

Cutting Speed $V_c = \frac{\pi \times D \times n}{1,000}$

Spindle Speed $n = V_c \div \pi \div D \times 1,000$

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

Feed per Tooth $f_z = \frac{V_f}{n \times Z}$

V_c = Cutting Speed (m/min)

π = 3.14 [The Circular Constant]

D = Diameter (mm)

n = Spindle Speed (min^{-1})

V_f = Feed (mm/min)

f_z = Feed per Tooth (mm/tooth)

Z = Number of Flutes

Manual Thread Milling Formulas

Daniel F McAuley



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