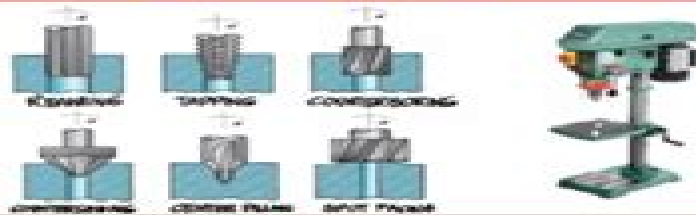


# MACHINE SHOP PRACTICE

## 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

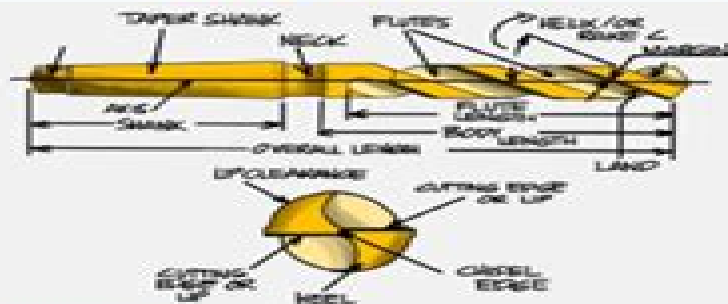
### TAPPING

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

$$V = \pi D N$$

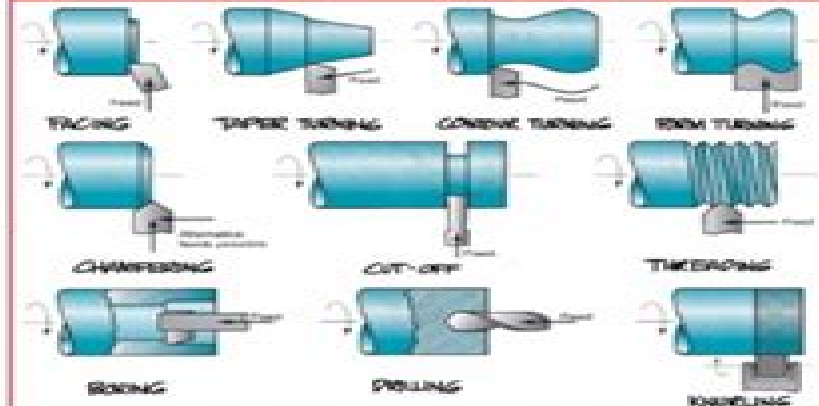
$D$  = DIAMETER, ft  
 $N$  = SPEED, rpm

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

### MILLING MACHINE FEED RATE

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

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

# Machine Shop Procedure Manual

**M Carnoy**



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