

Sr. No.	Process Parameters			$V_f$ (mm min <sup>-1</sup> )	$N$ (rpm)	Top Burr Width (down-milling side) ( $\mu\text{m}$ )				
	$f_z$ ( $\mu\text{m tooth}^{-1}$ )	$V_c$ (m min <sup>-1</sup> )	$a_p$ ( $\mu\text{m}$ )			Run 1	Run 2	Run 3	Avg.	SD
1	8	5	50	50.93	3183	29.15	30.67	34.12	31.31	2.55
2	8	7.5	75	76.39	4774	23.46	25.86	27.28	25.53	1.93
3	8	10	100	101.85	6366	20.55	24.14	26.34	23.68	2.92
4	10	5	75	63.66	3183	23.51	26.05	29.15	26.24	2.82
5	10	7.5	100	95.49	4774	17.32	22.59	25.16	21.69	4.00
6	10	10	50	127.31	6366	18.75	19.85	22.11	20.24	1.71
7	12	5	100	76.39	3183	9.23	10.98	12.63	10.95	1.70
8	12	7.5	50	114.58	4774	9.29	12.67	14.36	12.11	2.58
9	12	10	75	152.78	6366	9.09	10.18	11.64	10.30	1.28