

Lab 07	To perform facing operation on shaper machine to calculate machining time.														
	Sr No.	Length of Workpiece	Width of Workpiece	c	N	f	feed (mm/stroke)	Cutting Speed (Vc,Vs)	Thickness (t) mm	depth of cut (d) mm: set	Thickness (t) mm	Number of Passes (Np)	Tm=TM Theoretical Machining Time	Ta Actual Machining Time	% Dif (Ta-Tc)/Tc*100
	1		86	30	142	60	0.3	14200	21.3	1	20.3	1.00	6000	190	18900
							0.3								
							0.3								
Clearance (c)=															
Shaper Machine Lever Position indication															
1=	28 mm														
2=	20 stroke/min														
3=	40 stroke/min														
m=(returning stroke time/forward stroke time)*	60 stroke/min														
		0.6566666667													