|  |  |  |  |
| --- | --- | --- | --- |
| **Jenis *Coolant*** | ***Type Insert Tools*** | **Kecepatan putar (*Rpm*)** | ***Cutting speed*** |
| *Water coolant* | *TNMG 160408 MA TST 5080* | 838.083 *rpm* | 0.1 mm/putaran |
| *Cutting Oil* | *TNMG 160408 MA TST 5080* | 838.083 *rpm* | 0.1 mm/putaran |
| *Air blow* | *TNMG 160408 MA TST 5080* | 838.083 *rpm* | 0.1 mm/putaran |

**Tabel 1** Data Awal Pengujian Ke-1

**Tabel 2.** Data Awal Pengujian ke – 2

|  |  |  |  |
| --- | --- | --- | --- |
| Jenis *Coolant* | *Type Insert Tools* | Kecepatan putar (*Rpm*) | *Cutting speed* |
| *Water coolant* | *TNMG 160408 MA TST 5080* | 1447,596 *rpm* | 0.1 mm/putaran |
| *Cutting Oil* | *TNMG 160408 MA TST 5080* | 1447,596 *rpm* | 0.1 mm/putaran |
| *Air blow* | *TNMG 160408 MA TST 5080* | 1447,596 *rpm* | 0.1 mm/putaran |

**Tabel 3.** Data Awal Pengujian ke – 3.

|  |  |  |  |
| --- | --- | --- | --- |
| Jenis *Coolant* | *Type Insert Tools* | Kecepatan putar (*Rpm*) | *Cutting speed* |
| *Water coolant* | *TNMG 160408 MA TST 5080* | 1990,445 *rpm* | 0.1 mm/putaran |
| *Cutting Oil* | *TNMG 160408 MA TST 5080* | 1990,445 *rpm* | 0.1 mm/putaran |
| *Air blow* | *TNMG 160408 MA TST 5080* | 1990,445 *rpm* | 0.1 mm/putaran |

**Tabel 4.** Tabel Hasil Uji Kekasaran dan Waktu Pengerjaan

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
| **No.** | **Material** | **Jenis Coolant** | **Rpm Mesin CNC** | **CT**  **Cycle Time** | **Hasil Dimensi** | **Hasil Kekasaran (µm)** |
| 1 | SUS 304 Ø38 | *Water Coolant* | 838 | 126,12 detik | Ø30 | 1,591 |
| 2 | SUS 304 Ø22 | *Water Coolant* | 1447 | 73,02 detik | Ø14 | 1,125 |
| 3 | SUS 304 Ø16 | *Water Coolant* | 1990 | 53,093 detik | Ø8 | 0,657 |
| 4 | SUS 304 Ø38 | *Airblow* | 838 | 126,12 detik | Ø30 | 0,748 |
| 5 | SUS 304 Ø22 | *Airblow* | 1447 | 73,02 detik | Ø14 | 1,156 |
| 6 | SUS 304 Ø16 | *Airblow* | 1990 | 53,093 detik | Ø8 | 0,286 |
| 7 | SUS 304 Ø38 | *Cutting Oil* | 838 | 126,12 detik | Ø30 | 0,452 |
| 8 | SUS 304 Ø22 | *Cutting Oil* | 1447 | 73,02 detik | Ø14 | 1,177 |
| 9 | SUS 304 Ø16 | *Cutting Oil* | 1990 | 53,093 detik | Ø8 | 2,355 |