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**The title of the article („Times New Roman” font 12, single spacing)**

## **KEYWORDS**

Five or six key words that properly describe the content of the article. The words should be separated with comma . („Times New Roman” font 12, single spacing).

## **ABSTRACT**

The abstract of the article describing the content and the effect of the undertaken research („Times New Roman” font 12, single spacing).

## **Introduction**

„Sustainable production, instrumentation and engineering sciences” (SPIES) publishes articles only in English. The whole article should be written in „Times New Roman” font 12, with single spacing. The margins should be standard (2,5 cm on each side). Please, do not use any text formatting or styles. All additional formats and styles make further editing more difficult.

The introduction should extensively describe literature research and describe the research context of all presented results. It should point and present the research gap justifying the researches undertaken by the authors.

The division of the article into sections and subsections is optional.

## **Methodology**

This section should include a precise description of research methods and the devices and tools used for the research. The incomplete description or lack of description can make the analysis and the assessment of the article difficult.

The figures and tables should be preceded by particular notice in the text.

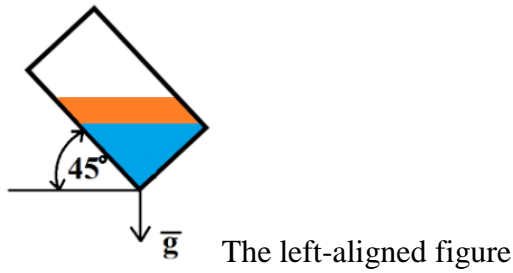


Fig. 3. The description under the figure („Times New Roman” font 12, single spacing).

Table 3. The description of the table („Times New Roman” font 12, single spacing).

Mechanical properties		
Tensile strenght	$R_m$ [MPa]	250 -350
Yield Strenght	$R_e$ [MPa]	165 – 228 MPa
Elongation	$A$ [%]	0.8 – 0.3 %
Modulus of elasticity	$E$ [GPa]	103 – 118 GPa
Poisson’s ratio	$\nu$	0.26
Fracturetoughness	$K_{IC}$	480

The left-aligned table

## Results& Discussion

The content of the section („Times New Roman” font 12, single spacing).

## Conclusions

The conclusions should briefly describe the results and refer to precise values of the results („Times New Roman” font 12, single spacing).

## References

1. Binali, R., Sıcak iş takım çeliğinin (TOOLOX 44) işlenebilirliğinin incelenmesi.Karabük Üniversitesi Fen Bilimleri Enstitüsü, 2017.
2. Mao, J., et al., A material constitutive model-basedprediction method for flank milling force considering the deformation of workpiece.Journal of Manufacturing Processes, 2022. 84: p. 403–413.
3. Rodríguez, J., J. Carbonell, and P. Jonsen, Numerical methods for the modelling of chip formation. Archives of Computational Methods in Engineering, 2020. 27: p. 387–412.

The references list should be prepared according to the works cited. The exaple is above. („Times New Roman” font 12, single spacing).