

3. DESIGN OF EXPERIMENTS AND ANALYSIS

3.1 Design of Experiments

The experimental layout for the machining parameters using the L_{16} orthogonal array was used in this study.

Table no. 3.3.1 Input Machining Parameters

S.NO -	INPUT PARAMETERS	LEVEL,				OBSERVED VALUE
		1	2	3	4	
1.	Current (Ip)	10	13	17	20	Material removal rate (MRR) in g/min.
2.	Pulse on time (T_{on})	50	100	150	200	
3.	Pulse off time (T_{off})	3	6	9	12	
4.	Voltage(V)	20	30	40	50	

This array consists of four control parameters and four levels, as shown in table no. 3.3.1. In the taguchi method, most all of the observed values are calculated based on "higher is the better". Each experimental trial was performed with three simple replications at each set value. Next, the optimization of the observed values was determined by comparing the standard analysis and analysis of variance (ANOVA) which was based on the taguchi method.

3.2 Results and analysis of MRR for machined surface

The effect of parameters I_p , Current, Pulse on time, Pulse off time and Voltage some of their interactions were evaluated using ANOVA. A confidence interval of 95% has been used for the analysis. To measure Signal to Noise ratio (S/N ratio) calculated by the formula.

$$\text{Where } \text{MSD}_{\text{H}} = \frac{1}{n} \sum_{i=1}^n \left(\frac{1}{Y_i} \right)$$

$$(\text{S/N})_{\text{H}} = -10 \log (\text{MSD}_{\text{H}})$$

For material removal rate (MRR) the S/N ratio is larger is better.

Where MSD_H = Mean Square deviation for higher the better response.

3.3 Observation table

During the conduction of all the 16 experiments with different set of input parameters observation were made for the weight lost in the gram from the workpiece in each experiment and time taken in the minute for the machining of each experiment was also observed. For all the readings time taken was 1 hour. After the completion of all the experiments the observation reading of the weight loss and time taken were filled in orthogonal array as shown in table 3.3.1

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Table of Contents Nfitting And Machining April 2013

1. Understanding the eBook Nfitting And Machining April 2013
 - The Rise of Digital Reading Nfitting And Machining April 2013
 - Advantages of eBooks Over Traditional Books
2. Identifying Nfitting And Machining April 2013
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Nfitting And Machining April 2013
 - User-Friendly Interface
4. Exploring eBook Recommendations from Nfitting And Machining April 2013
 - Personalized Recommendations
 - Nfitting And Machining April 2013 User Reviews and Ratings
 - Nfitting And Machining April 2013 and Bestseller Lists
5. Accessing Nfitting And Machining April 2013 Free and Paid eBooks
 - Nfitting And Machining April 2013 Public Domain eBooks
 - Nfitting And Machining April 2013 eBook Subscription Services
 - Nfitting And Machining April 2013 Budget-Friendly Options
6. Navigating Nfitting And Machining April 2013 eBook Formats
 - ePub, PDF, MOBI, and More
 - Nfitting And Machining April 2013 Compatibility with Devices
 - Nfitting And Machining April 2013 Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Nfitting And Machining April 2013
 - Highlighting and Note-Taking Nfitting And Machining April 2013
 - Interactive Elements Nfitting And Machining April 2013
8. Staying Engaged with Nfitting And Machining April 2013

- Joining Online Reading Communities
- Participating in Virtual Book Clubs
- Following Authors and Publishers Nfitting And Machining April 2013
- 9. Balancing eBooks and Physical Books Nfitting And Machining April 2013
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Nfitting And Machining April 2013
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Nfitting And Machining April 2013
 - Setting Reading Goals Nfitting And Machining April 2013
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Nfitting And Machining April 2013
 - Fact-Checking eBook Content of Nfitting And Machining April 2013
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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