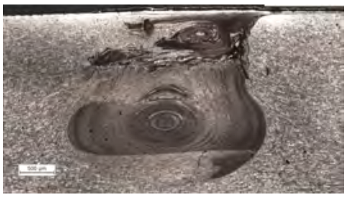
Appendix

Table A.1: FSP parameters

No.	Rotational speed in rpm	Travel speed in mm/min	Feed rate in rev/min
C1	20	1600	0.0125
C2	20	1800	0.011
C3	20	2000	0.01
C4	40	1600	0.025
C5	40	1800	0.022
C6	40	2000	0.02
C7	60	1600	0.375
C8	60	1800	0.033
C9	60	2000	0.03
T1	20	1600	0.0125
T2	20	1800	0.011
T3	20	2000	0.01
T4	40	1600	0.025
T5	40	1800	0.022
T6	40	2000	0.02
T7	60	1600	0.375
T8	60	1800	0.033
T9	60	2000	0.03
S1	20	1600	0.0125
S2	20	1800	0.011
S3	20	2000	0.01
S4	40	1600	0.025
S5	40	1800	0.022
S6	40	2000	0.02
S7	60	1600	0.375
S8	60	1800	0.033
S9	60	2000	0.03
F1	20	1600	0.0125
F2	20	1800	0.011
F3	20	2000	0.01
F4	40	1600	0.025
F5	40	1800	0.022
F6	40	2000	0.02
F7	60	1600	0.375
F8	60	1800	0.033
F9	60	2000	0.03

(a) C1

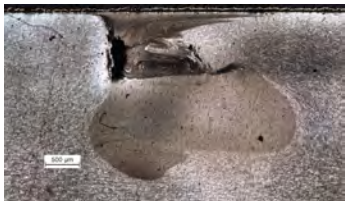


(b) C1-2

(c) C2

(d) C2-2

(e) C3



(f) C3-2

(g) C4

(h) C4-2

(i) C5

(j) C5-2

(k) C6

(l) C6-2

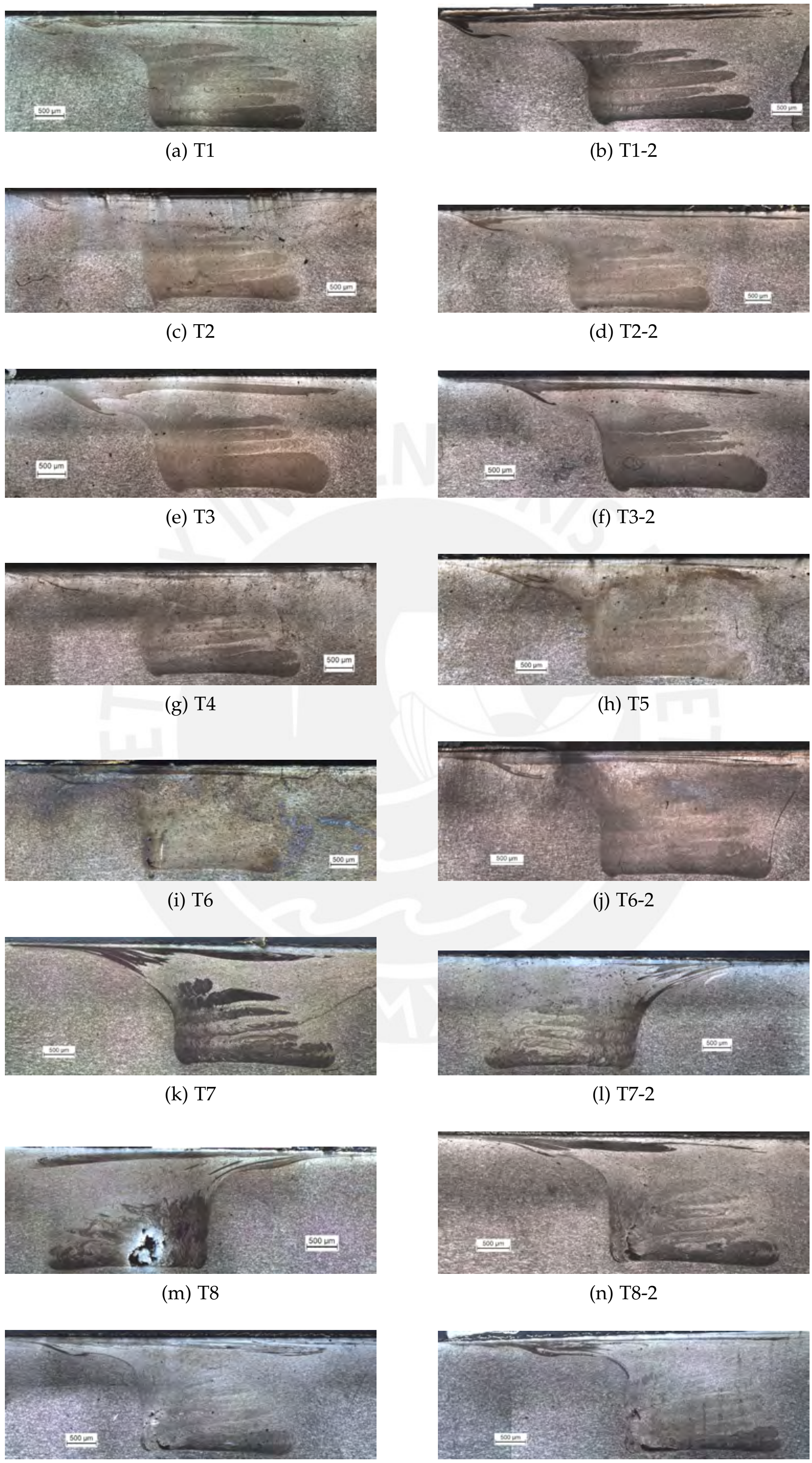
(m) C6

(n) C6-2

(o) C9

(p) C9-2

Figure A.1: Cross sections of samples produced by the cylindrical profile



(a) T1 (b) T1-2
(c) T2 (d) T2-2
(e) T3 (f) T3-2
(g) T4 (h) T5
(i) T6 (j) T6-2
(k) T7 (l) T7-2
(m) T8 (n) T8-2
(o) T9 (p) T9-2

Figure A.2: Cross sections of samples produced by the triangular profile


(a) S1


(b) S1-2


(c) S2


(d) S2-2

(e) S3


(f) S3-2


(g) S4


(h) S4-2


(i) S5

(j) S5-2


(k) S6


(l) S6-2

(m) S7


(n) S7-2


(o) S8


(p) S9

Figure A.3: Cross sections of samples produced by the square profile

(a) F1

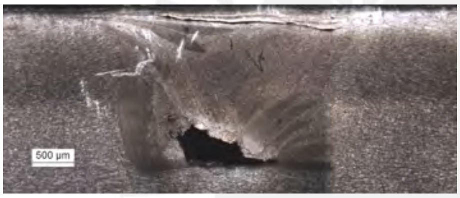
(b) F2-2

(c) F3

(d) F3-2

(e) F4

(f) F4-2

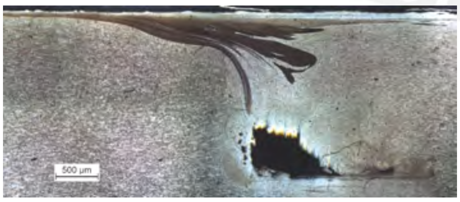


(g) F5

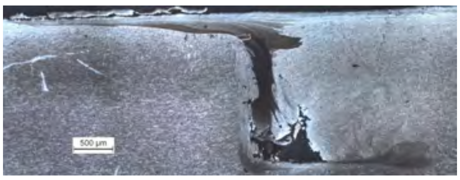
(h) F6

(i) F6-2

(j) F7



(k) F7-2



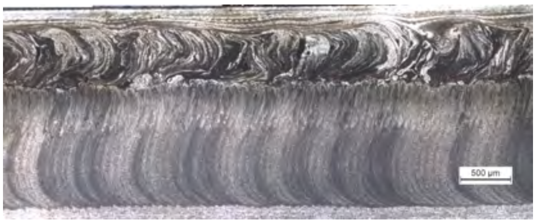
(l) F8

(m) F8-2

(n) F9

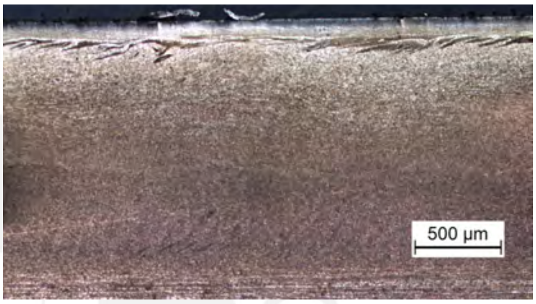
Figure A.4: Cross sections of samples produced by the fluted profile

(a) C1



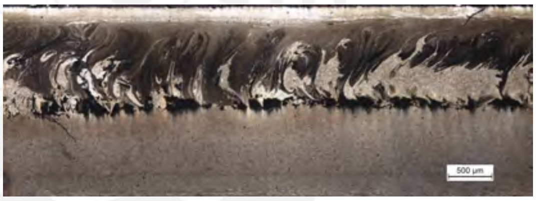
(b) C2

(c) C3

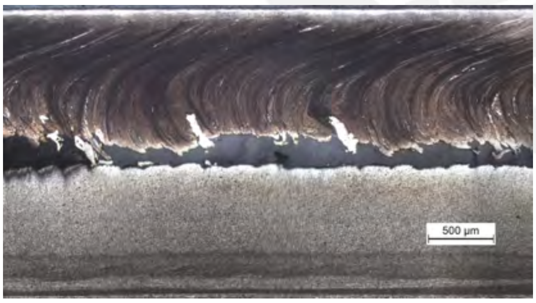


(d) C4

(e) C5



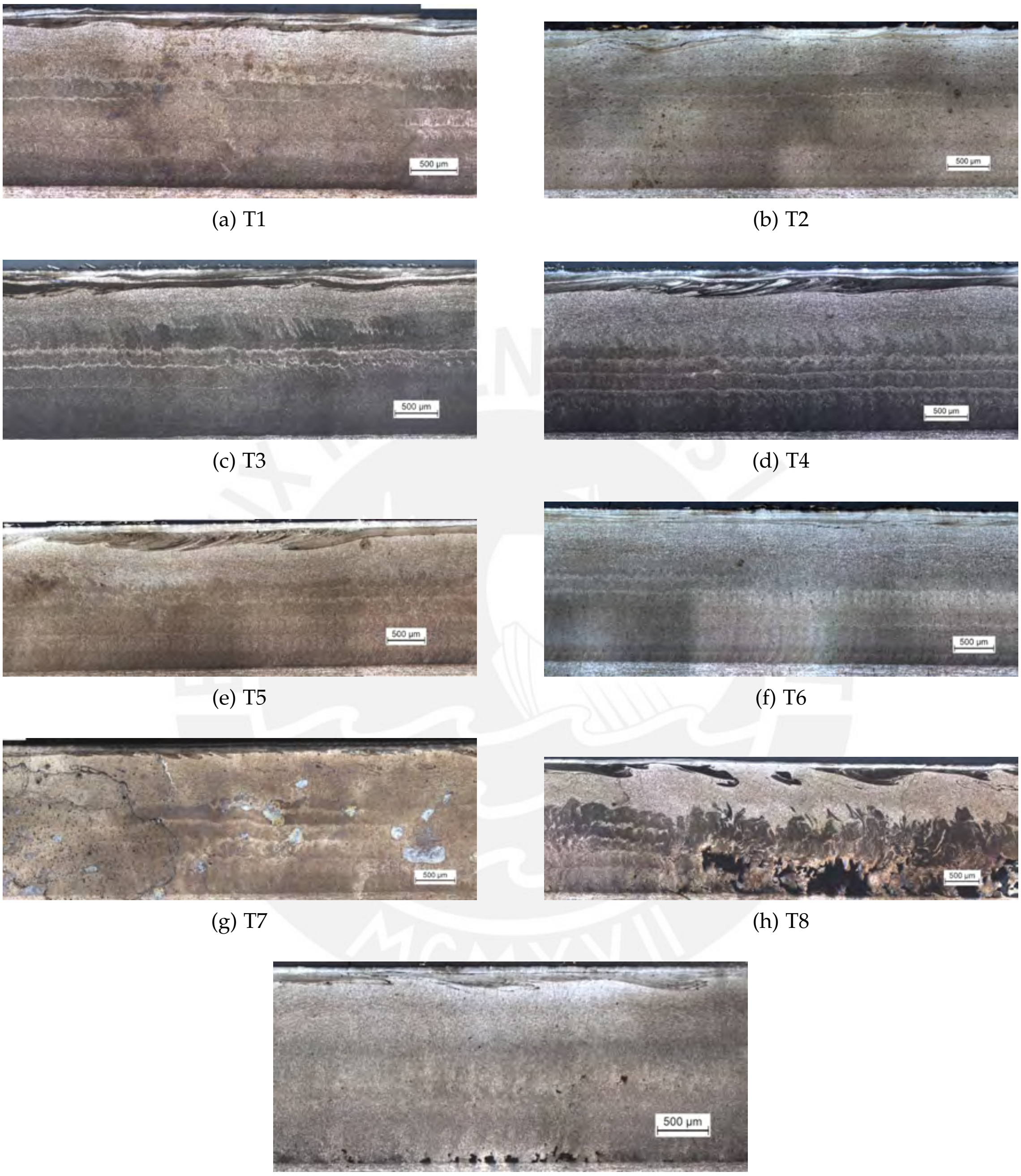
(f) C6



(g) C8

(h) C9

Figure A.5: Longitudinal sections of samples produced by the cylindrical profile



(a) T1 (b) T2

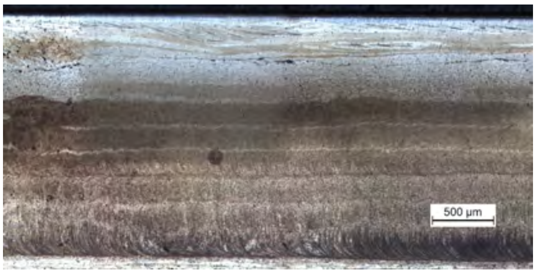
(c) T3 (d) T4

(e) T5 (f) T6

(g) T7 (h) T8

(i) T9

Figure A.6: Longitudinal sections of samples produced by the triangular profile



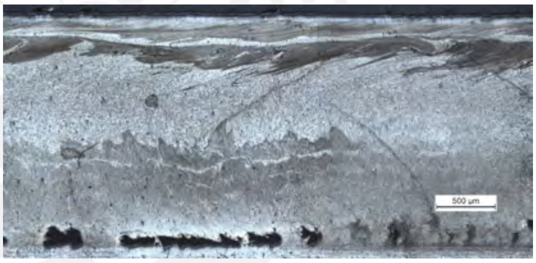
(a) S1

(b) S2

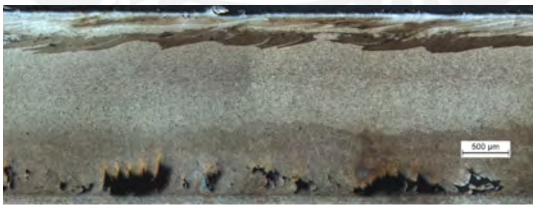
(c) S3

(d) S4

(e) S5

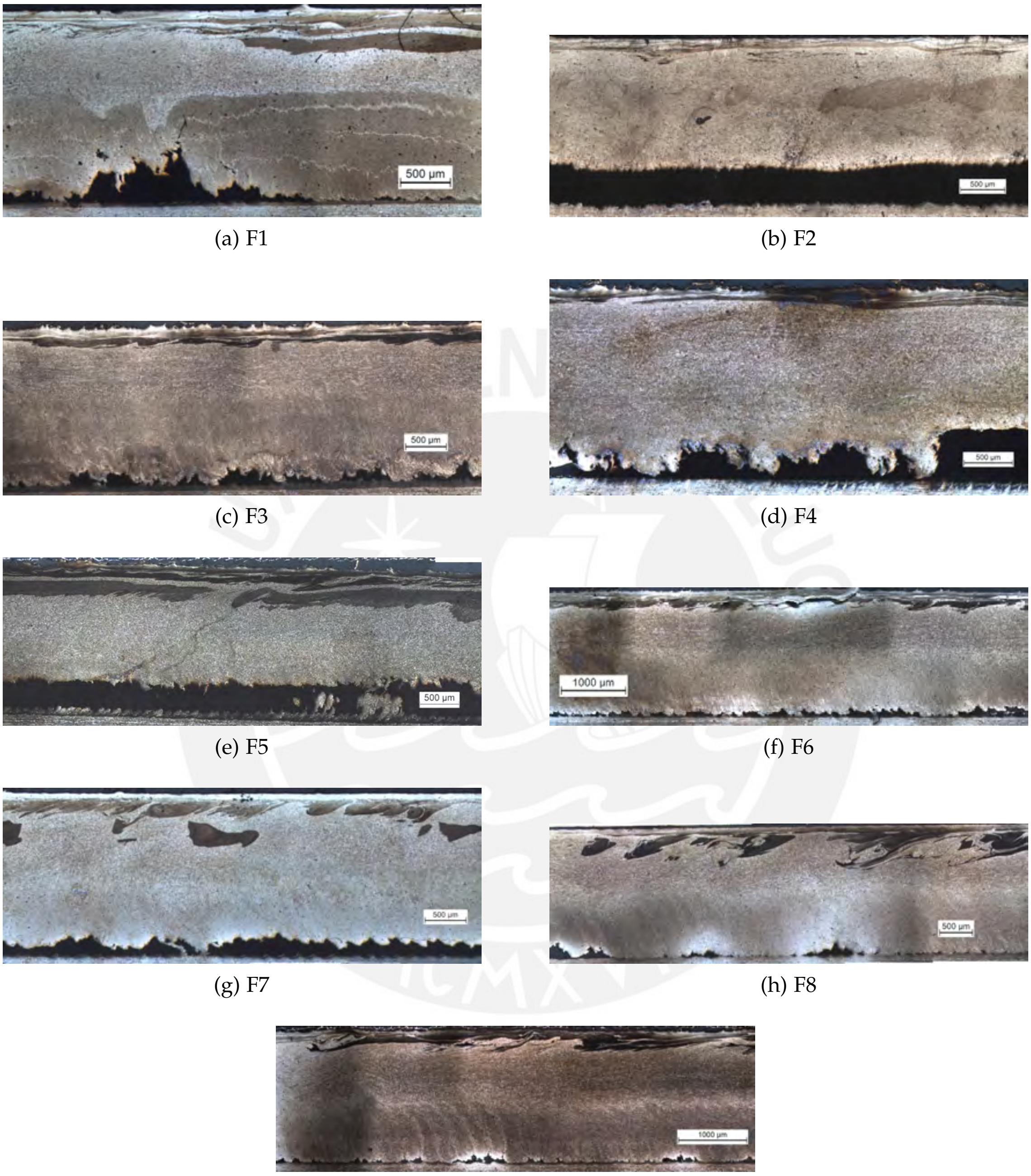


(f) S6



(g) S7

Figure A.7: Longitudinal sections of samples produced by the square profile



(a) F1 (b) F2

(c) F3 (d) F4

(e) F5 (f) F6

(g) F7 (h) F8

(i) F9

Figure A.8: Longitudinal sections of samples produced by the fluted profile

List of Tables

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