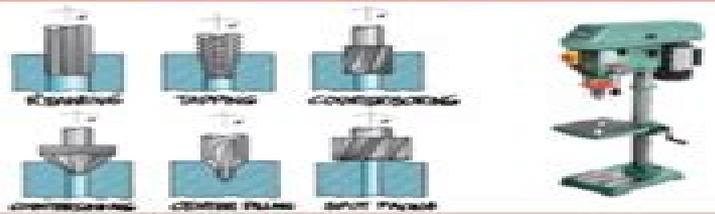


MACHINE SHOP PRACTICE

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

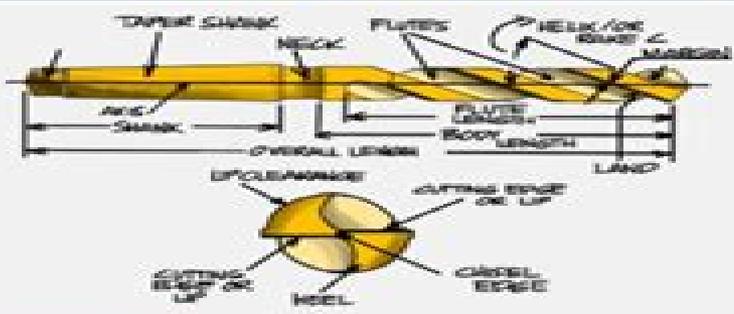
TAPPING

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



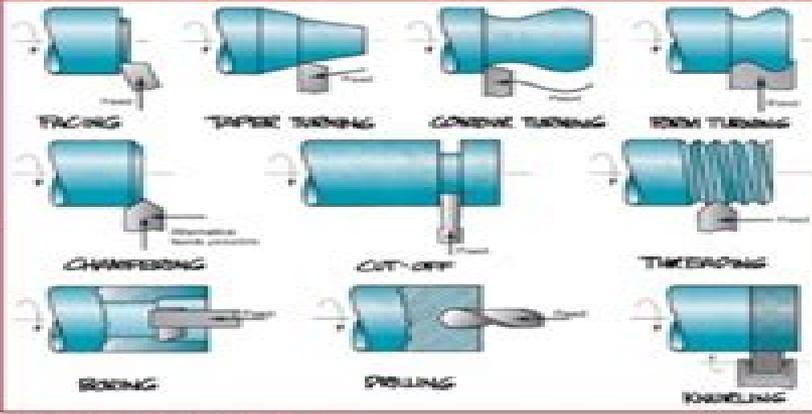
CUTTING SPEED

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

CUTTING TIME FOR TURNING, BORING, AND FACING

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

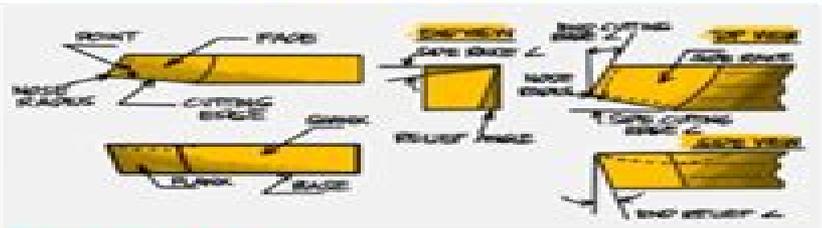
LATHE STANDARD OPERATIONS



TAPER CALCULATIONS

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

CUTTING TOOL



MILLING CUTTERS

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

D = CUTTER ϕ , 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.

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S Ashworth



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