Calculation for Cutting Speed, Rotation Speed and Feed Rate

\[ V = \frac{\pi \times D \times N}{12} \]

\[ F = f \times N \]

**V**= Cutting Speed (SFM)

**F**= Feed/min. (inch/min)

\( \pi = 3.14 \) [Circular Constant]

**D**= Tool Diameter (inch)

**N**= 1 Rotation Per Minute [RPM] (min\(^{-1}\))

**f**= 1 Feed rate/rev. (IPR)

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If your machine cannot meet the recommended rotation speed, please use the higher speed and adjust the feed rate appropriately.

**Recommended Step Feed Amount(Q)**

<table>
<thead>
<tr>
<th>Diameter (mm)</th>
<th>Pecking</th>
</tr>
</thead>
<tbody>
<tr>
<td>Ø0.05~ Ø0.4</td>
<td>D×0.1</td>
</tr>
<tr>
<td>Ø0.5~ Ø0.9</td>
<td>D×0.2</td>
</tr>
<tr>
<td>Ø1~ Ø3</td>
<td>D×0.2 ~0.5</td>
</tr>
</tbody>
</table>

\[ \text{Pecking}(Q)=\frac{\text{Diameter}(D) \times \text{Coefficient Number}}{} \]