**Tabel 1.** Tabel Variabel Pengujian Kekasaran Permukaan

|  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- |
| **No. Spc** | **Jenis Endmill** | **Kec. Spindel (*Rpm*)** | **Depth Of Cuts atau Mak. Pemakanan (mm)** | ***Feed rate* atau Kec. Pemakanan (mm/menit)** | **Nilai Kekasaran *Surface Rougness Tester* (*µm*)** |
| 1. | HSS | 2000 | 2 | 500 | - |
| 2. | HSS | 2500 | 2 | 500 | - |
| 3. | HSS | 3000 | 2 | 500 | - |
| 4. | Karbida | 2000 | 2 | 500 | - |
| 5. | Karbida | 2500 | 2 | 500 | - |
| 6. | Karbida | 3000 | 2 | 500 | - |

**Tabel 2.** Spesifikasi Mesin CNC Milling

|  |  |
| --- | --- |
| **Item** | **Spesifikasi** |
| Jenis Mesin | Mesin CNC Milling |
| Type | Weidamc VMC-640 |
| Kecepatan Max Spindel | 6000 Rpm |
| Dimensi keseluruhan ( P x L x t ) | 2000 mm x 1800 mm x 2250 mm |
| Ukuran Table ( P x L) | 800 mm x 320 mm |
| Max. Beban Table | 350 Kg |
| Torsi Servo Tiga Sumbu | 6 Nm / 6 Nm / 10 Nm |
| Berat Bersih | 2000 Kg |

**Tabel 3.** Tabel Hasil Pengujian Kekasaran Permukaan

|  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- |
| **No. Spc** | **Nama Spc** | **Kec. Spindel (*Rpm*)** | **Ra 1** | **Ra 2** | **Rata-Rata** |
| 1. | H1 | 2000 | 1.045 | 0.962 | 1.035 |
| 2. | H2 | 2500 | 0.959 | 0.964 | 0.961 |
| 3. | H3 | 3000 | 0.927 | 0.894 | 0.910 |
| 4. | K4 | 2000 | 1.359 | 1.371 | 1.365 |
| 5. | K5 | 2500 | 0.570 | 0.570 | 0.570 |
| 6. | K6 | 3000 | 0.547 | 0.532 | 0.539 |