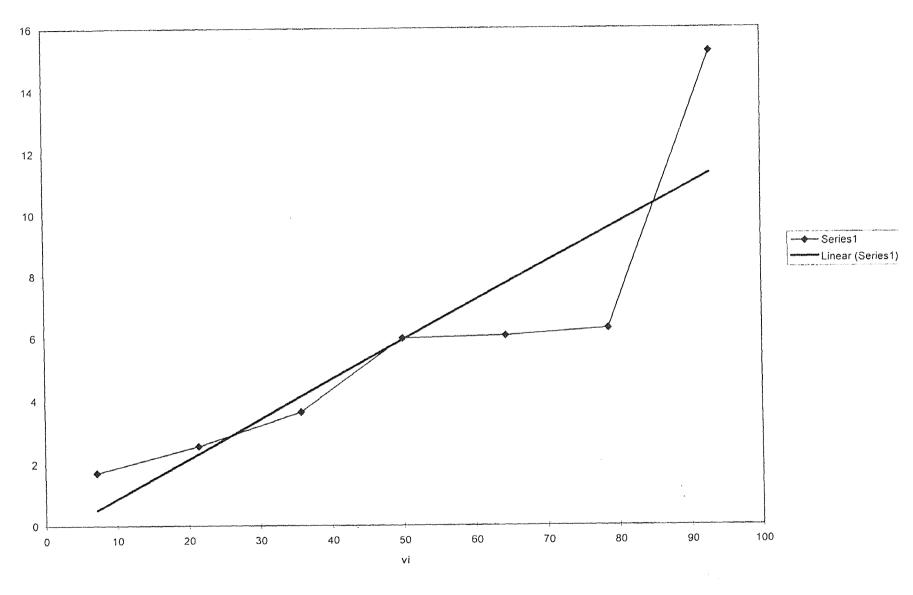
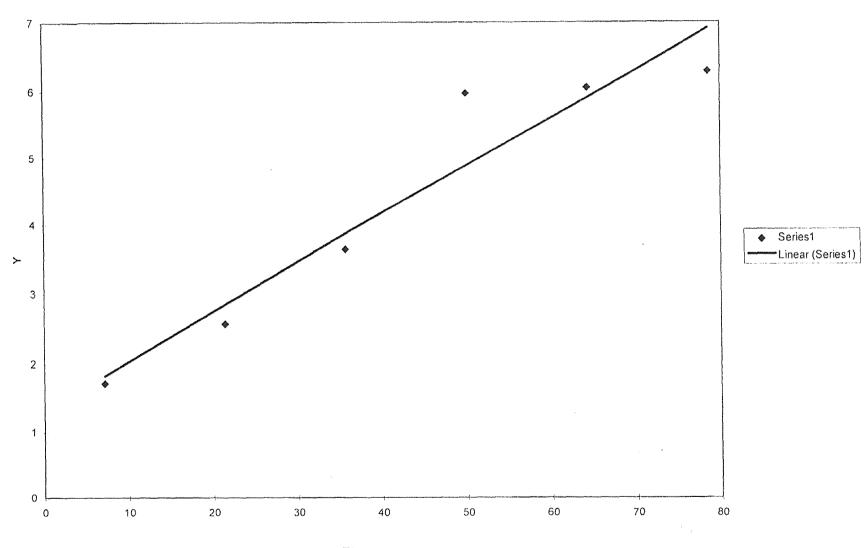


Fig 5.6 Probability Plotting

S/N Rt



S/N Rt (mod)

Fig 5.7 Probability Plotting

71

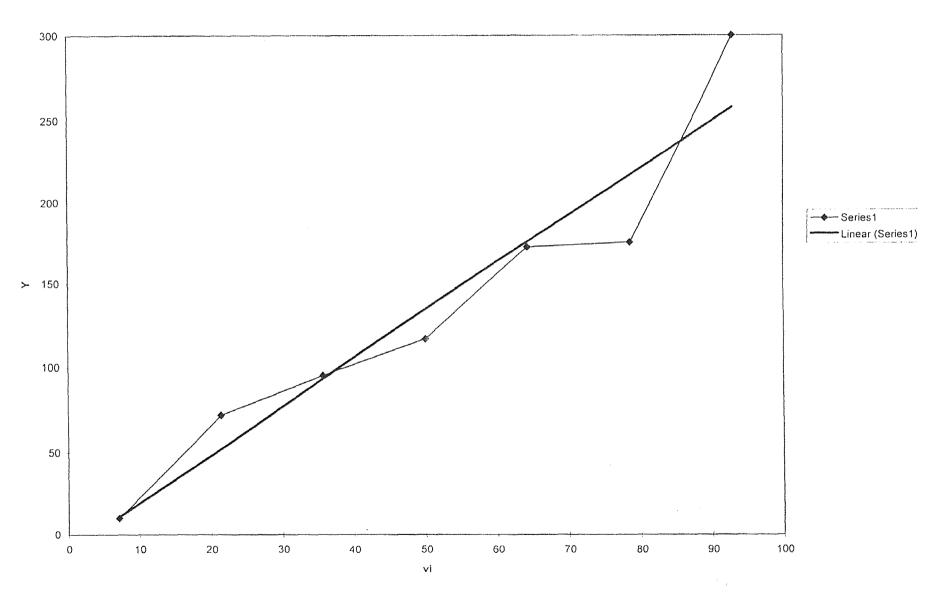


Fig 5.8 Probability Plotting

Rt

Cutting in Y Direction F avg.

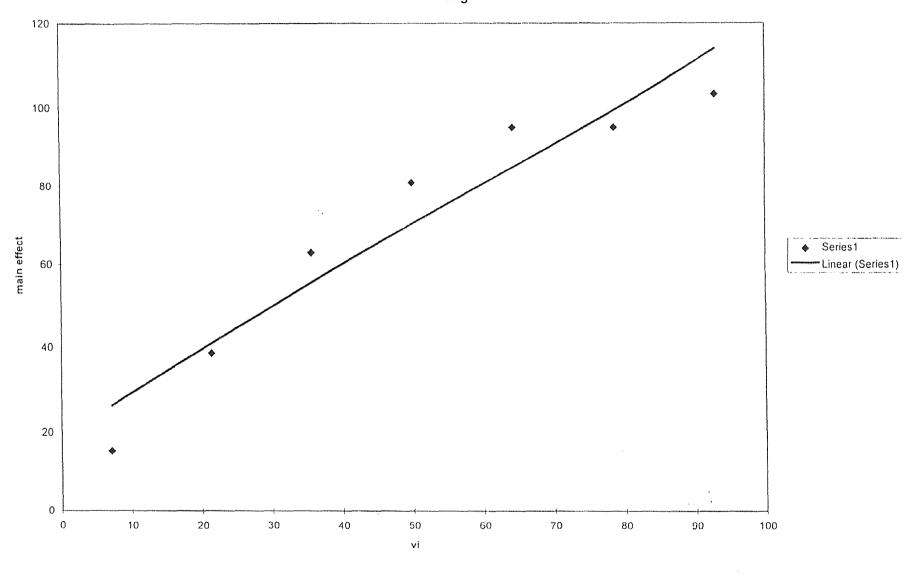


Fig 5.9 Probability Plotting



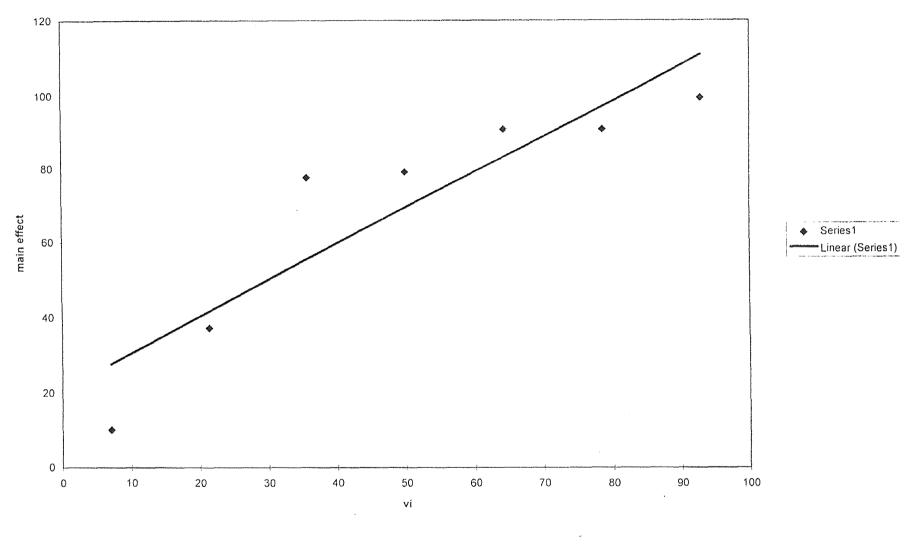
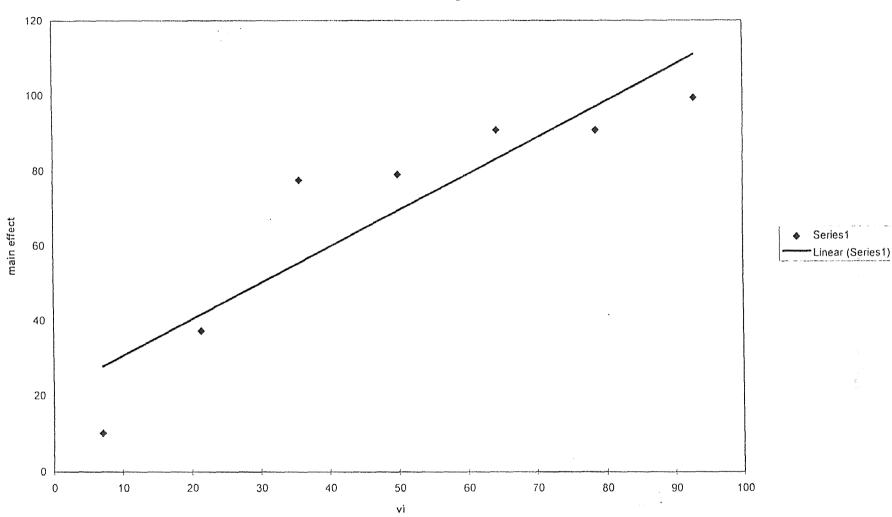


Fig 5.10 Probability Plotting



Cutting in XY Direction Favg

Fig 5.11 Probability Plotting

5.2 Cutting in X Direction

For cutting in the X Direction it was observed that the two interaction effect of speed-feed, feed-depth of cut, speed-depth of cut had a significant effect on the maximum cutting force. The two interaction effect of speed-feed and the single effect of depth of cut had a significant effect on the average value of the cutting forces. The triple interaction effect of speed-feed-depth of cut had a significant effect on the average value of the cutting forces. The triple interaction effect of speed-feed-depth of cut had a significant effect on the log stdev of the Fmax values.

5.3 Cutting in XY Direction

For cutting in the XY Direction it was observed that the single effect of depth of cut had a significant effect on the average value of the cutting forces. There was no significant effect of any particular operating parameter seen on the maximum value of the cutting forces. The triple interaction effect of speed-feed-depth of cut had a significant effect on the log stdev of the Fmax values.

5.4 Cutting in Y Direction

For cutting in the Y Direction it was seen that the two interaction effect of speedfeed and the single effect of depth of cut had a significant effect on the maximum value of the cutting forces. The triple interaction effect of speed-feed-depth of cut had a significant effect on the log stdev of the Fmax values. There was no significant effect of any particular operating parameter seen on the average value of the cutting forces. It was observed that for cutting in any of the three directions, the S/N Ratio of the Fmax values did not show any significance at any level of cutting.

The following table summarizes the above results, showing the factor, level of cutting, main effect for cutting in the three directions.

Analysis for X Axis speed feed depth Fmax(Effect) Favg(effect) log Fmax(eff 3000 0.001 0.02 116.17	stdev
Fmax(eff	
	a at \
2000 0.001 0.02 116.17	ect)
3000 0.001 0.02 110.17	
3000 0.001 0.02 101.94	
4500 0.02 0.001 85.7	
4500 0.005 0.02 75.16	
4500 0.005 0.02 70.46	
1500 0.02 0.05 1.338	

Table 5.1	Analysis	of Results	of Probability	Plottings
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Analysis	s for Y Axis				11. 11. 11.		
			*: :				
speed	feed	depth	Fmax(effect)	Favg(effect)	log	stdev	
					Fmax(effect)	
3000	0.01	0.02	49.3				
3000	0.01	0.02	37.02				
3000	0.02	0.05			0.86		
					und allen aven beschligter		

After the analysis of the results, It was observed that the level of speed to obtain the maximum cutting force is 3000 RPM.

The feed at which the maximum cutting force can be obtained is 0.001 in the X Direction and 0.01 in the Y Direction. If these are the feed rates in the X and Y Directions then theoretically, according to the geometry of the workpiece the feed in the XY direction should be a little over 0.01 inches/min. However practically it would not be possible to achieve that feed rate and we could go to a feed rate of 0.02.

The depth of cut at which the maximum cutting force can be obtained is 0.02 in. in the X and the Y Direction, for maximum cutting force in the XY direction the depth of cut could be reduced to 0.001.

From these above observations and results it can be concluded that the optimum level of cutting to obtain the maximum cutting forces would be speed = 3000 RPM

feedrate = 0.001 (X Direction), 0.02 (XY Direction), 0.01 (Y Direction) in/min.

5.5 Analysis of the Comparisons of Different Surface Texture Parameters and Cutting Forces versus the 4 Different Feedrates at a Particular Spindle Speed and Depth of cut.

From the graphs in Chapter 5 it is very evident that the surface texture parameters display similar characteristics for cutting in the three directions. The Ra and Rq values for cutting in each direction show a similar trend and it is right as Rq is the RMS value of the Ra, thus proving that the results obtained and analysis carried out is quite accurate.

Rp, Rt and Fmax also have similarities in the trend for cutting in the three directions. These graphs give support to the probability plottings and after the analysis of these graphs it can be stated that the cutting conditions for optimum results would be

speed = 3000 RPM

feed rate = 0.005 in/min

depth of cut = 0.05 in.

CHAPTER 6

CONCLUSIONS AND RECOMMENDATIONS

6.1 Conclusions

The research work that has been done gives the empirical relationship between the different Surface Texture Parameters and the Milling Operation parameters. It gives the empirical relatioship between the maximum and the average cutting forces and the Milling operating parameters. It also gives us the empirical relationship between the Surface Texture parameters and the Cutting Forces.

Hence, It is now possible to have an estimate of the output of the Cutting Force or the Surface Texture result by the empirical relatinships. The equations that have been derived can be used to estimate the expected Surface Texture result and the expected Cutting force if a particular combination of spindle speed, feed rate and depth of cut be used.

Those equations having a higher value of the Correlation Coefficient should give better and more accurate predictions of the results. These equations shall be a great help when actual milling operation is being carried out. One can have an idea before hand as to what kind of Surface Texture should he expect and also what would the cutting forces be.

In an unattended machining environment it would be possible to predict the results before the actual machining and then set the operating parameters of speed, feed and depth of cut according to the results that are desired.

The probability plottings give us the significant factors and their effects in

80

obtaining a particular Surface Texture result or a particular Cutting Force. These plottings have given an optimum level of cutting. When cutting would be done at that level one should get the most optimum results for Surface Texture and Cutting forces. This would greatly enhance the productivity and also improve the quality of the machined component.

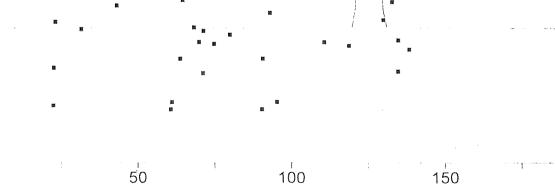
6.2 Recommendations

The research work that has been done helps greatly in determining the optimum conditions of cutting in a milling operation. In unattended machining environment, there should be an adaptive control system, which would give a constant feedback of the Surface Texture being obtained and the Cutting Forces being developed. This adaptive control system should be capable of comparing the actual obtained values of the forces and the texture to those that are desired. The desired values are calculated by the equations already derived. The adaptive control system would compare the desired and the actual value and then take corrective actions by either changing the speed or feed or the depth of cut or any combination of the three milling operating parameters. It can also be in the form of a G and M code where it would immediately halt the machining operation if the actual measured results deviate largely from the desired results.

APPENDIX A

TABLE CURVE SOFTWARE RESULTS

Cutting in X Direction Rank 1 Eqn 8005 $y=a+bexp(-0.5(ln(x/c)/d)^2)$ [Log-Normal] r²=0.395338573 DF Adj r²=0.317317744 FitStdErr=1.00695681 Fstat=6.97405952 a=3.51925 b=38,803566 c=125.44229 d=0.011578976 9 8 7 6 Rku 2 4 3



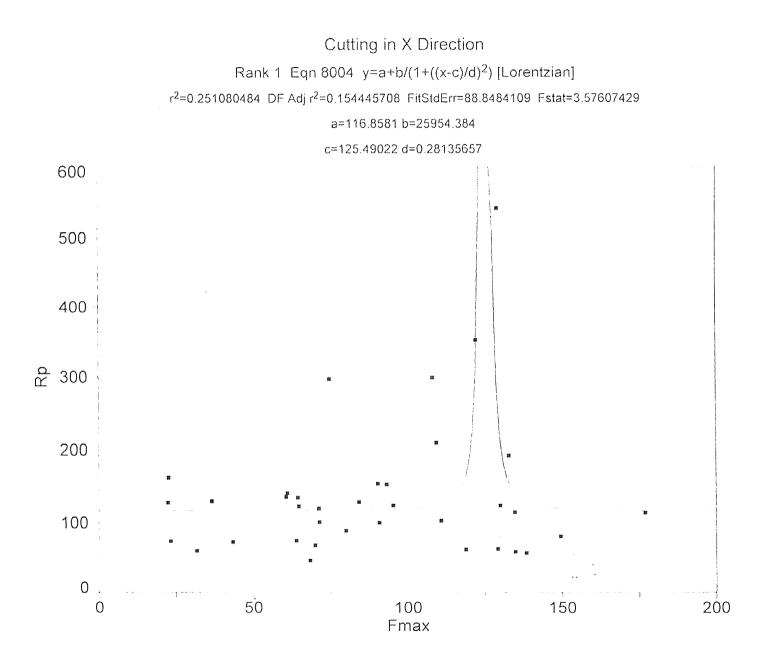
Fmax

200

2

1

0

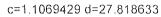


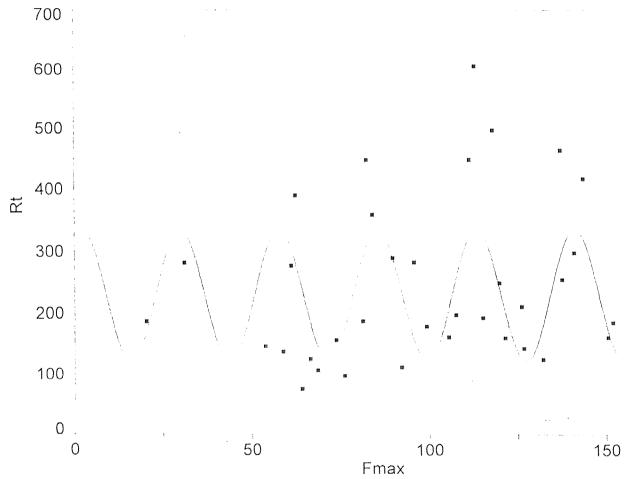
Cutting in XY Direction

Rank 1 Eqn 8014 y=a+bsin(2πx/d+c) [Sine]

r²=0.323578678 DF Adj r²=0.236298507 FitStdErr=112.519609 Fstat=5.10259772

a=228.78952 b=106.99618



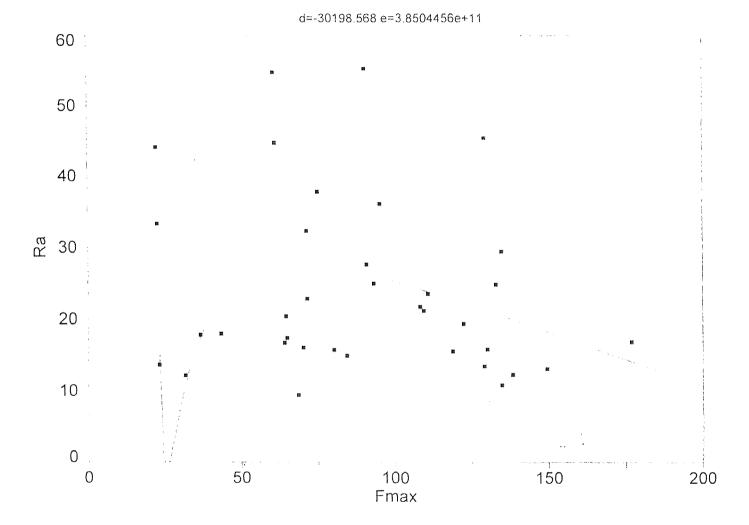


Cutting in X Direction

Rank 1 Eqn 4776 $y=a+bx+cx^{3}+d/x^{2}+ee^{-x}$

r²=0.214754964 DF Adj r²=0.0838807915 FitStdErr=11.6657357 Fstat=2.11953071

a=46.759246 b=-0.18822465 c=2.9462718e-07



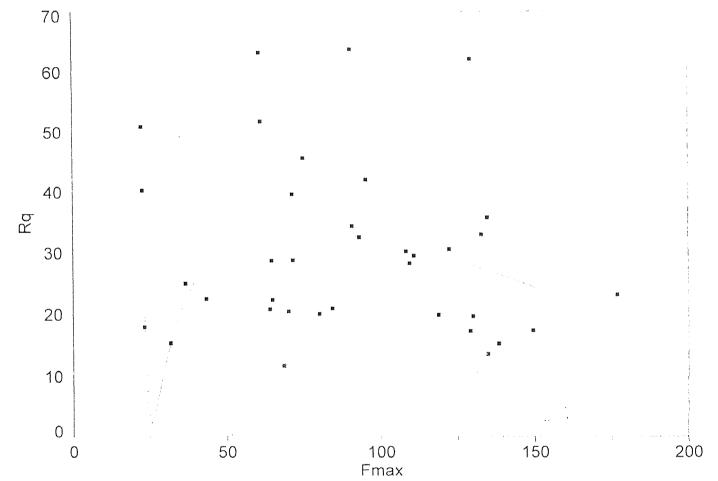
Cutting in X Direction

Rank 1 Eqn 5090 y=a+bx+c/lnx+d/x^{0 5}+ee^{-x}

r²=0.186145907 DF Adj r²=0.0505035586 FitStdErr=13.6424853 Fstat=1.77259142

a=1763.8827 b=-0.53819104 c=-12959.913

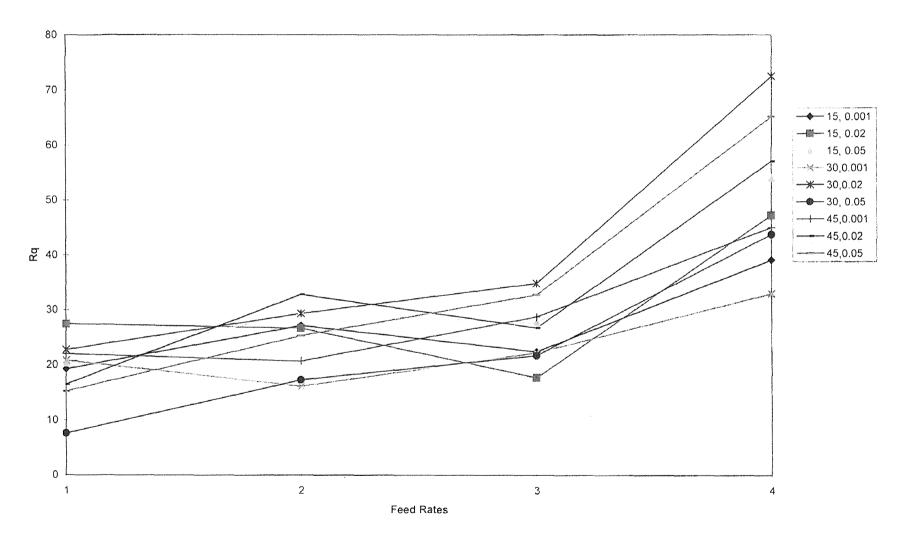
d=11362.144 e=4.1992917e+11



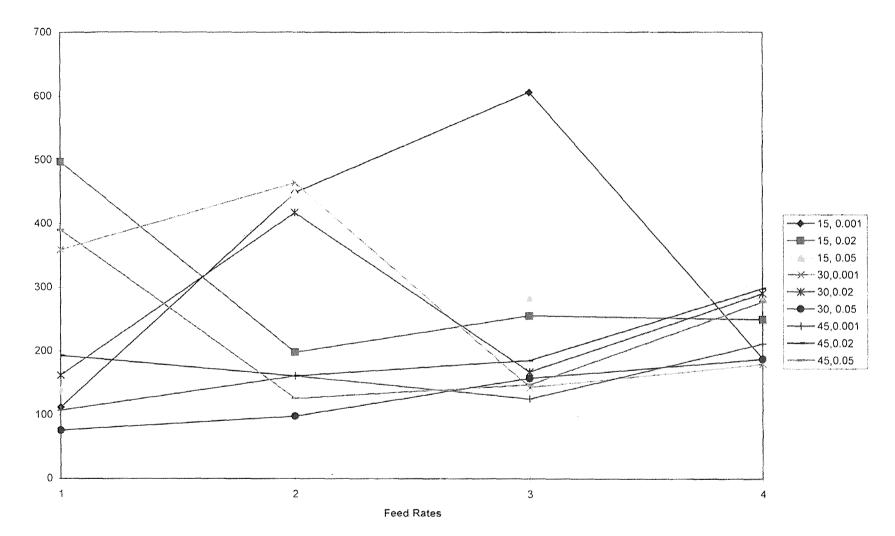
APPENDIX B

PLOTTINGS OF THE COMPARISONS OF THE DIFFERENT OPERATING PARAMETERS AT DIFFERENT LEVELS OF CUTTING

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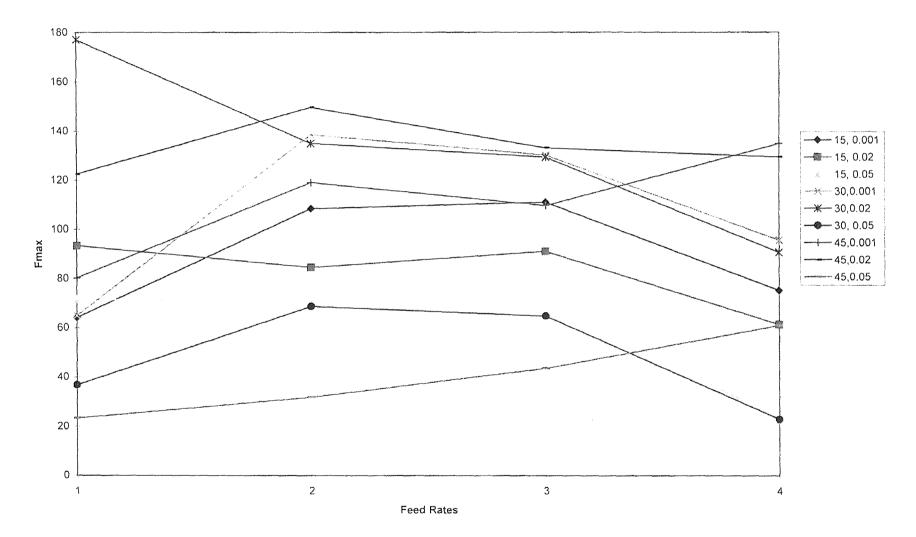


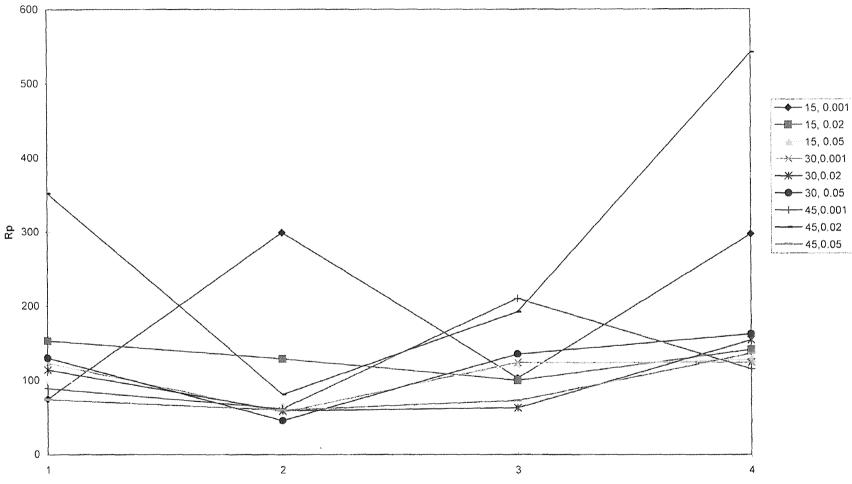
Comparison of the Rq values at different levels of cutting for cutting in the Y Direction



Comparison of the Rt values at different levels of cutting for cutting in the XY direction

comparison of the Fmax values at different levels of cutting for cutting in the X Direction

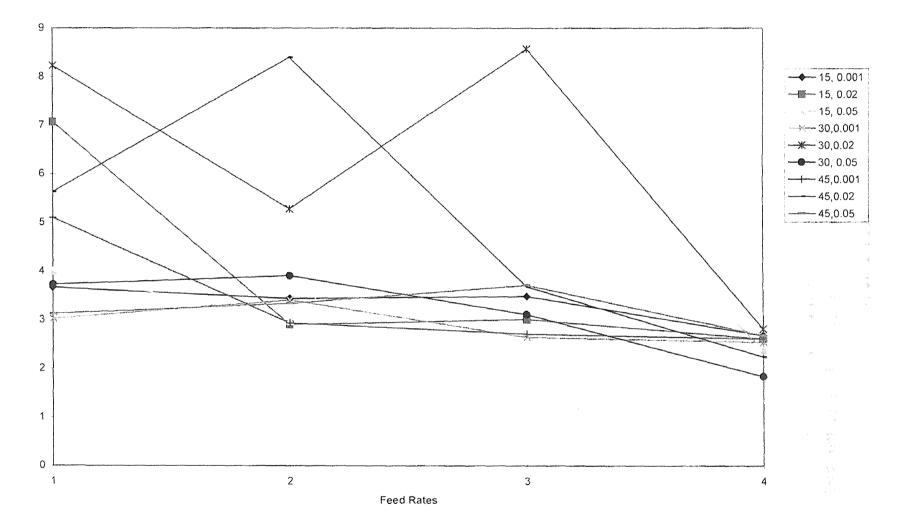




Comparison of the Rp values at different levels of cutting for cutting in the X Direction

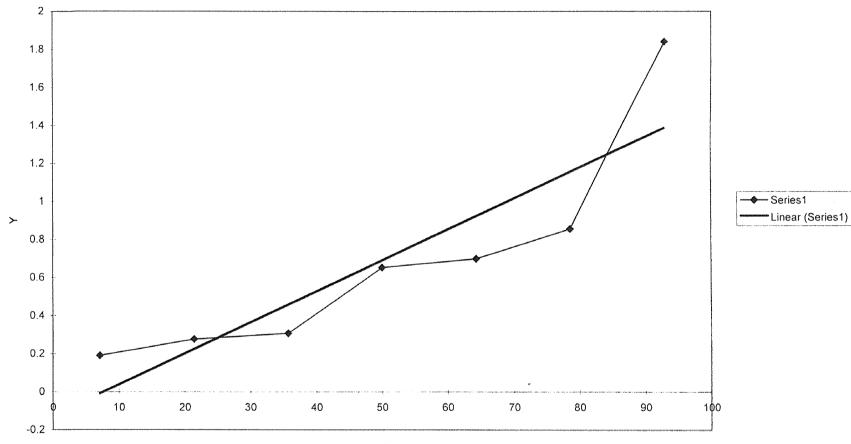
Feed Rates

Comparison of the Rku values at different levels of cutting for cutting in the Y Direction



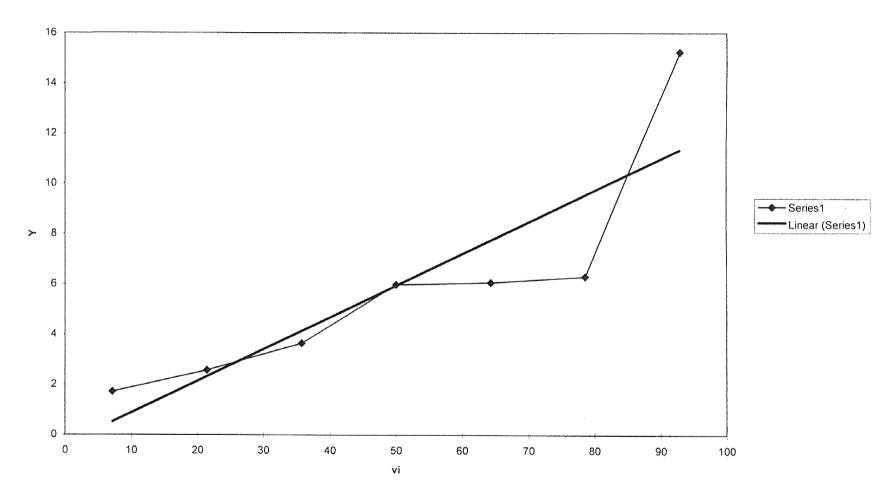
APPENDIX C

PLOTTINGS OF THE VARIATIONS OF THE SURACE TEXTURE AND THE CUTTING FORCE PARAMETERS AT DIFFERENT LEVELS OF CUTTING

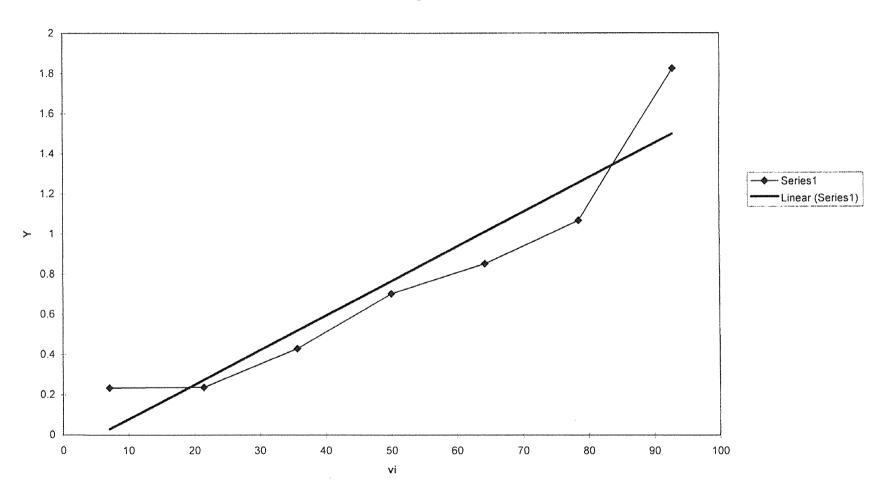


Log Std Rt

vi



S/N Rt



log std Rt

97

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