

Hydraulic chuck pressure must be great enough to overcome centrifugal force of high RPM if max RPM is not governed.

			50-175 PSI Low cutting forces				175-400 PSI Extreme holding force required			
Carbide Inserts With Advanced Coatings			.001"-.008" IPR Finishing 3 HP Higher RPM When Finishing Can Override Chuck Clamping Pressure		.008"-.012" IPR Medium 7 HP Good Starting Point For General Turning Chuck 25% of workpiece length minimum when possible		.012"-.020" IPR Medium Roughing 15 HP Work Your way Up To This For Production *Serrated Hard Jaws Chuck 25% of workpiece length minimum when possible		.020"-.050" IPR Heavy Roughing >20 HP Use Caution *Serrated Hard Jaws 25% of workpiece length - Tabstock	
WORKPIECE MATERIAL	SFM Roughing	SFM Finishing	.008" Radius	.0156" Radius	.0156" Radius	.0313" Radius	.0313" Radius	.0625" Radius	.0313" Radius	.0625" Radius
N (Aluminum 6061 7073 Coolant ON / MQL ON)	0-3000 1500	0-3000 2500	.008-.080 DOC	.016-.080 DOC	.050-.100 DOC	.050-.100 DOC	.100-.150 DOC	.100-.150 DOC	.150-.250 DOC	.150-.250 DOC
P (Carbon Steel 1018 A36 Roughing-Coolant ON Finishing-Air-Coolant ON)	0-1500 1000	*600-1500 1300	.008-.080 DOC	.016-.080 DOC	.050-.100 DOC	.050-.100 DOC	.100-.150 DOC	.100-.150 DOC	.150-.250 DOC	.150-.250 DOC
P (Alloy Steel 4130 4140 Roughing-Coolant ON Finishing-Air-Coolant ON)	0-1100 800	*450-1100 1100	.008-.080 DOC	.016-.080 DOC	.050-.100 DOC	.050-.100 DOC	.100-.150 DOC	.100-.150 DOC	.150-.250 DOC	.150-.250 DOC
M (300 Series Stainless Steel 303 304 316 Coolant ON)	0-650 450	0-650 450	.008-.080 DOC	.016-.080 DOC	.050-.100 DOC	.050-.100 DOC	.100-.150 DOC	.100-.150 DOC	.150-.250 DOC	.150-.250 DOC
M (400 Series Stainless Steel 418 420 Coolant ON)	0-550 400	0-550 400	.008-.080 DOC	.016-.080 DOC	.050-.100 DOC	.050-.100 DOC	.100-.150 DOC	.100-.150 DOC	.150-.250 DOC	.150-.250 DOC
MPH Stainless Steel 15-5 17-4 Coolant ON)	0-300 250	0-300 250	.008-.080 DOC	.016-.080 DOC	.050-.100 DOC	.050-.100 DOC	.100-.150 DOC	.100-.150 DOC	.150-.250 DOC	.150-.250 DOC
K (Cast Iron Air-Coolant ON)	0-800 400	0-800 400	.008-.080 DOC	.016-.080 DOC	.050-.100 DOC	.050-.100 DOC	.100-.150 DOC	.100-.150 DOC	.150-.250 DOC	.150-.250 DOC
S (Titanium 6AL-4V Coolant ON)	0-250 150	0-250 150	.008-.080 DOC	.016-.080 DOC	.050-.100 DOC	.050-.100 DOC	.100-.150 DOC	.100-.150 DOC	.150-.250 DOC	.150-.250 DOC

Manual Lathe Speeds And Feeds Chart

Joseph C. Derse



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Table of Contents Manual Lathe Speeds And Feeds Chart

1. Understanding the eBook Manual Lathe Speeds And Feeds Chart
 - The Rise of Digital Reading Manual Lathe Speeds And Feeds Chart
 - Advantages of eBooks Over Traditional Books
2. Identifying Manual Lathe Speeds And Feeds Chart
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Manual Lathe Speeds And Feeds Chart
 - User-Friendly Interface
4. Exploring eBook Recommendations from Manual Lathe Speeds And Feeds Chart
 - Personalized Recommendations
 - Manual Lathe Speeds And Feeds Chart User Reviews and Ratings
 - Manual Lathe Speeds And Feeds Chart and Bestseller Lists
5. Accessing Manual Lathe Speeds And Feeds Chart Free and Paid eBooks
 - Manual Lathe Speeds And Feeds Chart Public Domain eBooks
 - Manual Lathe Speeds And Feeds Chart eBook Subscription Services
 - Manual Lathe Speeds And Feeds Chart Budget-Friendly Options

6. Navigating Manual Lathe Speeds And Feeds Chart eBook Formats
 - ePub, PDF, MOBI, and More
 - Manual Lathe Speeds And Feeds Chart Compatibility with Devices
 - Manual Lathe Speeds And Feeds Chart Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Manual Lathe Speeds And Feeds Chart
 - Highlighting and Note-Taking Manual Lathe Speeds And Feeds Chart
 - Interactive Elements Manual Lathe Speeds And Feeds Chart
8. Staying Engaged with Manual Lathe Speeds And Feeds Chart
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Manual Lathe Speeds And Feeds Chart
9. Balancing eBooks and Physical Books Manual Lathe Speeds And Feeds Chart
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Manual Lathe Speeds And Feeds Chart
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Manual Lathe Speeds And Feeds Chart
 - Setting Reading Goals Manual Lathe Speeds And Feeds Chart
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Manual Lathe Speeds And Feeds Chart
 - Fact-Checking eBook Content of Manual Lathe Speeds And Feeds Chart
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
 - Integration of Multimedia Elements

-
- Interactive and Gamified eBooks

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