APPENDIX 1

Figure A 1.1 Cutting force detail of 2 minutes dipped insert for the experimental run 1

Figure A 1.2 Cutting force detail of 2 minutes dipped insert for experimental run 2
Figure A 1.3 Cutting force detail of 2 minutes dipped insert for experimental run 3

Figure A 1.4 Cutting force detail of 2 minutes dipped insert for experimental run 4
Figure A 1.5 Cutting force detail of 2 minutes dipped insert for experimental run 5

Figure A 1.6 Cutting force detail of 2 minutes dipped insert for experimental run 6
Figure A 1.7 Cutting for Cutting force detail of 2 minutes dipped insert for experimental run 7

Figure A 1.8 Cutting for Cutting force detail of 2 minutes dipped insert for experimental run 8
Figure A 1.9 Cutting for Cutting force detail of 2 minutes dipped insert for experimental run 9
APPENDIX 2

Figure A 2.1 Cutting force detail of 3 minutes dipped insert for experimental run 1

Figure A 2.2 Cutting force detail of 3 minutes dipped insert for experimental run 2
Figure A 2.3 Cutting force detail of 3 minutes dipped insert for experimental run 3

Figure A 2.4 Cutting force detail of 3 minutes dipped insert for experimental run 4
Figure A 2.5 Cutting force detail of 3 minutes dipped insert for experimental run 5

Figure A 2.6 Cutting force detail of 3 minutes dipped insert for experimental run 6
Figure A 2.7 Cutting force detail of 3 minutes dipped insert for experimental run 7

Figure A 2.8 Cutting force detail of 3 minutes dipped insert for experimental run 8
Figure A 2.9 Cutting force detail of 3 minutes dipped insert for experimental run 9
APPENDIX 3

Figure A 3.1 Cutting force detail of 4 minutes dipped insert for experimental run 1

Figure A 3.2 Cutting force detail of 4 minutes dipped insert for experimental run 2
Figure A 3.3 Cutting force detail of 4 minutes dipped insert for experimental run 3

Figure A 3.4 Cutting force detail of 4 minutes dipped insert for experimental run 4
Figure A 3.5 Cutting force detail of 4 minutes dipped insert for experimental run 5

Figure A 3.6 Cutting force detail of 4 minutes dipped insert for experimental run 6
Figure A 3.7 Cutting force detail of 4 minutes dipped insert for experimental run 7

Figure A 3.8 Cutting force detail of 4 minutes dipped insert for experimental run 8
Figure A 3.9 Cutting force detail of 4 minutes dipped insert for experimental run 2
Figure A 4.1 Cutting force detail of 5 minutes dipped insert for experimental run 1

Figure A 4.2 Cutting force detail of 5 minutes dipped insert for experimental run 2
Figure A 4.3 Cutting force detail of 5 minutes dipped insert for experimental run 3

Figure A 4.4 Cutting force detail of 5 minutes dipped insert for experimental run 4
Figure A 4.5 Cutting force detail of 5 minutes dipped insert for experimental run 5

Figure A 4.6 Cutting force detail of 5 minutes dipped insert for experimental run 6
Figure A 4.7 Cutting force detail of 5 minutes dipped insert for experimental run 7

Figure A 4.8 Cutting force detail of 5 minutes dipped insert for experimental run 8
Figure A 4.9 Cutting force detail of 5 minutes dipped insert for experimental run 9