

Tab. 1: Independent variables (the conditions of experiments), concrete values in the first part and normalized values in the second part of table

run	$T$ [°C]	$t$ [hours]	$C$ [wt.%]	$MR$ [-]	$f$ [rpm]	$T$ [-]	$t$ [-]	$C$ [-]	$MR$ [-]	$f$ [-]
1	60	2	1.33	6:1	20000	+1	+1	+1	-1	+1
2	25	2	1.33	7.5:1	10000	-1	+1	+1	+1	-1
3	25	1.5	1.33	7.5:1	20000	-1	-1	+1	+1	+1
4	60	1.5	0.89	7.5:1	20000	+1	-1	-1	+1	+1
5	25	2	0.89	6:1	20000	-1	+1	-1	-1	+1
6	60	1.5	1.33	6:1	10000	+1	-1	+1	-1	-1
7	60	2	0.89	7.5:1	10000	+1	+1	-1	+1	-1
8	25	1.5	0.89	6:1	10000	-1	-1	-1	-1	-1
9	60	1.75	0.89	6:1	20000	+1	0	-1	-1	+1
10	42.5	2	1.11	6:1	10000	0	+1	0	-1	-1
11	42.5	1.75	1.33	6.75:1	10000	0	0	+1	0	-1
12	25	1.75	1.11	7.5:1	20000	-1	0	0	+1	+1
13	60	1.5	1.11	6.75:1	10000	+1	-1	0	0	-1
14	25	2	0.89	6.75:1	15000	-1	+1	-1	0	0
15	25	1.5	1.33	6:1	15000	-1	-1	+1	-1	0
16	42.5	1.5	0.89	7.5:1	15000	0	-1	-1	+1	0
17	60	2	1.33	7.5:1	20000	+1	+1	+1	+1	+1