

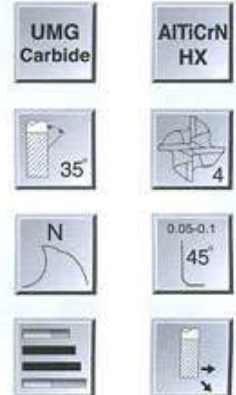
LAMPIRAN 1

Finishing End Mills Schlichtfräser

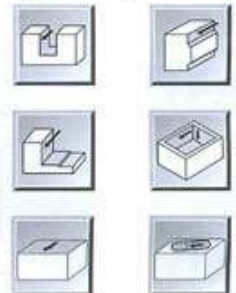


Fresas de acabado

Code No. F604HX-Dc				
Dc h10	Lc mm	L mm	d h5	AlTiCrN F604HX
1	3	50	6	•
1.5	5	50	6	•
2	7	50	6	•
2.5	8	50	6	•
3	8	57	6	•
4	11	57	6	•
5	13	57	6	•
6	13	57	6	•
8	19	63	8	•
10	22	72	10	•
12	26	83	12	•
16	32	92	16	•
20	38	104	20	•



Type of Operation



Work Material



Code No. F606HX-Dc				
Dc h10	Lc mm	L mm	d h5	AlTiCrN F606HX
3	12	63	6	•
4	17	63	6	•
5	19	63	6	•
6	19	63	6	•
8	28	72	8	•
10	34	84	10	•
12	40	97	12	•
16	48	108	16	•
20	56	122	20	•



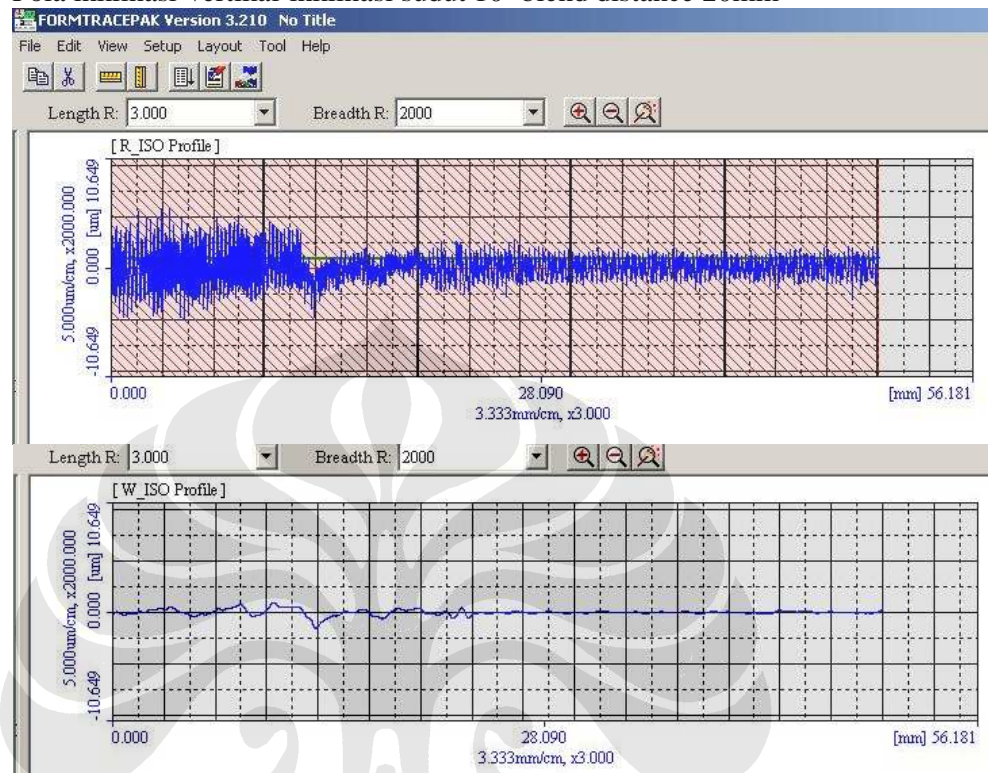
LAMPIRAN 2

Amplitude Parameters (average of ordinates)

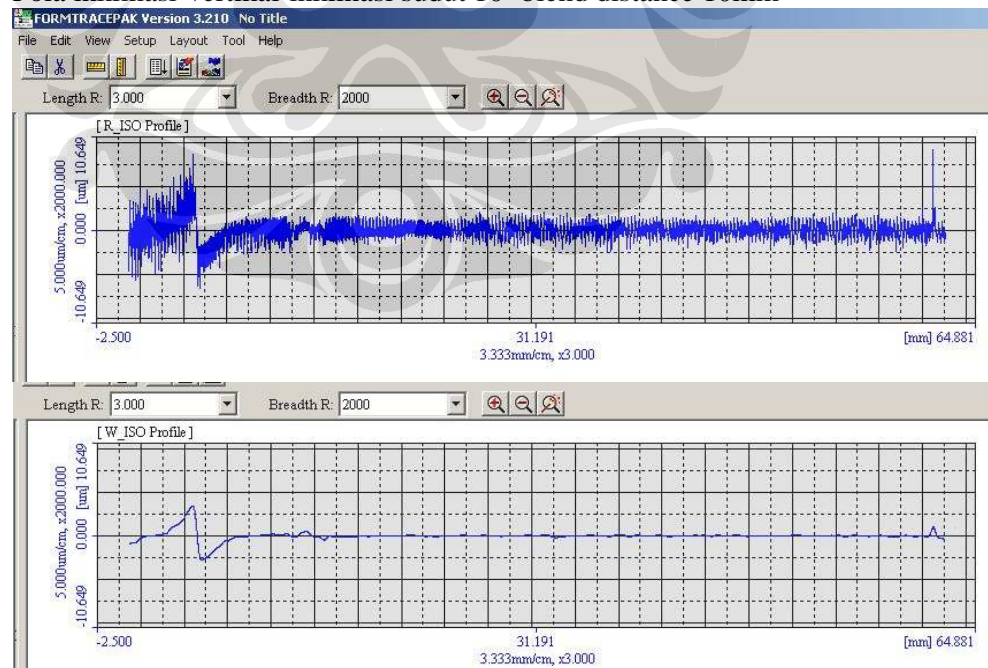
Name	<i>Ra (Pa, Wa)</i>
Type	Amplitude (average)
Calculated from	Roughness Profile
Description	Arithmetical mean deviation of the assessed profile Pa, Ra, Wa arithmetic mean of the absolute ordinate values $Z(x)$ within a sampling length
Mathematical	$Pa, Ra, Wa = \frac{1}{l} \int_0^l Z(x) dx$ with $l = lp, lr$ or lw according to the case.
Graphic	
Source	ISO 4287 – 1996 section 4.2.1
Digital Implementation	Use a natural cubic spline to interpolate through the discrete data values. For each sample length $i = 1, \dots, CN$ Calculate $Ra_i = \frac{1}{l} \int_0^l Z(x) dx$ Calculate $Ra = \frac{1}{CN} \sum_{i=1}^{CN} Ra_i$
Other Information	1. Care required to determine crossover points.

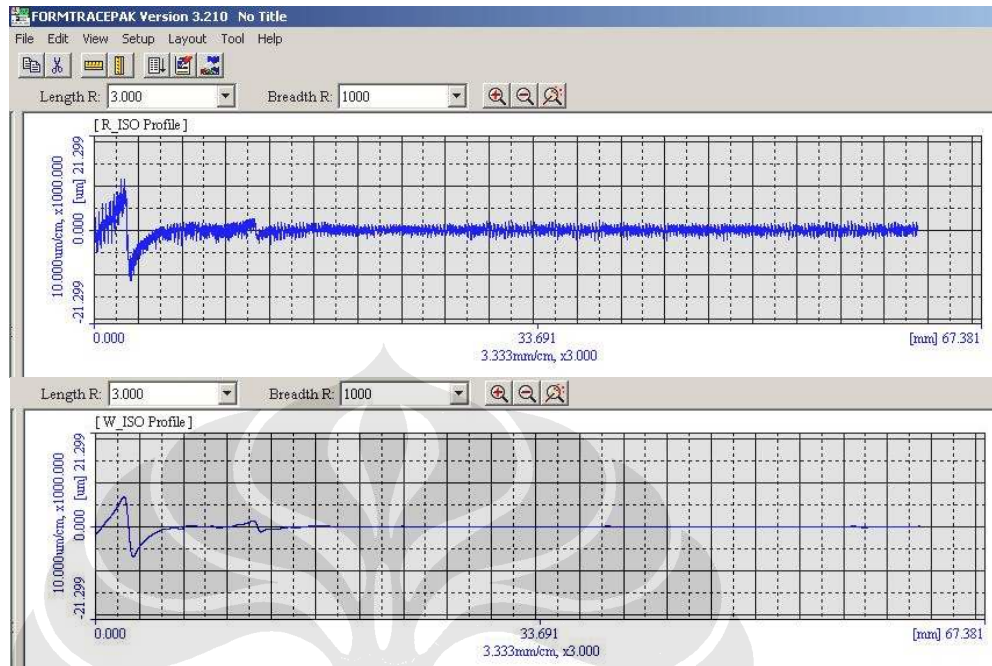
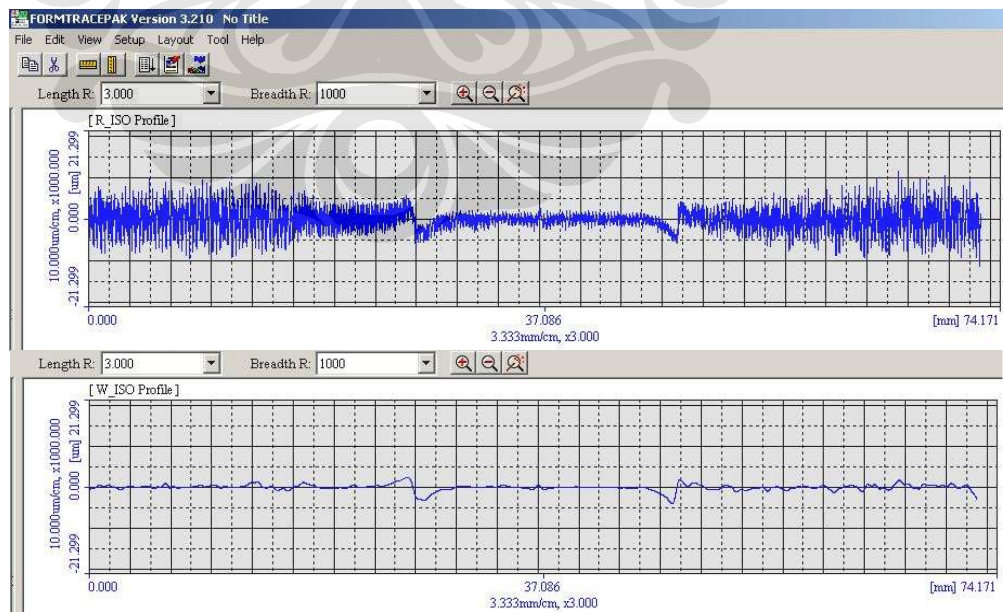
LAMPIRAN 3 (Grafik hasil pengukuran dengan Formtracepak SCV 3000)

Pola inklinali-vertikal-inklinali sudut 10° blend distance 20mm

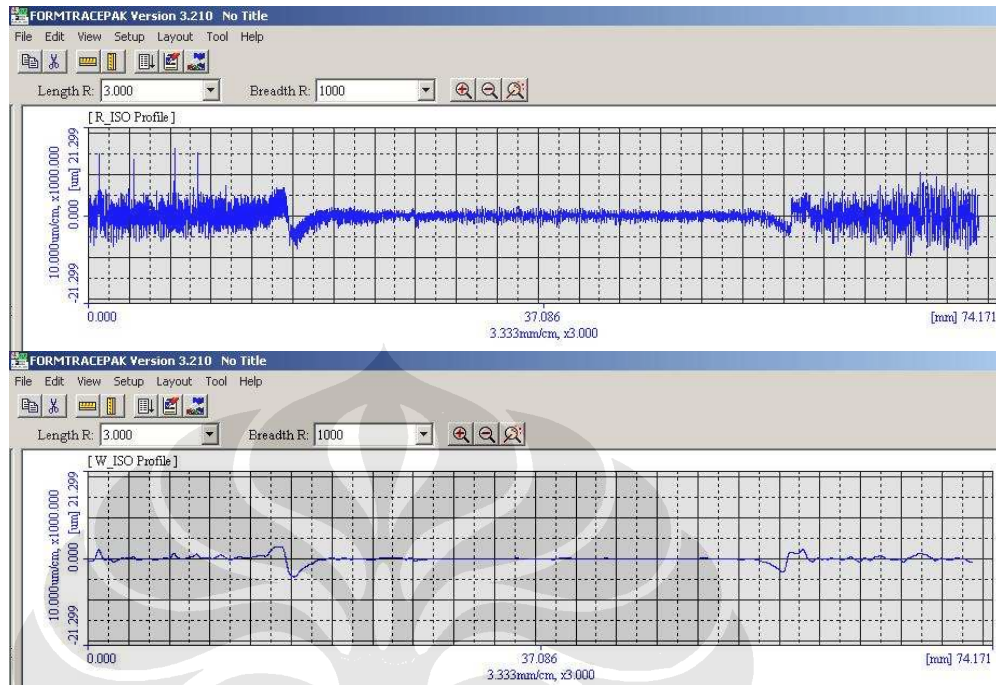


Pola inklinali-vertikal-inklinali sudut 10° blend distance 10mm

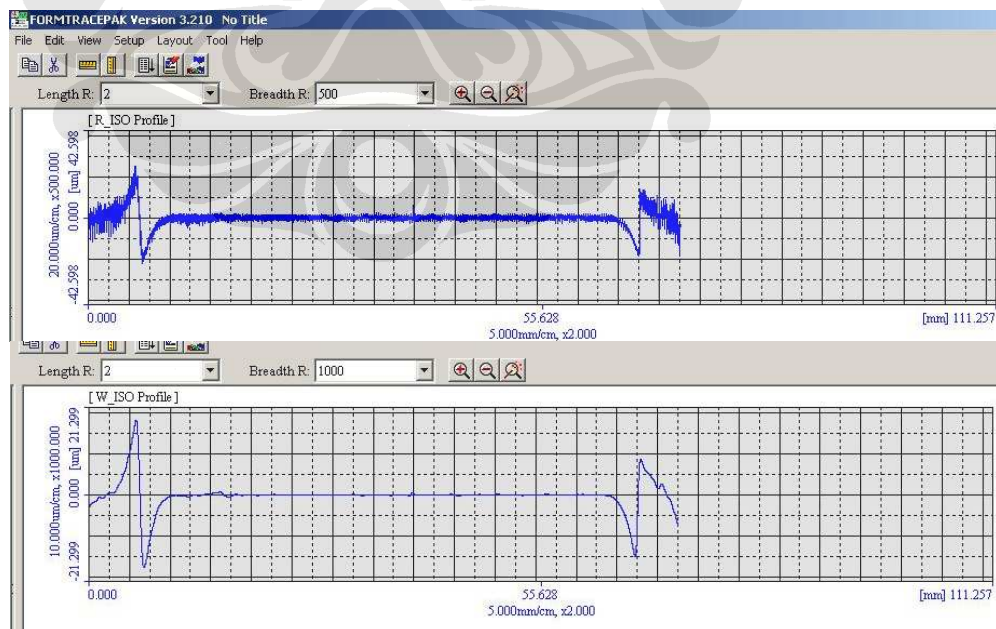


Pola inklinali-vertikal-inklinali sudut 10° blend distance 5mmPola inklinali-vertikal-inklinali sudut 20° blend distance 30mm

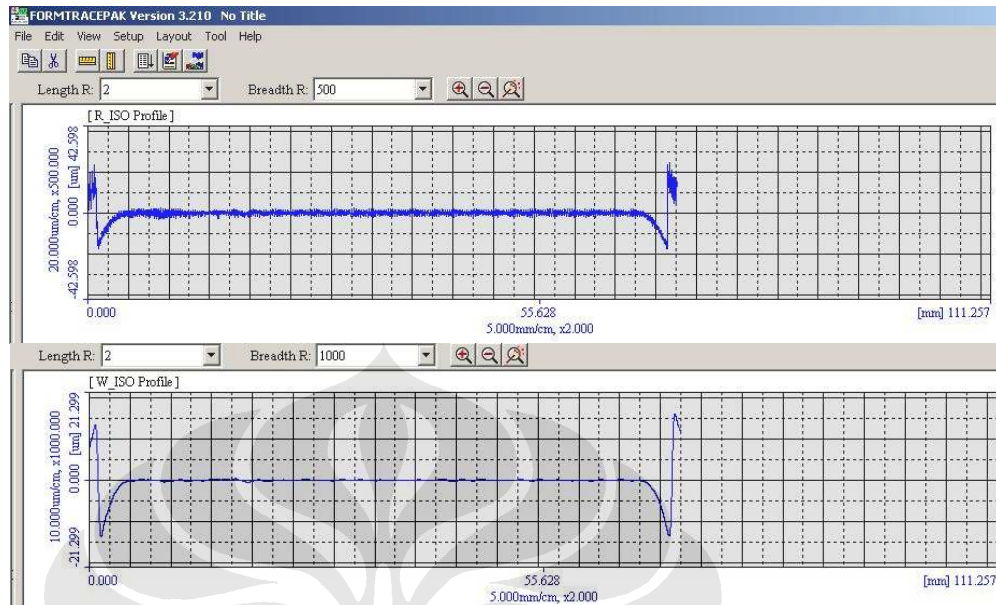
Pola inklinali-vertikal-inklinali sudut 20° blend distance 20mm



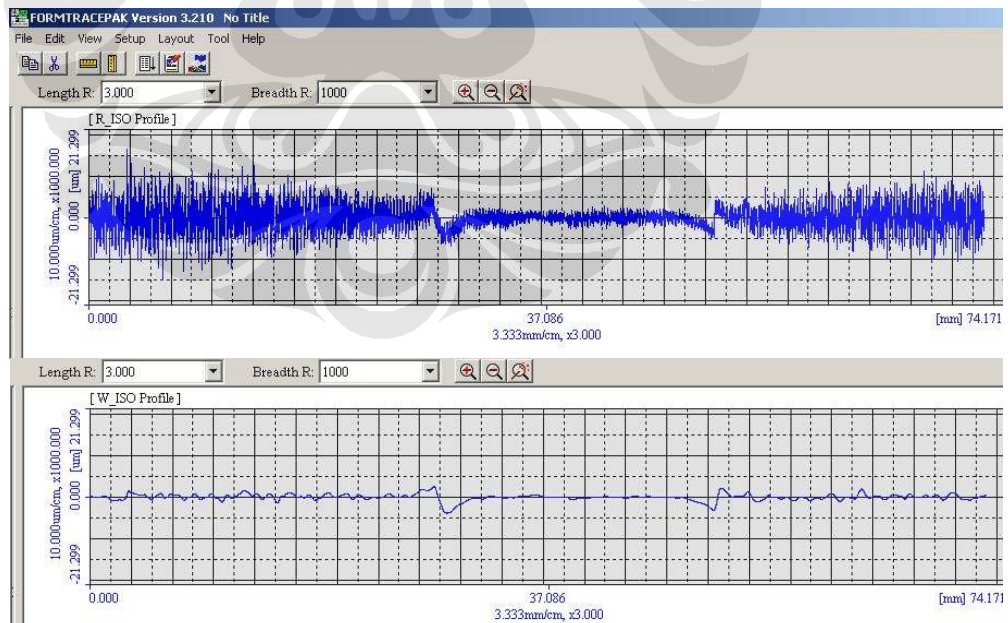
Pola inklinali-vertikal-inklinali sudut 20° blend distance 10mm



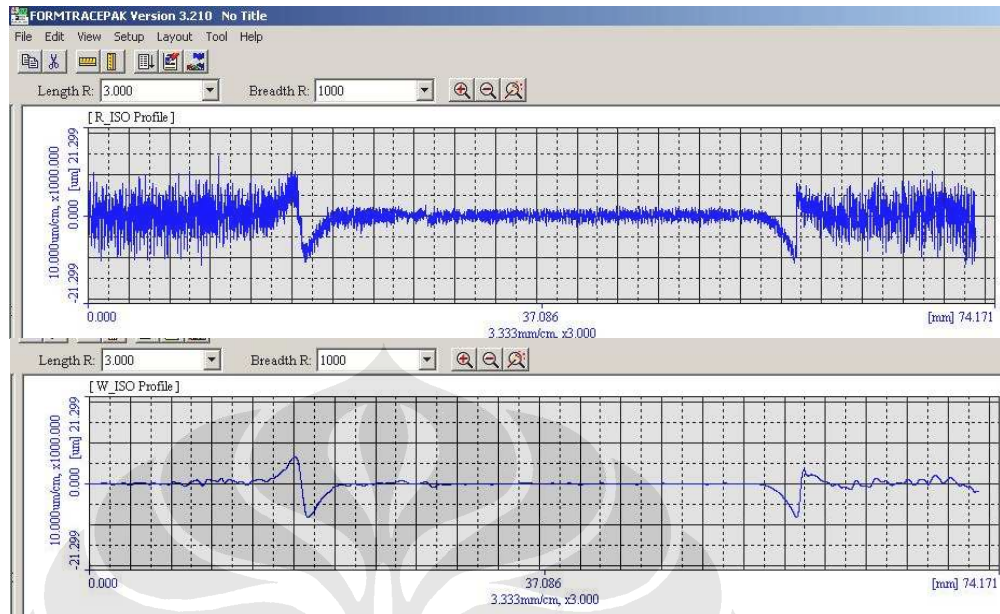
Pola inklinali-vertikal-inklinali sudut 20° blend distance 5mm



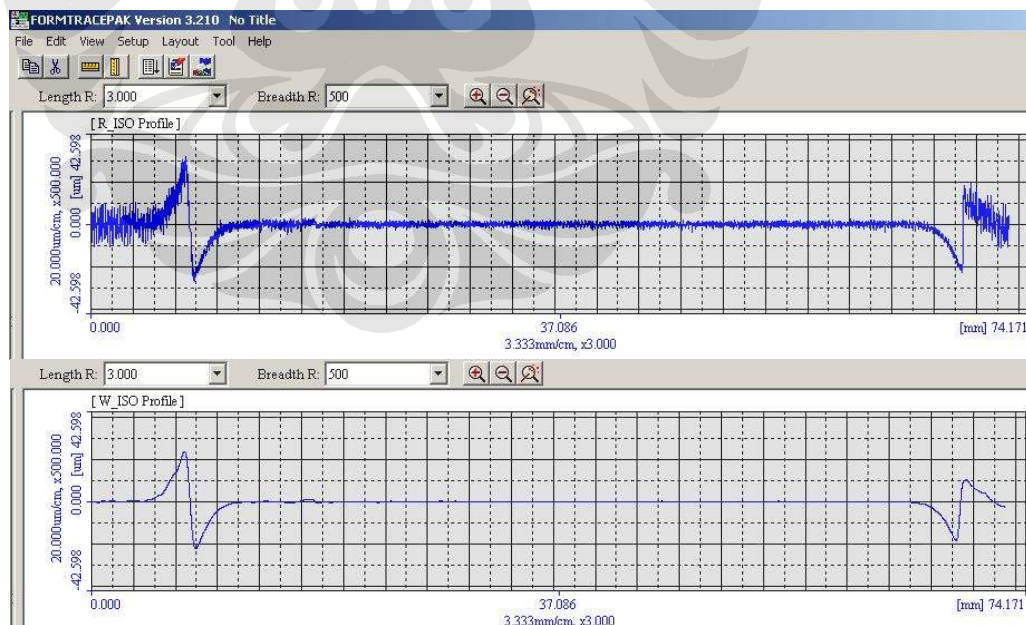
Pola inklinali-vertikal-inklinali sudut 30° blend distance 30mm



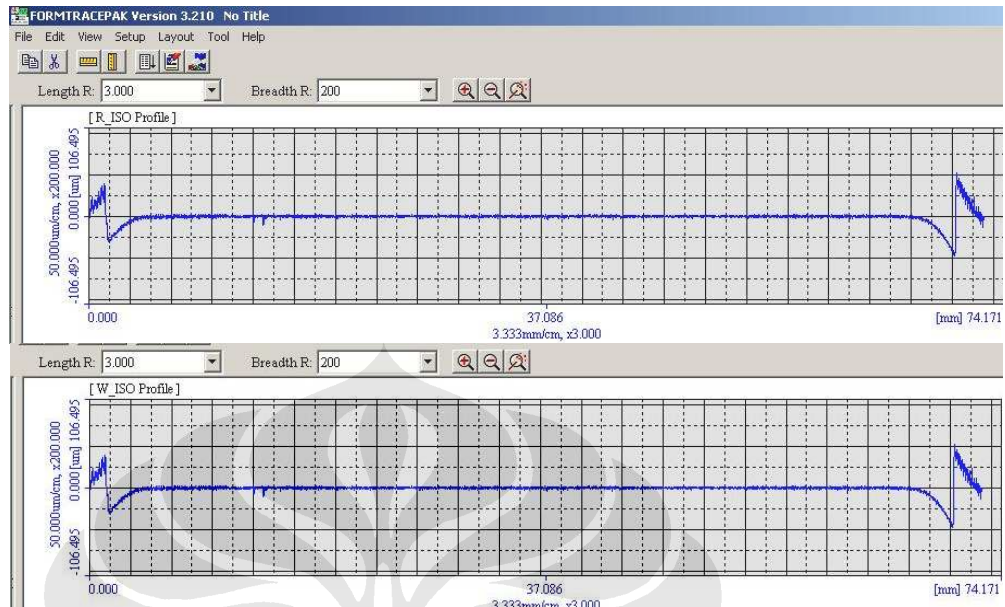
Pola inklinsi-vertikal-inklinsi sudut 30° blend distance 20mm



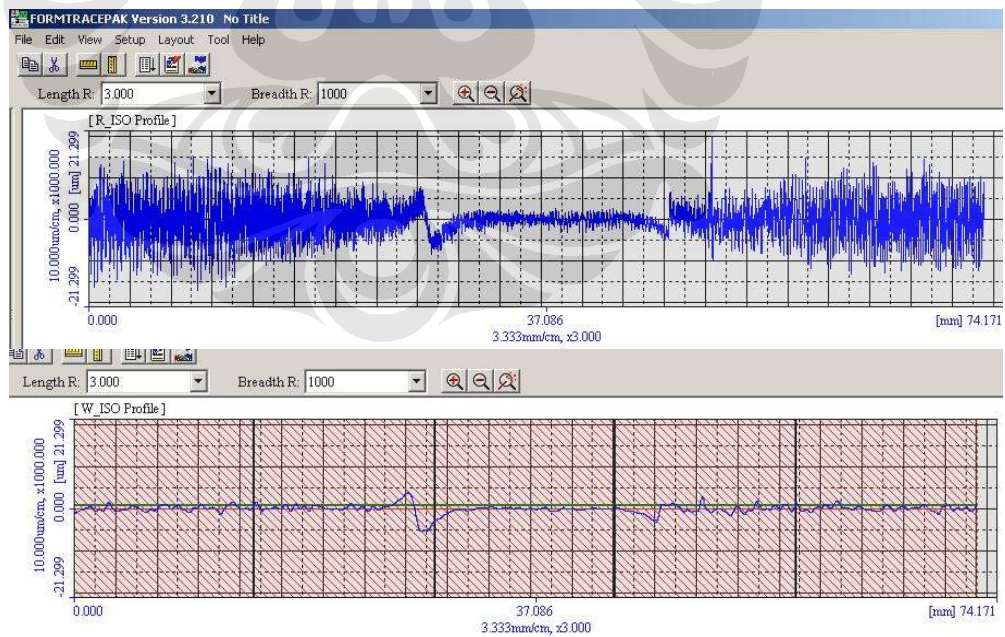
Pola inklinsi-vertikal-inklinsi sudut 30° blend distance 10mm



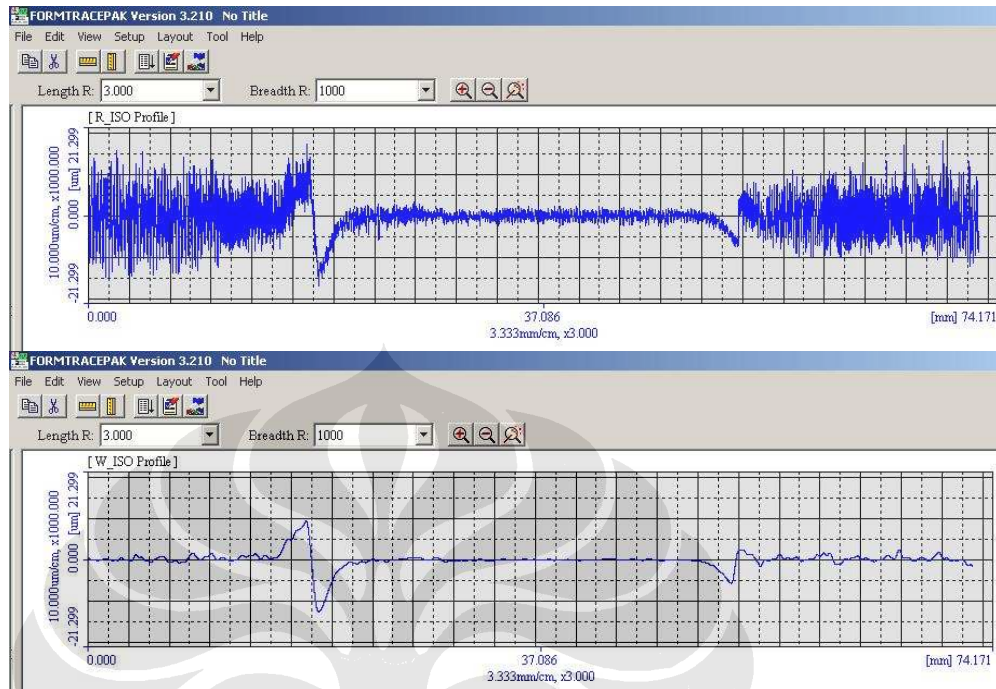
Pola inklinali-vertikal-inklinali sudut 30° blend distance 5mm



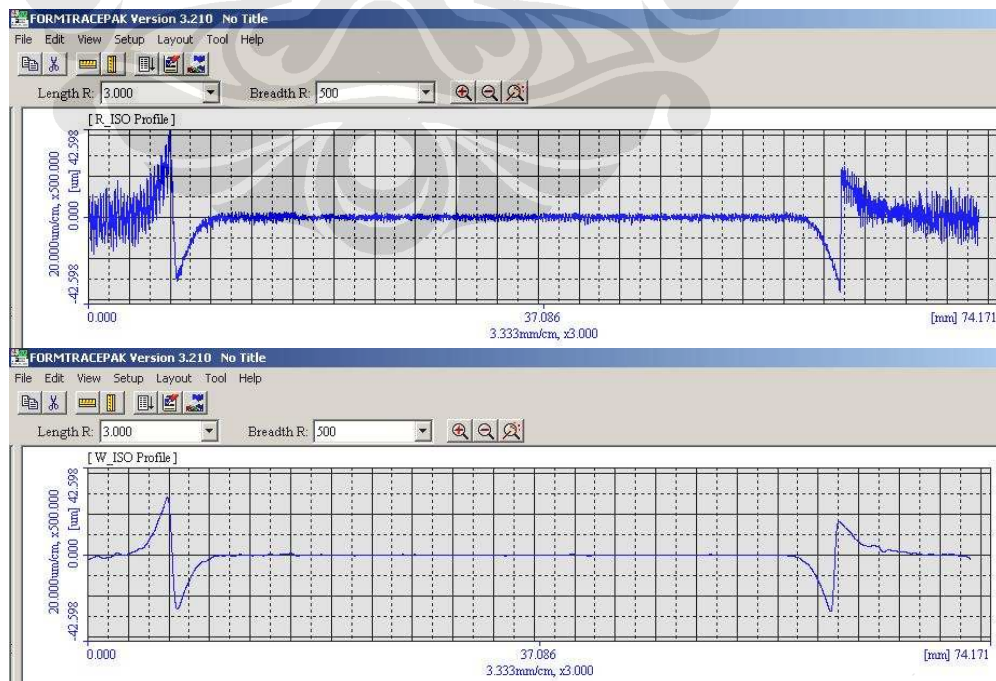
Pola inklinali-vertikal-inklinali sudut 45° blend distance 30mm



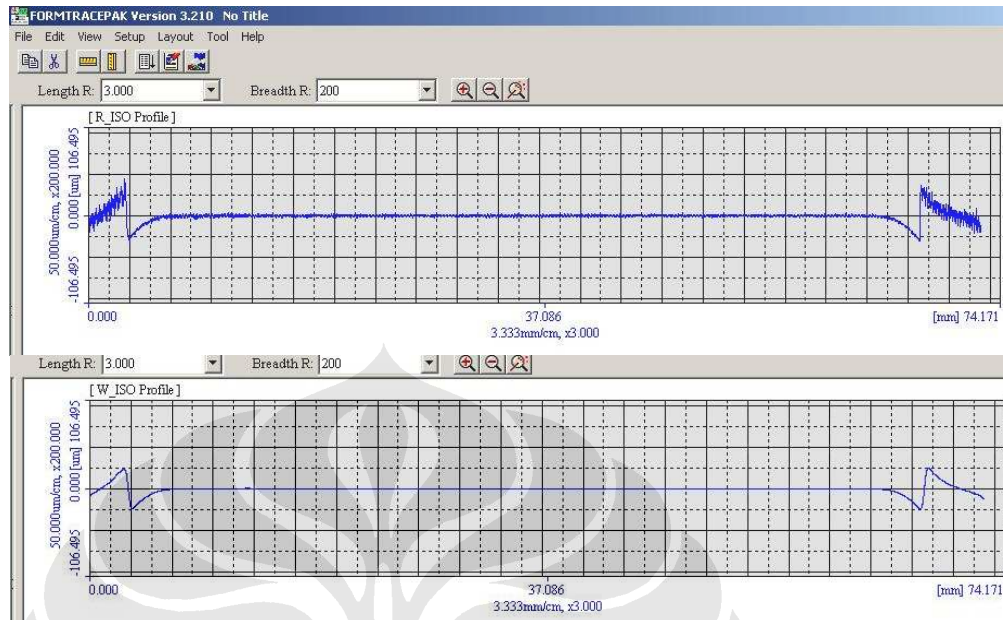
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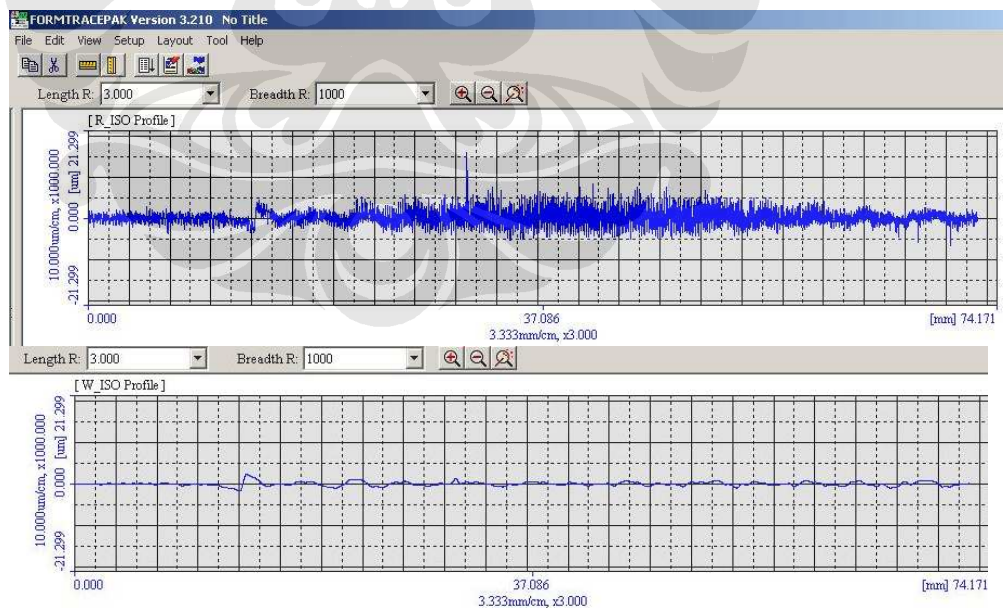
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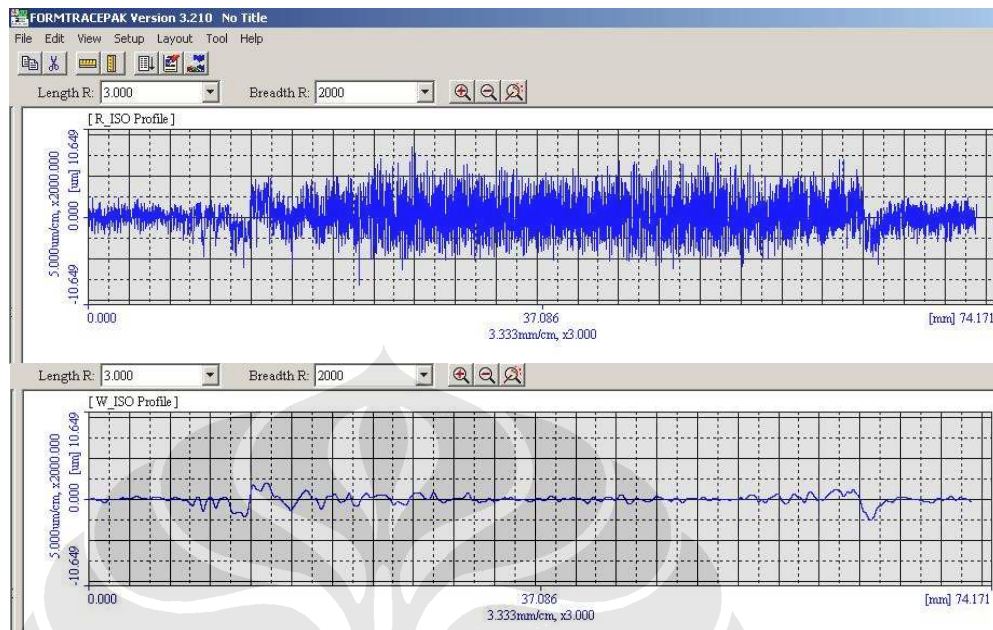
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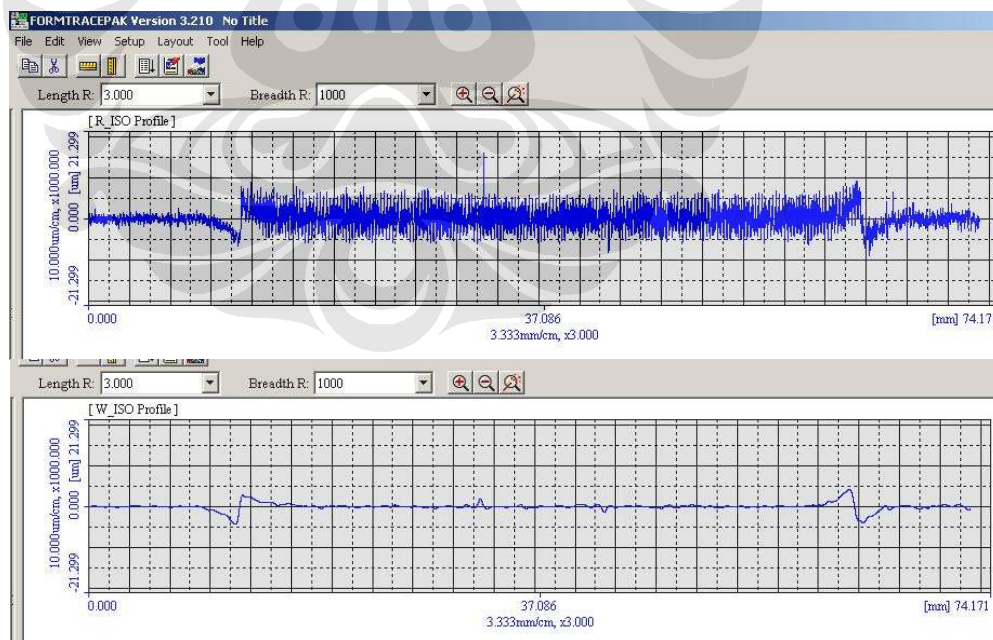
Pola vertikal-inklinali-vertikal sudut 10° blend distance 30mm

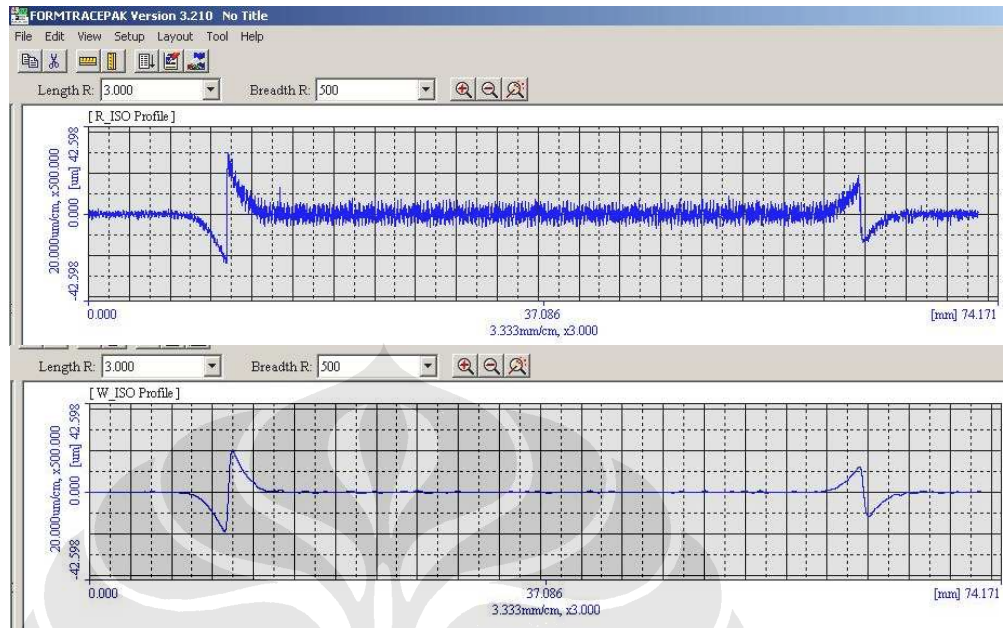
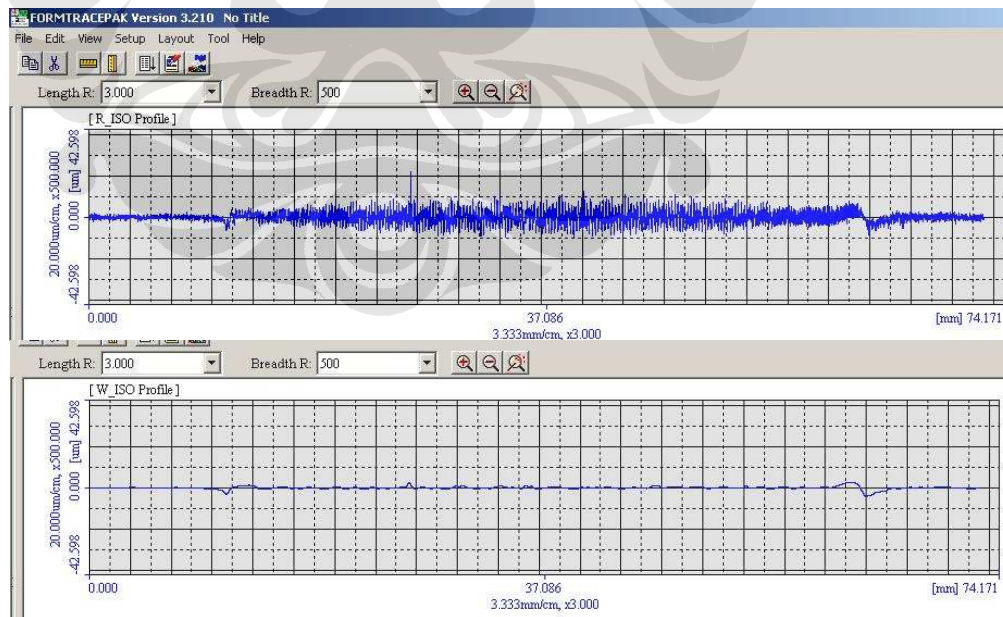


Pola vertikal-inklinasi-vertikal sudut 10° blend distance 20mm

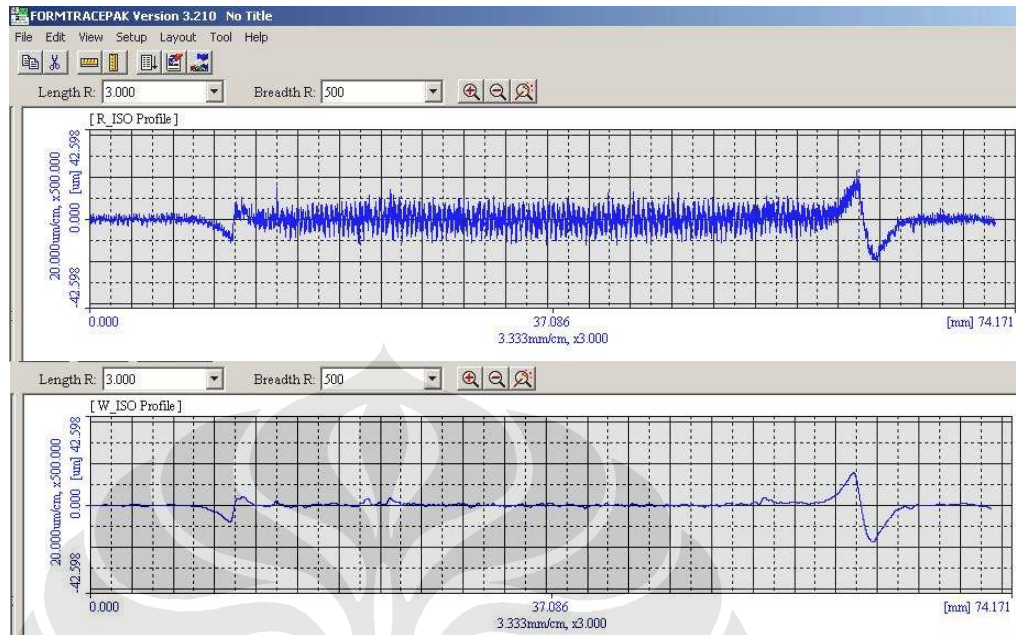


Pola vertikal-inklinasi-vertikal sudut 10° blend distance 10mm

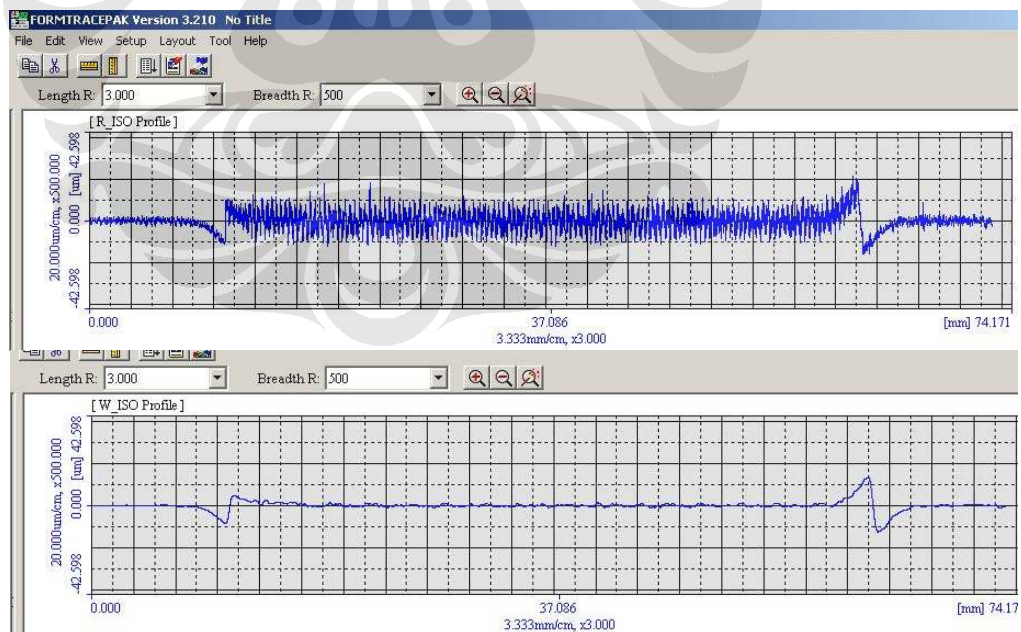


Pola vertikal-inklinasi-vertikal sudut 10° blend distance 5mmPola vertikal-inklinasi-vertikal sudut 20° blend distance 30mm

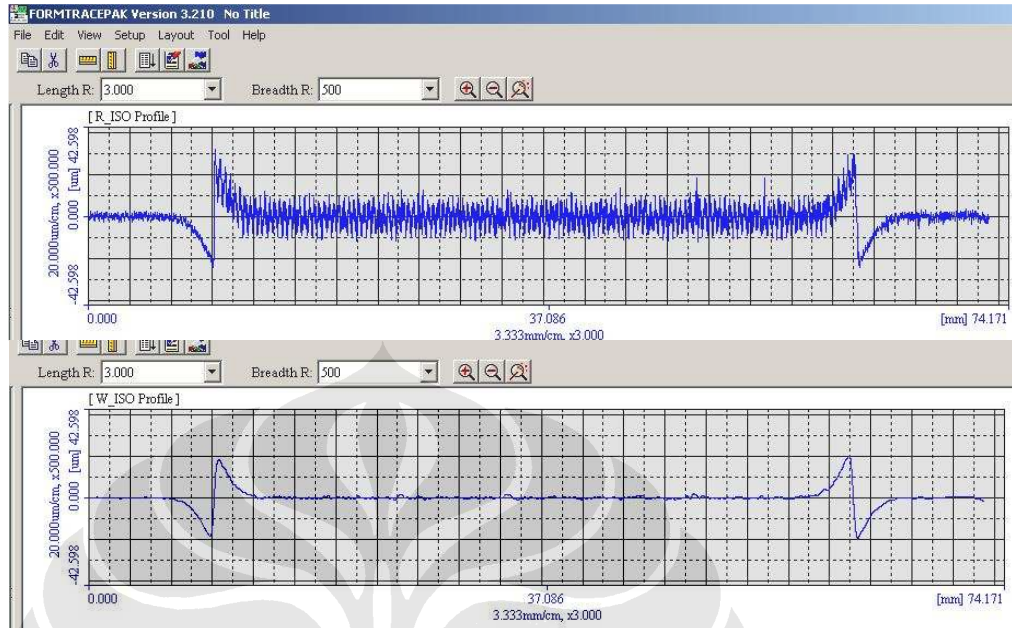
Pola vertikal-inklinasi-vertikal sudut 20° blend distance 20mm



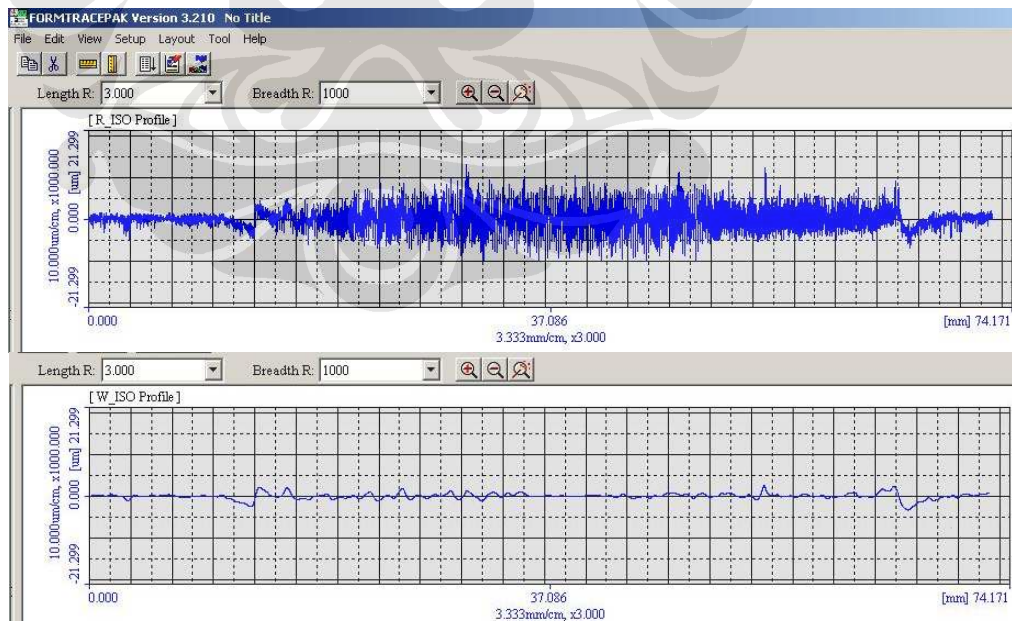
Pola vertikal-inklinasi-vertikal sudut 20° blend distance 10mm



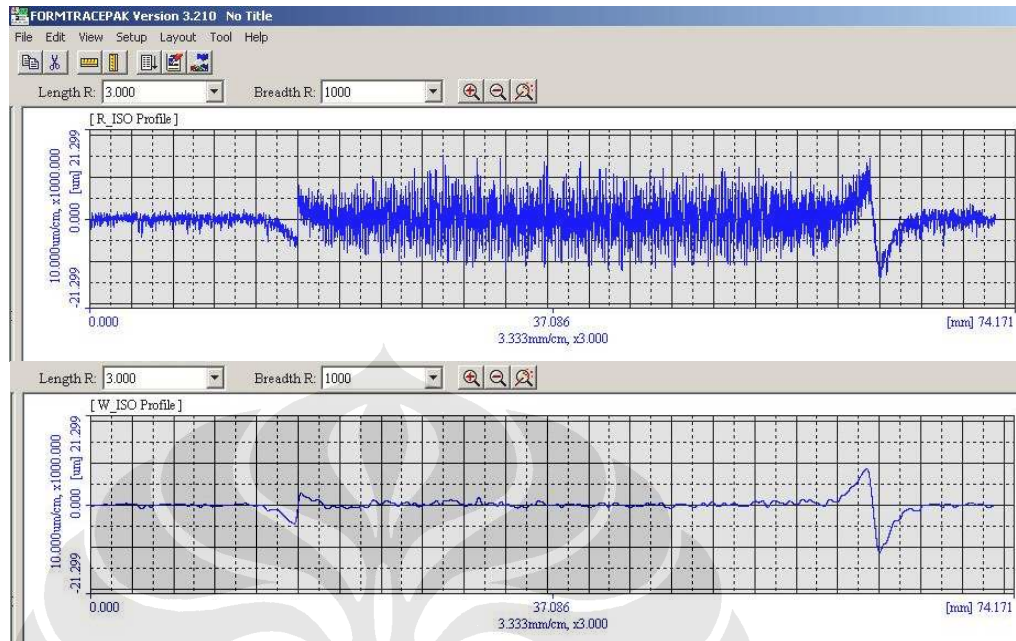
Pola vertikal-inklinasi-vertikal sudut 20° blend distance 5mm



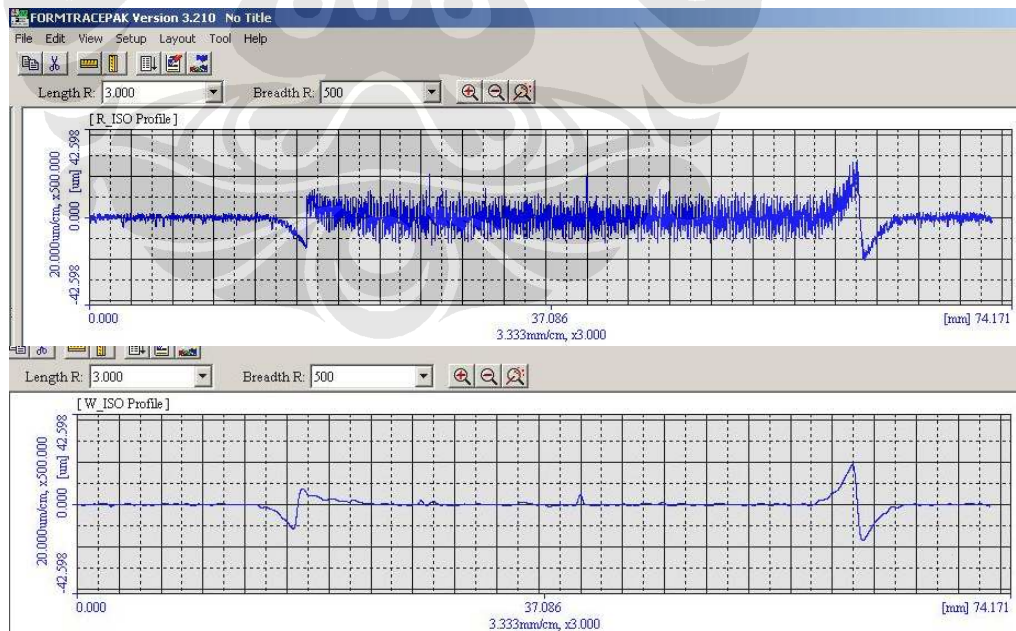
Pola vertikal-inklinasi-vertikal sudut 30° blend distance 30mm



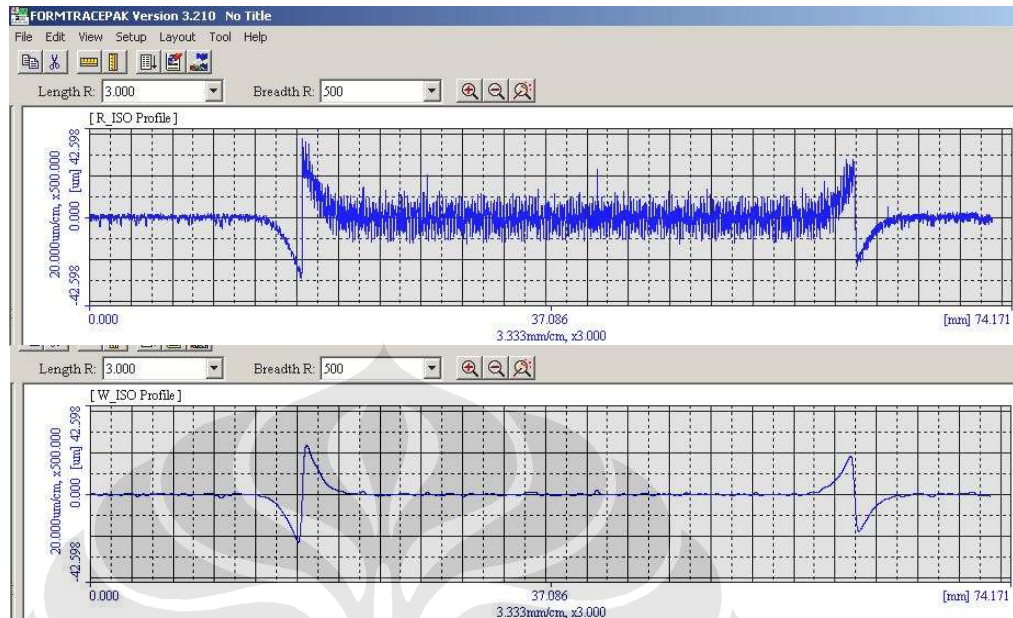
Pola vertikal-inklinasi-vertikal sudut 30° blend distance 20mm



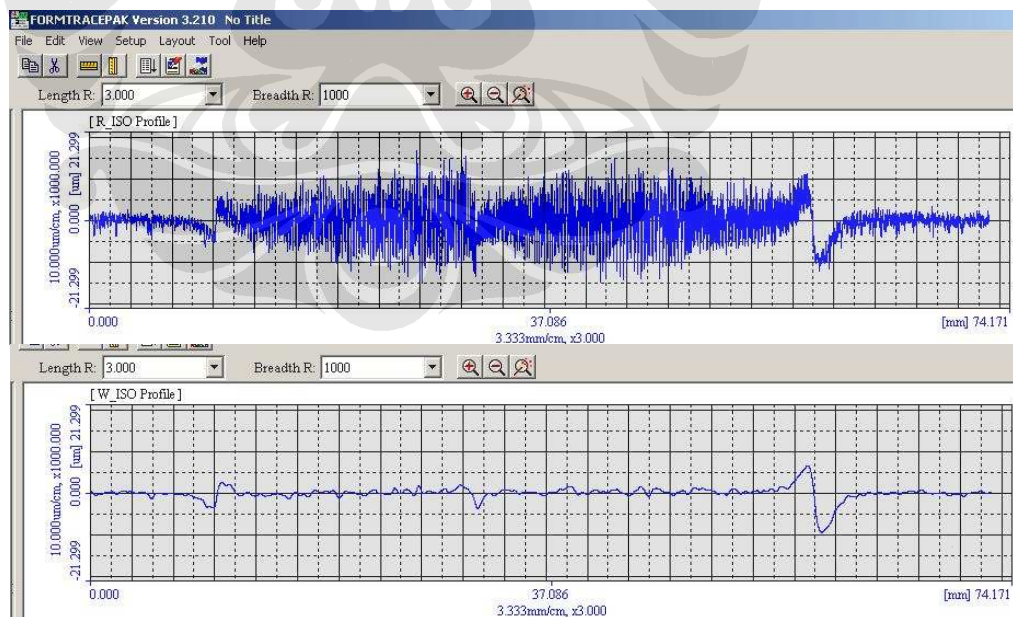
Pola vertikal-inklinasi-vertikal sudut 30° blend distance 10mm



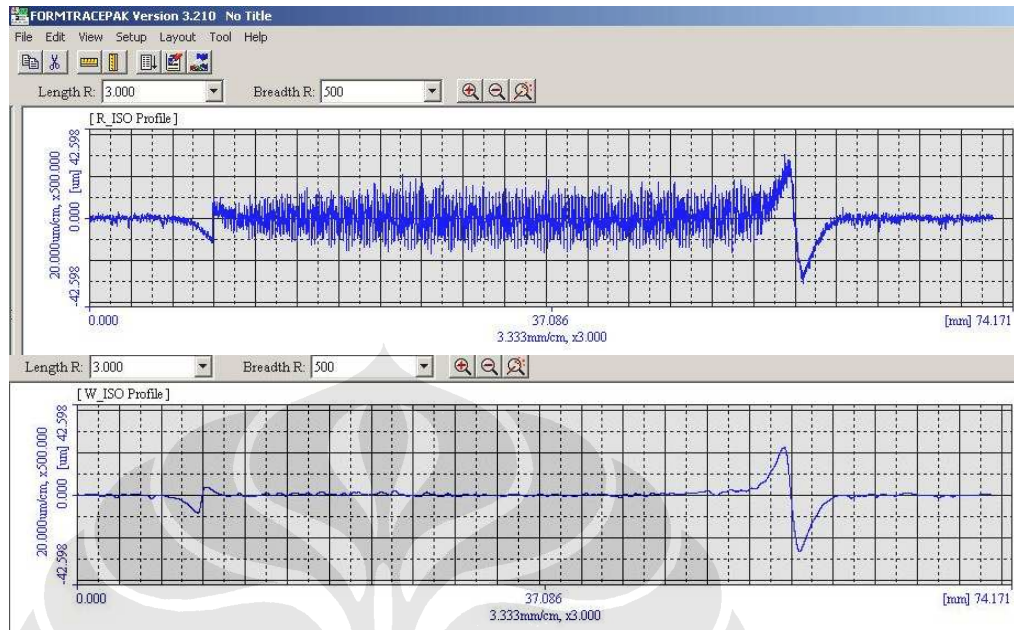
Pola vertikal-inklinasi-vertikal sudut 30° blend distance 5mm



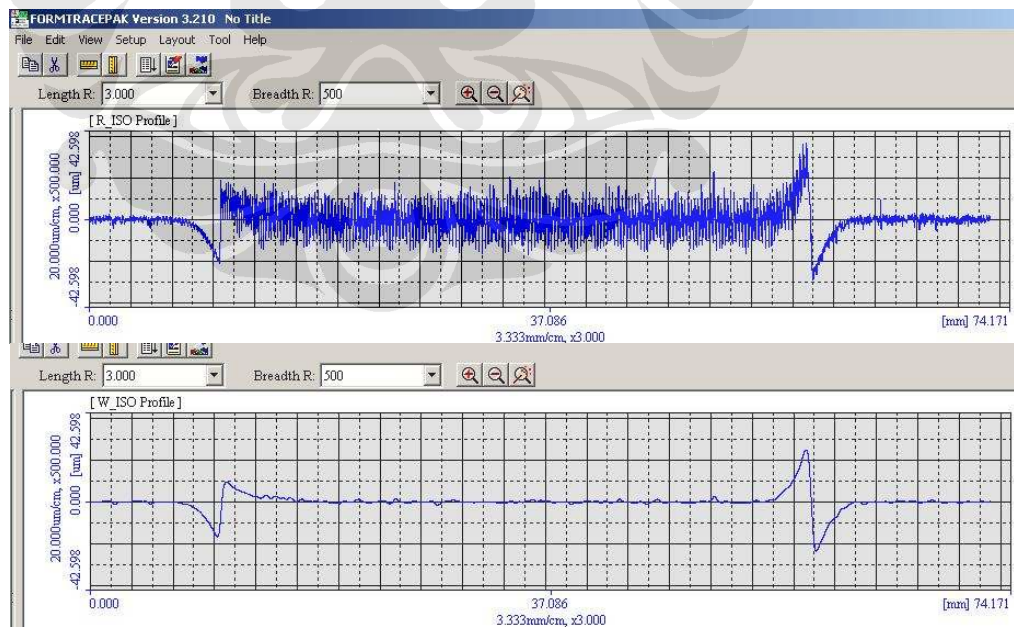
Pola vertikal-inklinasi-vertikal sudut 45° blend distance 30mm



Pola vertikal-inklinasi-vertikal sudut 45° blend distance 20mm



Pola vertikal-inklinasi-vertikal sudut 45° blend distance 10mm



Pola vertikal-inklinasi-vertikal sudut 45° blend distance 5mm

