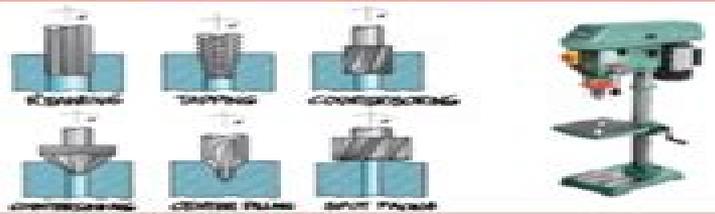


# MACHINE SHOP PRACTICE

## 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

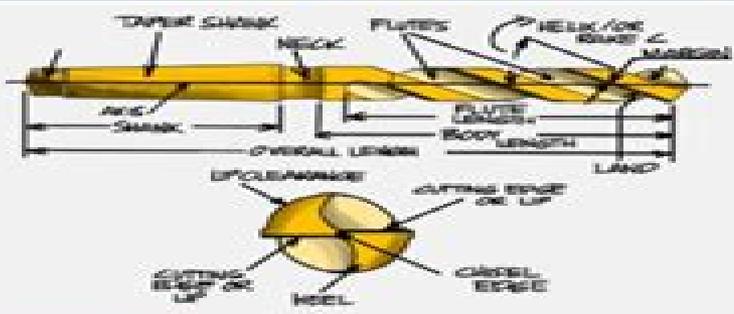
### TAPPING

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



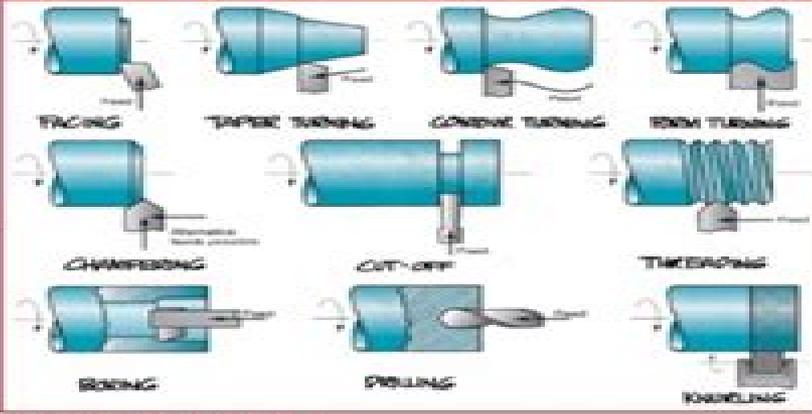
### CUTTING SPEED

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

### 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

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

$D$  = 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

$$f_m = f_t \times N_t \times N$$

$f_m$  = 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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**Yicheng Fang**



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