

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)

- 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)

Diameter (mm)	Pecking
Ø0.05~Ø0.4	D×0.1
Ø0.5~Ø0.9	D×0.2
Ø1~Ø3	D×0.2 ~0.5

$$\text{Pecking(Q)} = \text{Diameter(D)} \times \text{Coefficient Number}$$