शोध पत्र भेजते समय कृपया निम्न बिन्दुओं पर ध्यान दें –

 शोध-पत्र अधिकतम 3000 -7000 शब्दों तक में हों तथा 100- 150 शब्दों का सारांश भी प्रेषित करें।

 शोध-पत्र A -4 साइज़ के कागज पर कंप्यूटर से एक तरफ मुद्रित हो।

 शोध-पत्र Microsoft Office Word में  हिंदी में Krutidev 10   के Font Size 10 में टाइप करवाकर भेजें।

* सन्दर्भ ग्रन्थ सूची का उल्लेख अवश्य करें।  सन्दर्भ ग्रन्थ सूची में लेखक का उपनाम, मुख्य नाम, पुस्तक का नाम, प्रकाशन का वर्ष एवं पृष्ठ संख्या अंकित होना चाहिए। पत्रिका के सन्दर्भ में लेख का शीर्षक, पत्रिका का नाम, अंक, पृष्ठ क्रम एवं प्रकाशन वर्ष दें।

**Main Heading in Times New Roman 12 pt. Main Heading in Times New Roman 12 pt.**

**First Author1\*, Second Author2 and Third Author3 (size 11pt)**

 *1Designation, Department, City (State), India (Size 8 pt. in Italic Font)*

 *2 Designation, Department, City (State), India*

 *3 Designation, Department, City (State), India*

\* Corresponding author. E-mail:  xyz@gmail.com

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| Abstract (All Headings should be in 12 pt Times New Roman Fonts) |
| Flexible Manufacturing System in 1960’s has evolved with the composition of machines with different capability and capacity constraints. Installation of flexible manufacturing system can be increased through research with physical significance and practical approach & acceptance. In coming decades, the diversity has reduced to negligible amount with technological improvements and advances with the development of advanced CNC’s, tool changers, tool transportation systems, automatic material handling system, developments in computer technologies etc. The acceptance and installation of FMS is much lower than expected because of higher installation, running and maintenance cost. FMS is the most (Size 10.5pt ) |
| Keywords: unbold |

**1. Introduction (All Headings/sub-headings should be in 12 pt Times New Roman Fonts)**

Flexible Manufacturing System in 1960’s has evolved with the composition of machines with different capability and capacity constraints. Installation of flexible manufacturing system can be increased through research with physical significance and practical approach & acceptance. In coming decades, the diversity has reduced to negligible amount with technological improvements and advances with the development of advanced CNC’s, tool changers, tool transportation systems, automatic material handling system, developments in computer technologies etc. The acceptance and installation of FMS is much lower than expected because of higher installation, running and maintenance cost. FMS is the most **(Size 11.5pt Times New Roman).**

**All figures and tables should be centered.**

**These must be cited in text as Figure 1, Figure 2, etc. and Table 1, Table 2 etc.**

**All the references should be cited in the text as; Author’s surname with year in bracket as given below.**

Gilmore (2008) proposed that ultrasonic Machining (USM) is a non-conventional mechanical material removal process used for machining both electrically conductive and non-metallic materials; preferably those with low ductility (Gilmore, 1989; Moreland, 1988) and a hardness above 40 HRC (Gilmore, 1990; Haslehurst, 1981) for example, inorganic glasses, ceramics, nickel alloys, etc. The process came into existence in 1945 when L. Balamuth was granted the fist patent for the process. USM has been variously termed ultrasonic drilling; ultrasonic cutting; ultrasonic abrasive machining and slurry drilling. Verma et al. (2002) found that in USM, high frequency electrical energy is converted into mechanical vibrations via a transducer/booster combination, which are then transmitted to an energy focusing as well as amplifying device: horn/tool assembly. This causes the tool to vibrate along its longitudinal axis at high frequency; usually >20 kHz with an amplitude of 12–50 μm (Kennedy and Grieve, 1975; Kremer, 1991).

\* If single authors then cite as; author’s surname name e.g. Gilmore (2008)

\*If two authors then use ‘and’ between author’s surname name e.g. Kennedy and Greive (1975)

\*If more than two then use et al. after first author’s surname name e.g. Verma et al. (2002)

**The references should be written as per APA format, as given below;**

Roberds, S. L., Leturcq, F., Allamand, V., Piccolo, F., Jeanpierre, M., Anderson, R. D., ... & Fardeau, M. (1994). Missense mutations in the adhalin gene linked to autosomal recessive muscular dystrophy. *Cell*, *78*(4), 625-633.