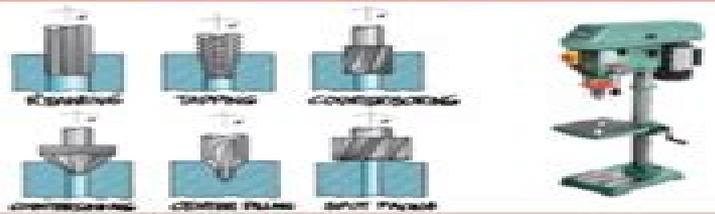


# MACHINE SHOP PRACTICE

## DRILL PRESS STANDARD OPERATIONS



### DRILLING

PRODUCING A HOLE BY REMOVING METAL FROM A SOLID MASS USING A CUTTING TOOL CALLED TWIST DRILL

### COUNTERSINKING

PRODUCING A TAPERED OR CONE-SHAPED ENLARGEMENT TO THE END OF A HOLE

### REAMING

SIZING AND PRODUCING A SMOOTH ROUND HOLE FROM A PREVIOUSLY DRILLED

### SPOT-FACING

SMOOTHING AND SQUARING THE SURFACE AROUND A HOLE TO PROVIDE A SEAT FOR THE HEAD OF A CAP SCREW OR A NUT

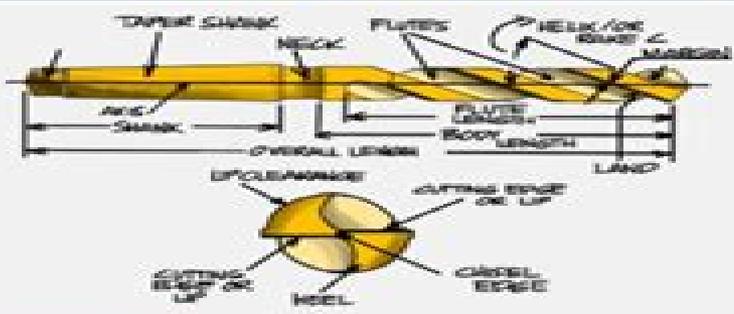
### TAPPING

CUTTING INTERNAL THREADS IN A HOLE WITH A CUTTING TOOL CALLED A TAP

### COUNTERBORING

ENLARGING THE TOP OF A PREVIOUSLY DRILLED HOLE TO A GIVEN DEPTH TO PROVIDE A SQUARE SHOULDER FOR THE HEAD OF A BOLT OR A CAP SCREW

## TWIST DRILL PARTS



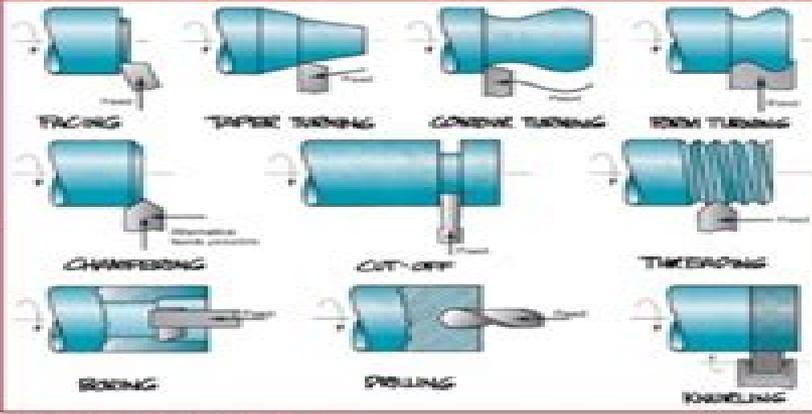
### CUTTING SPEED

$$V = TDN \quad \left| \begin{array}{l} D = \text{DIAMETER, in} \\ N = \text{SPEED, rpm} \end{array} \right.$$

### CUTTING TIME FOR TURNING, BORING, AND FACING

$$T = \frac{L}{fN} \quad \left| \begin{array}{l} f = \text{FEED RATE, in/rev} \\ N = \text{LATHE SPINDLE SPEED, rpm} \end{array} \right.$$

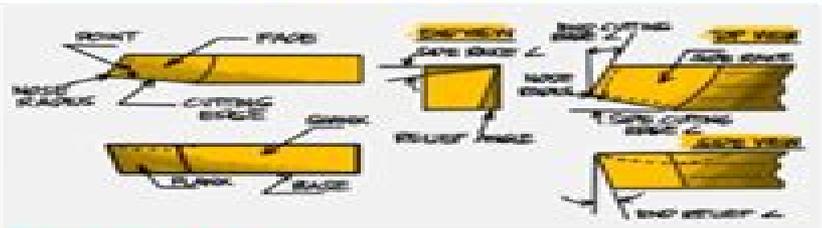
## LATHE STANDARD OPERATIONS



### TAPER CALCULATIONS

$$\text{TAPER} = \frac{\text{LARGE } \phi - \text{SMALL } \phi}{\text{TAPER LENGTH}}$$

### CUTTING TOOL



### MILLING CUTTERS

$$T = \frac{63D}{W} = \frac{12.6DC \cos A}{D + Ad}$$

$D$  = CUTTER  $\phi$ , in.     $T$  = NUMBER OF TEETH     $d$  = DEPTH OF CUT, in.  
 $W$  = WIDTH OF CUT, in.     $A$  = HELIX  $\angle$  OF CUTTER

### MILLING MACHINE FEED RATE

$$f_m = f_t \times N_t \times N$$

$f_m$  = MILLING MACHINE FEED RATE, in/min  
 $f_t$  = FEED RATE, in/tooth  
 $N_t$  = NUMBER OF TEETH  
 $N$  = SPEED, rpm

### PLANNING TIME

$$T = \frac{W}{L} \left[ L \times \left( \frac{1}{V_c} + \frac{1}{W} \right) + 0.025 \right]$$

$T$  = TIME, min  
 $W$  = WIDTH OF SURFACE, in.     $L$  = LENGTH OF STROKE, ft  
 $V_c$  = CUTTING SPEED, ft/min     $W$  = WIDTH OF SURFACE, in.

# Machine Shop Practice Test

**Wolfgang Guggemos**



**Machine Shop Practice Test:**

The Top Books of the Year Machine Shop Practice Test The year 2023 has witnessed a noteworthy surge in literary brilliance, with numerous engrossing novels enthralling the hearts of readers worldwide. Lets delve into the realm of popular books, exploring the fascinating narratives that have charmed audiences this year. Machine Shop Practice Test : Colleen Hoover's "It Ends with Us" This poignant tale of love, loss, and resilience has captivated readers with its raw and emotional exploration of domestic abuse. Hoover skillfully weaves a story of hope and healing, reminding us that even in the darkest of times, the human spirit can prevail. Machine Shop Practice Test : Taylor Jenkins Reids "The Seven Husbands of Evelyn Hugo" This intriguing historical fiction novel unravels the life of Evelyn Hugo, a Hollywood icon who defies expectations and societal norms to pursue her dreams. Reids compelling storytelling and compelling characters transport readers to a bygone era, immersing them in a world of glamour, ambition, and self-discovery. Discover the Magic : Delia Owens "Where the Crawdads Sing" This captivating coming-of-age story follows Kya Clark, a young woman who grows up alone in the marshes of North Carolina. Owens spins a tale of resilience, survival, and the transformative power of nature, captivating readers with its evocative prose and mesmerizing setting. These popular novels represent just a fraction of the literary treasures that have emerged in 2023. Whether you seek tales of romance, adventure, or personal growth, the world of literature offers an abundance of captivating stories waiting to be discovered. The novel begins with Richard Papen, a bright but troubled young man, arriving at Hampden College. Richard is immediately drawn to the group of students who call themselves the Classics Club. The club is led by Henry Winter, a brilliant and charismatic young man. Henry is obsessed with Greek mythology and philosophy, and he quickly draws Richard into his world. The other members of the Classics Club are equally as fascinating. Bunny Corcoran is a wealthy and spoiled young man who is always looking for a good time. Charles Tavis is a quiet and reserved young man who is deeply in love with Henry. Camilla Macaulay is a beautiful and intelligent young woman who is drawn to the power and danger of the Classics Club. The students are all deeply in love with Morrow, and they are willing to do anything to please him. Morrow is a complex and mysterious figure, and he seems to be manipulating the students for his own purposes. As the students become more involved with Morrow, they begin to commit increasingly dangerous acts. The Secret History is a masterful and suspenseful novel that will keep you speculating until the very end. The novel is a cautionary tale about the dangers of obsession and the power of evil.

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