Speeds and Feeds-RPM #5

$$\frac{3.82 x SFPM}{ DIA}=RPM$$

Using the proper SFPM for the following materials using HSS, Carbide, and Coated Carbide, Find the RPM for the material and Tool.

1. 7000 Series Aluminum DIA 8”

HSS\_\_\_\_\_\_\_\_\_\_\_\_\_ Carbide\_\_\_\_\_\_\_\_\_\_\_\_ Coated Carbide\_\_\_\_\_\_\_\_\_\_\_\_\_

2. 1212 DIA 4.50”

HSS\_\_\_\_\_\_\_\_\_\_\_\_\_ Carbide\_\_\_\_\_\_\_\_\_\_\_\_ Coated Carbide\_\_\_\_\_\_\_\_\_\_\_\_\_

3. 1018 Steel Cutter Dia .750”

HSS\_\_\_\_\_\_\_\_\_\_\_\_\_ Carbide\_\_\_\_\_\_\_\_\_\_\_\_ Coated Carbide\_\_\_\_\_\_\_\_\_\_\_\_\_

4. 1040 Steel Cutter Dia 1.875”

HSS\_\_\_\_\_\_\_\_\_\_\_\_\_ Carbide\_\_\_\_\_\_\_\_\_\_\_\_ Coated Carbide\_\_\_\_\_\_\_\_\_\_\_\_\_

5. 4150 Steel Cutter Dia .250”

HSS\_\_\_\_\_\_\_\_\_\_\_\_\_ Carbide\_\_\_\_\_\_\_\_\_\_\_\_ Coated Carbide\_\_\_\_\_\_\_\_\_\_\_\_\_

6. 6118 Steel Cutter Dia 4.5”

HSS\_\_\_\_\_\_\_\_\_\_\_\_\_ Carbide\_\_\_\_\_\_\_\_\_\_\_\_ Coated Carbide\_\_\_\_\_\_\_\_\_\_\_\_\_

7. S2 Steel Cutter Dia 6.25”

HSS\_\_\_\_\_\_\_\_\_\_\_\_\_ Carbide\_\_\_\_\_\_\_\_\_\_\_\_ Coated Carbide\_\_\_\_\_\_\_\_\_\_\_\_\_

8. H13 Steel Dia 1.25”

HSS\_\_\_\_\_\_\_\_\_\_\_\_\_ Carbide\_\_\_\_\_\_\_\_\_\_\_\_ Coated Carbide\_\_\_\_\_\_\_\_\_\_\_\_\_

9. 409 Stainless Dia 1.25”

HSS\_\_\_\_\_\_\_\_\_\_\_\_\_ Carbide\_\_\_\_\_\_\_\_\_\_\_\_ Coated Carbide\_\_\_\_\_\_\_\_\_\_\_\_\_

10. 300M Dia 3.0”

HSS\_\_\_\_\_\_\_\_\_\_\_\_\_ Carbide\_\_\_\_\_\_\_\_\_\_\_\_ Coated Carbide\_\_\_\_\_\_\_\_\_\_\_\_\_

\*\*\*\*\*\* REMEMBER THESE ARE JUST “GOOD” STARTING POINTS\*\*\*\*\*\*