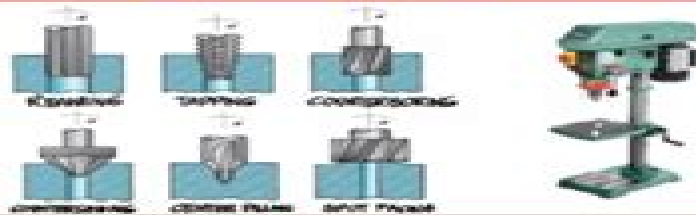


MACHINE SHOP PRACTICE

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

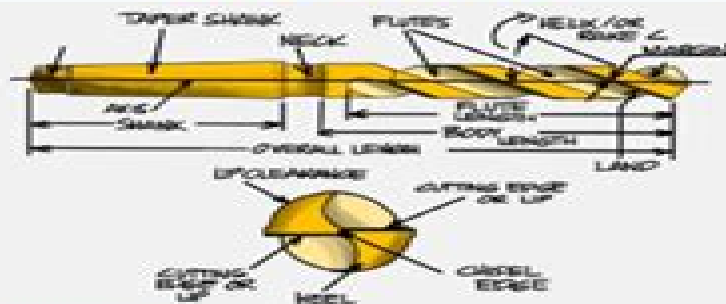
TAPPING

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

$$V = \pi D N$$

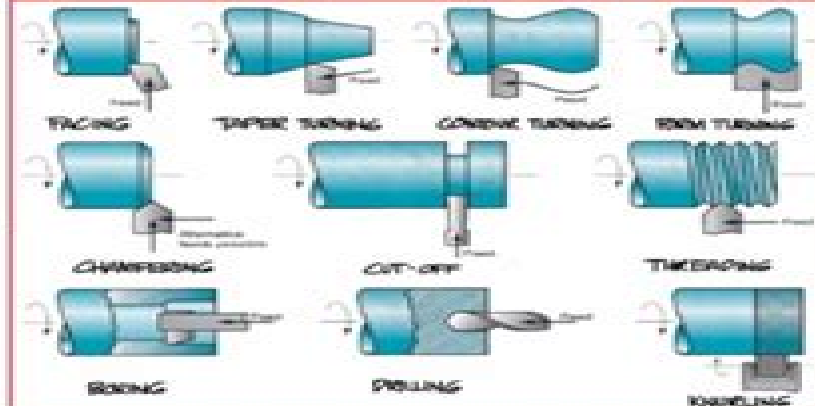
D = DIAMETER, ft
 N = SPEED, rpm

CUTTING TIME FOR TURNING, BORING, AND FACING

$$T = \frac{L}{fN}$$

f = FEED RATE, in/rev
 N = LATHE SPINDLE SPEED, rpm

LATHE STANDARD OPERATIONS



TAPER CALCULATIONS

$$TAPER = \frac{LARGE D - SMALL D}{TAPER LENGTH}$$

CUTTING TOOL



MILLING CUTTERS

$$T = \frac{6.3 D}{W} = \frac{12.6 D \cos A}{D + d}$$

D = CUTTER D, in. T = NUMBER OF TEETH d = DEPTH OF CUT, in.
 W = WIDTH OF CUT, in. A = HELIX L OF CUTTER

MILLING MACHINE FEED RATE

$$f_m = f_t \times n_t \times N$$

f_t = MILLING MACHINE FEED RATE, in/rev
 n_t = FEED RATE, in/rev
 N = 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. L = LENGTH OF STROKE, ft
 W = WIDTH OF SURFACE, in. V_c = CUTTING SPEED, ft/min
 V_c = CUTTING SPEED, ft/min

Machine Shop Procedure Manual

M Tight



Machine Shop Procedure Manual:

Unveiling the Magic of Words: A Report on "**Machine Shop Procedure Manual**"

In a world defined by information and interconnectivity, the enchanting power of words has acquired unparalleled significance. Their capability to kindle emotions, provoke contemplation, and ignite transformative change is truly awe-inspiring. Enter the realm of "**Machine Shop Procedure Manual**," a mesmerizing literary masterpiece penned with a distinguished author, guiding readers on a profound journey to unravel the secrets and potential hidden within every word. In this critique, we shall delve into the book's central themes, examine its distinctive writing style, and assess its profound effect on the souls of its readers.

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