

## 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.

$$\text{Where } \text{MSD}_{\text{Hm}} = \frac{1}{n} \sum_{i=1}^n C_{ij}^2$$

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

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

Where MSD<sub>Hm</sub> = 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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