Investigation of surface roughness in face milling processes

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Abstract

This study aims to investigate the effects of dry, minimum quantity lubrication (MQL) and nanofluid cutting conditions on surface roughness (Ra) and material removal rate (MRR) for Al6082-T6. Three controllable factors namely feed rate (Fr), spindle speed (Vs) and depth of cut (Dc) are studied at three levels using Taguchi method. Single-response optimization is conducted using S/N ratio and contour plots. Empirical models of Ra and MRR for all cutting conditions are developed and analysis of variance (ANOVA) is used to measure the adequacy of these models. Experimental results reveal that 26%~30% improvement in Ra could be observed when experimental setup shifted from dry to MQL and 13%~16% improvement is recorded when further shifted to nanofluid cutting condition. No remarkable effect of cutting conditions (dry, MQL and nanofluid) is observed on MRR. Additionally, Vs is observed insignificant for MRR in all cutting conditions. The appropriate cutting conditions and optimum values of input variables are proposed to the practitioners for industrial machining and production when contemplating face milling processes.

Keywords: Minimum quantity lubrication (MQL), Nanofluid, Surface roughness, Face milling, Material removal rate (MRR).

Nomenclature

ANOVA	Analysis of variance
MQL	Minimum quantity lubrication
MRR	Material removal rate
Ra	Surface roughness
S/N ratio	Signal to noise ratio
Fr	Feed rate
Vs	Spindle speed
Dc	Depth of cut

1 Introduction

Face milling is the secondary process used for the cutting and finishing of parts. The process is employed for the fabrication of tooling for other processes with high accuracy in a suitable processing time [1] and also used in the parts of aerospace and automotive industries, where quality is the prime factor [2]. Surface roughness is the measure of quality in machined parts, highly depends upon controlling parameters: Fr, cutting speed and Dc [3]. There is a need to optimize these controlling parameters to enhance the quality of parts as Ra is sensitive to Fr [4, 5]. It was observed that the parameters other than feed (axial & radial Dc and cutting speed) are also significant factors that affects the Ra [6]. Material removal rate is the second major measure, which need to be maximized without compromising the surface quality of the part [7]. The factors that contribute in achieving maximum MRR are Fr and Dc [8]. High Fr results in higher MRR but it also increase the cutting temperature which reduces the tool life [9] and surface quality [10]. Beside input parameters, cutting fluid has the prime importance in metal cutting processes for enhancing the quality of the workpiece by lubricating the tool. Workpiece interface Lubrications (cutting fluid) improves the machining characteristics and work piece's surface quality [11]. But flooded cooling increases the manufacturing cost by 16% [12]. To minimize the coolant cost, MQL technique was introduced. Researchers focused on MQL technique as it reduces the consumption of lubricant by sprinkling the blend of air and lubricant and as environmental friendly [13]. In MQL, coolant mixed with compressed air is sprayed at the tool-workpiece interface at a low flow rate [14]. It is reported that the MQL reduces the coolant consumption 3 times than flooded cooling using flow rate 50-500 ml/h approximately. It is investigated that MQL produce superior surface finish than other conventional methods of lubrication [15, 16]. MQL not only improves the surface finish but also reduces cutting temperature and enhances the tool life by reducing the flank wear [17, 18] as it provides excess amount of oxygen at tool-workpiece interface forming the protective oxide layer [19]. But for material removal rate, it is evident that MQL did not show significant improvement for medium carbon steel [20].

To enhance the efficiency of MQL, nanoparticles are contaminated in the fluid. The addition of nanoparticles improves the surface quality [21]. It is claimed that 46% reduction in surface roughness was achieved as compared to the commonly used lubricant [12]. In nanofluid, particles form a lubrication film and fills the surface cavities which polish the surface and improve the surface quality [22, 23]. It is noticed that nanofluid exhibits better Ra as compared to base fluid [24]. However, increasing of nanoparticles concentration results in reduced Ra since the excess nanoparticles concentration enhances the viscosity of cutting fluid and fills the surface pores. Incoming nanoparticles shear off the existing ones and other ploughed off particles remain stuck on exfoliated film in tool-workpiece interface. Therefore, increased nanoparticles concentration may negatively influence the surface quality [25]. But the percentage improvement is different for soft and hard material while using MQL and nanofluid. And there is a need to study the trends of the input variables/parameters in different cutting conditions.

Number of statistical and mathematical techniques including Response surface methodology, Factorial design, Taguchi method, Genetic algorithm, Fuzzy logic and Artificial neural network have been used [26-32]. Among these techniques, Genetic algorithm, Fuzzy logic and Artificial neural network are the soft computing while, Response surface methodology, Factorial design and Taguchi method are statistical techniques. Soft computing techniques also have the ability to predict the response measures and repetitive hit and trial is used for prediction. However, statistical techniques require less number of experiments for the prediction and optimization. Therefore, Taguchi method has been observed with less number of experiments and also considered as cost effective [33]. After the selection of suitable experimental design, various analysis techniques including Multi-criteria decision-making (MCDM) analysis, Grey relational analysis (GRA) and Analysis of variance (ANOVA) have also been used by the researchers in order to optimize the response measures [34-36].

Industrial sector is still in efforts to obtain a proper combination of workpiece material, lubrication and nanoparticles, which are highly efficient and inexpensive for the machining of specific material. For example, a lubrication and nanoparticles used for the machining of hard material can be expensive for the softer materials. The alloy chosen for this research commonly used in machining application due to its high strength and corrosion resistance. However, little study is observed on investigating the effects of these cutting conditions on Ra along with MRR for this specific aluminum alloy in face milling process. Therefore, this study aims to analyze the impact of dry, MQL and nanofluid cutting conditions on Ra and MRR. The influence of three effective input variables including Fr, Vs and Dc have been investigated using Taguchi method.

The rest of this paper is organized as follows. Section 2 explains the experimental procedure for the machining of aluminum specimens with dry, MQL and nanofluid medium and the Taguchi method used for the design of experiment. Investigated results, analysis using ANOVA and optimization through contour plots have been presented in section 3. Finally, conclusions of overall research and recommendations for the future study are discussed in section 4.

2 Experimental procedure

This section gives a detail about material composition, experimental setup, sample preparation and response measurements. Aluminum alloy 6082-T6 selected for the machining purpose having mechanical properties and composition are given in Table 1 and 2 respectively. Optical emission spectrometer is operated to check the chemical composition of work piece material used. Machining of workpiece material highly depends upon its mechanical properties. Machinability refers to the ease of cutting of metal and allowing the removal of material swiftly. Materials with superior machinability requires less cutting power and time. Machinability of aluminum is considered to be excellent in term of achieving minimum Ra and maximum MRR. To further improve the machinability of the selected workpiece material different parameters and cutting conditions has been adopted. From the previous research it has been observed that Fr, Vs and Dc are the most effective input parameters for Ra and MRR [37-39]. Therefore, Fr, Vs and Dc are used as process variables in three different cutting conditions; dry, MQL and nanofluid. Fr is the linear motion of tool throughout the machining. Vs is the rotational motion of tool and Dc is controlled by the vertical movement of the tool. Commercial soluble oil is used as lubricant in MQL machining. A system has been developed for the delivery of MQL between the tool and workpiece interface. Air pressure gun attached with a compressor has been employed to throw air-lubricant mist using 5 bar pressure. The oil mist has been produced inside the tank using air pressure. Flow rate of aerosol has been kept constant at 400 ml/h. In nanofluid, Al_2O_3 nanoparticles of size 80 μm mixed with soluble oil in 5 percent by weight ratio was used with same flow rate.

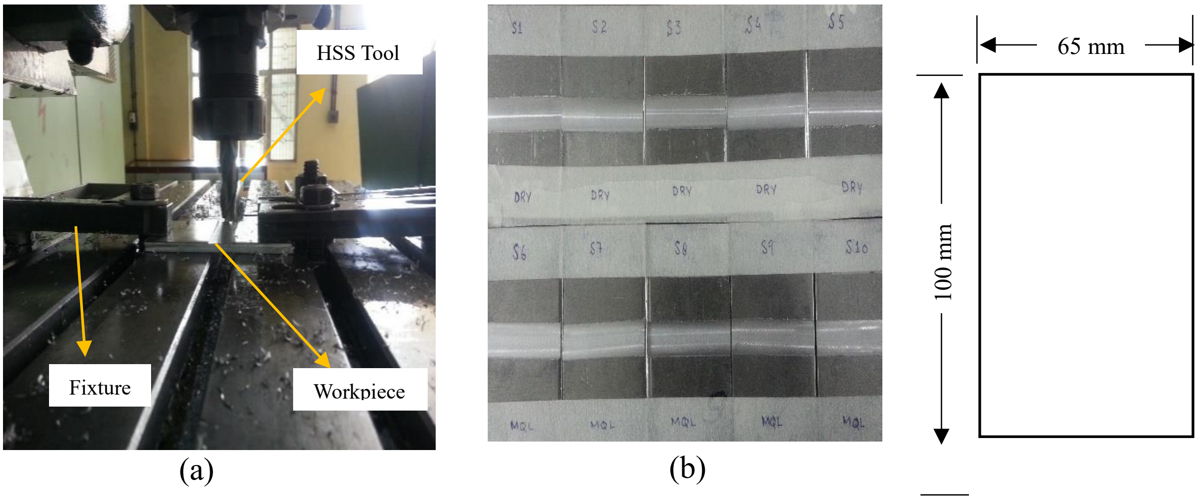
Table 1. Properties of Al6082-T6 [40]

Properties	Value
Density (g/cm³)	2.7
Hardness (Vickers)	95
Ultimate tensile strength (MPa)	300
Yield strength (MPa)	255
Elongation at break (%)	10
Modulus of elasticity (GPa)	69
Shear strength (MPa)	200
Modulus (GPa)	26

Table 2. Chemical composition of aluminum alloy (Al-6082)

Si	Fe	Zn	Cr	Mg	Mn	Cu	Al	Others
1.2	0.33	0.05	0.14	0.78	0.5	0.08	Bal	0.15

Machining process is performed using NC MIKRON WF21C milling machine having maximum Vs of 4000 rpm is shown in Figure 1(a). Workpiece is clamped using fixtures to avoid any vibration and distortion during the machining. To avoid the effect of machine-tool fixture environment on the machining rate and quality, all workpiece are clamped with same type and number of fixtures. Use of proper machine tool fixtures enables experimental process to present the true effects of input parameters and cutting conditions. Cutting tool made of HSS with 16 mm diameter is employed. The specimens prepared for the face milling process along with dimensions are shown in Fig. 1 (b) and (c) respectively. Surface roughness of the specimens was measured through surface roughness tester, shown in Fig. 2.



(a) (b) (c)

Figure 1. (a) Face milling process of aluminum specimen (b) machined specimens and (c) dimensions of specimen prepared for machining

Figure 2. Surface roughness measuring apparatus

2.1 Experimental design

Taguchi design is a robust technique used for the optimization of input variables and reduces the process variation. The technique uses signal-to-noise (S/N) ratio as quality characteristic measurement [41]. Using S/N ratios, Taguchi empirically found the two stage optimization process indeed offers the optimum level combination while keeping mean on target, minimizing the standard deviation [42]. S/N ratio is beneficial in improvement of measurement and improving quality through variability reduction. Properties of S/N can be classified in three categories:

Smaller the better property; $S/N = -10 \log \frac{1}{n} (\sum Y^2)$ (1)

Nominal the best property; $S/N = 10 \log \frac{Y}{S_y^2}$ (2)

Larger the better property; $S/N = -10 \log \frac{1}{n} (\sum \frac{1}{Y^2})$ (3)

where Y is mean of all the observed values, $S_y{}^2$ is variance of y, y is observed data and n depicts number of observed values. Smaller the better case was employed for Ra and larger the better for MRR. Fr, Vs and Dc have been specified as input variables due to their remarkable impact on machining properties [43-46]. The input variables along with selected levels are shown in Table 3.

Table 3. Face milling input variables with levels

Input Variables	**Levels**		
	Low	**Medium**	**High**

Feed rate (mm/min)	500	1000	2000
Spindle speed (rpm)	1000	2000	4000
Depth of cut (mm)	0.25	0.5	1

Nine experiments were performed using Taguchi method L_93^4 array for each cutting condition. Experiments were performed at each level of the input variables to measure the response variables included Ra and MRR. Three different readings of the machined surface have been taken for each specimen and their mean value is considered as final reading. Mean and standard deviation of the measured values against each experimental run have been presented in Table 4. MRR is calculated using relation 4 [47].

$$MRR = \frac{(W_1 - W_2)}{t \times \rho} \tag{4}$$

Here W_1 is initial weight of a specimen before machining, W_2 is final weight after machining, ρ is density of workpiece material and t is machining time.

Table 4. Design matrix with observed responses

Exp. Run	Input variables			Response variables								
				Surface roughness (µm)						Material Removal Rate (mm³/sec)		
	Feed rate (mm/min)	Spindle speed (rpm)	Depth of cut (mm)	Dry		MQL		Nanofluid		Dry	MQL	Nanofluid
				Mean	Std. dev	Mean	Std. dev	Mean	Std. dev			
1.	500	1000	0.25	1.105	0.0042	0.785	0.0089	0.683	0.00025	30.906	29.606	30.556
2.	500	2000	0.5	0.940	0.00098	0.677	0.00064	0.582	0.00051	75.811	76.931	75.901
3.	500	4000	1	0.658	0.00027	0.480	0.00091	0.403	0.00029	148.620	149.342	148.892
4.	1000	1000	0.5	1.713	0.0016	1.216	0.00022	1.046	0.0054	149.622	147.622	151.523
5.	1000	2000	1	1.542	0.0075	1.141	0.0021	1.016	0.00069	289.774	287.224	290.534
6.	1000	4000	0.25	0.694	0.00051	0.486	0.00062	0.423	0.00024	69.811	69.781	67.764
7.	2000	1000	1	3.381	0.0232	2.468	0.071	2.172	0.039	506.489	508.490	506.015
8.	2000	2000	0.25	2.339	0.0099	1.684	0.0064	1.465	0.0087	163.552	161.622	163.642
9.	2000	4000	0.5	1.520	0.0056	1.064	0.0051	0.936	0.00061	269.244	271.894	269.723

3 Results and discussion

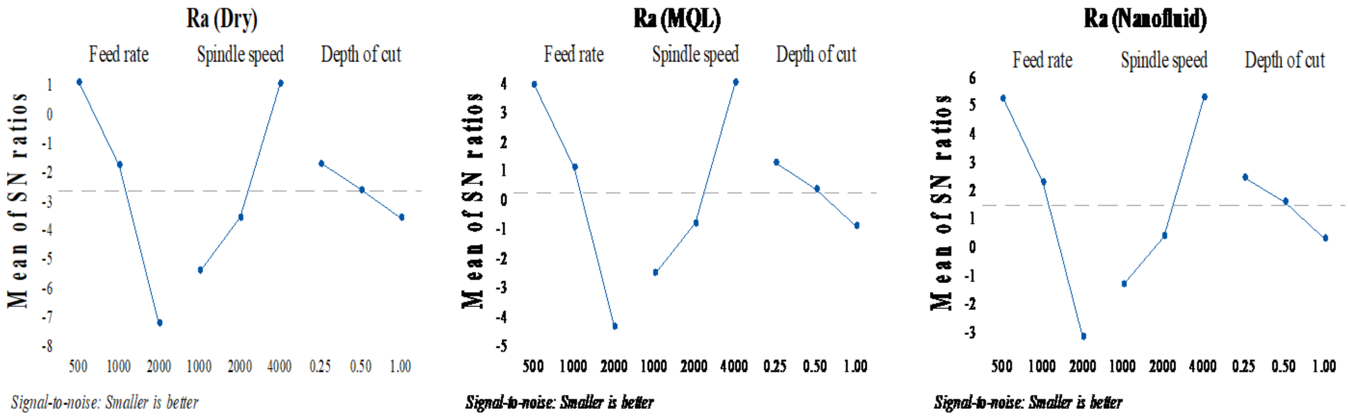
3.1 Graphical representation using Signal to Noise Ratio Approach

Taguchi's S/N ratio represents the response or quality characteristics and largest S/N ratio value is desirable. S/N ratio was used for selecting the best combination of input variables to achieve optimum response. Average values of signal to noise ratio for Ra of different variables at their levels are shown in Table 5 and represented in graphical form in Figure 3. The peak values of S/N ratio of control variables were selected representing the optimum conditions for the Ra. S/N ratio is also used to rank the input parameters on the basis of their contribution in Ra. Fr is the highest contributing factor followed by the Vs and Dc. At higher values of Fr and Dc and lower values of Vs, deformed chip cross section and volume and sharp and brittle fractures occur on the machining surface which increases the surface roughness [48, 49]. In dry condition, Ra is found to be minimum at low level of Fr and Dc and high level of Vs. Similar trends are observed for MQL and nanofluid cutting conditions as shown in Figure 3(b) and (c) respectively.

Table 5. Average values of S/N ratios of Ra at different levels

Level	Dry			MQL			Nanofluid		
	Fr	Vs	Dc	Fr	Vs	Dc	Fr	Vs	Dc

1.	1.103	-5.376	-1.722	3.9573	-2.4815	1.2833	5.3020	-1.2715	2.4930
2.	-1.785	-3.533	-2.591	1.1411	-0.7594	0.3842	2.3184	0.4179	1.6276
3.	-7.199	1.028	-3.568	-4.3043	4.0349	-0.8735	-3.1609	5.3131	0.3388
Delta	8.303	6.404	1.846	8.2616	6.5164	2.1568	8.4629	6.5846	2.1541
Rank	1	2	3	1	2	3	1	2	3



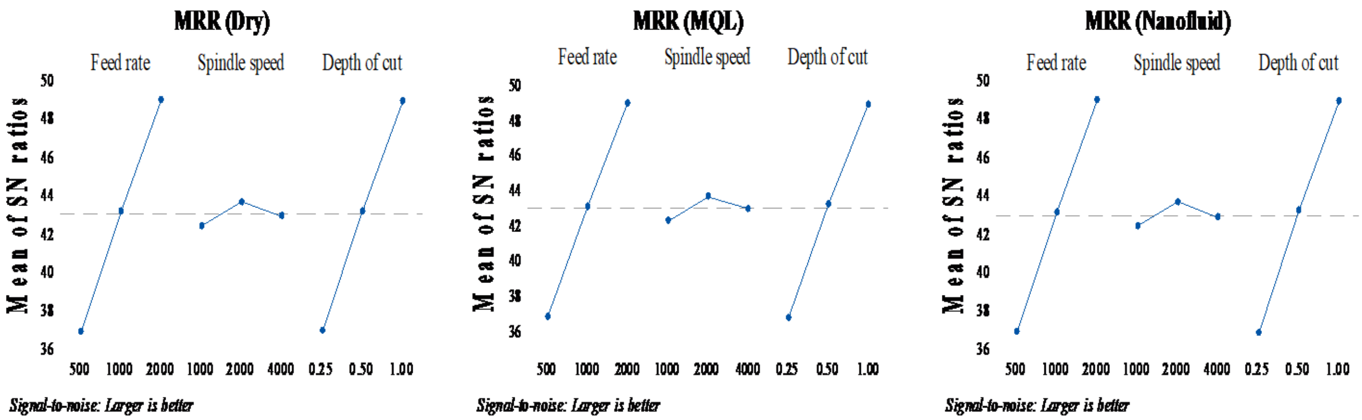
(a) (b) (c)

Figure 3. S/N ratio graph showing the effects of Fr, Vs and Dc on Ra for (a) Dry (b) MQL (c) Nanofluid

Average values of signal to noise ratio for MRR are given in Table 6 and graph for the S/N ratio are presented in Figure 4. Ranking of input parameters on the basis of their S/N ratio shows that Fr is the most contributing input parameter for MRR. While Dc and Vs are the second and third most contributing input parameters respectively and same can be seen in Fig. 4. MRR is maximum at high level of Fr and Dc and mid-level of Vs.

Table 6. Average values of S/N ratio of MRR at different levels

Level	DRY			MQL			Nanofluid		
	Fr	Vs	Dc	Fr	Vs	Dc	Fr	Vs	Dc
1	36.95	42.46	36.98	36.88	42.31	36.82	36.92	42.46	36.87
2	43.21	43.70	43.23	43.14	43.69	43.26	43.16	43.72	43.28
3	48.99	42.97	48.92	48.99	43.01	48.92	48.99	42.90	48.93
Delta	12.04	1.24	11.94	12.12	1.37	12.10	12.07	1.25	12.07
Rank	1	3	2	1	3	2	1	3	2



(a) (b) (c)

Figure 4. S/N ratio graph showing the effects of Fr, Vs and Dc on MRR for (a) Dry (b) MQL (c) Nanofluid

3.2 Analysis of results through Analysis of variance

For the modelling of response variables, regression analysis is performed using statistical software Minitab. Analysis of variance (ANOVA) is employed to test the adequacy of the developed models.

3.2.1 ANOVA for Ra

ANOVA results declared that the effects of input variables: Fr, Vs and Dc associated with Ra were significant for dry conditions. Same input variables were obtained significant for MQL and Nanofluid cutting. ANOVA results along with adequacy measures R^2, adjusted R^2 and predicted R^2 values are provided in Table 4. The results demonstrate that the regression models are significant having p-value less than 0.05. Adequacy measures R^2, R^2 (adjusted) and R^2 (predicted) values for dry, MQL and nanofluid conditions are close to one, indicating the adequacy of models. For the prediction of Ra, empirical models for dry, MQL, nanofluid conditions are presented in equation 5, 6 and 7 respectively.

$$Ra\ (Dry) = 0.801 + 0.001021\times Fr - 0.000363\times Vs + 0.684\times Dc \quad (5)$$

$$Ra\ (MQL) = 0.561 + 0.000737\times Fr - 0.000267\times Vs + 0.540 \times Dc \quad (6)$$

$$Ra\ (Nanofluid) = 0.472 + 0.000653\times Fr - 0.000313\times Vs + 0.486\times Dc \quad (7)$$

Percentage contribution of each factor in Ra for all cutting conditions extracted from the ANOVA tables has been presented as pie charts in Figure 5 (a). Fr is the most contributing factor for Ra with percentage contribution of 60%. Percentage contribution of Vs and Dc are 30% and 7% respectively.

3.2.2 ANOVA for MRR

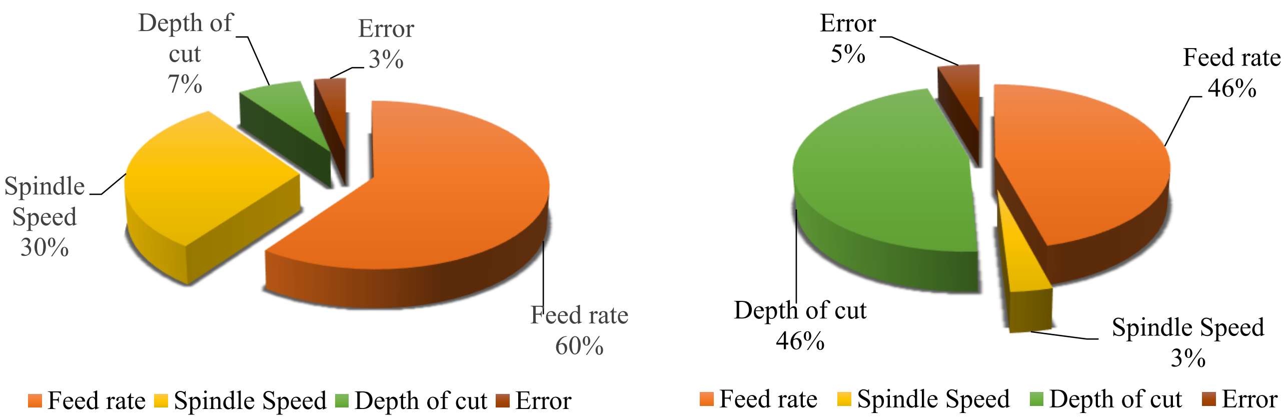
The input parameters that significantly influence in MRR include Fr and Dc. Models developed for MRR are significant with p-value less than 0.05 as shown in Table 6. Adequacy measures R^2, R^2(adjusted) and R^2(predicted) are close to one, showing the adequacy of the models. For the prediction of MRR, empirical models for dry, MQL and nanofluid are developed and presented in equation 8, 9 and 10 respectively.

$$MRR\ (Dry) = -116.2 + 0.1508\times Fr - 0.0200\times Vs + 302.2\times Dc \quad (8)$$

$$MRR\ (MQL) = -119.3 + 0.1515\times Fr - 0.0194\times Vs + 303.3\times Dc \quad (9)$$

$$MRR\ (Nanofluid) = -116.0 + 0.1507\times Fr - 0.0203\times Vs + 303.1\times Dc \quad (10)$$

Pie chart in Figure 5 (b) showing the percentage contribution of different input variables for MRR has been obtained from the ANOVA table. Fr and Dc are the major contributing factors with percentage contribution of 46% each. Vs has very small contribution in achieving maximum MRR.



(a) (b)

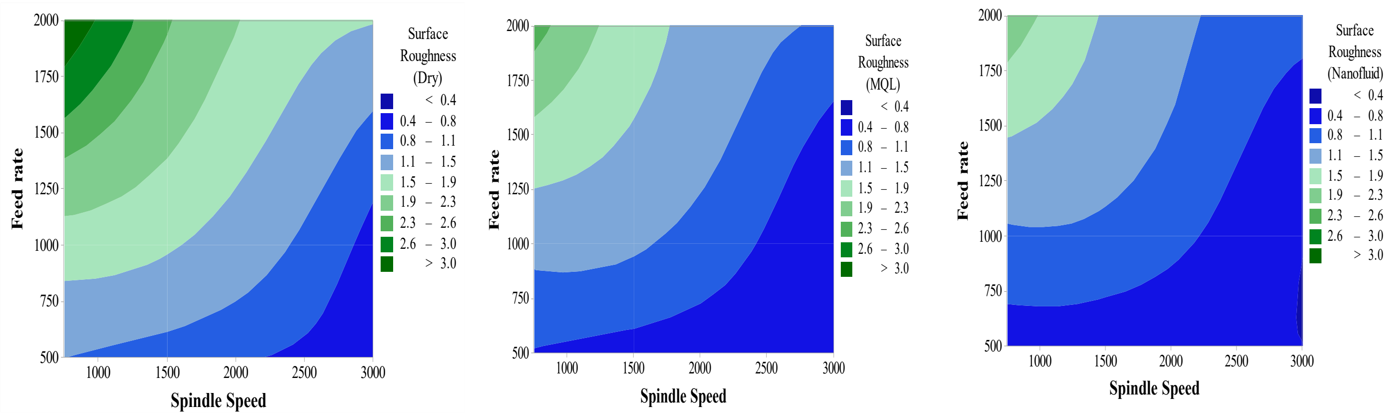
Figure 5. Pie chart of percentage contributions for (a) Ra and (b) MRR

3.3 Optimization using contour plots

Contour plots normally used for the optimization and prediction of the response variables. Optimization of milling process can be considered as multivariate and multi-criteria problems in which objective is to maximize or minimize the single variable. Here the effects of input variables on Ra and MRR has been analyzed using contour plots. It is apt that the graphs represent the effects of two input variables at the middle level of all the other variables.

3.3.1 Contour plots for Ra

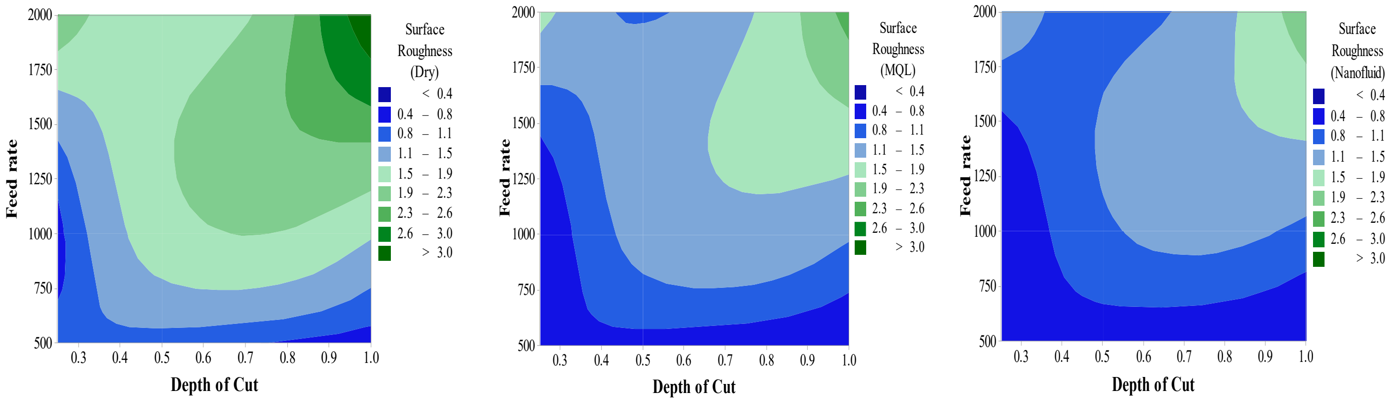
Figure 6(a-c) represent the effects of Fr and Vs on Ra for dry, MQL and nanofluid respectively. By comparing the Ra of dry, MQL and nanofluid cutting conditioned parts, it is evident that the effect of Fr and Vs on Ra are similar. Ra is more sensitive to Fr as compared to Vs. Moreover, Ra decreases with increasing Vs and decreasing Fr. It is virtuous to state that minimum Ra is achieved in nanofluid cutting condition as compared to dry and MQL.



(a) (b) (c)

Figure 6. Contour plots of Ra vs Fr and Vs (a) Dry (b) MQL (c) nanofluid

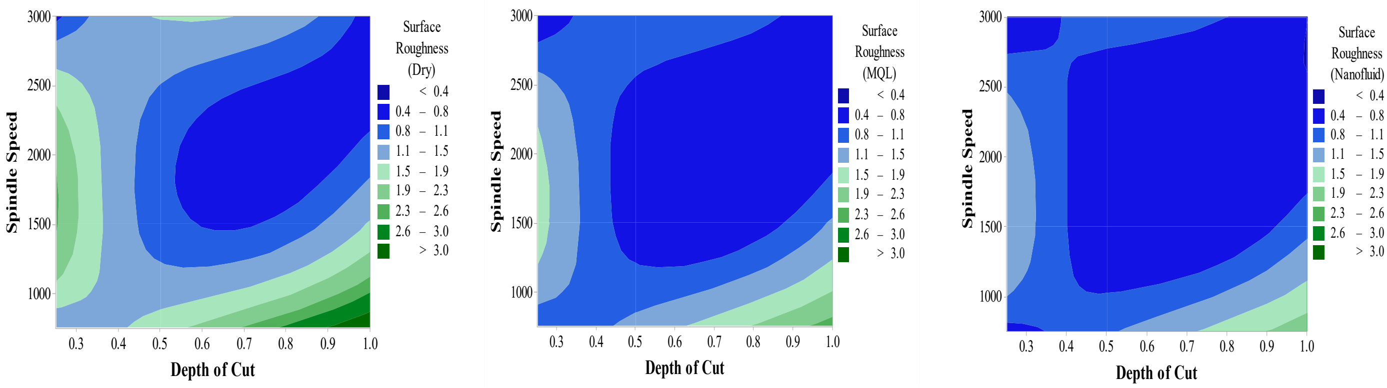
The effects of input variables; Fr and Dc for all cutting conditions are shown in figure 7 (a) to 7 (c). The contour plot demonstrates that Ra is affected by Fr significantly, and it is less altered by Dc and same trend has been observed in all cutting conditions. Among three different types of cutting conditions nanofluid machining yields better results.



(a) (b) (c)

Figure 7. Contour plots for Ra vs Dc and Fr (a) Dry (b) MQL (c) nanofluid

While distinguishing the influence of Vs and Dc on Ra under dry, MQL and nanofluid cutting conditions, identical trends has been observed (Figure 8a to 8c). Ra decreases with increasing Vs and decreasing Dc. Among different cutting conditions, nanofluid produce the improved surface quality.



(a) (b) (c)

Figure 8. Contour plots of Ra vs Dc and Vs (a) Dry (b) MQL (c) nanofluid

Table 6. Analysis of variance for Ra and MRR

Surface Roughness (Dry)

Source	DF	Adj SS	Adj MS	F-Value	P-Value	
Regression	3	5.904	1.968	50.12	<0.0001	Significant
Fr	1	3.648	3.648	92.90	<0.0001	
Vs	1	1.847	1.847	47.05	0.001	
Dc	1	0.409	0.409	10.42	0.023	
Error	5	0.196	0.039			
Total	8	6.101				
Model Summary						
R^2	96.78%	R^2 (adj)	94.85%	R^2 (Pred)	85.73%	

Material Removal Rate (Dry)

Source	DF	Adj SS	Adj MS	F-Value	P-Value	
Regression	3	165017	55006	33.48	0.001	Significant
Fr	1	79545	79545	48.41	0.001	
Vs	1	5584	5584	3.40	0.125	
Dc	1	79888	79888	48.62	0.001	
Error	5	8216	1643			
Total	8	173233				
Model Summary						
R^2	95.26%	R^2(adj)	92.41%	R^2(pred)	78.32%	

Surface Roughness (MQL)

Source	DF	Adj SS	Adj MS	F-Value	P-Value	
Regression	3	3.155	1.051	46.76	<0.0001	Significant
Fr	1	1.899	1.899	84.46	<0.0001	
Vs	1	1.001	1.001	44.49	0.001	
Dc	1	0.255	0.255	11.35	0.020	
Error	5	0.112	0.022			
Total	8	3.267				
Model Summary						
R^2	96.56%	R^2 (adj)	94.49%	R^2 (Pred)	84.84%	

Material Removal Rate (MQL)

Source	DF	Adj SS	Adj MS	F-Value	P-Value	
Regression	3	166115	55372	31.82	0.001	Significant
Fr	1	80352	80352	46.18	0.001	
Vs	1	5255	5255	3.02	0.143	
Dc	1	80508	80508	46.27	0.001	
Error	5	8699	1740			
Total	8	174815				
Model Summary						
R^2	95.02%	R^2(adj)	92.04%	R^2(pred)	77.29%	

Surface Roughness (Nanofluid)

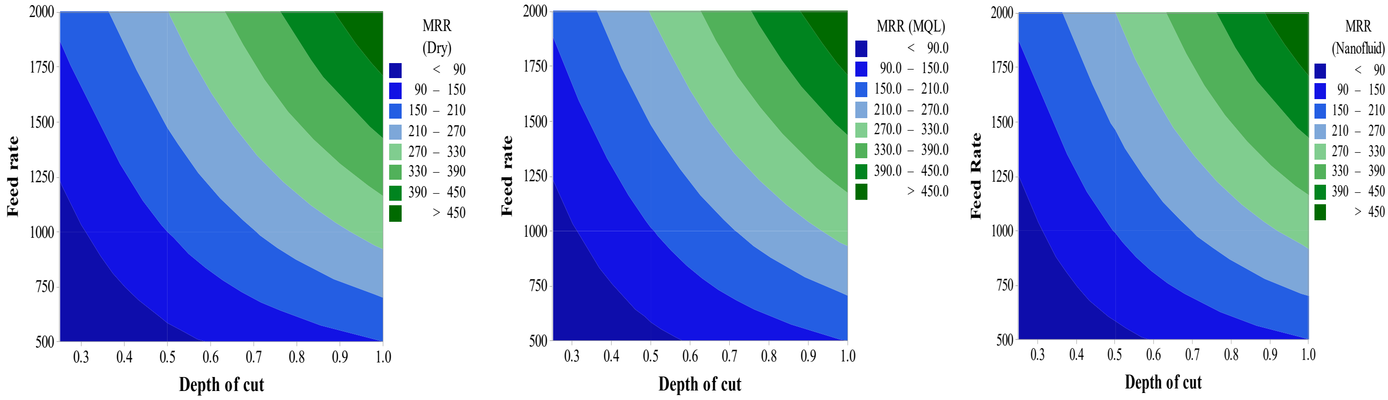
Source	DF	Adj SS	Adj MS	F-Value	P-Value	
Regression	3	2.469	0.823	49.67	<0.0001	Significant
Fr	1	1.491	1.491	90.02	<0.0001	
Vs	1	0.770	0.770	46.50	0.001	
Dc	1	0.207	0.207	12.49	0.017	
Error	5	0.082	0.016			
Total	8	2.552				
Model Summary						
R^2	96.75%	R^2 (adj)	94.81%	R^2 (Pred)	85.76%	

Material Removal Rate (Nanofluid)

Source	DF	Adj SS	Adj MS	F-Value	P-Value	
Regression	3	165647	55216	34.83	0.001	Significant
Fr	1	79536	79536	50.17	0.001	
Vs	1	5742	5742	3.62	0.115	
Dc	1	80369	80369	50.70	0.001	
Error	5	7926	1585			
Total	8	173573				
Model Summary						
R^2	95.43%	R^2 (Adj)	92.69%	R^2 (Pred)	79.14%	

3.3.2 Contour plots for MRR

Based on the previous discussions, Fr and Dc are significant factors for MRR. Therefore, it is no need to consider the Vs in MRR optimization. From Figure 9 (a) to 9 (c), it is cleared that MRR is maximum at high level of Fr and Dc. And different cutting conditions has no effect on MRR.



(a) (b) (c)

Figure 9. Contour plots of MRR vs Dc and Fr (a) Dry (b) MQL (c) nanofluid

3.4 Comparison of cutting conditions (Dry, MQL and Nanofluid)

It is observed that MQL is better than dry cutting and Nanofluid lubrication is better than MQL cutting for Ra. Observed responses of dry, MQL and nanofluid conditions are compared in Figure 10. The figure has been drawn from the design matrix given in Table 3. From the figure it is evident that when move from dry to MQL cutting the percentage improvement range from 26%~30% and further shifted from MQL to nanofluid the percentage improvement 13%~16% for Ra. In MQL, lubricant penetrates in the machining zone between tool and workpiece with air pressure in a very effective way which reduces the surface roughness [50]. Moreover, in nanofluid the particles present in the lubricant possess filling and polishing effect and rolled at tool-workpiece interface which reduces the Ra and frictional co-efficient [51, 52]. From Figure 11 it is clear that no improvement has been noticed in MRR in all cutting conditions and negligible variation observed, can be due to the error.

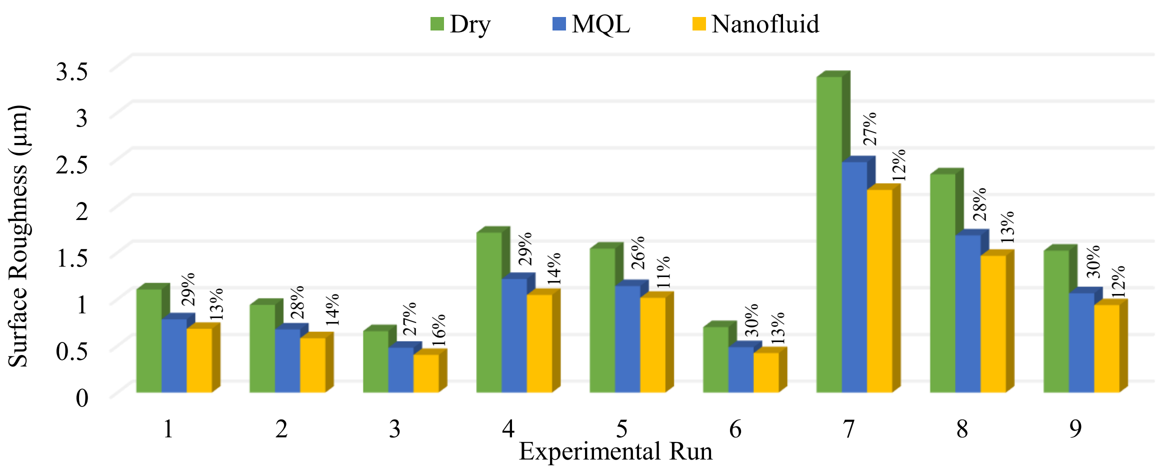


Figure 10. Percentage improvement results of Ra

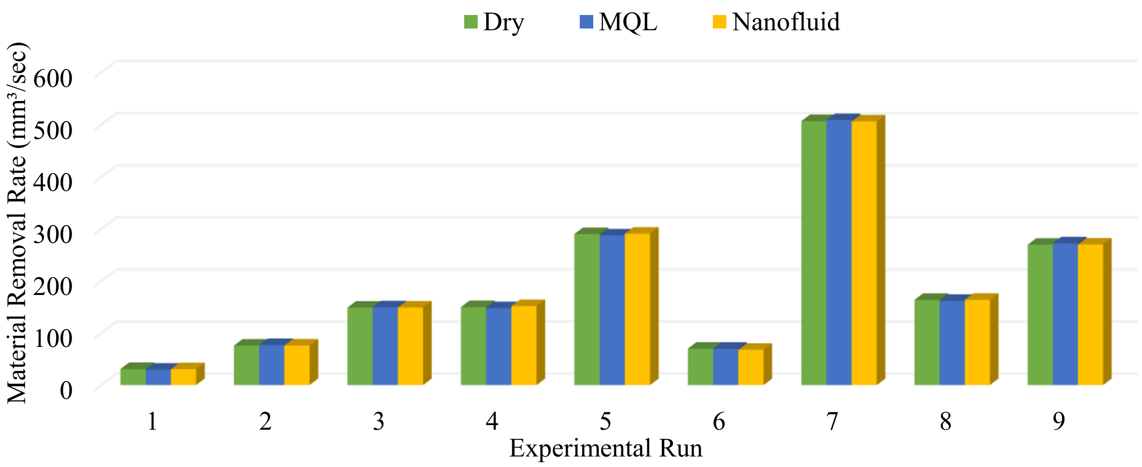


Figure 11. Percentage improvement results of MRR

4 Conclusion

The focus of this research is to analyze the effects of dry, MQL and nanofluid cutting conditions in face milling process for Al-6082 alloy. The effects of Fr, Vs and Dc on Ra and MRR analyzed for dry, MQL and nanofluid cutting conditions using Taguchi method.

- The experimental results reveal that for Ra: 1) Fr is most significant input variables with percentage contribution of 60%; 2) Vs is significant with percentage contribution of 30%; and 3) Dc is less significant as compared to feed rate and Vs with percentage contribution of 7% for dry, MQL and nanofluid cutting conditions.
- For material removal rate, Fr and Dc are significant factors with percentage contribution of 46% each for all cutting conditions while Vs is not as significant as Fr and Dc.
- Comparative analysis for Ra shows that the 26%~30% improvement will be achieved when shifted from dry to MQL and 13%~16% improvement will be obtained when further move to nanofluid cutting condition.
- Negligible effect of cutting conditions (dry, MQL and nanofluid) is observed for material removal rate.
- Other machining conditions including machine tool fixture environment are kept constant for all experiments to avoid their influence on surface roughness.

This research verified that the proposed nanofluid cutting condition for face milling process could be used by the practitioners to improve the quality of machined parts. Furthermore, the contour plots and developed empirical models for Ra and MRR will aid practitioners to select the optimum level of input variables for the desired Ra and MRR.

As aluminum is a softer material therefore, it is necessary to use some soft nanoparticles in lubricant to keep surface roughness at its minimum level. Therefore, future study can be conducted on the comparative analysis of the performance of metallic and non-metallic or some soft nano particles in the lubricant. If non-metallic nanoparticles yield low surface roughness, then further studies will be conducted to optimize the particle's size and concentration with respect to workpiece materials. The lowest surface roughness achieved in case of soft nanoparticles will eliminate the post processing of workpiece material. Elimination of single process on industrial scale may reduce the consumption of resources. Moreover, the combination of such nanoparticles and some environmental friendly lubricants can be used to make the process healthy on industrial scale.

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