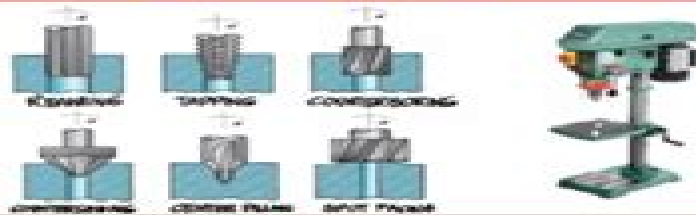


MACHINE SHOP PRACTICE

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

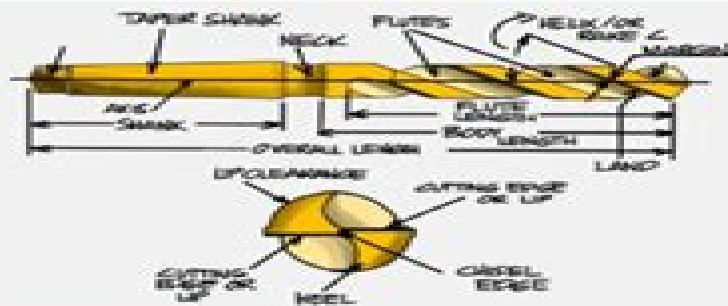
TAPPING

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

$$V = \pi D N$$

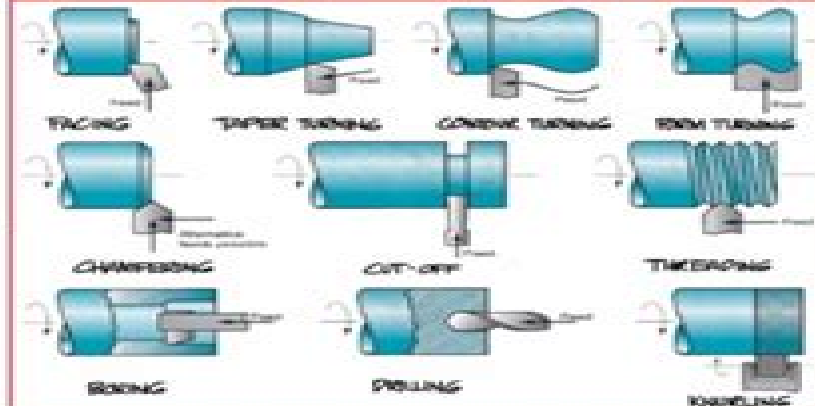
D = DIAMETER, ft
 N = SPEED, rpm

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

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

CUTTING TOOL



MILLING CUTTERS

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

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_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

United States. War Department



Machine Shop Procedure Manual:

Technical Manual United States. War Department,1944 Index of Research Projects ... United States. Work Projects Administration,1938 Monthly Catalogue, United States Public Documents ,1984 **United States Educational, Scientific, and Cultural Motion Pictures and Filmstrips, Selected and Available for Use Abroad; Education Section** United States. Interdepartmental Committee on Visual and Auditory Materials for Distribution Abroad. Subcommittee on Catalog,1959 **Popular Mechanics** ,1953-03 Popular Mechanics inspires instructs and influences readers to help them master the modern world Whether it s practical DIY home improvement tips gadgets and digital technology information on the newest cars or the latest breakthroughs in science PM is the ultimate guide to our high tech lifestyle *Circular* United States. Office of Education,1964 **Popular Science** ,1948-01 Popular Science gives our readers the information and tools to improve their technology and their world The core belief that Popular Science and our readers share The future is going to be better and science and technology are the driving forces that will help make it better **Popular Science** ,1953-10 Popular Science gives our readers the information and tools to improve their technology and their world The core belief that Popular Science and our readers share The future is going to be better and science and technology are the driving forces that will help make it better *Journal of American Insurance* ,1926 **The 1984 Guide to the Evaluation of Educational Experiences in the Armed Services** ,1984 **Resources in Education** ,1987 **United States Educational, Scientific, and Cultural Motion Pictures and Filmstrips: Education Section 1958, Selected and Available for Use Abroad** United States Information Agency,1959 **United States Educational, Scientific, and Cultural Motion Pictures and Filmstrips, Selected and Available for Use Abroad: Education Section, 1958, Education and Productivity** United States Information Agency,1959 *Popular Science* ,1948-05 Popular Science gives our readers the information and tools to improve their technology and their world The core belief that Popular Science and our readers share The future is going to be better and science and technology are the driving forces that will help make it better *Hyundai Excel Automotive Repair Manual* Mike Stubblefield,John Harold Haynes,1995 Hyundai Excel 1986 94 Shop Manual Haynes 247 pgs 592 b w ill **Popular Science** ,1949-01 Popular Science gives our readers the information and tools to improve their technology and their world The core belief that Popular Science and our readers share The future is going to be better and science and technology are the driving forces that will help make it better **Annual Report** Saint Louis (Mo.). Board of Education,1909 **Catalogue of Publications Issued by the Government of the United States** United States. Superintendent of Documents,1984 February issue includes Appendix entitled Directory of United States Government periodicals and subscription publications September issue includes List of depository libraries June and December issues include semiannual index Popular Science ,1949-11 Popular Science gives our readers the information and tools to improve their technology and their world The core belief that Popular Science and our readers share The future is going to

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