

ภาคผนวก ก ตารางบันทึกผลการทดลอง

ตารางภาคผนวก ก 1 แสดงผลการทดลองค่าความขรุขระของพื้นผิวที่ผ่านการกลึงด้วยใบมีดคาร์ไบด์

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	Dia (mm)	RPM (rev/min)	$R_a$				$R_q$				$R_t$			
						1	2	3	ave	1	2	3	ave	1	2	3	ave
1	400	0.1	0.2	56.97	2236	0.67	0.66	0.64	0.66	0.86	0.82	0.8	0.83	6.53	5.14	6.1	5.92
2	400	0.02	0.2	63.18	2016	0.45	0.47	0.51	0.48	0.59	0.67	0.68	0.65	5.39	8.2	4.54	6.04
3	250	0.1	0.1	67.44	1181	0.69	0.7	0.72	0.70	0.89	0.97	0.94	0.93	8.55	11.46	10.84	10.28
4	550	0.1	0.3	68.61	2553	0.64	0.63	0.61	0.63	0.8	0.79	0.78	0.79	7.33	5.1	7.22	6.55
5	550	0.06	0.1	73.59	2380	0.76	0.68	0.72	0.72	1.07	0.83	0.95	0.95	12.55	6.09	7.37	8.67
6	400	0.06	0.1	60.79	2096	0.46	0.48	0.43	0.46	0.7	0.62	0.56	0.63	10.39	7.46	5.51	7.79
7	250	0.02	0.2	72.02	1106	0.66	0.6	0.64	0.63	0.83	0.79	0.82	0.81	6.67	6.39	6.08	6.38
8	250	0.06	0.1	70.2	1134	0.42	0.46	0.45	0.44	0.52	0.62	0.57	0.57	3.71	6.31	5.38	5.13
9	250	0.1	0.3	65.86	1209	0.7	0.71	0.74	0.72	0.84	0.89	0.93	0.89	4.59	9.2	7.06	6.95
10	250	0.02	0.1	72.44	1099	0.59	0.65	0.64	0.63	0.77	0.8	0.82	0.80	6.97	4.71	6.04	5.91
11	550	0.1	0.1	70.6	2481	0.81	0.83	0.84	0.83	0.98	1.02	1.04	1.01	5.54	7.65	7.04	6.74
12	550	0.02	0.3	74.98	2336	0.56	0.58	0.6	0.58	0.76	0.76	0.81	0.78	7.1	7.8	7.96	7.62
13	400	0.06	0.3	58.99	2160	0.55	0.51	0.53	0.53	0.91	0.65	0.7	0.75	12.94	6.6	5.72	8.42

ตารางภาคผนวก ก 1 (ต่อ)

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	Dia (mm)	RPM (rev/min)	R <sub>s</sub>				R <sub>a</sub>				R <sub>z</sub>			
						1	2	3	ave	1	2	3	ave	1	2	3	ave
14	550	0.06	0.2	72.79	2406	0.61	0.62	0.63	0.62	0.78	0.68	0.71	0.72	5.27	5.47	8.39	6.38
15	550	0.02	0.1	54.39	3220	0.66	0.64	0.65	0.65	0.84	0.86	0.85	0.85	7.01	8.2	6.33	7.18
16	400	0.02	0.3	62.19	2048	0.47	0.45	0.51	0.48	0.64	0.57	0.7	0.64	7.86	4.23	8.35	6.81
17	250	0.1	0.2	66.63	1195	0.73	0.73	0.71	0.72	0.89	0.9	0.87	0.89	7.53	6.17	5.64	6.45
18	550	0.06	0.3	71.8	2440	0.6	0.67	0.58	0.62	0.81	0.88	0.83	0.84	7.88	11.04	7.48	8.80
19	550	0.1	0.2	69.6	2517	0.64	0.66	0.61	0.64	0.83	0.83	0.78	0.81	10.85	5.17	5.52	7.18
20	400	0.1	0.3	55.81	2283	0.65	0.6	0.59	0.61	0.83	0.76	0.74	0.78	5.52	5.81	5.41	5.58
21	400	0.1	0.1	57.8	2204	0.7	0.68	0.67	0.68	0.86	0.85	0.85	0.85	5.04	6.39	8.07	6.50
22	250	0.06	0.3	68.63	1160	0.58	0.53	0.57	0.56	0.77	0.69	0.75	0.74	4.9	6.06	4.08	5.01
23	550	0.02	0.2	53.43	3278	0.62	0.57	0.61	0.60	0.83	0.82	0.81	0.82	6.66	7.3	9.59	7.85
24	400	0.02	0.1	64.2	1984	0.53	0.49	0.5	0.51	0.66	0.62	0.67	0.65	5.04	4.77	8.6	6.14
25	250	0.02	0.3	71.14	1119	0.62	0.65	0.6	0.62	0.82	0.91	0.75	0.83	6.9	11.19	6.11	8.07
26	400	0.06	0.2	59.98	2124	0.63	0.55	0.66	0.61	0.86	0.72	0.89	0.82	10.43	6.61	9.02	8.69

ตารางภาคผนวก ก 1 (ต่อ)

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	Dia (mm)	RPM (rev/min)	$R_a$				$R_q$				$R_t$			
						1	2	3	ave	1	2	3	ave	1	2	3	ave
27	250	0.06	0.2	69.42	1147	0.51	0.49	0.5	0.50	0.69	0.64	0.67	0.67	6.52	5.89	5.69	6.03
28	400	0.1	0.2	56.97	2236	0.66	0.65	0.64	0.65	0.86	0.81	0.78	0.82	9.14	7.44	5.51	7.36
29	250	0.1	0.2	66.63	1195	0.73	0.69	0.7	0.71	0.98	0.91	0.87	0.92	12.84	9.07	7.59	9.83
30	250	0.02	0.2	72.02	1106	0.57	0.62	0.6	0.60	0.75	0.84	0.81	0.80	8.79	7.47	7.65	7.97
31	550	0.06	0.3	71.79	2440	0.69	0.67	0.65	0.67	0.84	0.8	0.77	0.80	4.66	5.51	4.55	4.91
32	550	0.06	0.1	73.59	2380	0.72	0.72	0.71	0.72	0.93	0.89	0.87	0.90	8	6.9	5.23	6.71
33	400	0.1	0.3	55.8	2283	0.59	0.62	0.66	0.62	0.8	0.84	0.84	0.83	11.13	9.96	6.62	9.24
34	250	0.06	0.3	68.62	1160	0.52	0.54	0.5	0.52	0.67	0.71	0.64	0.67	3.91	6.8	3.83	4.85
35	400	0.1	0.1	57.8	2204	0.7	0.7	0.67	0.69	0.84	0.86	0.83	0.84	5.97	6.72	8.1	6.93
36	550	0.02	0.3	74.98	2336	0.67	0.66	0.62	0.65	0.89	0.86	0.87	0.87	6.58	6.69	9.05	7.44
28	400	0.1	0.2	56.97	2236	0.66	0.65	0.64	0.65	0.86	0.81	0.78	0.82	9.14	7.44	5.51	7.36
29	250	0.1	0.2	66.63	1195	0.73	0.69	0.7	0.71	0.98	0.91	0.87	0.92	12.84	9.07	7.59	9.83
30	250	0.02	0.2	72.02	1106	0.57	0.62	0.6	0.60	0.75	0.84	0.81	0.80	8.79	7.47	7.65	7.97
31	550	0.06	0.3	71.79	2440	0.69	0.67	0.65	0.67	0.84	0.8	0.77	0.80	4.66	5.51	4.55	4.91

ตารางภาคผนวก ก 1 (ต่อ)

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	Dia (mm)	RPM (rev/min)	$R_a$				$R_q$				$R_t$			
						1	2	3	ave	1	2	3	ave	1	2	3	ave
32	550	0.06	0.1	73.59	2380	0.72	0.72	0.71	0.72	0.93	0.89	0.87	0.90	8	6.9	5.23	6.71
33	400	0.1	0.3	55.8	2283	0.59	0.62	0.66	0.62	0.8	0.84	0.84	0.83	11.13	9.96	6.62	9.24
34	250	0.06	0.3	68.62	1160	0.52	0.54	0.5	0.52	0.67	0.71	0.64	0.67	3.91	6.8	3.83	4.85
35	400	0.1	0.1	57.8	2204	0.7	0.7	0.67	0.69	0.84	0.86	0.83	0.84	5.97	6.72	8.1	6.93
36	550	0.02	0.3	74.98	2336	0.67	0.66	0.62	0.65	0.89	0.86	0.87	0.87	6.58	6.69	9.05	7.44
37	250	0.02	0.1	72.44	1099	0.59	0.63	0.65	0.62	0.77	0.84	0.83	0.81	10.12	9.63	5.12	8.29
38	250	0.1	0.1	67.43	1181	0.66	0.67	0.65	0.66	0.86	0.85	0.84	0.85	7.74	8.66	6.33	7.58
39	250	0.1	0.3	65.87	1209	0.71	0.7	0.72	0.71	0.86	0.86	0.89	0.87	5.09	7.59	7.1	6.59
40	400	0.06	0.3	58.97	2160	0.55	0.54	0.55	0.55	0.74	0.75	0.82	0.77	8.2	8.81	10.75	9.25
41	250	0.06	0.1	70.2	1134	0.47	0.49	0.47	0.48	0.59	0.62	0.58	0.60	4.23	6.9	3.94	5.02
42	400	0.02	0.2	63.18	2016	0.47	0.5	0.48	0.48	0.59	0.65	0.6	0.61	3.87	4.79	3.94	4.20
43	250	0.06	0.2	69.42	1147	0.52	0.53	0.5	0.52	0.72	0.7	0.65	0.69	8.5	7.04	4.96	6.83
44	550	0.06	0.2	72.79	2406	0.66	0.61	0.64	0.64	0.79	0.69	0.79	0.76	6.43	4.22	6.31	5.65
45	250	0.02	0.3	71.13	1119	0.66	0.65	0.67	0.66	0.9	0.82	0.91	0.88	8.89	6.7	7.55	7.71

ตารางภาคผนวก ก 1 (ต่อ)

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	Dia (mm)	RPM (rev/min)	$R_s$				$R_a$				$R_t$			
						1	2	3	ave	1	2	3	ave	1	2	3	ave
46	550	0.02	0.2	53.43	3278	0.65	0.66	0.62	0.64	0.82	0.85	0.89	0.85	7.25	5.7	10.21	7.72
47	550	0.1	0.1	70.6	2481	0.8	0.76	0.82	0.79	1	0.96	1.03	1.00	8.3	8.35	8.77	8.47
48	550	0.02	0.1	54.4	3220	0.67	0.65	0.7	0.67	0.88	0.86	0.96	0.90	8.55	6.49	9.09	8.04
49	550	0.1	0.3	68.6	2553	0.63	0.61	0.66	0.63	0.82	0.79	0.85	0.82	8.25	7.38	6.65	7.43
50	400	0.06	0.1	60.78	2096	0.41	0.42	0.44	0.42	0.5	0.55	0.53	0.53	3.37	7.49	4.46	5.11
51	400	0.02	0.3	62.2	2048	0.55	0.57	0.52	0.55	0.69	0.73	0.65	0.69	7.12	6.33	5.16	6.20
52	400	0.06	0.2	59.98	2124	0.65	0.57	0.61	0.61	0.84	0.71	0.77	0.77	7.86	5.46	5.4	6.24
53	400	0.02	0.1	64.2	1984	0.46	0.47	0.48	0.47	0.66	0.62	0.62	0.63	9.13	5.88	5.4	6.80
54	550	0.1	0.2	69.59	2517	0.69	0.67	0.65	0.67	0.94	0.87	0.79	0.87	10.17	8.47	4.72	7.79
55	250	0.02	0.3	71.14	1119	0.64	0.61	0.63	0.63	0.89	0.78	0.84	0.84	9.63	6.78	7.91	8.11
56	400	0.06	0.1	60.79	2096	0.42	0.45	0.48	0.45	0.52	0.56	0.61	0.56	3.17	3.63	3.88	3.56
57	250	0.06	0.1	70.2	1134	0.44	0.48	0.47	0.46	0.55	0.59	0.55	0.56	3.17	3.33	3.16	3.22
58	400	0.02	0.1	64.21	1984	0.48	0.5	0.48	0.49	0.63	0.71	0.73	0.69	10.47	6.65	12.89	10.00
59	250	0.1	0.2	66.63	1195	0.68	0.73	0.71	0.71	0.86	0.93	0.96	0.92	5	9.65	9.62	8.09

ตารางภาคผนวก ก 1 (ต่อ)

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	Dia (mm)	RPM (rev/min)	$R_a$				$R_q$				$R_t$			
						1	2	3	ave	1	2	3	ave	1	2	3	ave
60	250	0.06	0.2	69.42	1147	0.6	0.58	0.59	0.59	0.76	0.72	0.72	0.73	7.35	5.4	6.2	6.32
61	400	0.1	0.3	55.81	2283	0.58	0.67	0.64	0.63	0.79	0.93	0.8	0.84	7.33	7.5	6.17	7.00
62	400	0.1	0.1	57.8	2204	0.73	0.7	0.71	0.71	0.89	0.83	0.85	0.86	6.23	4.62	7.68	6.18
63	250	0.02	0.1	72.44	1099	0.51	0.61	0.6	0.57	0.77	0.85	0.9	0.84	10.19	10.67	14.63	11.83
64	550	0.1	0.1	70.6	2481	0.82	0.83	0.77	0.81	1.16	1.08	0.98	1.07	17.65	10.4	8.09	12.05
65	550	0.06	0.3	71.78	2440	0.67	0.67	0.62	0.65	0.84	0.88	0.83	0.85	4.84	8.32	5.39	6.18
66	550	0.06	0.1	73.59	2380	0.71	0.74	0.69	0.71	0.93	0.94	0.9	0.92	7.1	6.39	7.91	7.13
67	400	0.1	0.2	56.98	2236	0.64	0.62	0.61	0.62	0.8	0.83	0.76	0.80	4.83	8.43	5.28	6.18
68	550	0.02	0.3	74.97	2336	0.63	0.66	0.62	0.64	0.83	0.97	0.78	0.86	5.67	11.67	4.87	7.40
69	550	0.06	0.2	72.79	2406	0.53	0.55	0.59	0.56	0.75	0.75	0.82	0.77	6.07	4.45	5.53	5.35
70	550	0.02	0.1	54.39	3220	0.6	0.61	0.64	0.62	0.85	0.75	0.85	0.82	8.44	6.97	8.76	8.06
71	250	0.1	0.3	65.85	1209	0.75	0.72	0.74	0.74	0.94	0.89	0.9	0.91	7.61	6.15	5.69	6.48
72	250	0.02	0.2	72.02	1106	0.61	0.56	0.59	0.59	0.81	0.71	0.76	0.76	7.52	5.85	6.68	6.68
73	400	0.06	0.3	58.98	2160	0.55	0.52	0.5	0.52	0.72	0.65	0.62	0.66	7.65	6.5	4.32	6.16

ตารางภาคผนวก ก 1 (ต่อ)

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	Dia (mm)	RPM (rev/min)	R <sub>a</sub>				R <sub>q</sub>				R <sub>t</sub>			
						1	2	3	ave	1	2	3	ave	1	2	3	ave
74	400	0.06	0.2	59.97	2124	0.66	0.6	0.61	0.62	0.81	0.74	0.8	0.78	5.11	4.87	7.18	5.72
75	550	0.1	0.2	69.6	2517	0.66	0.59	0.61	0.62	0.94	0.81	0.87	0.87	10.89	9.8	10.72	10.47
76	550	0.1	0.3	68.6	2553	0.6	0.59	0.64	0.61	0.88	0.75	0.85	0.83	10.98	5.44	7.15	7.86
77	550	0.02	0.2	53.43	3278	0.66	0.63	0.6	0.63	0.92	0.83	0.77	0.84	10.73	11.46	5.38	9.19
78	400	0.02	0.2	63.19	2016	0.48	0.51	0.51	0.50	0.6	0.68	0.66	0.65	4.03	6.92	7.03	5.99
79	250	0.1	0.1	67.43	1181	0.71	0.69	0.68	0.69	0.92	0.88	0.87	0.89	7.17	7.16	5.6	6.64
80	400	0.02	0.3	62.2	2048	0.58	0.52	0.57	0.56	0.78	0.71	0.72	0.74	6.04	7.07	4.43	5.85
81	250	0.06	0.3	68.62	1160	0.55	0.53	0.57	0.55	0.69	0.72	0.73	0.71	4.29	8.96	7.52	6.92
82	550	0.1	0.2	69.58	2517	0.62	0.63	0.61	0.62	0.8	0.82	0.79	0.80	6.97	8.29	7.25	7.50
83	250	0.06	0.2	69.42	1147	0.57	0.53	0.59	0.56	0.75	0.74	0.79	0.76	5.88	5.63	5.54	5.68
84	400	0.1	0.2	56.98	2236	0.64	0.59	0.62	0.62	0.8	0.74	0.79	0.78	5.29	6.14	6.03	5.82
85	550	0.02	0.1	54.39	3220	0.63	0.64	0.68	0.65	0.86	0.88	0.88	0.87	9.34	9.31	6.93	8.53
86	550	0.02	0.2	53.43	3278	0.61	0.65	0.67	0.64	0.78	0.86	0.84	0.83	6.62	9.14	5.69	7.15
87	250	0.1	0.3	65.86	1209	0.74	0.72	0.75	0.74	0.92	0.93	0.94	0.93	4.91	9.45	4.89	6.42

ตารางภาคผนวก ก 1 (ต่อ)

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	Dia (mm)	RPM (rev/min)	$R_a$				$R_q$				$R_t$			
						1	2	3	ave	1	2	3	ave	1	2	3	ave
88	550	0.1	0.1	70.6	2481	0.8	0.77	0.8	0.79	1.11	1.01	1	1.04	10.46	10.76	8.15	9.79
89	400	0.02	0.2	63.18	2016	0.45	0.43	0.56	0.48	0.6	0.6	0.7	0.63	4.2	6.32	4.77	5.10
90	250	0.02	0.1	72.45	1099	0.62	0.6	0.62	0.61	0.76	0.87	0.77	0.80	5.51	11.44	5.91	7.62
91	550	0.06	0.3	71.78	2440	0.72	0.68	0.66	0.69	0.89	0.8	0.79	0.83	6.86	5.3	4.18	5.45
92	400	0.1	0.3	55.8	2283	0.61	0.6	0.64	0.62	0.94	0.8	0.98	0.91	11.56	6.16	14.7	10.81
93	400	0.06	0.3	58.99	2160	0.54	0.51	0.51	0.52	0.64	0.7	0.65	0.66	4.85	7.54	6.07	6.15
94	400	0.06	0.1	60.79	2096	0.49	0.42	0.49	0.47	0.61	0.51	0.61	0.58	4.83	3.31	5.68	4.61
95	250	0.1	0.1	67.43	1181	0.76	0.73	0.75	0.75	0.99	0.89	0.95	0.94	8.05	4.96	6.74	6.58
96	400	0.1	0.1	57.8	2204	0.71	0.74	0.71	0.72	0.84	0.93	0.87	0.88	4.38	10.37	5.41	6.72
97	550	0.06	0.1	73.59	2380	0.76	0.71	0.68	0.72	0.97	0.88	0.85	0.90	8.08	6.58	5.83	6.83
98	250	0.06	0.1	70.21	1134	0.44	0.45	0.43	0.44	0.55	0.57	0.55	0.56	3.16	4.67	4.03	3.95
99	400	0.02	0.1	64.2	1984	0.43	0.49	0.48	0.47	0.53	0.69	0.61	0.61	3.37	9.29	5.85	6.17
100	550	0.1	0.3	68.6	2553	0.58	0.59	0.61	0.59	0.78	0.77	0.86	0.80	5.05	7.56	9.31	7.31
101	400	0.06	0.2	59.98	2124	0.63	0.61	0.59	0.61	0.79	0.76	0.72	0.76	4.67	5.46	4.04	4.72



ตารางภาคผนวก ก 1 (ต่อ)

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	Dia (mm)	RPM (rev/min)	$R_a$				$R_q$				$R_t$			
						1	2	3	ave	1	2	3	ave	1	2	3	ave
102	400	0.02	0.3	62.2	2048	0.55	0.53	0.57	0.55	0.72	0.68	0.77	0.72	5.82	6.21	5.84	5.96
103	250	0.06	0.3	68.62	1160	0.5	0.55	0.57	0.54	0.64	0.69	0.78	0.70	5.18	4.41	9.51	6.37
104	550	0.02	0.3	74.98	2336	0.66	0.58	0.62	0.62	0.85	0.73	0.86	0.81	6	5.28	6.26	5.85
105	250	0.02	0.3	71.14	1119	0.61	0.67	0.64	0.64	0.74	0.85	0.8	0.80	4.38	6.52	5.1	5.33
106	250	0.1	0.2	66.62	1195	0.7	0.66	0.64	0.67	0.87	0.82	0.84	0.84	7.04	7.3	10.35	8.23
107	550	0.06	0.2	72.79	2406	0.61	0.59	0.6	0.60	0.83	0.77	0.79	0.80	5.46	5.35	6	5.60
108	250	0.02	0.2	72.02	1106	0.6	0.59	0.61	0.60	0.76	0.74	0.79	0.76	5.73	5.67	9.35	6.92

ตารางภาคผนวก ก 2 แสดงผลการทดลองค่าความขรุขระของพื้นผิวที่ผ่านการกลึงด้วยใบมีดเซรามิก

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	Dia (mm)	RPM (rev/min)	$R_a$				$R_q$				$R_t$			
						1	2	3	ave	1	2	3	ave	1	2	3	ave
1	400	0.1	0.2	56.97	2236	0.67	0.61	0.63	0.64	1.09	1	0.76	0.95	10.78	19.1	4.21	11.36
2	400	0.02	0.2	63.19	2016	0.46	0.47	0.43	0.45	0.62	0.59	0.55	0.59	6.72	7.01	4.31	6.01
3	250	0.1	0.1	67.43	1181	0.57	0.6	0.59	0.59	0.72	0.87	0.73	0.77	4.68	9.88	5.31	6.62
4	550	0.1	0.3	68.6	2553	0.49	0.46	0.47	0.47	0.65	0.58	0.68	0.64	7.12	4.49	8.39	6.67
5	550	0.06	0.1	73.59	2380	0.46	0.43	0.43	0.44	0.59	0.53	0.58	0.57	6.74	3.92	8.18	6.28
6	400	0.06	0.1	60.78	2096	0.49	0.48	0.47	0.48	0.61	0.59	0.57	0.59	4.78	4.98	4.65	4.80
7	250	0.02	0.2	72.02	1106	0.56	0.57	0.54	0.56	0.8	0.75	0.67	0.74	10.31	5.54	4.28	6.71
8	250	0.06	0.1	70.2	1134	0.72	0.7	0.72	0.71	0.88	0.86	0.86	0.87	4.5	5.02	6.37	5.30
9	250	0.1	0.3	65.86	1209	0.48	0.57	0.52	0.52	0.64	0.72	0.63	0.66	10.74	4.68	4.82	6.75
10	250	0.02	0.1	72.44	1099	0.67	0.63	0.72	0.67	0.84	0.8	0.92	0.85	5.81	5.2	6.43	5.81
11	550	0.1	0.1	70.6	2481	0.48	0.49	0.49	0.49	0.63	0.67	0.5	0.60	9.25	9.41	3	7.22
12	550	0.02	0.3	74.98	2336	0.43	0.42	0.44	0.43	0.64	0.64	0.56	0.61	7.47	5.32	4.66	5.82
13	400	0.06	0.3	58.99	2160	0.45	0.43	0.46	0.45	0.61	0.55	0.6	0.59	7.63	4.99	8.44	7.02
14	550	0.06	0.2	72.79	2406	0.47	0.44	0.43	0.45	0.58	0.54	0.5	0.54	4.69	4.86	3.64	4.40

ตารางภาคผนวก ก 2 (ต่อ)

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	Dia (mm)	RPM (rev/min)	$R_a$				$R_q$				$R_t$			
						1	2	3	ave	1	2	3	ave	1	2	3	ave
15	550	0.02	0.1	54.39	3220	0.38	0.4	0.48	0.42	0.48	0.51	0.63	0.54	3.95	4.32	5.09	4.45
16	400	0.02	0.3	62.19	2048	0.45	0.48	0.49	0.47	0.55	0.61	0.64	0.60	3.45	4.41	5.07	4.31
17	250	0.1	0.2	66.63	1195	0.53	0.65	0.58	0.59	0.69	0.84	0.92	0.82	5.89	7.98	14.57	9.48
18	550	0.06	0.3	71.79	2440	0.49	0.44	0.43	0.45	0.67	0.55	0.54	0.59	7.59	4.04	3.78	5.14
19	550	0.1	0.2	69.6	2517	0.43	0.49	0.41	0.44	0.62	0.72	0.54	0.63	9.23	10.03	5.42	8.23
20	400	0.1	0.3	55.8	2283	0.64	0.63	0.61	0.63	0.77	0.76	0.79	0.77	4.88	7.36	6.73	6.32
21	400	0.1	0.1	57.8	2204	0.69	0.73	0.71	0.71	0.85	0.9	0.9	0.88	5.65	6.57	6.24	6.15
22	250	0.06	0.3	68.63	1160	0.44	0.5	0.46	0.47	0.6	0.62	0.57	0.60	5.93	5.55	4.39	5.29
23	550	0.02	0.2	53.43	3278	0.4	0.43	0.41	0.41	0.54	0.6	0.5	0.55	4	5.69	3.51	4.40
24	400	0.02	0.1	64.21	1984	0.51	0.49	0.54	0.51	0.67	0.62	0.68	0.66	6.69	4.42	4.6	5.24
25	250	0.02	0.3	71.13	1119	0.58	0.55	0.57	0.57	0.69	0.66	0.72	0.69	4.87	3.71	6.64	5.07
26	400	0.06	0.2	59.98	2124	0.42	0.41	0.46	0.43	0.59	0.57	0.73	0.63	9.02	8.52	14.83	10.79
27	250	0.06	0.2	69.42	1147	0.43	0.47	0.46	0.45	0.54	0.61	0.57	0.57	3.33	5.72	3.7	4.25
28	400	0.1	0.2	56.96	2236	0.66	0.63	0.64	0.64	0.83	0.76	0.77	0.79	5.3	4.37	4.93	4.87

ตารางภาคผนวก ก 2 (ต่อ)

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	Dia (mm)	RPM (rev/min)	$R_a$				$R_q$				$R_t$			
						1	2	3	ave	1	2	3	ave	1	2	3	ave
29	250	0.1	0.2	66.62	1195	0.61	0.63	0.64	0.63	0.75	0.8	0.81	0.79	4.92	8.12	8.12	7.05
30	250	0.02	0.2	72.01	1106	0.57	0.56	0.6	0.58	0.74	0.73	0.78	0.75	5.42	4.76	5.74	5.31
31	550	0.06	0.3	71.79	2440	0.46	0.43	0.46	0.45	0.57	0.53	0.58	0.56	3.85	3.76	3.75	3.79
32	550	0.06	0.1	73.6	2380	0.45	0.46	0.41	0.44	0.57	0.6	0.51	0.56	4.33	7.08	4.62	5.34
33	400	0.1	0.3	55.8	2283	0.65	0.67	0.69	0.67	0.79	0.81	0.88	0.83	6.26	7.06	9.96	7.76
34	250	0.06	0.3	68.61	1160	0.48	0.49	0.47	0.48	0.58	0.62	0.57	0.59	3.71	5.7	3.95	4.45
35	400	0.1	0.1	57.8	2204	0.71	0.7	0.71	0.71	0.84	0.88	0.87	0.86	4.52	6.16	5.57	5.42
36	550	0.02	0.3	74.99	2336	0.48	0.45	0.44	0.46	0.59	0.55	0.53	0.56	5.36	3.68	4.13	4.39
37	250	0.02	0.1	72.42	1099	0.7	0.68	0.69	0.69	0.88	0.86	0.85	0.86	6.39	5.96	5.58	5.98
38	250	0.1	0.1	67.44	1181	0.64	0.61	0.6	0.62	0.82	0.74	0.74	0.77	9.08	4.16	5.03	6.09
39	250	0.1	0.3	65.86	1209	0.56	0.5	0.51	0.52	0.82	0.64	0.65	0.70	14.02	5.49	6.48	8.66
40	400	0.06	0.3	58.97	2160	0.45	0.49	0.46	0.47	0.56	0.62	0.57	0.58	3.53	4.36	3.59	3.83
41	250	0.06	0.1	70.19	1134	0.79	0.77	0.75	0.77	0.98	0.94	0.91	0.94	11.1	7.6	7.41	8.70
42	400	0.02	0.2	63.2	2016	0.45	0.46	0.48	0.46	0.57	0.6	0.69	0.62	4.75	5.77	10.15	6.89

ตารางภาคผนวก ก 2 (ต่อ)

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	Dia (mm)	RPM (rev/min)	$R_a$				$R_q$				$R_t$			
						1	2	3	ave	1	2	3	ave	1	2	3	ave
43	250	0.06	0.2	69.44	1147	0.43	0.47	0.46	0.45	0.52	0.59	0.57	0.56	3.26	3.95	4.11	3.77
44	550	0.06	0.2	72.8	2406	0.43	0.4	0.44	0.42	0.54	0.54	0.64	0.57	3.18	3.97	7.1	4.75
45	250	0.02	0.3	71.15	1119	0.54	0.51	0.53	0.53	0.7	0.64	0.69	0.68	5.64	3.65	4.62	4.64
46	550	0.02	0.2	53.44	3278	0.42	0.4	0.41	0.41	0.54	0.52	0.54	0.53	3.65	4.74	4.43	4.27
47	550	0.1	0.1	70.59	2481	0.47	0.41	0.41	0.43	0.75	0.58	0.55	0.63	14.78	9.02	6.78	10.19
48	550	0.02	0.1	54.39	3220	0.46	0.42	0.44	0.44	0.58	0.53	0.55	0.55	4.9	3.49	4.27	4.22
49	550	0.1	0.3	68.6	2553	0.46	0.45	0.47	0.46	0.62	0.56	0.57	0.58	7.6	4.15	4.23	5.33
50	400	0.06	0.1	60.77	2096	0.5	0.47	0.53	0.50	0.64	0.59	0.67	0.63	4.69	4.22	4.3	4.40
51	400	0.02	0.3	62.21	2048	0.46	0.46	0.52	0.48	0.59	0.66	0.98	0.74	5.81	5.53	4.08	5.14
52	400	0.06	0.2	59.98	2124	0.46	0.45	0.49	0.47	0.54	0.58	0.6	0.57	3.36	6.64	4.14	4.71
53	400	0.02	0.1	64.22	1984	0.57	0.56	0.54	0.56	0.73	0.75	0.72	0.73	5.4	7.03	6.52	6.32
54	550	0.1	0.2	69.6	2517	0.48	0.47	0.46	0.47	0.61	0.65	0.63	0.63	5.99	9.94	7.62	7.85
55	250	0.02	0.3	71.15	1119	0.56	0.57	0.59	0.57	0.71	0.74	0.73	0.73	4.8	5.47	5.04	5.10
56	400	0.06	0.1	60.77	2096	0.56	0.58	0.55	0.56	0.7	0.74	0.69	0.71	4.92	6.42	6.24	5.86

ตารางภาคผนวก ก 2 (ต่อ)

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	Dia (mm)	RPM (rev/min)	$R_a$				$R_q$				$R_t$			
						1	2	3	ave	1	2	3	ave	1	2	3	ave
57	250	0.06	0.1	70.19	1134	0.75	0.79	0.81	0.78	0.9	0.94	0.97	0.94	4.54	4.9	6.11	5.18
58	400	0.02	0.1	64.21	1984	0.6	0.58	0.59	0.59	0.8	0.75	0.75	0.77	7.19	5.51	5.13	5.94
59	250	0.1	0.2	66.62	1195	0.62	0.64	0.6	0.62	0.79	0.79	0.73	0.77	7.64	5.6	4.53	5.92
60	250	0.06	0.2	69.42	1147	0.53	0.5	0.54	0.52	0.65	0.61	0.66	0.64	4.08	4.03	3.83	3.98
61	400	0.1	0.3	55.8	2283	0.69	0.69	0.71	0.70	0.84	0.81	0.87	0.84	7.37	4.88	7.62	6.62
62	400	0.1	0.1	57.8	2204	0.69	0.71	0.73	0.71	0.84	0.88	0.89	0.87	5.39	7.14	5.39	5.97
63	250	0.02	0.1	72.42	1099	0.66	0.69	0.67	0.67	0.83	0.87	0.85	0.85	6.31	6.12	6.34	6.26
64	550	0.1	0.1	70.6	2481	0.45	0.48	0.41	0.45	0.57	0.64	0.54	0.58	5.44	7.24	7.25	6.64
65	550	0.06	0.3	71.78	2440	0.43	0.46	0.47	0.45	0.54	0.57	0.6	0.57	3.59	3.35	5.14	4.03
66	550	0.06	0.1	73.59	2380	0.42	0.41	0.43	0.42	0.51	0.52	0.52	0.52	2.89	3.51	2.96	3.12
67	400	0.1	0.2	56.96	2236	0.61	0.67	0.68	0.65	0.76	0.91	0.84	0.84	4.73	10.94	6.34	7.34
68	550	0.02	0.3	74.98	2336	0.45	0.41	0.46	0.44	0.62	0.58	0.6	0.60	4.36	4.04	3.53	3.98
69	550	0.06	0.2	72.8	2406	0.46	0.45	0.41	0.44	0.57	0.53	0.5	0.53	3.99	3.42	3.69	3.70
70	550	0.02	0.1	54.39	3220	0.49	0.47	0.46	0.47	0.62	0.58	0.55	0.58	5.01	3.46	3.64	4.04

ตารางภาคผนวก ก 2 (ต่อ)

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	Dia (mm)	RPM (rev/min)	$R_a$				$R_q$				$R_t$			
						1	2	3	ave	1	2	3	ave	1	2	3	ave
71	250	0.1	0.3	65.85	1209	0.56	0.53	0.59	0.56	0.69	0.67	0.74	0.70	4.63	5.49	5.26	5.13
72	250	0.02	0.2	71.97	1106	0.52	0.54	0.57	0.54	0.67	0.7	0.75	0.71	4.92	5.36	5.61	5.30
73	400	0.06	0.3	58.99	2160	0.44	0.42	0.47	0.44	0.54	0.51	0.57	0.54	2.95	4.11	3.68	3.58
74	400	0.06	0.2	59.99	2124	0.48	0.45	0.44	0.46	0.62	0.56	0.57	0.58	6.06	3.91	3.76	4.58
75	550	0.1	0.2	69.59	2517	0.49	0.5	0.47	0.49	0.6	0.63	0.63	0.62	4.71	8.94	7.32	6.99
76	550	0.1	0.3	68.6	2553	0.5	0.51	0.52	0.51	0.63	0.62	0.71	0.65	6.87	4	7.56	6.14
77	550	0.02	0.2	53.44	3278	0.41	0.43	0.4	0.41	0.52	0.56	0.52	0.53	3.68	4.56	6.21	4.82
78	400	0.02	0.2	63.19	2016	0.49	0.47	0.5	0.49	0.62	0.59	0.62	0.61	4.86	4.05	4.8	4.57
79	250	0.1	0.1	67.41	1181	0.64	0.69	0.67	0.67	0.8	0.89	0.82	0.84	5.13	9.33	5.55	6.67
80	400	0.02	0.3	62.19	2048	0.54	0.56	0.53	0.54	0.63	0.67	0.57	0.62	4.59	5.27	3.87	4.58
81	250	0.06	0.3	68.63	1160	0.52	0.55	0.51	0.53	0.63	0.69	0.63	0.65	4.95	5.57	4.15	4.89
82	550	0.1	0.2	69.59	2517	0.45	0.44	0.45	0.45	0.59	0.59	0.57	0.58	7.65	6.35	5	6.33
83	250	0.06	0.2	69.41	1147	0.55	0.51	0.54	0.53	0.7	0.63	0.69	0.67	4.71	3.57	5.05	4.44
84	400	0.1	0.2	56.97	2236	0.67	0.61	0.67	0.65	0.85	0.79	0.87	0.84	6.55	6	7.43	6.66

ตารางภาคผนวก ก 2 (ต่อ)

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	Dia (mm)	RPM (rev/min)	$R_a$				$R_q$				$R_t$			
						1	2	3	ave	1	2	3	ave	1	2	3	ave
85	550	0.02	0.1	54.4	3220	0.44	0.45	0.48	0.46	0.61	0.56	0.64	0.60	6.81	4.13	4.84	5.26
86	550	0.02	0.2	53.44	3278	0.45	0.46	0.44	0.45	0.62	0.6	0.63	0.62	7.97	5.25	6.34	6.52
87	250	0.1	0.3	65.84	1209	0.58	0.59	0.61	0.59	0.85	0.73	0.8	0.79	14.49	5.31	6.88	8.89
88	550	0.1	0.1	70.59	2481	0.41	0.43	0.47	0.44	0.54	0.58	0.6	0.57	5.42	6.24	6.29	5.98
89	400	0.02	0.2	63.2	2016	0.52	0.48	0.48	0.49	0.72	0.61	0.63	0.65	7.35	5.21	5.42	5.99
90	250	0.02	0.1	72.43	1099	0.73	0.67	0.66	0.69	0.93	0.86	0.83	0.87	5.19	6.49	5.52	5.73
91	550	0.06	0.3	71.78	2440	0.45	0.47	0.48	0.47	0.54	0.57	0.61	0.57	3.22	3.81	6.21	4.41
92	400	0.1	0.3	55.8	2283	0.62	0.65	0.67	0.65	0.76	0.82	0.85	0.81	5.61	7.4	10.28	7.76
93	400	0.06	0.3	58.97	2160	0.47	0.46	0.49	0.47	0.58	0.59	0.6	0.59	3.59	5	3.97	4.19
94	400	0.06	0.1	60.77	2096	0.5	0.53	0.52	0.52	0.64	0.66	0.68	0.66	4.38	3.96	7.62	5.32
95	250	0.1	0.1	67.43	1181	0.64	0.69	0.67	0.67	0.78	0.88	0.83	0.83	5.28	8.46	6	6.58
96	400	0.1	0.1	57.8	2204	0.69	0.7	0.71	0.70	0.88	0.85	0.87	0.87	6.95	5.68	5.03	5.89
97	550	0.06	0.1	73.6	2380	0.46	0.49	0.47	0.47	0.6	0.64	0.59	0.61	5.98	8.53	4.49	6.33
98	250	0.06	0.1	70.19	1134	0.78	0.73	0.79	0.77	1.02	0.88	0.95	0.95	12.22	5.06	5.7	7.66



ตารางภาคผนวก ก 2 (ต่อ)

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	Dia (mm)	RPM (rev/min)	$R_a$				$R_q$				$R_t$			
						1	2	3	ave	1	2	3	ave	1	2	3	ave
99	400	0.02	0.1	64.21	1984	0.58	0.57	0.59	0.58	0.85	0.71	0.73	0.76	14.49	4.75	4.89	8.04
100	550	0.1	0.3	68.61	2553	0.49	0.46	0.44	0.46	0.61	0.58	0.58	0.59	4.26	4.15	7.97	5.46
101	400	0.06	0.2	59.97	2124	0.43	0.44	0.41	0.43	0.54	0.56	0.53	0.54	3.96	4.43	4.81	4.40
102	400	0.02	0.3	62.21	2048	0.48	0.5	0.46	0.48	0.65	0.72	0.68	0.68	4.59	4.98	4.88	4.82
103	250	0.06	0.3	68.61	1160	0.43	0.49	0.52	0.48	0.53	0.62	0.65	0.60	3.81	4.96	4.36	4.38
104	550	0.02	0.3	74.98	2336	0.5	0.46	0.48	0.48	0.57	0.5	0.54	0.54	3.74	3.78	3.33	3.62
105	250	0.02	0.3	71.14	1119	0.62	0.57	0.6	0.60	0.75	0.72	0.73	0.73	4.99	5.42	4.39	4.93
106	250	0.1	0.2	66.62	1195	0.67	0.62	0.67	0.65	0.84	0.77	0.85	0.82	5.79	5.08	5.53	5.47
107	550	0.06	0.2	72.8	2406	0.44	0.42	0.43	0.43	0.59	0.55	0.58	0.57	4.6	4.56	3.19	4.12
108	250	0.02	0.2	71.97	1106	0.59	0.58	0.55	0.57	0.8	0.73	0.69	0.74	7.57	5.45	4.86	5.96

ตารางภาคผนวก ก 3 แสดงผลการทดลองค่าความคลาดเคลื่อนของขนาดชิ้นงานที่ผ่านการกลึงด้วยใบมีดคาร์

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	RPM (rev/min)	Diameter ก่อนกลึง				Diameter หลังกลึง				Exp. Dim	Dim.Err.
					1	2	3	ave	1	2	3	ave		
1	400	0.1	0.2	2236	56.97	56.97	56.97	56.97	56.52	56.53	56.53	56.53	56.57	-0.04
2	400	0.02	0.2	2016	63.18	63.18	63.18	63.18	62.76	62.75	62.76	62.76	62.78	-0.02
3	250	0.1	0.1	1181	67.44	67.44	67.44	67.44	67.19	67.20	67.19	67.19	67.24	-0.05
4	550	0.1	0.3	2553	68.60	68.61	68.61	68.61	67.97	67.97	67.97	67.97	68.01	-0.04
5	550	0.06	0.1	2380	73.59	73.59	73.59	73.59	73.34	73.34	73.34	73.34	73.39	-0.05
6	400	0.06	0.1	2096	60.78	60.79	60.79	60.79	60.56	60.56	60.55	60.56	60.59	-0.03
7	250	0.02	0.2	1106	72.02	72.02	72.02	72.02	71.59	71.6	71.59	71.59	71.62	-0.03
8	250	0.06	0.1	1134	70.20	70.20	70.20	70.20	69.97	69.98	69.98	69.98	70.00	-0.02
9	250	0.1	0.3	1209	65.86	65.86	65.86	65.86	65.21	65.21	65.21	65.21	65.26	-0.05
10	250	0.02	0.1	1099	72.44	72.44	72.44	72.44	72.2	72.2	72.2	72.20	72.24	-0.04
11	550	0.1	0.1	2481	70.60	70.60	70.60	70.60	70.35	70.36	70.35	70.35	70.40	-0.05
12	550	0.02	0.3	2336	74.98	74.98	74.98	74.98	74.34	74.35	74.34	74.34	74.38	-0.04
13	400	0.06	0.3	2160	58.99	58.99	58.99	58.99	58.36	58.36	58.36	58.36	58.39	-0.03
14	550	0.06	0.2	2406	72.79	72.79	72.79	72.79	72.35	72.35	72.34	72.35	72.39	-0.04

ตารางภาคผนวก ก 3 (ต่อ)

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	RPM (rev/min)	Diameter ก่อนกลึง				Diameter หลังกลึง				Exp. Dim	Dim. Err.
					1	2	3	ave	1	2	3	ave		
15	550	0.02	0.1	3220	54.39	54.39	54.39	54.39	54.15	54.15	54.15	54.15	54.19	-0.04
16	400	0.02	0.3	2048	62.19	62.19	62.20	62.19	61.56	61.56	61.55	61.56	61.59	-0.03
17	250	0.1	0.2	1195	66.63	66.63	66.63	66.63	66.18	66.18	66.18	66.18	66.23	-0.05
18	550	0.06	0.3	2440	71.79	71.80	71.80	71.80	71.16	71.16	71.16	71.16	71.20	-0.04
19	550	0.1	0.2	2517	69.60	69.60	69.59	69.60	69.16	69.17	69.16	69.16	69.20	-0.04
20	400	0.1	0.3	2283	55.80	55.81	55.81	55.81	55.18	55.18	55.17	55.18	55.21	-0.03
21	400	0.1	0.1	2204	57.80	57.80	57.80	57.80	57.56	57.55	57.56	57.56	57.60	-0.04
22	250	0.06	0.3	1160	68.63	68.63	68.63	68.63	68.00	68.00	68.00	68.00	68.03	-0.03
23	550	0.02	0.2	3278	53.43	53.42	53.43	53.43	52.97	52.98	52.97	52.97	53.01	-0.04
24	400	0.02	0.1	1984	64.20	64.20	64.20	64.20	63.98	63.98	63.99	63.98	64.00	-0.02
25	250	0.02	0.3	1119	71.13	71.14	71.14	71.14	70.5	70.5	70.5	70.50	70.54	-0.04
26	400	0.06	0.2	2124	59.98	59.98	59.98	59.98	59.55	59.54	59.54	59.54	59.58	-0.04
27	250	0.06	0.2	1147	69.42	69.42	69.42	69.42	69.00	69.00	69.00	69.00	69.02	-0.02
28	400	0.1	0.2	2236	56.97	56.97	56.97	56.97	56.53	56.53	56.53	56.53	56.57	-0.04

ตารางภาคผนวก ก 3 (ต่อ)

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	RPM (rev/min)	Diameter ก่อนกลึง				Diameter หลังกลึง				Exp. Dim	Dim.Err.
					1	2	3	ave	1	2	3	ave		
29	250	0.1	0.2	1195	66.62	66.63	66.63	66.63	66.18	66.18	66.18	66.18	66.23	-0.05
30	250	0.02	0.2	1106	72.02	72.02	72.02	72.02	71.59	71.59	71.6	71.59	71.62	-0.03
31	550	0.06	0.3	2440	71.79	71.80	71.79	71.79	71.15	71.15	71.15	71.15	71.19	-0.04
32	550	0.06	0.1	2380	73.59	73.59	73.59	73.59	73.34	73.34	73.34	73.34	73.39	-0.05
33	400	0.1	0.3	2283	55.80	55.80	55.80	55.80	55.16	55.16	55.16	55.16	55.20	-0.04
34	250	0.06	0.3	1160	68.62	68.62	68.62	68.62	67.99	68.00	67.99	67.99	68.02	-0.03
35	400	0.1	0.1	2204	57.80	57.80	57.80	57.80	57.55	57.55	57.54	57.55	57.60	-0.05
36	550	0.02	0.3	2336	74.99	74.98	74.98	74.98	74.34	74.34	74.34	74.34	74.38	-0.04
37	250	0.02	0.1	1099	72.44	72.44	72.44	72.44	72.2	72.2	72.2	72.20	72.24	-0.04
38	250	0.1	0.1	1181	67.44	67.43	67.43	67.43	67.19	67.19	67.19	67.19	67.23	-0.04
39	250	0.1	0.3	1209	65.87	65.87	65.87	65.87	65.22	65.23	65.22	65.22	65.27	-0.05
40	400	0.06	0.3	2160	58.98	58.97	58.97	58.97	58.34	58.34	58.34	58.34	58.37	-0.03
41	250	0.06	0.1	1134	70.20	70.20	70.20	70.20	69.97	69.97	69.98	69.97	70.00	-0.03
42	400	0.02	0.2	2016	63.18	63.18	63.18	63.18	62.75	62.76	62.75	62.75	62.78	-0.03

ตารางภาคผนวก ก 3 (ต่อ)

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	RPM (rev/min)	Diameter ก่อนกลึง				Diameter หลังกลึง				Exp. Dim	Dim. Err.
					1	2	3	ave	1	2	3	ave		
43	250	0.06	0.2	1147	69.42	69.42	69.42	69.42	68.99	68.99	69.00	68.99	69.02	-0.03
44	550	0.06	0.2	2406	72.79	72.79	72.79	72.79	72.35	72.35	72.35	72.35	72.39	-0.04
45	250	0.02	0.3	1119	71.13	71.13	71.13	71.13	70.49	70.49	70.49	70.49	70.53	-0.04
46	550	0.02	0.2	3278	53.43	53.43	53.43	53.43	52.99	52.99	53.00	52.99	53.03	-0.04
47	550	0.1	0.1	2481	70.60	70.60	70.60	70.60	70.35	70.35	70.35	70.35	70.40	-0.05
48	550	0.02	0.1	3220	54.41	54.40	54.40	54.40	54.16	54.16	54.16	54.16	54.20	-0.04
49	550	0.1	0.3	2553	68.60	68.60	68.60	68.60	67.96	67.96	67.97	67.96	68.00	-0.04
50	400	0.06	0.1	2096	60.78	60.78	60.78	60.78	60.56	60.56	60.57	60.56	60.58	-0.02
51	400	0.02	0.3	2048	62.20	62.20	62.20	62.20	61.58	61.57	61.57	61.57	61.60	-0.03
52	400	0.06	0.2	2124	59.98	59.98	59.98	59.98	59.54	59.55	59.54	59.54	59.58	-0.04
53	400	0.02	0.1	1984	64.20	64.20	64.20	64.20	63.98	63.98	63.98	63.98	64.00	-0.02
54	550	0.1	0.2	2517	69.59	69.59	69.59	69.59	69.15	69.15	69.15	69.15	69.19	-0.04
55	250	0.02	0.3	1119	71.14	71.14	71.14	71.14	70.5	70.5	70.5	70.50	70.54	-0.04
56	400	0.06	0.1	2096	60.79	60.79	60.79	60.79	60.56	60.57	60.57	60.57	60.59	-0.02

ตารางภาคผนวก ก 3 (ต่อ)

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	RPM (rev/min)	Diameter ก่อนกลึง				Diameter หลังกลึง				Exp. Dim	Dim. Err.
					1	2	3	ave	1	2	3	ave		
57	250	0.06	0.1	1134	70.20	70.20	70.20	70.20	69.98	69.97	69.98	69.98	70.00	-0.02
58	400	0.02	0.1	1984	64.21	64.21	64.21	64.21	63.98	63.98	63.98	63.98	64.01	-0.03
59	250	0.1	0.2	1195	66.63	66.62	66.63	66.63	66.18	66.18	66.19	66.18	66.23	-0.05
60	250	0.06	0.2	1147	69.42	69.42	69.42	69.42	68.99	68.99	68.99	68.99	69.02	-0.03
61	400	0.1	0.3	2283	55.81	55.81	55.81	55.81	55.17	55.17	55.16	55.17	55.21	-0.04
62	400	0.1	0.1	2204	57.80	57.80	57.80	57.80	57.55	57.55	57.55	57.55	57.60	-0.05
63	250	0.02	0.1	1099	72.44	72.44	72.44	72.44	72.2	72.2	72.2	72.20	72.24	-0.04
64	550	0.1	0.1	2481	70.60	70.60	70.60	70.60	70.36	70.35	70.35	70.35	70.40	-0.05
65	550	0.06	0.3	2440	71.78	71.79	71.78	71.78	71.14	71.14	71.14	71.14	71.18	-0.04
66	550	0.06	0.1	2380	73.59	73.59	73.59	73.59	73.34	73.33	73.34	73.34	73.39	-0.05
67	400	0.1	0.2	2236	56.98	56.98	56.98	56.98	56.55	56.55	56.55	56.55	56.58	-0.03
68	550	0.02	0.3	2336	74.98	74.97	74.97	74.97	74.33	74.33	74.33	74.33	74.37	-0.04
69	550	0.06	0.2	2406	72.79	72.78	72.79	72.79	72.37	72.35	72.37	72.36	72.39	-0.03
70	550	0.02	0.1	3220	54.39	54.39	54.39	54.39	54.17	54.16	54.16	54.16	54.19	-0.03

ตารางภาคผนวก ก 3 (ต่อ)

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	RPM (rev/min)	Diameter ก่อนกลึง				Diameter หลังกลึง				Exp. Dim	Dim.Err.
					1	2	3	ave	1	2	3	ave		
71	250	0.1	0.3	1209	65.85	65.85	65.84	65.85	65.20	65.20	65.20	65.20	65.25	-0.05
72	250	0.02	0.2	1106	72.02	72.01	72.02	72.02	71.58	71.58	71.58	71.58	71.62	-0.04
73	400	0.06	0.3	2160	58.98	58.98	58.98	58.98	58.35	58.35	58.35	58.35	58.38	-0.03
74	400	0.06	0.2	2124	59.97	59.97	59.97	59.97	59.53	59.53	59.53	59.53	59.57	-0.04
75	550	0.1	0.2	2517	69.60	69.60	69.60	69.60	69.16	69.16	69.16	69.16	69.20	-0.04
76	550	0.1	0.3	2553	68.60	68.60	68.60	68.60	67.96	67.96	67.96	67.96	68.00	-0.04
77	550	0.02	0.2	3278	53.43	53.43	53.43	53.43	52.99	53.00	52.99	52.99	53.03	-0.04
78	400	0.02	0.2	2016	63.19	63.19	63.19	63.19	62.77	62.76	62.76	62.76	62.79	-0.03
79	250	0.1	0.1	1181	67.43	67.43	67.43	67.43	67.18	67.19	67.18	67.18	67.23	-0.05
80	400	0.02	0.3	2048	62.21	62.20	62.20	62.20	61.57	61.57	61.58	61.57	61.60	-0.03
81	250	0.06	0.3	1160	68.62	68.62	68.62	68.62	67.99	67.99	67.99	67.99	68.02	-0.03
82	550	0.1	0.2	2517	69.58	69.58	69.58	69.58	69.14	69.14	69.14	69.14	69.18	-0.04
83	250	0.06	0.2	1147	69.42	69.42	69.42	69.42	68.99	68.99	68.99	68.99	69.02	-0.03
84	400	0.1	0.2	2236	56.98	56.98	56.98	56.98	56.55	56.55	56.55	56.55	56.58	-0.03

ตารางภาคผนวก ก 3 (ต่อ)

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	RPM (rev/min)	Diameter ก่อนกลึง				Diameter หลังกลึง				Exp. Dim	Dim. Err.
					1	2	3	ave	1	2	3	ave		
85	550	0.02	0.1	3220	54.38	54.39	54.39	54.39	54.16	54.15	54.15	54.15	54.19	-0.04
86	550	0.02	0.2	3278	53.43	53.43	53.43	53.43	52.99	52.99	52.99	52.99	53.03	-0.04
87	250	0.1	0.3	1209	65.86	65.86	65.85	65.86	65.21	65.21	65.21	65.21	65.26	-0.05
88	550	0.1	0.1	2481	70.60	70.60	70.60	70.60	70.35	70.35	70.35	70.35	70.40	-0.05
89	400	0.02	0.2	2016	63.18	63.18	63.18	63.18	62.75	62.76	62.76	62.76	62.78	-0.02
90	250	0.02	0.1	1099	72.44	72.45	72.45	72.45	72.21	72.21	72.21	72.21	72.25	-0.04
91	550	0.06	0.3	2440	71.78	71.78	71.78	71.78	71.14	71.13	71.13	71.13	71.18	-0.05
92	400	0.1	0.3	2283	55.80	55.80	55.80	55.80	55.16	55.16	55.16	55.16	55.20	-0.04
93	400	0.06	0.3	2160	58.99	58.99	58.99	58.99	58.36	58.36	58.36	58.36	58.39	-0.03
94	400	0.06	0.1	2096	60.79	60.79	60.79	60.79	60.56	60.57	60.57	60.57	60.59	-0.02
95	250	0.1	0.1	1181	67.43	67.43	67.43	67.43	67.19	67.20	67.19	67.19	67.23	-0.04
96	400	0.1	0.1	2204	57.80	57.80	57.79	57.80	57.55	57.55	57.55	57.55	57.60	-0.05
97	550	0.06	0.1	2380	73.59	73.59	73.59	73.59	73.34	73.34	73.34	73.34	73.39	-0.05
98	250	0.06	0.1	1134	70.21	70.21	70.21	70.21	69.99	69.98	69.99	69.99	70.01	-0.02



ตารางภาคผนวก ก 3 (ต่อ)

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	RPM (rev/min)	Diameter ก่อนกลึง				Diameter หลังกลึง				Exp. Dim	Dim.Err.
					1	2	3	ave	1	2	3	ave		
99	400	0.02	0.1	1984	64.20	64.20	64.20	64.20	63.98	63.99	63.98	63.98	64.00	-0.02
100	550	0.1	0.3	2553	68.60	68.60	68.60	68.60	67.97	67.96	67.96	67.96	68.00	-0.04
101	400	0.06	0.2	2124	59.98	59.98	59.98	59.98	59.53	59.53	59.54	59.53	59.57	-0.04
102	400	0.02	0.3	2048	62.20	62.20	62.20	62.20	61.57	61.57	61.57	61.57	61.60	-0.03
103	250	0.06	0.3	1160	68.62	68.62	68.62	68.62	67.99	68.00	67.99	67.99	68.02	-0.03
104	550	0.02	0.3	2336	74.98	74.97	74.98	74.98	74.35	74.35	74.35	74.35	74.38	-0.03
105	250	0.02	0.3	1119	71.14	71.14	71.14	71.14	70.5	70.5	70.5	70.50	70.54	-0.04
106	250	0.1	0.2	1195	66.62	66.62	66.62	66.62	66.19	66.18	66.18	66.18	66.22	-0.04
107	550	0.06	0.2	2406	72.79	72.78	72.79	72.79	72.36	72.35	72.36	72.36	72.39	-0.03
108	250	0.02	0.2	1106	72.02	72.02	72.02	72.02	71.6	71.59	71.59	71.59	71.62	-0.03

ตารางภาคผนวก ก 4 แสดงผลการทดลองค่าความคลาดเคลื่อนของขนาดชิ้นงานที่ผ่านการกลึงด้วยใบมีดเซรามิก

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	RPM (rev/min)	Diameter ก่อนกลึง				Diameter หลังกลึง				Exp. Dim	Dim.Err.
					1	2	3	ave	1	2	3	ave		
1	400	0.1	0.2	2236	56.97	56.97	56.97	56.97	56.53	56.54	56.53	56.53	56.57	-0.04
2	400	0.02	0.2	2016	63.19	63.19	63.19	63.19	62.77	62.77	62.77	62.77	62.79	-0.02
3	250	0.1	0.1	1181	67.43	67.43	67.43	67.43	67.19	67.20	67.20	67.20	67.23	-0.03
4	550	0.1	0.3	2553	68.60	68.60	68.60	68.60	67.98	67.97	67.98	67.98	68.00	-0.02
5	550	0.06	0.1	2380	73.59	73.59	73.59	73.59	73.37	73.37	73.37	73.37	73.39	-0.02
6	400	0.06	0.1	2096	60.78	60.78	60.78	60.78	60.55	60.55	60.56	60.55	60.58	-0.03
7	250	0.02	0.2	1106	72.01	72.02	72.02	72.02	71.59	71.59	71.59	71.59	71.62	-0.03
8	250	0.06	0.1	1134	70.20	70.20	70.20	70.20	69.96	69.95	69.96	69.96	70.00	-0.04
9	250	0.1	0.3	1209	65.86	65.86	65.86	65.86	65.23	65.23	65.23	65.23	65.26	-0.03
10	250	0.02	0.1	1099	72.43	72.44	72.44	72.44	72.21	72.2	72.2	72.20	72.24	-0.04
11	550	0.1	0.1	2481	70.60	70.60	70.60	70.60	70.37	70.37	70.37	70.37	70.40	-0.03
12	550	0.02	0.3	2336	74.98	74.98	74.99	74.98	74.35	74.35	74.35	74.35	74.38	-0.03
13	400	0.06	0.3	2160	58.99	58.99	58.99	58.99	58.37	58.37	58.37	58.37	58.39	-0.02
14	550	0.06	0.2	2406	72.79	72.79	72.79	72.79	72.37	72.36	72.37	72.37	72.39	-0.02

ตารางภาคผนวก ก 4 (ต่อ)

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	RPM (rev/min)	Diameter ก่อนกลึง				Diameter หลังกลึง				Exp. Dim	Dim. Err.
					1	2	3	ave	1	2	3	ave		
15	550	0.02	0.1	3220	54.39	54.39	54.39	54.39	54.16	54.16	54.16	54.16	54.19	-0.03
16	400	0.02	0.3	2048	62.19	62.19	62.19	62.19	61.57	61.57	61.56	61.57	61.59	-0.02
17	250	0.1	0.2	1195	66.63	66.63	66.63	66.63	66.19	66.19	66.20	66.19	66.23	-0.04
18	550	0.06	0.3	2440	71.79	71.78	71.79	71.79	71.18	71.17	71.18	71.18	71.19	-0.01
19	550	0.1	0.2	2517	69.60	69.60	69.61	69.60	69.18	69.17	69.18	69.18	69.21	-0.03
20	400	0.1	0.3	2283	55.81	55.80	55.80	55.80	55.16	55.16	55.16	55.16	55.20	-0.04
21	400	0.1	0.1	2204	57.80	57.80	57.80	57.80	57.55	57.55	57.56	57.55	57.60	-0.05
22	250	0.06	0.3	1160	68.63	68.62	68.63	68.63	68.01	68.01	68.01	68.01	68.03	-0.02
23	550	0.02	0.2	3278	53.43	53.43	53.43	53.43	53.01	53.02	53.02	53.02	53.03	-0.01
24	400	0.02	0.1	1984	64.21	64.21	64.21	64.21	63.98	63.99	63.98	63.98	64.01	-0.03
25	250	0.02	0.3	1119	71.13	71.13	71.13	71.13	70.51	70.51	70.51	70.51	70.53	-0.02
26	400	0.06	0.2	2124	59.98	59.98	59.97	59.98	59.56	59.55	59.56	59.56	59.58	-0.02
27	250	0.06	0.2	1147	69.42	69.43	69.42	69.42	69.00	69.00	68.99	69.00	69.02	-0.02
28	400	0.1	0.2	2236	56.96	56.96	56.96	56.96	56.52	56.52	56.52	56.52	56.56	-0.04

ตารางภาคผนวก ก 4 (ต่อ)

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	RPM (rev/min)	Diameter ก่อนกลึง				Diameter หลังกลึง				Exp. Dim	Dim.Err.
					1	2	3	ave	1	2	3	ave		
29	250	0.1	0.2	1195	66.62	66.62	66.63	66.62	66.18	66.18	66.18	66.18	66.22	-0.04
30	250	0.02	0.2	1106	72.01	72.01	72.01	72.01	71.58	71.59	71.58	71.58	71.61	-0.03
31	550	0.06	0.3	2440	71.78	71.78	71.78	71.78	71.17	71.17	71.17	71.17	71.18	-0.01
32	550	0.06	0.1	2380	73.60	73.60	73.60	73.60	73.38	73.38	73.37	73.38	73.40	-0.02
33	400	0.1	0.3	2283	55.80	55.80	55.80	55.80	55.17	55.17	55.17	55.17	55.21	-0.04
34	250	0.06	0.3	1160	68.61	68.61	68.61	68.61	67.99	68.00	67.99	67.99	68.01	-0.02
35	400	0.1	0.1	2204	57.80	57.80	57.80	57.80	57.55	57.55	57.55	57.55	57.60	-0.05
36	550	0.02	0.3	2336	74.99	74.99	74.98	74.99	74.37	74.37	74.37	74.37	74.39	-0.02
37	250	0.02	0.1	1099	72.43	72.42	72.41	72.42	72.19	72.18	72.18	72.18	72.22	-0.04
38	250	0.1	0.1	1181	67.44	67.44	67.44	67.44	67.20	67.20	67.20	67.20	67.24	-0.04
39	250	0.1	0.3	1209	65.86	65.86	65.86	65.86	65.23	65.23	65.23	65.23	65.26	-0.03
40	400	0.06	0.3	2160	58.98	58.97	58.97	58.97	58.34	58.35	58.35	58.35	58.37	-0.02
41	250	0.06	0.1	1134	70.20	70.19	70.19	70.19	69.95	69.94	69.94	69.94	69.99	-0.05
42	400	0.02	0.2	2016	63.20	63.21	63.20	63.20	62.78	62.77	62.78	62.78	62.80	-0.02

ตารางภาคผนวก ก 4 (ต่อ)

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	RPM (rev/min)	Diameter ก่อนกลึง				Diameter หลังกลึง				Exp. Dim	Dim.Err.
					1	2	3	ave	1	2	3	ave		
43	250	0.06	0.2	1147	69.44	69.43	69.44	69.44	69.01	69.02	69.02	69.02	69.04	-0.02
44	550	0.06	0.2	2406	72.80	72.80	72.80	72.80	72.39	72.39	72.39	72.39	72.40	-0.01
45	250	0.02	0.3	1119	71.15	71.15	71.15	71.15	70.53	70.52	70.52	70.52	70.55	-0.03
46	550	0.02	0.2	3278	53.44	53.44	53.44	53.44	53.03	53.03	53.03	53.03	53.04	-0.01
47	550	0.1	0.1	2481	70.59	70.59	70.59	70.59	70.37	70.36	70.37	70.37	70.39	-0.02
48	550	0.02	0.1	3220	54.39	54.39	54.39	54.39	54.17	54.17	54.17	54.17	54.19	-0.02
49	550	0.1	0.3	2553	68.59	68.60	68.60	68.60	67.97	67.98	67.98	67.98	68.00	-0.02
50	400	0.06	0.1	2096	60.76	60.77	60.77	60.77	60.54	60.54	60.54	60.54	60.57	-0.03
51	400	0.02	0.3	2048	62.21	62.21	62.21	62.21	61.58	61.59	61.59	61.59	61.61	-0.02
52	400	0.06	0.2	2124	59.98	59.98	59.98	59.98	59.56	59.56	59.55	59.56	59.58	-0.02
53	400	0.02	0.1	1984	64.22	64.22	64.22	64.22	63.99	63.99	64.00	63.99	64.02	-0.03
54	550	0.1	0.2	2517	69.60	69.60	69.60	69.60	69.18	69.18	69.18	69.18	69.20	-0.02
55	250	0.02	0.3	1119	71.16	71.15	71.15	71.15	70.53	70.53	70.53	70.53	70.55	-0.02
56	400	0.06	0.1	2096	60.76	60.77	60.77	60.77	60.54	60.54	60.53	60.54	60.57	-0.03

ตารางภาคผนวก ก 4 (ต่อ)

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	RPM (rev/min)	Diameter ก่อนกลึง				Diameter หลังกลึง				Exp. Dim	Dim. Err.
					1	2	3	ave	1	2	3	ave		
57	250	0.06	0.1	1134	70.19	70.19	70.19	70.19	69.95	69.94	69.94	69.94	69.99	-0.05
58	400	0.02	0.1	1984	64.20	64.21	64.21	64.21	63.98	63.98	63.98	63.98	64.01	-0.03
59	250	0.1	0.2	1195	66.62	66.62	66.62	66.62	66.18	66.19	66.18	66.18	66.22	-0.04
60	250	0.06	0.2	1147	69.41	69.42	69.42	69.42	68.99	68.99	68.99	68.99	69.02	-0.03
61	400	0.1	0.3	2283	55.80	55.80	55.80	55.80	55.15	55.15	55.15	55.15	55.20	-0.05
62	400	0.1	0.1	2204	57.80	57.80	57.80	57.80	57.55	57.56	57.55	57.55	57.60	-0.05
63	250	0.02	0.1	1099	72.42	72.42	72.43	72.42	72.18	72.18	72.19	72.18	72.22	-0.04
64	550	0.1	0.1	2481	70.59	70.59	70.58	70.59	70.36	70.36	70.36	70.36	70.38	-0.02
65	550	0.06	0.3	2440	71.79	71.79	71.79	71.79	71.18	71.18	71.18	71.18	71.19	-0.01
66	550	0.06	0.1	2380	73.59	73.59	73.59	73.59	73.37	73.37	73.37	73.37	73.39	-0.02
67	400	0.1	0.2	2236	56.96	56.96	56.96	56.96	56.53	56.52	56.52	56.52	56.56	-0.04
68	550	0.02	0.3	2336	74.98	74.98	74.98	74.98	74.36	74.36	74.35	74.36	74.38	-0.02
69	550	0.06	0.2	2406	72.80	72.80	72.80	72.80	72.38	72.38	72.38	72.38	72.40	-0.02
70	550	0.02	0.1	3220	54.39	54.40	54.39	54.39	54.17	54.17	54.17	54.17	54.19	-0.02

ตารางภาคผนวก ก 1 (ต่อ)

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	RPM (rev/min)	Diameter ก่อนกลึง				Diameter หลังกลึง				Exp. Dim	Dim.Err.
					1	2	3	ave	1	2	3	ave		
71	250	0.1	0.3	1209	65.85	65.85	65.85	65.85	65.22	65.22	65.23	65.22	65.25	-0.03
72	250	0.02	0.2	1106	71.97	71.97	71.97	71.97	71.54	71.54	71.54	71.54	71.57	-0.03
73	400	0.06	0.3	2160	58.99	58.99	58.99	58.99	58.36	58.37	58.37	58.37	58.39	-0.02
74	400	0.06	0.2	2124	59.98	59.99	59.99	59.99	59.57	59.57	59.56	59.57	59.59	-0.02
75	550	0.1	0.2	2517	69.59	69.59	69.60	69.59	69.16	69.17	69.17	69.17	69.20	-0.03
76	550	0.1	0.3	2553	68.59	68.60	68.60	68.60	67.97	67.97	67.97	67.97	68.00	-0.03
77	550	0.02	0.2	3278	53.44	53.44	53.44	53.44	53.02	53.03	53.03	53.03	53.04	-0.01
78	400	0.02	0.2	2016	63.19	63.20	63.19	63.19	62.77	62.77	62.78	62.77	62.79	-0.02
79	250	0.1	0.1	1181	67.40	67.41	67.41	67.41	67.17	67.17	67.17	67.17	67.21	-0.04
80	400	0.02	0.3	2048	62.19	62.19	62.19	62.19	61.57	61.57	61.56	61.57	61.59	-0.02
81	250	0.06	0.3	1160	68.63	68.63	68.63	68.63	68.00	68.00	68.00	68.00	68.03	-0.03
82	550	0.1	0.2	2517	69.59	69.59	69.59	69.59	69.17	69.17	69.17	69.17	69.19	-0.02
83	250	0.06	0.2	1147	69.41	69.41	69.41	69.41	68.98	68.98	68.99	68.98	69.01	-0.03
84	400	0.1	0.2	2236	56.96	56.97	56.97	56.97	56.53	56.53	56.53	56.53	56.57	-0.04

ตารางภาคผนวก ก 4 (ต่อ)

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	RPM (rev/min)	Diameter ก่อนกลึง				Diameter หลังกลึง				Exp. Dim	Dim.Err.
					1	2	3	ave	1	2	3	ave		
85	550	0.02	0.1	3220	54.39	54.40	54.40	54.40	54.18	54.18	54.18	54.18	54.20	-0.02
86	550	0.02	0.2	3278	53.44	53.44	53.44	53.44	53.03	53.03	53.02	53.03	53.04	-0.01
87	250	0.1	0.3	1209	65.84	65.85	65.84	65.84	65.20	65.20	65.21	65.20	65.24	-0.04
88	550	0.1	0.1	2481	70.60	70.60	70.59	70.60	70.37	70.37	70.37	70.37	70.39	-0.02
89	400	0.02	0.2	2016	63.20	63.20	63.20	63.20	62.78	62.78	62.78	62.78	62.80	-0.02
90	250	0.02	0.1	1099	72.43	72.43	72.43	72.43	72.19	72.18	72.18	72.18	72.23	-0.05
91	550	0.06	0.3	2440	71.78	71.77	71.78	71.78	71.17	71.17	71.17	71.17	71.18	-0.01
92	400	0.1	0.3	2283	55.80	55.80	55.80	55.80	55.17	55.16	55.16	55.16	55.20	-0.04
93	400	0.06	0.3	2160	58.97	58.97	58.97	58.97	58.35	58.35	58.35	58.35	58.37	-0.02
94	400	0.06	0.1	2096	60.77	60.78	60.77	60.77	60.55	60.55	60.54	60.55	60.57	-0.02
95	250	0.1	0.1	1181	67.43	67.43	67.43	67.43	67.19	67.19	67.19	67.19	67.23	-0.04
96	400	0.1	0.1	2204	57.80	57.80	57.80	57.80	57.55	57.55	57.55	57.55	57.60	-0.05
97	550	0.06	0.1	2380	73.60	73.60	73.60	73.60	73.39	73.39	73.39	73.39	73.40	-0.01
98	250	0.06	0.1	1134	70.19	70.19	70.19	70.19	69.94	69.94	69.95	69.94	69.99	-0.05



ตารางภาคผนวก ก 4 (ต่อ)

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	RPM (rev/min)	Diameter ก่อนกลึง				Diameter หลังกลึง				Exp. Dim	Dim.Err.
					1	2	3	ave	1	2	3	ave		
85	550	0.02	0.1	3220	54.39	54.40	54.40	54.40	54.18	54.18	54.18	54.18	54.20	-0.02
86	550	0.02	0.2	3278	53.44	53.44	53.44	53.44	53.03	53.03	53.02	53.03	53.04	-0.01
87	250	0.1	0.3	1209	65.84	65.85	65.84	65.84	65.20	65.20	65.21	65.20	65.24	-0.04
88	550	0.1	0.1	2481	70.60	70.60	70.59	70.60	70.37	70.37	70.37	70.37	70.39	-0.02
89	400	0.02	0.2	2016	63.20	63.20	63.20	63.20	62.78	62.78	62.78	62.78	62.80	-0.02
90	250	0.02	0.1	1099	72.43	72.43	72.43	72.43	72.19	72.18	72.18	72.18	72.23	-0.05
91	550	0.06	0.3	2440	71.78	71.77	71.78	71.78	71.17	71.17	71.17	71.17	71.18	-0.01
92	400	0.1	0.3	2283	55.80	55.80	55.80	55.80	55.17	55.16	55.16	55.16	55.20	-0.04
93	400	0.06	0.3	2160	58.97	58.97	58.97	58.97	58.35	58.35	58.35	58.35	58.37	-0.02
94	400	0.06	0.1	2096	60.77	60.78	60.77	60.77	60.55	60.55	60.54	60.55	60.57	-0.02
95	250	0.1	0.1	1181	67.43	67.43	67.43	67.43	67.19	67.19	67.19	67.19	67.23	-0.04
96	400	0.1	0.1	2204	57.80	57.80	57.80	57.80	57.55	57.55	57.55	57.55	57.60	-0.05
97	550	0.06	0.1	2380	73.60	73.60	73.60	73.60	73.39	73.39	73.39	73.39	73.40	-0.01
98	250	0.06	0.1	1134	70.19	70.19	70.19	70.19	69.94	69.94	69.95	69.94	69.99	-0.05

ตารางภาคผนวก ก 4 (ต่อ)

Run No.	Speed (m/min)	Feed (mm/rev)	Depth (mm)	RPM (rev/min)	Diameter ก่อนกลึง				Diameter หลังกลึง				Exp. Dim	Dim. Err.
					1	2	3	ave	1	2	3	ave		
99	400	0.02	0.1	1984	64.21	64.21	64.21	64.21	63.98	63.98	63.98	63.98	64.01	-0.03
100	550	0.1	0.3	2553	68.61	68.61	68.60	68.61	67.99	67.98	67.99	67.99	68.01	-0.02
101	400	0.06	0.2	2124	59.98	59.97	59.97	59.97	59.54	59.55	59.55	59.55	59.57	-0.02
102	400	0.02	0.3	2048	62.21	62.22	62.21	62.21	61.60	61.60	61.59	61.60	61.61	-0.01
103	250	0.06	0.3	1160	68.61	68.61	68.61	68.61	67.99	68.00	67.99	67.99	68.01	-0.02
104	550	0.02	0.3	2336	74.99	74.98	74.98	74.98	74.36	74.36	74.35	74.36	74.38	-0.02
105	250	0.02	0.3	1119	71.14	71.14	71.14	71.14	70.52	70.51	70.52	70.52	70.54	-0.02
106	250	0.1	0.2	1195	66.62	66.63	66.62	66.62	66.19	66.20	66.19	66.19	66.22	-0.03
107	550	0.06	0.2	2406	72.80	72.80	72.80	72.80	72.38	72.38	72.38	72.38	72.40	-0.02
108	250	0.02	0.2	1106	71.97	71.97	71.97	71.97	71.55	71.55	71.55	71.55	71.57	-0.02