

Speeds and Feeds Table PDF

To Find	Use	Formula
SFM = Surface Feet Per Minute	RPM = Revolutions per Minute	RPM / 3.82 x Dia = SFM
	Dia = Tool Diameter	
RPM = Revolutions per Minute	SPM = Surface Feet per Minute	SFM x 3.82 / Dia = RPM
	Dia = Tool Diameter	
IPM = Inches per Minute	RPM = Revolutions per Minute	RPM / IPT x #FL = IPM
	IPT = Inches per Tooth per Rev	
	#FL - # of Cutting Flutes	
IPT = Inches per Tooth	IPM = Inches per Minute	IPM / RPM / #FL = IPT
	RPM = Revolutions per Minute	
	#FL - # of Cutting Flutes	
IPR = Inches per Revolution (feed rate)	IPM = Inches per Minute	IPM / RPM = IPR (FR)
	RPM = Revolutions per Minute	
MR = Metal Removal Cubic Inches per Minute	ADC = Axial Depth of Cut	ADC x RDC x IPM = MR
	RDC = Radial Depth of Cut	
	IPM = Inches per Minute	
HP = Horsepower Machine Horsepower Required	IPM = Inches per Minute	IPM x RDC x ADC x PC = HP
	RDC = Radial Depth of Cut	
	ADC = Axial Depth of Cut	
	PC = Power Constants	