# Formula Sheet

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*$ • R = R' $*

*$ t1 = 0.25 mm $*

*$ v = 244 m/min $*

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*$ Continuous ChipsRake angle = 0 degree; V = 1 mm/s; brass Y . Guo, W.D. Compton, S. Chandrasekar . In situ analysis of flow dynamics and deformation fields in cutting and sliding of metals. Proceedings of the Royal Society A 471, 20150194 (2015).Indian Institute of Technology Guwahati 17 $*

Variables:

cutting: expensive one–Substantial amount of work removal from workpiece–Lot of energy will be expended INDISPENSABLE

*$ Discontinuous ChipsRake angle = -50 degree; V = 1 mm/s; 70-30 brass Y. Guo, W .D. Compton, S. Chandrasekar . In situ analysis of flow dynamics and deformation fields in cutting and sliding of metals. Proceedings of the Royal Society A 471, 20150194 (2015).Indian Institute of Technology Guwahati 19 $*

Variables:

cutting: expensive one–Substantial amount of work removal from workpiece–Lot of energy will be expended INDISPENSABLE

*$ Segmented ChipsRake angle = -20 degree; V = 1 mm/s; 70-30 brass Y. Guo, W .D. Compton, S. Chandrasekar . In situ analysis of flow dynamics and deformation fields in cutting and sliding of metals. Proceedings of the Royal Society A 471, 20150194 (2015).Indian Institute of Technology Guwahati 20 $*

Variables:

cutting: expensive one–Substantial amount of work removal from workpiece–Lot of energy will be expended INDISPENSABLE