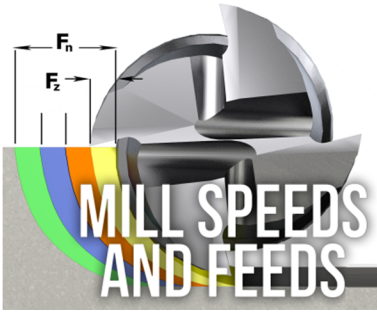


MILL SPEEDS AND FEEDS

METRIC

TIP OF THE DAY

SPINDLE SPEED

$$n = V_c \times 318 \div D$$

RPM = (m/min) x 318 ÷ Ø

TABLE FEED END MILL

$$V_f = f_z \times Z \times n$$

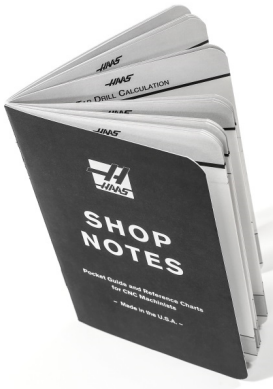
mm/min = Feed per Tooth x Number of Teeth x RPM

FEED DRILLS

$$V_f = f_n \times n$$

mm/min = Feed per Rev. x RPM

V_C	Cutting Speed (m/min)
π	Pi (3.14, our Ø to Circ. ratio)
D	Tool Diameter (mm)
n	rev/min (RPM, S-Code)
V_F	Table Feed (mm/min, F-Code)
f_Z	Feed per Tooth (mm)
f_n	Feed per Revolution (mm)
Z	Number of Flutes
a_e	Width of Cut, Radial Depth of Cut
a_p	Depth of Cut, Axial Depth of Cut



Download **Haas Shop Notes**, the Machinist's CNC Reference Guide, from diy.Haascnc.com for more tips and formulas