

MATERIAL	Hardness: 29-37 Rc (279-344 HBn)														
	SPM	Chip Load (IPT)			Depth of Cut		Chip Load (IPT)						Depth of Cut		
		0.015	0.031	0.047	Radial	Axial	0.062	0.078	0.093	0.117	0.187	0.250	Radial	Axial	
CARBON STEELS	600	Turning	.00008	.00012	.00018	1 x Dia	.20 x Dia	.00021	.00026	.00031	.00042	.00062	.00083	1 x Dia	.50 x Dia
Free-Machining/Low Carbon steels, 10xx - 1029 & all 12Lxx, 11xx - 1139 & all 11Lxx, 12xx - 1215 & all 12Lxx		Roughing	.00007	.00014	.00021	.30 x Dia	1 x Dia	.00024	.00031	.00036	.00049	.00073	.00098	.60 x Dia	1 x Dia
		Finishing	.00007	.00015	.00023	.13 x Dia	1 x Dia	.00027	.00034	.00040	.00054	.00081	.00109	.25 x Dia	1 x Dia
1030 - 1035, 1140 - 1151, 12xx, 15xx, 2xx, 3xx, 4xx & 4Lxx, 6xx & 6Lxx, 51xx & 52Lxx, 51xx & 51Lxx, 52xx & 52Lxx, 6xx, 8xx, 9xx	200	Turning	.00005	.00011	.00016	1 x Dia	.20 x Dia	.00019	.00024	.00026	.00038	.00057	.00076	1 x Dia	.50 x Dia
		Roughing	.00006	.00013	.00019	.30 x Dia	1 x Dia	.00022	.00028	.00033	.00045	.00067	.00089	.60 x Dia	1 x Dia
		Finishing	.00007	.00014	.00021	.13 x Dia	1 x Dia	.00025	.00031	.00037	.00050	.00074	.00099	.25 x Dia	1 x Dia
STAINLESS STEELS	450	Turning	.00006	.00012	.00018	1 x Dia	.20 x Dia	.00021	.00026	.00031	.00042	.00062	.00083	1 x Dia	.50 x Dia
303 EZ, 303 (all types), 416, 416Se, 416 Plus X, 430F, 430FSe, 430F, 430FSe, 440F, 440FSe		Roughing	.00007	.00014	.00021	.30 x Dia	1 x Dia	.00024	.00031	.00036	.00049	.00073	.00098	.60 x Dia	1 x Dia
		Finishing	.00007	.00015	.00023	.13 x Dia	1 x Dia	.00027	.00034	.00040	.00054	.00081	.00109	.25 x Dia	1 x Dia
301, 302, 303, 305, 301, 302, 304, 304L, 308, 309, 316, 314, 316, 316L, 317, 321, 329, 330, 347, 348, 385, 403, 405, 409, 410, 413, 420, 429, 430, 434, 436, 442, 446, 501, 502	200	Turning	.00005	.00011	.00016	1 x Dia	.20 x Dia	.00019	.00024	.00026	.00038	.00057	.00076	1 x Dia	.50 x Dia
		Roughing	.00006	.00013	.00019	.30 x Dia	1 x Dia	.00022	.00028	.00033	.00045	.00067	.00089	.60 x Dia	1 x Dia
		Finishing	.00007	.00014	.00021	.13 x Dia	1 x Dia	.00025	.00031	.00037	.00050	.00074	.00099	.25 x Dia	1 x Dia

Manual Lathe Speeds And Feeds Chart

United States Department of the Army

A red circular graphic with a gradient, appearing as a stylized arrow or a partial circle, located to the right of the United States Department of the Army text.

Manual Lathe Speeds And Feeds Chart:

Technical Manual United States Department of the Army,1983 **Operator's, Organizational, Direct Support and General Support Maintenance Manual (including Repair Parts List) for Lathe, Engine, Bench Type 12" (NSN 3416-00-449-7188).** ,1983 **Organizational Maintenance Manual (including Repair Parts and Special Tools Lists)** ,1990 Operator's, Organizational, Direct Support, and General Support Maintenance Manual Including Repair Parts List for Lathe, Engine Model 1754 (NSN 3416-00-250-6550) Standard-Modern Tool Company, Limited ,1991 **How to Machine Parts on Turret Lathes, a Tooling Guide Book** Warner & Swasey,1944 *Operator's, organizational, direct support and general support maintenance manual including repair parts list for lathe, engine toolroom model 1530 (3416-00-517-1051).* ,1983 **Operator's, Organizational, Direct Support, and General Support Maintenance Manual Including Repair Parts List for Lathe, Engine Model B-40 (McIlvanie Machine Works) (NSN 3416-00-725-3508).** ,1992 **Machine Operation Times for Estimators** Joseph C. Derse,1946 **Operator, Organizational, Direct Support and General Support Maintenance Manual Including Repair Parts List for Engine Lathe, Model A-40H (NSN 3416-00-252-7094).** ,1983 **Manufacturing Processes & Materials, 5th Edition** Ahmad K. Elshennawy,Gamal S. Weheba,2015-01-02 Manufacturers know the value of a knowledgeable workforce The challenge today is finding skilled people to fill these positions Since publication of the first edition in 1961 instructors students and practitioners have relied on Manufacturing Processes and Materials for the foundational knowledge needed to perform in manufacturing roles across a myriad of industries As an on the job reference anyone working in a technical department of a manufacturing company regardless of education experience and skill level will use this book to gain a basic understanding of manufacturing processes materials and equipment Now in its fifth edition the book covers the basic processes materials and machinery used in the job shop toolroom or small manufacturing facility At the same time it describes advanced equipment used in larger production environments The reader is given a thorough review of metals composites plastics and other engineering materials including their physical properties testing treatment and suitability for use in manufacturing Quality measurement and gaging process planning and cost analysis and manufacturing systems are all addressed Questions and problems at the end of each chapter can be used as a self test or as assignments in the classroom Manufacturing Processes and Materials is also available as an eBook Additional teaching materials for instructors Instructor s Guide eBook only Instructor s Slides zip file **Manufacturing Processes and Materials, Fourth Edition** George F. Schrader,Ahmad K. Elshennawy,2000 This best selling textbook for major manufacturing engineering programs across the country masterfully covers the basic processes and machinery used in the job shop tool room or small manufacturing facility At the same time it describes advanced equipment and processes used in larger production environments Questions and problems at the end of each chapter can be used as self tests or assignments An Instructor s Guide is available to tailor a more structured learning

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A Laboratory Manual of Machine Shop Practice Jerry H. Service,George E. Frease,1924 Industrial Mathematics Practically Applied Paul V. Farnsworth,1921 American Machinist ,1917 *Machine Tool Technology* Willard J. McCarthy,1968 **The Railway Engineer** Lawrence Saunders,S. R. Blundstone,1923 **Huebner's Machine Tool Specs: Threading through turning machines** ,1980

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