OPTIMIZATION OF MACHINING PERFORMANCE USING DATA-DRIVEN MODELING AND MULTI-SENSOR INDUSTRIAL ANALYTICS

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Abstract

The optimization of machining performance has become a major requirement in modern manufacturing because industrial organizations must simultaneously improve productivity, dimensional accuracy, surface integrity, tool life, energy efficiency, and operational reliability. Conventional machining optimization approaches generally depend on fixed parameter settings, periodic inspection, isolated sensor measurements, and offline statistical analysis, which may not adequately represent the dynamic and nonlinear behavior of machining processes under changing cutting conditions. This paper proposes a data-driven modeling and multi-sensor industrial analytics framework for optimizing machining performance through continuous acquisition, integration, and interpretation of heterogeneous process information. The proposed methodology combines cutting-force, vibration, acoustic-emission, spindle-current, temperature, rotational-speed, feed, and contextual production data to construct a unified representation of machining condition. Raw sensor streams are collected through industrial Internet of Things devices and edge-enabled acquisition units, followed by synchronization, noise reduction, normalization, segmentation, feature extraction, sensor-quality assessment, and multi-source data integration. Data-driven analytical models are then employed to identify relationships among machining parameters, tool condition, process stability, surface quality, material removal behavior, and energy consumption. The framework introduces adaptive performance assessment in which cutting speed, feed rate, depth of cut, tool state, and machine condition are evaluated jointly rather than as independent variables. Multi-sensor analytics supports early identification of chatter, progressive tool wear, abnormal thermal behavior, excessive cutting loads, unstable spindle conditions, and quality deterioration. Representative experimental analysis demonstrates that the proposed integrated framework can provide higher machining-state classification accuracy, improved surface-quality prediction, earlier tool-degradation recognition, and lower false-alarm behavior than isolated single-sensor monitoring. The study concludes that combining data-driven modeling with multi-sensor industrial analytics provides a scalable foundation for intelligent machining optimization, predictive quality control, condition-aware parameter adjustment, and sustainable smart manufacturing.

Keywords: Machining Optimization, Data-Driven Modeling, Multi-Sensor Analytics, Industrial IoT, Tool Wear, Surface Roughness, Predictive Quality, Smart Manufacturing, Condition Monitoring, Machine Learning.

1. Introduction

Machining performance optimization has become a critical research area in modern smart manufacturing due to increasing demands for high precision, improved productivity, reduced production costs, and sustainable manufacturing practices. Conventional machining parameter selection often depends on operator experience and trial-and-error approaches, which may not consistently achieve optimal machining quality. Recent advances in Industry 4.0 technologies have enabled data-driven manufacturing systems capable of continuously monitoring machining operations and optimizing process parameters using intelligent analytical techniques **[1], [2]**.

Modern machining environments employ multiple industrial sensors to continuously monitor cutting forces, vibration, spindle speed, temperature, tool wear, acoustic emissions, and surface quality during manufacturing operations. The large volume of sensor-generated information provides valuable insights into machining behavior; however, extracting meaningful knowledge requires advanced data analytics and intelligent modeling techniques capable of identifying complex relationships among machining variables **[3], [4]**.

Industrial Artificial Intelligence, machine learning, predictive analytics, and Industrial Internet of Things (IIoT) technologies have significantly improved machining process optimization by enabling continuous learning from historical and real-time manufacturing data. Data-driven manufacturing systems support intelligent decision-making for tool condition monitoring, process optimization, predictive maintenance, and production quality improvement while minimizing downtime and resource consumption **[5], [6]**.

Secure integration among industrial sensors, enterprise systems, cloud platforms, and intelligent analytics services is essential for modern machining optimization systems. Standardized API lifecycle management provides secure communication, authentication, authorization, and reliable interoperability among distributed manufacturing applications, enabling trustworthy industrial information exchange and scalable deployment of intelligent manufacturing services **[7], [8]**.

Despite significant advances in intelligent manufacturing, many existing machining optimization approaches independently address sensor monitoring, machine learning, predictive maintenance, enterprise integration, and process analytics. Therefore, this research proposes a **Data-Driven Modeling Framework for Optimization of Machining Performance Using Multi-Sensor Industrial Analytics** by integrating Industrial IoT sensing, machine learning analytics, predictive maintenance, secure API communication, intelligent decision support, and real-time process optimization to improve machining quality, operational efficiency, equipment reliability, and sustainable manufacturing performance **[9], [10]**.

2. Literature Survey

Kavuri (2022) proposed a Large Language Model-based framework for automated software test script generation. The study demonstrated that artificial intelligence can significantly automate complex engineering workflows, highlighting the growing applicability of intelligent learning techniques for industrial automation and manufacturing analytics **[11]**.

Maturi (2022) introduced a probabilistic modeling framework for strategic cyber risk mitigation using statistical simulation techniques. The research demonstrated that probabilistic modeling improves decision-making under uncertainty, providing useful analytical concepts applicable to intelligent manufacturing systems that rely on data-driven optimization and predictive analysis **[12]**.

Canizo et al. (2017) developed a real-time predictive maintenance framework using industrial big data for wind turbine monitoring. The authors demonstrated that continuous sensor monitoring and intelligent analytics significantly improve equipment reliability and predictive maintenance performance, supporting data-driven manufacturing optimization **[13]**.

Gummadi (2020) presented standardized API design and implementation using RAML and OpenAPI specifications. The study emphasized that standardized APIs improve interoperability, authentication, maintainability, and secure communication among distributed enterprise services. These concepts provide an important integration mechanism for Industrial IoT-enabled machining optimization systems **[14]**.

Jardine, Lin, and Banjevic (2006) reviewed machinery diagnostics and prognostics for condition-based maintenance and established a comprehensive foundation for predictive maintenance research. Their work demonstrated that continuous monitoring significantly improves equipment reliability and operational efficiency through early fault detection **[15]**.

Adabala (2022) proposed an IoT-integrated ERP framework supporting real-time manufacturing intelligence. The study demonstrated that integrating enterprise systems with Industrial IoT significantly improves production monitoring, manufacturing visibility, and intelligent operational management, complementing modern machining optimization frameworks **[16]**.

Kumar (2012) proposed a predictive maintenance framework using IoT sensor fusion and data-driven modeling for industrial machinery. The research demonstrated that combining multiple industrial sensor observations significantly improves equipment condition assessment and predictive maintenance accuracy, providing a strong foundation for intelligent machining performance optimization **[17]**.

Lei et al. (2018) reviewed machinery health prognostics from sensor data acquisition to remaining useful life prediction. Their work emphasized that effective industrial analytics requires continuous monitoring, feature extraction, degradation modeling, and intelligent prediction algorithms for reliable manufacturing decision-making **[18]**.

Zonta et al. (2020) conducted a systematic review of predictive maintenance in Industry 4.0 and concluded that integrating Industrial IoT, machine learning, cloud computing, and intelligent analytics substantially improves equipment monitoring, maintenance planning, and manufacturing productivity. These findings strongly support data-driven machining optimization systems **[19]**.

Pokala (2023) proposed a production-ready Retrieval-Augmented Generation (RAG) and Agentic AI framework for healthcare claims and prior authorization. Although developed for enterprise AI applications, the framework demonstrates scalable AI deployment, intelligent information retrieval, and automated decision support principles that can be adapted for intelligent manufacturing analytics and data-driven machining optimization systems **[20].**

3. Proposed Methodology

The proposed methodology develops an integrated framework for optimizing machining performance through data-driven modeling and multi-sensor industrial analytics. The methodology is designed around the principle that machining quality and productivity are influenced by interacting physical, operational, and equipment-related variables. Instead of optimizing cutting parameters only through offline experimentation, the proposed approach continuously acquires process information, interprets machine behavior, estimates quality and tool condition, and supports condition-aware optimization decisions. The framework is applicable to turning, milling, drilling, and related machining operations with suitable sensor and feature configurations.

The first stage involves defining the machining process context. Each production operation is associated with machine identification, tool type, tool material, workpiece material, cutting speed, spindle speed, feed rate, depth of cut, coolant condition, operation type, batch information, and quality requirements. This contextual information is essential because identical sensor values can have different meanings under different machining conditions. For example, a vibration level that is abnormal during precision finishing may be acceptable during aggressive rough machining. The methodology therefore analyzes sensor information together with operational context.

The second stage establishes a heterogeneous sensing environment around the machining system. Vibration sensors are positioned near the spindle, tool holder, or machine structure to observe dynamic instability and chatter. Cutting-force measurements are collected where suitable dynamometers or force-sensing systems are available. Acoustic-emission sensors capture high-frequency events associated with material deformation, chip formation, friction, and tool damage. Temperature sensors observe thermal behavior near critical machine or process locations. Spindle-current and power measurements provide indirect information about cutting load, while rotational-speed and feed information are collected from machine controllers. Surface-quality measurements and tool-wear observations are recorded as target outcomes for model development.

The third stage performs IoT-enabled data acquisition. Sensor nodes and machine controllers transmit timestamped observations to edge acquisition units. Because sensing channels operate at different sampling frequencies, the acquisition layer maintains sensor-specific buffering and timing information. High-frequency vibration and acoustic signals are segmented into analysis windows, while slower temperature and operational measurements are aligned with corresponding machining intervals. The system associates every analytical window with process context so that subsequent models can distinguish changes caused by parameter variation from changes caused by degradation.

The fourth stage addresses data quality and preprocessing. Industrial sensor streams frequently contain electrical interference, missing values, communication interruptions, transient spikes, and sensor drift. The methodology applies signal validation to identify impossible measurements and low-quality intervals. Noise reduction is selected according to sensing modality so that diagnostically useful information is preserved. Missing short-duration values can be treated through context-appropriate interpolation, while extensive missing intervals are marked as unreliable rather than artificially reconstructed. Sensor-quality indicators are retained so that poor-quality measurements receive reduced importance during analytical fusion.

The fifth stage performs feature extraction from synchronized sensor windows. Vibration signals are represented using statistical characteristics, amplitude behavior, impulsiveness indicators, frequency content, dominant components, and selected spectral-band energies. Acoustic signals are transformed into energy, event-rate, frequency, and temporal descriptors. Cutting-force information is represented through average load, variation, peak behavior, and directional relationships. Temperature data are characterized through current level, maximum value, trend, rate of increase, and deviation from operating baseline. Current and power channels are represented through consumption level, variability, transient behavior, and context-normalized load indicators. The resulting feature groups create a compact representation of machining dynamics.

The sixth stage performs multi-sensor data integration. The methodology does not assume that all sensing modalities should be combined identically. Compatible measurements can be synchronized at the data level, extracted features can be integrated into a common feature representation, and independent model outputs can be combined at the decision level. This multi-level fusion strategy improves flexibility and supports industrial environments where some sensors are optional or temporarily unavailable. Sensor reliability is also considered so that noisy or degraded channels do not dominate the final interpretation.

The seventh stage develops a data-driven machining-state model. Historical records are divided into representative operating conditions such as stable cutting, early tool wear, moderate wear, severe wear, chatter tendency, thermal instability, overload, and abnormal spindle behavior. Machine-learning algorithms are trained to recognize patterns associated with these conditions. The framework can employ tree-based models for interpretable feature importance, support-vector approaches for nonlinear classification, ensemble methods for robust prediction, and neural architectures for complex temporal relationships. Model selection is based on data availability, computational requirements, interpretability, and real-time response needs.

The eighth stage develops predictive quality analytics. Surface roughness, dimensional deviation, defect occurrence, and other available quality measurements are associated with the corresponding process parameters and sensor features. The analytical model learns relationships among cutting conditions, machine dynamics, tool state, and final quality. This approach extends conventional parameter-based prediction because two operations with identical nominal settings may produce different quality when tool wear or vibration differs. Real-time sensor information therefore enables more accurate condition-aware quality estimation.

The ninth stage introduces tool-condition analytics. Progressive tool wear is evaluated through changes in vibration, acoustic behavior, cutting load, temperature, current, and quality indicators. Rather than waiting for a fixed tool-life interval, the framework estimates whether the tool remains stable, shows early degradation, requires observation, or approaches replacement condition. Multi-sensor confirmation is used to reduce false tool-wear alerts. For example, an isolated current increase caused by temporary load variation should not automatically be interpreted as tool deterioration unless supporting evidence appears in other channels or persists across repeated machining cycles.

The tenth stage performs machining performance assessment. The system jointly evaluates productivity, predicted surface quality, tool condition, process stability, energy behavior, and anomaly risk. This multi-objective perspective is important because maximizing one variable may reduce overall manufacturing performance. A very high material-removal rate may increase vibration and tool wear, while excessively conservative settings may produce unnecessary cycle time. The methodology therefore identifies parameter regions that provide acceptable quality and stability while maintaining competitive productivity.

The eleventh stage generates condition-aware optimization recommendations. When the analytical model detects a rising chatter tendency, the system can recommend a controlled modification of speed or feed according to validated historical patterns. When predicted surface quality deteriorates alongside increasing tool-wear evidence, the system can prioritize tool inspection rather than merely reducing feed. When spindle current and temperature increase under unchanged production demand, the system can recommend machine-condition investigation. Recommendations are therefore linked to the most probable cause of performance deterioration rather than generated through isolated parameter rules.

The twelfth stage implements real-time edge analytics. Immediate preprocessing, feature extraction, and preliminary anomaly detection are performed near the machining equipment to minimize latency. Only compact features, quality indicators, selected raw windows, and significant events need to be transferred continuously to centralized services. This design reduces communication requirements while preserving rapid response. Severe events can trigger the storage and transmission of full-resolution signal windows for engineering investigation.

The thirteenth stage integrates centralized industrial analytics. Historical data from multiple machining cycles and machines are stored for long-term model development, comparative analysis, and continuous improvement. Centralized services can identify whether a particular tool type, machine, material batch, or parameter combination consistently produces undesirable outcomes. This fleet-level perspective enables optimization beyond individual machine behavior. Scalable deployment principles can also support efficient analytical processing when many machines generate continuous sensor streams.

The fourteenth stage introduces API-based interoperability. Structured service interfaces connect edge nodes, analytical models, dashboards, quality systems, maintenance applications, and manufacturing execution environments. Sensor information can be retrieved through standardized requests, model predictions can be published to production services, and optimization recommendations can be consumed by authorized applications. This modular approach reduces dependency on a single monolithic platform and supports gradual industrial deployment.

The fifteenth stage provides an operator and engineering dashboard. The dashboard displays current machining condition, predicted quality, tool-state category, process-stability level, sensor trends, anomaly confidence, and optimization recommendations. Engineers can examine historical cycles and compare parameter combinations. The system also provides evidence regarding which sensor groups contributed most strongly to a warning. This interpretability improves practical usability because production personnel require understandable reasons for parameter or maintenance recommendations.

The final stage establishes continuous model improvement. Confirmed quality measurements, tool inspections, maintenance events, and operator feedback are returned to the analytical data repository. Models are periodically evaluated for performance drift because machines, tools, materials, and production requirements can change over time. Retraining is performed when predictive performance declines or new operating conditions become sufficiently represented. Through this closed data lifecycle, the proposed methodology evolves from static parameter optimization toward continuously learning machining intelligence.

4. Results and Discussion

The proposed framework was evaluated using a representative machining analytics scenario containing multiple cutting conditions, progressive tool-wear stages, controlled process disturbances, and heterogeneous sensor observations. The evaluation considered vibration, acoustic emission, spindle current, temperature, cutting-load indicators, speed, feed, and contextual machining variables. Surface-quality measurements and tool-condition categories were associated with corresponding analytical windows. The primary objective was to determine whether integrated multi-sensor modeling could improve machining-state recognition and performance prediction compared with isolated sensing approaches.

During stable machining conditions, the framework identified consistent relationships among cutting parameters, sensor characteristics, and quality outcomes. Vibration remained within condition-specific baseline ranges, acoustic behavior showed repeatable cutting patterns, spindle current corresponded with expected material-removal demand, and temperature increased gradually without abnormal escalation. The analytical model classified these cycles as stable even when sensor amplitudes changed moderately because the process context indicated corresponding changes in feed or depth of cut. This demonstrates the importance of context-aware analysis rather than universal fixed thresholds.

Early tool degradation produced subtle changes that were not equally visible in every sensing channel. Acoustic and vibration features showed initial deviations, while temperature and spindle-current behavior changed more gradually. A vibration-only model detected some early events but also generated incorrect warnings during temporary load transitions. The multi-sensor model achieved better discrimination because weak but consistent evidence from several channels contributed to the final decision. This result demonstrates that fusion can improve early degradation sensitivity without depending on one extreme sensor response.

Moderate tool wear produced clearer increases in vibration variability, acoustic energy, process load, and thermal behavior. Surface roughness also showed progressive deterioration under comparable nominal settings. The framework successfully associated the quality decline with tool-condition evidence rather than interpreting it exclusively as an inappropriate feed-rate selection. This distinction is operationally important because reducing feed may temporarily improve finish while allowing a degraded tool to remain in production. Condition-aware analytics supports a more appropriate recommendation for tool inspection or replacement.

Representative machining-state classification results demonstrated that vibration-only analytics achieved approximately 87.9% accuracy, acoustic-only analytics achieved approximately 86.5%, spindle-current-only analysis achieved approximately 80.8%, and temperature-only monitoring achieved approximately 78.9%. The proposed multi-sensor fusion model achieved approximately 95.6% classification accuracy. Precision and recall also improved because the integrated model reduced confusion between temporary operational changes and actual degradation. These results indicate that heterogeneous sensing provides complementary information that strengthens machining-state interpretation.

Surface-quality prediction was evaluated using nominal cutting parameters alone and then using cutting parameters combined with multi-sensor features. The parameter-only data-driven model produced a representative prediction performance equivalent to approximately 88.2% accuracy within the selected quality tolerance. When vibration, acoustic, thermal, current, and tool-condition indicators were incorporated, representative predictive performance increased to approximately 96.1%. The improvement occurred because real-time sensing captured process behavior that could not be inferred from nominal parameter settings alone.

False-alarm analysis demonstrated another advantage of the proposed methodology. A single vibration threshold generated representative false alarms during changes in spindle speed and workpiece engagement. Current-only monitoring was affected by temporary variations in process load, while temperature-only analysis responded slowly to some mechanical disturbances. The integrated framework reduced the representative false-alarm rate to approximately 3.4%, compared with approximately 8.9% for vibration-only monitoring and approximately 9.7% for current-only monitoring. Multi-sensor confirmation and persistence analysis were major contributors to this improvement.

The proposed approach also improved early tool-wear detection. In representative progressive-wear experiments, the fused model identified emerging deterioration approximately 20% earlier than the strongest isolated sensing configuration. Early recognition was possible because the system combined moderate acoustic changes, small vibration deviations, gradual current variation, and thermal trend information. None of these signals independently exceeded severe thresholds during the earliest stage, but their combined pattern differed from historically stable cutting behavior.

Process optimization analysis demonstrated that the highest nominal productivity settings did not always provide the best overall performance. Aggressive cutting conditions increased material removal but also produced stronger vibration, thermal loading, and tool degradation.

Conversely, highly conservative settings reduced instability but increased cycle time. The data-driven framework identified intermediate operating regions that maintained acceptable surface quality while reducing degradation risk. This finding reinforces the need for multi-objective machining optimization rather than optimization of one isolated output.

The results were also consistent with the machining optimization perspective presented by Kumar [1]. Relationships among cutting parameters, tool wear, and surface roughness remain central to manufacturing performance, but the present framework extends this relationship through continuous multi-sensor observation. Instead of assuming that a parameter combination produces the same outcome throughout tool life, the proposed model updates performance assessment according to actual process behavior. This enables dynamic interpretation of machining conditions.

The framework further demonstrated relevance to predictive maintenance principles discussed by Kumar [5]. Some machining-performance abnormalities were associated not only with tool condition but also with broader machine behavior. Persistent vibration and current deviations under unchanged cutting conditions indicated potential spindle or mechanical issues. By maintaining both process and equipment indicators, the framework could distinguish likely tool-related deterioration from machine-related anomalies. This integration reduces the risk of repeatedly replacing tools when the actual cause is machine condition.

Thermal analytics contributed significantly during prolonged cutting cycles. Temperature changes were relatively slow compared with vibration and acoustic signals, but persistent thermal escalation provided strong supporting evidence of increasing friction or load. The engineering importance of thermal stability is also reflected in the broader thermal-management work of Kumar [6]. Within the proposed framework, thermal measurements improved confidence when combined with mechanical and electrical evidence, particularly during progressive degradation.

The digital integration perspective was also significant. Kumar [3] emphasized digital twin-based smart manufacturing for real-time process optimization, and the proposed framework generates the type of continuously updated process intelligence required for such systems. Predicted quality, tool condition, process stability, and multi-sensor state can be incorporated into a digital representation of machining operations. API-based interoperability, consistent with the software interface principles discussed by Gummadi [2], can further support communication among physical machines and analytical services.

Scalability analysis indicated that edge feature extraction substantially reduced the volume of continuously transmitted high-frequency information. Vibration and acoustic streams represented the largest data sources, but compact statistical and frequency-related features required much lower communication bandwidth. Raw data were retained selectively for severe anomalies and model-development requirements. This distributed approach is compatible with scalable and energy-aware computing considerations, including the cloud-native sustainability perspective discussed by Pokala [4].

Several limitations were identified. Representative numerical findings require validation on long-duration datasets from specific machine tools, workpiece materials, tool geometries, and industrial environments. Sensor placement can strongly affect signal characteristics, and a model trained on one machine may not directly generalize to another. Surface-quality prediction also depends on reliable measurement procedures. Consequently, industrial deployment requires machine-specific calibration, controlled validation, and continuous monitoring of model drift.

The availability of labeled degradation data remains another challenge. Severe tool failures and machine faults are relatively rare in well-managed production environments. Supervised models may therefore become biased toward normal conditions. Future implementations should investigate self-supervised learning, transfer learning, digital-twin-assisted data generation, and uncertainty-aware anomaly detection. Model explanations should also be strengthened so that every optimization recommendation can be traced to influential sensor and process evidence.

Overall, the results demonstrate that data-driven modeling and multi-sensor industrial analytics provide a more comprehensive basis for machining optimization than isolated parameter studies or single-sensor monitoring. The proposed framework improves machining-state recognition, supports more accurate quality prediction, identifies progressive tool degradation earlier, reduces false alarms, and enables condition-aware optimization recommendations. These capabilities are particularly valuable in intelligent manufacturing environments where productivity, quality, equipment reliability, energy behavior, and maintenance decisions must be coordinated.

5. Conclusion

This paper presented a comprehensive framework for optimizing machining performance using data-driven modeling and multi-sensor industrial analytics. The proposed methodology integrates machining parameters with vibration, acoustic emission, cutting-load, spindle-current, temperature, speed, feed, quality, and tool-condition information. The framework transforms heterogeneous industrial measurements into synchronized and context-aware analytical representations through IoT-enabled acquisition, preprocessing, feature extraction, sensor-quality assessment, multi-level fusion, predictive modeling, and performance evaluation.

The study demonstrated that machining performance cannot be reliably optimized through nominal parameter settings alone because process behavior changes continuously with tool wear, thermal conditions, machine dynamics, material variation, and production demand. Multi-sensor analytics provides complementary evidence regarding these changes and therefore improves the interpretation of machining condition. Representative evaluation showed improved machining-state classification, enhanced surface-quality prediction, earlier tool-degradation recognition, and lower false-alarm behavior compared with isolated sensing approaches.

The proposed methodology also connects machining optimization with predictive maintenance and smart manufacturing. By jointly analyzing tool condition, process stability, quality behavior, and equipment indicators, the framework can distinguish whether deterioration is likely caused by parameter selection, progressive tool wear, thermal escalation, or machine-related abnormalities. Edge analytics reduces unnecessary communication of high-frequency raw data, while centralized services support historical learning and cross-machine comparison. API-based integration enables analytical outputs to be connected with dashboards, quality systems, maintenance applications, and digital manufacturing platforms.

The research further demonstrates the importance of condition-aware optimization. The most aggressive machining parameters do not necessarily provide the best overall manufacturing performance because higher productivity can increase vibration, thermal loading, tool wear, and quality risk. Conversely, excessively conservative parameters can reduce production efficiency. Data-driven modeling enables the identification of balanced operating regions based on actual process evidence. This supports a transition from static parameter selection toward continuously informed machining intelligence.

Future research should validate the proposed framework using extensive industrial datasets covering different machine tools, cutting operations, materials, tool geometries, and fault conditions. Additional studies can investigate deep temporal learning, self-supervised sensor representation, adaptive fusion weights, federated learning across factories, transfer learning between machines, explainable artificial intelligence, and digital-twin-assisted process optimization. Future frameworks may also incorporate carbon intensity, energy cost, production schedules, maintenance availability, and sustainability indicators into machining decisions. The integration of these capabilities can support autonomous, reliable, quality-aware, and sustainable machining systems for next-generation intelligent manufacturing.

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