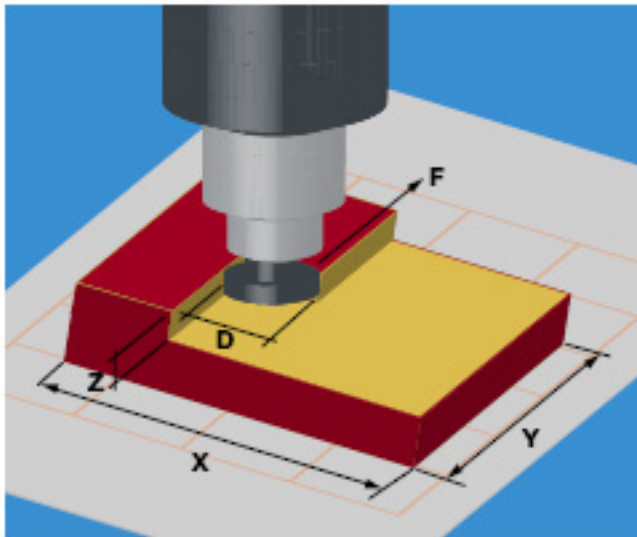


Application Worksheet



A = Workpiece Contact Surface Area (X x Y) (mm)

X = Workpiece Length (mm)

Y = Workpiece Width (mm)

Z = Depth of Cut (mm)

D = Cutting Tool Diameter (mm)

F = Feed rate (mm/min)

Δ = Material Coefficient

MSR = Maximum Stock Removal

1. Figure workpiece contact surface area:

$$(X \times Y) = \frac{\text{A}}{\text{mm}^2}$$

2. Calculate Maximum Stock Removal:

$$(A \times \Delta) = \frac{\text{MSR}}{\text{mm}^2/\text{min}}$$

3. Now you can figure:

$$\text{Max. Feed rate (F)} = \frac{\text{MSR}}{Z \times D} = \frac{\text{mm}^2/\text{min}}{\text{mm} \times \text{mm}} \times \text{mm/min}$$

$$\text{Max. Depth of Cut (Z)} = \frac{\text{MSR}}{D \times F} = \frac{\text{mm}^2/\text{min}}{\text{mm} \times \text{mm/min}} \times \text{mm}$$

$$\text{Max. Cutting Tool Dia. (D)} = \frac{\text{MSR}}{Z \times 2} = \frac{\text{mm}^2/\text{min}}{\text{mm} \times \text{mm/min}} \times \text{mm}$$

These values should be used as approximations based on testing. Actual results may be different due to workpiece material, contact area, and cutting parameters. TE-CO is not responsible for loss or damage associated with the use of this product.

- Workpiece should cover at least 4 poles for maximum holding power.
- Workpiece should be at least 0.4" thick.
- Chuck controller included with chuck

Coefficient Δ		EPPM	
Part pos.	Material	Machined	Rough
Against Stops	Mild steel	10	5
	Hard Steel	6	3
	Cast Iron	7.5	3.8
Free	Mild Steel	3.7	2
	Hard Steel	2.5	1.3
	Cast Iron	1.6	1.5

