



T.C. Clipper Co.
Your Cutting Tool Specialists

9940 Hamilton Road
 Eden Prairie, MN 55344

Phone: (612) 829-0545
 Fax: (612) 829-1749

Drilling Calculations

Looking For	Drilling Operation
Cutting Speed - Feed/Min	$V_c = .262 \times D_d \times \text{R.P.M.}$
Revolutions per Minute	$\text{RPM} = 3.82 \times \frac{V_c}{D_d}$
Feed Rate - Inches/ Minute	$f_m = f_r \times \text{RPM}$
Feed per Tooth - Inches	$f_t = \frac{f_m}{T \times \text{RPM}}$
Cutting Time - Minute	$t = \frac{L}{f_m}$

Symbol	Definition
Dm	Diameter of milling cutter inches
Dd	Diameter of drill - inches
d	Depth of cut - inches
f _m	Feed rate - inches per minute
f _r	Feed - inches per revolution
f _t	Feed - inches per tooth
L	Length of cut - inches
RPM	Revolutions per minute of work or cutter
t	Cutting time - minutes

Quality Products - Extensive Cutting Tool Inventory - Direct Computer Entry - Same Day Shipping
 Stocking TiN & TiCN Coated Tools - On-Site Product Experts - No Voice Mail Maze - Quick Response Time