To perform floring poperation on shipper machining time. 1 w c N feed feed floring speed Cutting Speed Cut														
Sr No. Longth of Workpiece Midth of Workpiece Actual Machining Time Midth of Workpiece Actual Machining Time Midth of Workpiece Midth of Workpiece Actual Machining Time Midth of Workpiece Midth of	to calculate machining time.													
Sr No. Length of Vorkplieze Width of Workplieze Width of Workplieze Midth of Workplieze Clearance Length No. of Stroke per min. (ministrike) 7,5 /s/s Thickness (ii) mm	_	*	O	~	7	_						Tm=TM	Ta	
1 86 30 142 60 0.3 14200 21.3 1 20.3 1,40 6000 190 190 18900 190 18900 190 18900 190 18900 190 18900 190 18900 190 18900 190 18900 190 18900 190 18900 190 18900 190 18900 190 18900 190 18900 190 18900 190 18900 190 190 18900 190 190 190 190 190 190 190 190 190	Sr No. Length	h of Workpiece W	lidth of Workpiece C.	learance Length N	Vo. of Stroke per min	feed (mm/stroke)	Cutting Speed (Vc,Vs)	Thickness (ti) mm	depth of cut (d) mm: set	Thickness (tf) mm	Number of Passes (Np)	Theoritcal Machining Time	Actual Machining Time %	Diff (Ta-Tc/Tc)*100
0.3	-	98	30	142	09	0.3	14200	21.3	-	20.3	1.00	0009	190	18900
0.3						0.3								
						0,3								
	28 mm													
29 ram														
28 nm	20 stroke/min													
29 mm 20 stroke/min	40 stroke/min													
29 smm 20 stroke/min 40 stroke/min	60 stroke/min													
29 rmm 20 strokefmin 40 strokefmin 60 strokefmin 60 strokefmin	0	0.6666666667												