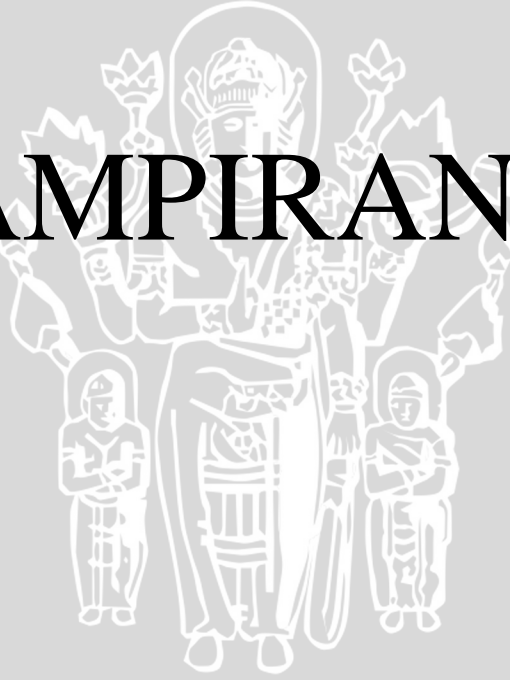


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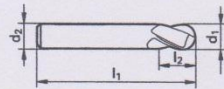
Lampiran 1 Spesifikasi Pahat

Ball nose slot drills (2-fluted)

centre cutting

Gühring no.	3308	3679	6724
Standard	DIN 6527 L		
Tool material	Solid carbide		
Carbide grade	K	K/P	
Surface	○	Ⓡ	Ⓢ
Type	N	N	N
Shank design	HA	HA	HA
Helix	30°	30°	30°
Tolerance	h10	h10	h10
Discount group	117	117	106
Techn. data page	1100	1100	1100

NEW



d1	d2	l1	l2	Z	Code no.
mm	mm	mm	mm		
0.500	3.000	38.00	1.00	2	0.500
0.800	3.000	38.00	1.00	2	0.800
1.000	3.000	38.00	2.00	2	1.000
1.500	3.000	38.00	3.00	2	1.500
2.000	6.000	57.00	6.00	2	2.000
3.000	6.000	57.00	7.00	2	3.000
4.000	6.000	57.00	8.00	2	4.000
5.000	6.000	57.00	10.00	2	5.000
6.000	6.000	57.00	10.00	2	6.000
8.000	8.000	63.00	16.00	2	8.000
10.000	10.000	72.00	19.00	2	10.000
12.000	12.000	83.00	22.00	2	12.000
14.000	14.000	83.00	22.00	2	14.000
14.000	16.000	92.00	26.00	2	14.001
16.000	16.000	92.00	26.00	2	16.000
18.000	18.000	92.00	26.00	2	18.000
18.000	20.000	104.00	32.00	2	18.001
20.000	20.000	104.00	32.00	2	20.000



HPC radius end mills

Ⓒ TiCN
Ⓒ Carbo
Ⓓ Crisall
Ⓡ FIRE/nanoFIRE
Ⓟ AlCrN
Ⓢ TiN
Ⓢ+ TiN+
Ⓜ MolyGlide
Ⓢ Signum

GUHRING

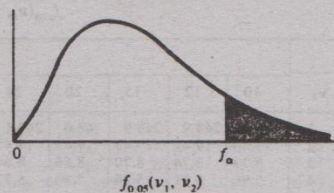
1171

Lampiran 2 Tabel Uji F

Lampiran

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TABEL A.7
Nilai Kritik Sebaran F

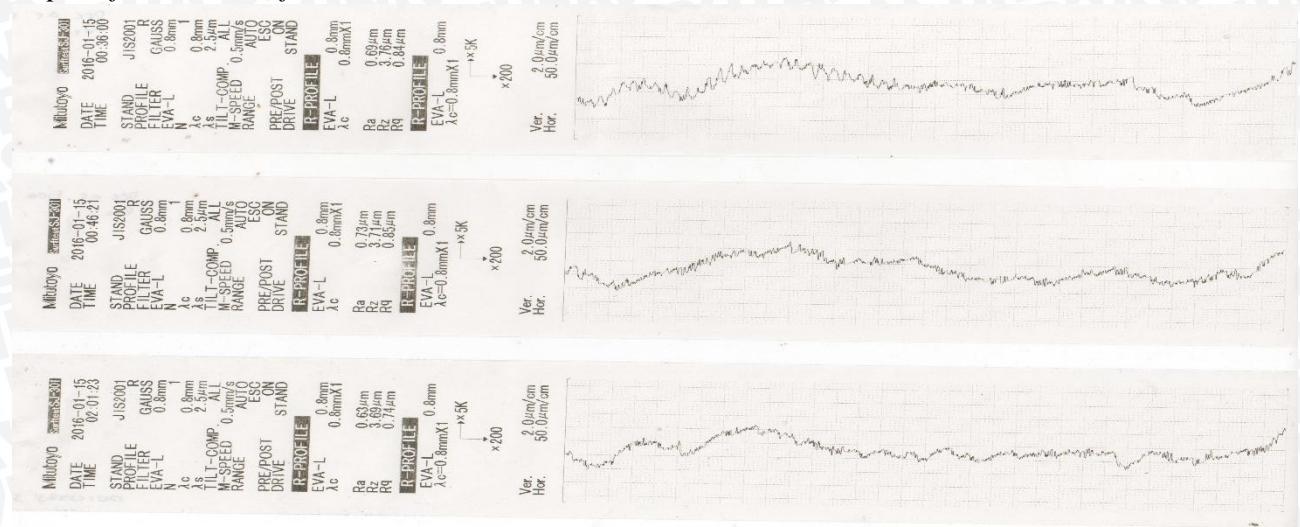


ν_2	ν_1								
	1	2	3	4	5	6	7	8	9
1	161.4	199.5	215.7	224.6	230.2	234.0	236.8	238.9	240.5
2	18.51	19.00	19.16	19.25	19.30	19.33	19.35	19.37	19.38
3	10.13	9.55	9.28	9.12	9.01	8.94	8.89	8.85	8.81
4	7.71	6.94	6.59	6.39	6.26	6.16	6.09	6.04	6.00
5	6.61	5.79	5.41	5.19	5.05	4.95	4.88	4.82	4.77
6	5.99	5.14	4.76	4.53	4.39	4.28	4.21	4.15	4.10
7	5.59	4.74	4.35	4.12	3.97	3.87	3.79	3.73	3.68
8	5.32	4.46	4.07	3.84	3.69	3.58	3.50	3.44	3.39
9	5.12	4.26	3.86	3.63	3.48	3.37	3.29	3.23	3.18
10	4.96	4.10	3.71	3.48	3.33	3.22	3.14	3.07	3.02
11	4.84	3.98	3.59	3.36	3.20	3.09	3.01	2.95	2.90
12	4.75	3.89	3.49	3.26	3.11	3.00	2.91	2.85	2.80
13	4.67	3.81	3.41	3.18	3.03	2.92	2.83	2.77	2.71
14	4.60	3.74	3.34	3.11	2.96	2.85	2.76	2.70	2.65
15	4.54	3.68	3.29	3.06	2.90	2.79	2.71	2.64	2.59
16	4.49	3.63	3.24	3.01	2.85	2.74	2.66	2.59	2.54
17	4.45	3.59	3.20	2.96	2.81	2.70	2.61	2.55	2.49
18	4.41	3.55	3.16	2.93	2.77	2.66	2.58	2.51	2.46
19	4.38	3.52	3.13	2.90	2.74	2.63	2.54	2.48	2.42
20	4.35	3.49	3.10	2.87	2.71	2.60	2.51	2.45	2.39
21	4.32	3.47	3.07	2.84	2.68	2.57	2.49	2.42	2.37
22	4.30	3.44	3.05	2.82	2.66	2.55	2.46	2.40	2.34
23	4.28	3.42	3.03	2.80	2.64	2.53	2.44	2.37	2.32
24	4.26	3.40	3.01	2.78	2.62	2.51	2.42	2.36	2.30
25	4.24	3.39	2.99	2.76	2.60	2.49	2.40	2.34	2.28
26	4.23	3.37	2.98	2.74	2.59	2.47	2.39	2.32	2.27
27	4.21	3.35	2.96	2.73	2.57	2.46	2.37	2.31	2.25
28	4.20	3.34	2.95	2.71	2.56	2.45	2.36	2.29	2.24
29	4.18	3.33	2.93	2.70	2.55	2.43	2.35	2.28	2.22
30	4.17	3.32	2.92	2.69	2.53	2.42	2.33	2.27	2.21
40	4.08	3.23	2.84	2.61	2.45	2.34	2.25	2.18	2.12
60	4.00	3.15	2.76	2.53	2.37	2.25	2.17	2.10	2.04
120	3.92	3.07	2.68	2.45	2.29	2.17	2.09	2.02	1.96
∞	3.84	3.00	2.60	2.37	2.21	2.10	2.01	1.94	1.88

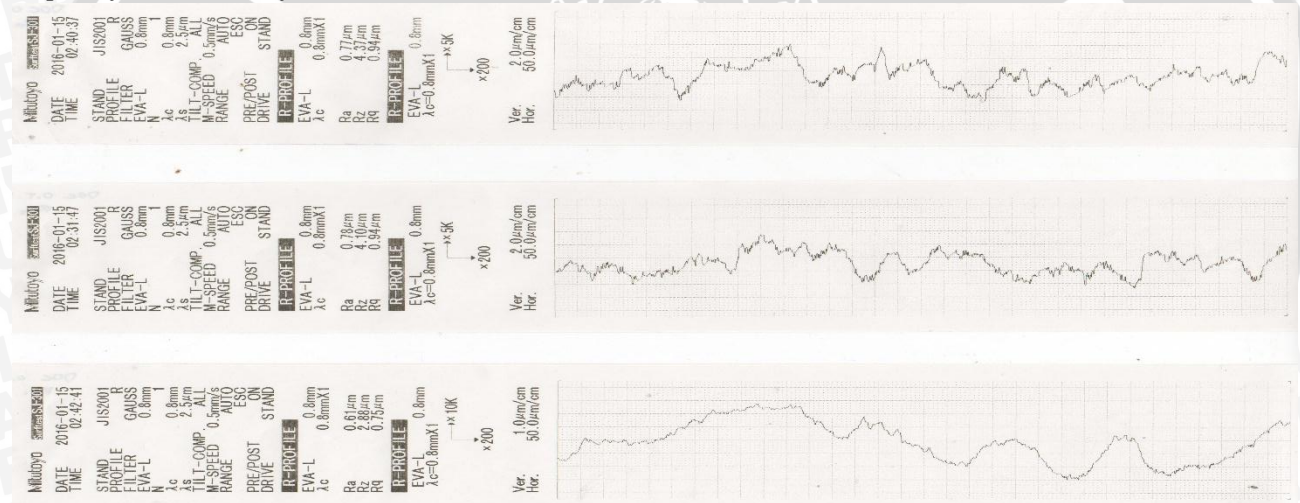
*Direproduksi dari Tabel 18 *Biometrika Tables for Statisticians*, Vol. I, dengan izin dari E. S. Pearson dan Biometrika Trustees.

Lampiran 3 Hasil uji kekerasan permukaan

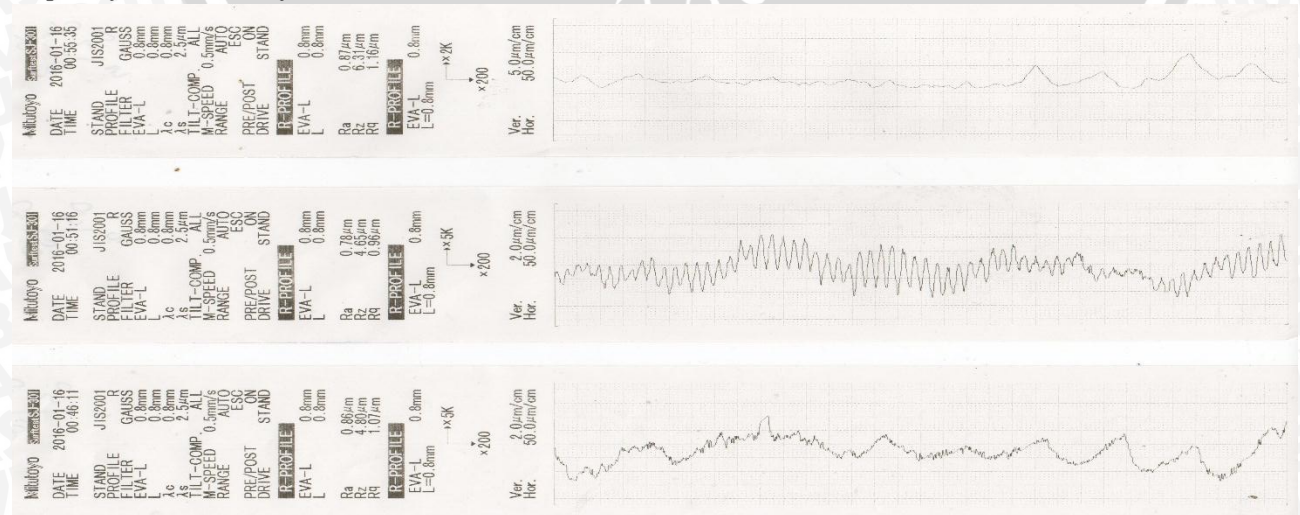
Depth of cut 0,5mm, feed rate 100mm/min



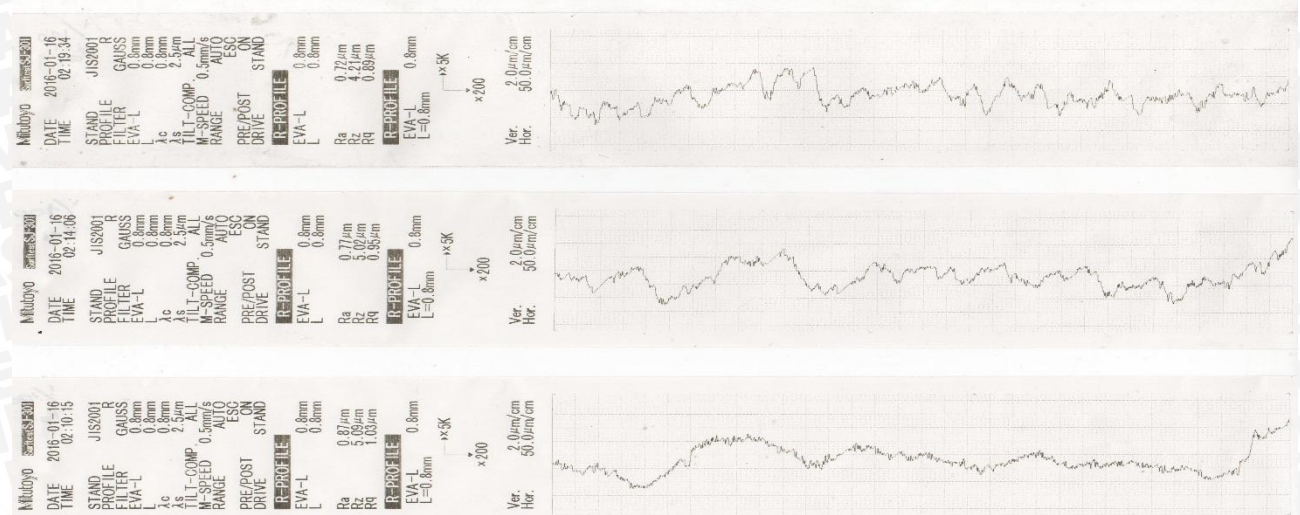
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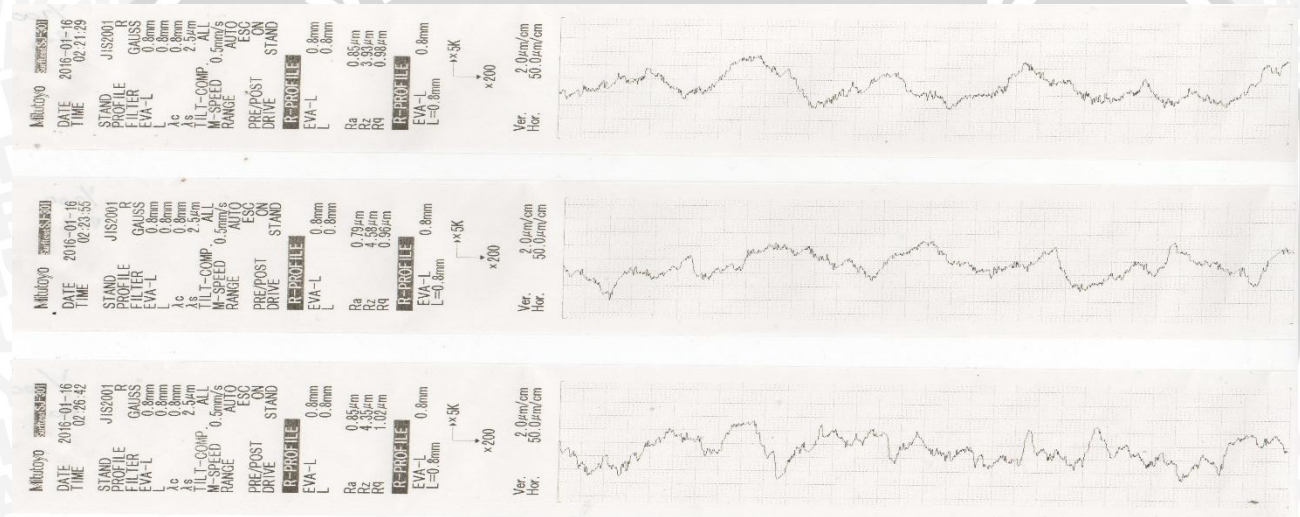
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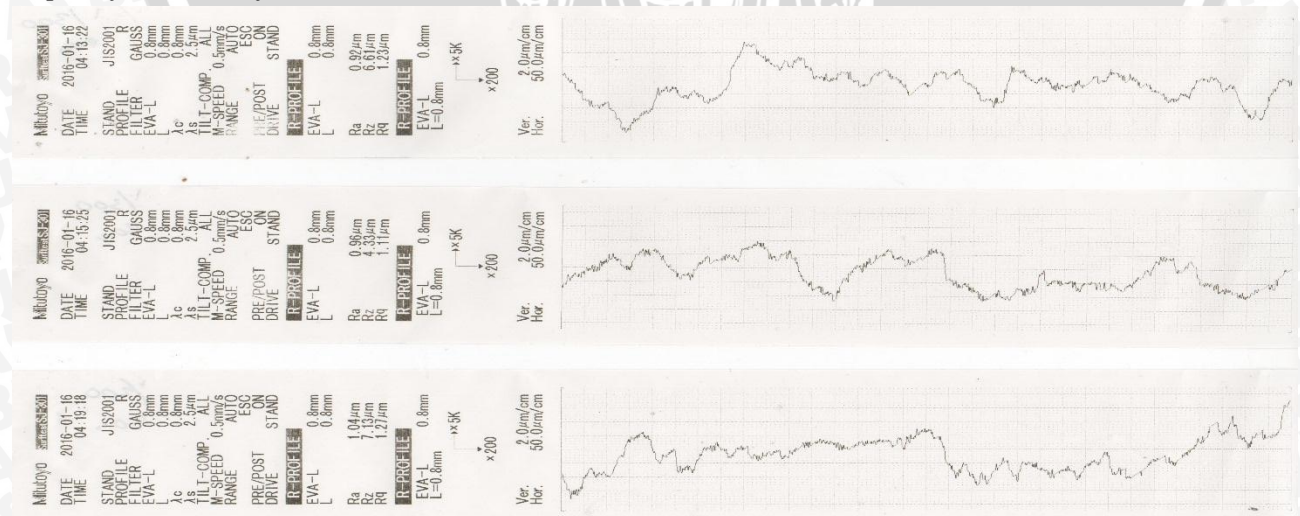
Depth of cut 1mm, feed rate 100mm/min



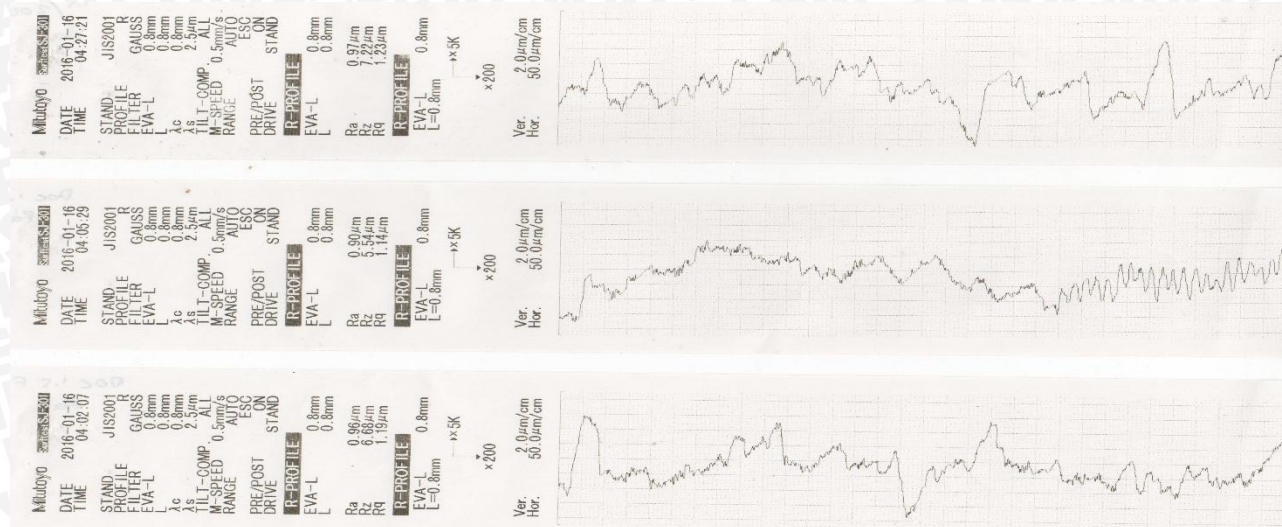
Depth of cut 1mm, feed rate 200mm/min



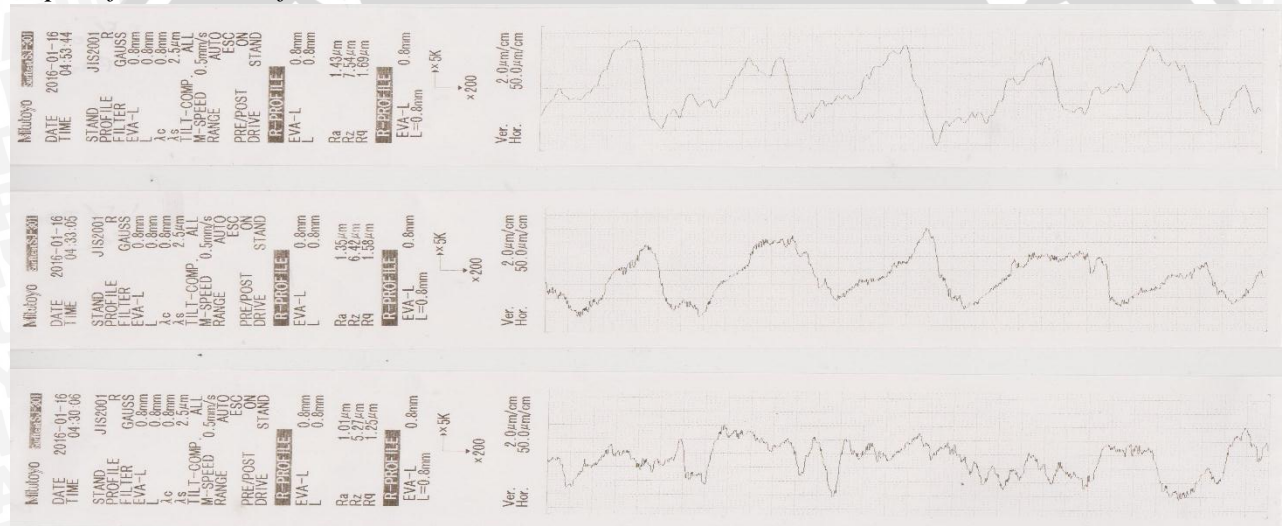
Depth of cut 1mm, feed rate 300



Depth of cut 1,5mm, feed rate 100mm/min



Depth of cut 1,5mm, feed rate 200mm/min

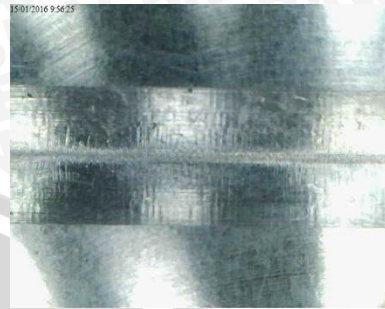
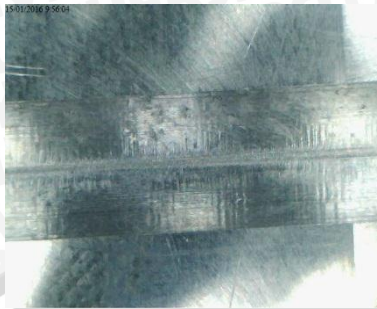
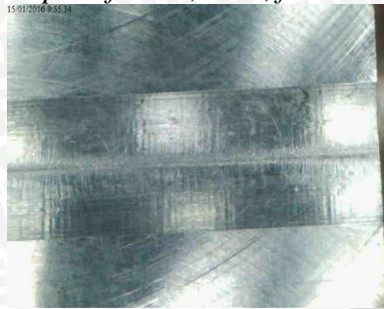


Depth of cut 1,5mm, feed rate 300\

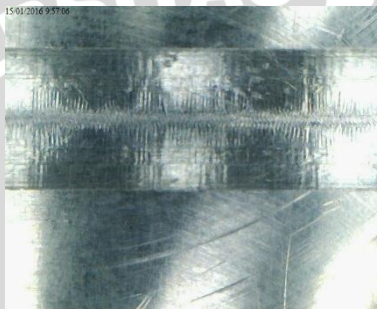
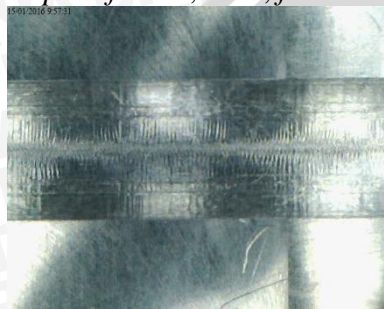


Lampiran 4 Foto makro

Depth of cut 0,5mm, feed rate 100mm/min



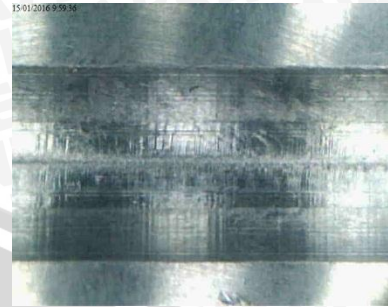
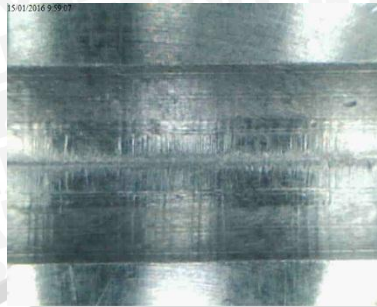
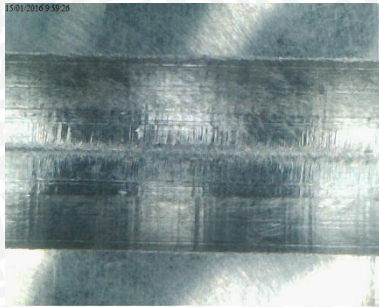
Depth of cut 0,5mm, feed rate 200mm/min



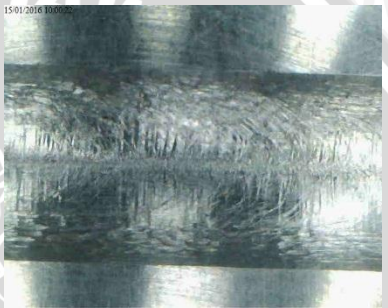
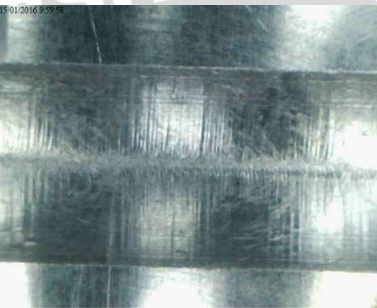
Depth of cut 0,5mm, feed rate 300mm/min



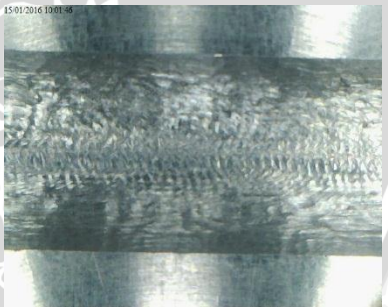
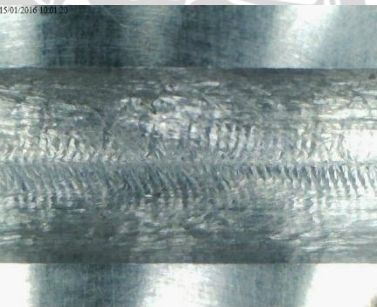
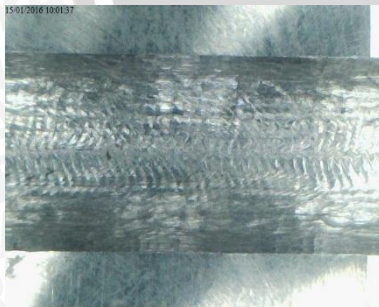
Depth of cut 1mm, feed rate 100mm/min



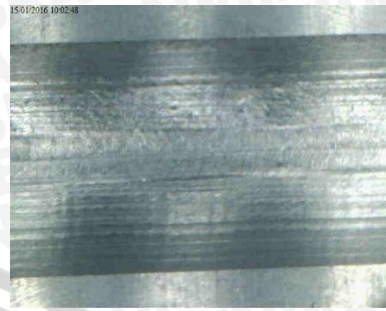
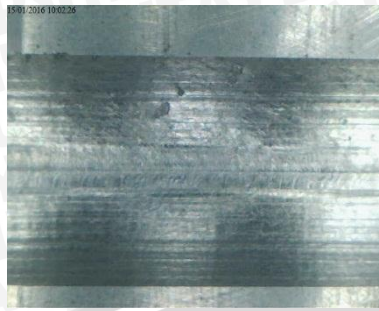
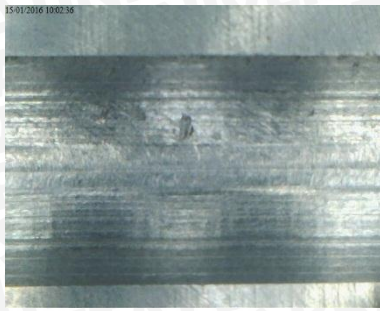
Depth of cut 1mm, feed rate 200mm/min



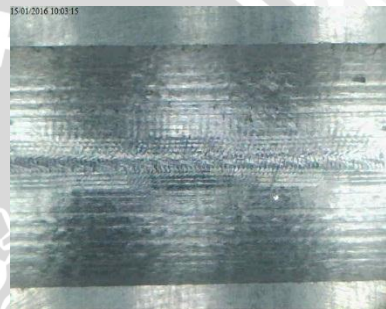
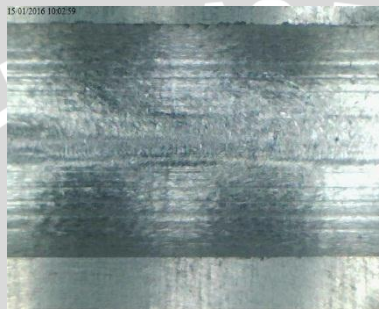
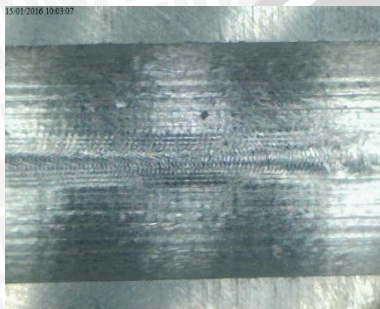
Depth of cut 1mm, feed rate 300mm/min



Depth of cut 1,5mm, feed rate 100mm/min



Depth of cut 1,5mm, feed rate 200mm/min



Depth of cut 1,5mm, feed rate 300mm/min

