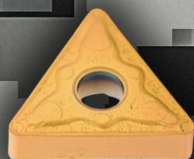
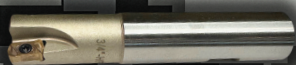
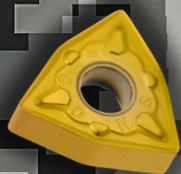
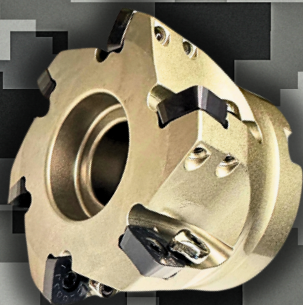
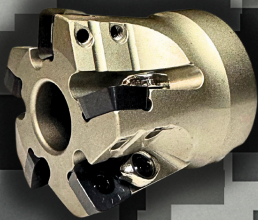


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HAM PRECISION	ZCC USA

Speeds and Feeds

Machining Formulas

$$\text{SFM} = .262 \times \text{DIA} \times \text{RPM}$$

$$\text{RPM} = 3.82 \times \text{SFM/DIA}$$

$$\text{IPM} = \text{IPR} \times \text{RPM}$$

$$\text{IPR} = \text{IPM} / \text{RPM}$$

Inch to Metric

$$\text{IPM} = .0337 \times \text{mm/min}$$

$$\text{IPM} = .03937 \times \text{mm/rev}$$

$$\text{SFM} = 3.281 \times \text{m/min}$$

Milling Formulas

$$\text{IPM} = \text{IPR} \times (\# \text{ of Teeth}) \times \text{RPM}$$

Metric to Inch

$$\text{IPM} = \text{IPR} \times (\# \text{ of Teeth}) \times \text{RPM}$$

$$\text{m/min} = .3048 \times \text{SFM}$$

$$\text{mm/REV} = \text{IPR} \times 25.4$$

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