**Taguchi L32 Array for surface grinding**

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| --- | --- | --- | --- | --- | --- |
| **Experiment No.** | **Grinding**  **wheel speed**  **(rpm)** | **Table travel speed (m/min)** | **Depth**  **of cut**  **(µm)** | **Material and grade of**  **grinding wheel** | **Table cross feed**  **(m/min)** |
| 1 | 1 | 1 | 1 | 1 | 1 |
| 2 | 1 | 1 | 2 | 2 | 2 |
| 3 | 1 | 1 | 3 | 3 | 3 |
| 4 | 1 | 1 | 4 | 4 | 4 |
| 5 | 1 | 2 | 1 | 1 | 2 |
| 6 | 1 | 2 | 2 | 2 | 1 |
| 7 | 1 | 2 | 3 | 3 | 4 |
| 8 | 1 | 2 | 4 | 4 | 3 |
| 9 | 1 | 3 | 1 | 2 | 3 |
| 10 | 1 | 3 | 2 | 1 | 4 |
| 11 | 1 | 3 | 3 | 4 | 1 |
| 12 | 1 | 3 | 4 | 3 | 2 |
| 13 | 1 | 4 | 1 | 2 | 4 |
| 14 | 1 | 4 | 2 | 1 | 3 |
| 15 | 1 | 4 | 3 | 4 | 2 |
| 16 | 1 | 4 | 4 | 3 | 1 |
| 17 | 2 | 1 | 1 | 4 | 1 |
| 18 | 2 | 1 | 2 | 3 | 2 |
| 19 | 2 | 1 | 3 | 2 | 3 |
| 20 | 2 | 1 | 4 | 1 | 4 |
| 21 | 2 | 2 | 1 | 4 | 2 |
| 22 | 2 | 2 | 2 | 3 | 1 |
| 23 | 2 | 2 | 3 | 2 | 4 |
| 24 | 2 | 2 | 4 | 1 | 3 |
| 25 | 2 | 3 | 1 | 3 | 3 |
| 26 | 2 | 3 | 2 | 4 | 4 |
| 27 | 2 | 3 | 3 | 1 | 1 |
| 28 | 2 | 3 | 4 | 2 | 2 |
| 29 | 2 | 4 | 1 | 3 | 4 |
| 30 | 2 | 4 | 2 | 4 | 3 |
| 31 | 2 | 4 | 3 | 1 | 2 |
| 32 | 2 | 4 | 4 | 2 | 1 |