



Engineering Formulas for Metalcutting

Edmund Isakov

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Maximize the productivity of cutting.

- Linear regression equations for converting Rockwell, Vickers, Knoop, and Scleroscope hardness numbers into Brinell hardness numbers.
- Formulas and linear regression equations for calculating ultimate tensile strength of the most commonly used work materials in relationship with their hardness.
- Formulas for calculating the number of inserts simultaneously engaged with the workpiece depending on milling conditions.
- Formulas to calculate machining time when facing, cutoff, and deep grooving and for feed and radial forces in relationship with tangential force.
- Set of formulas to calculate overhang of boring bars made of tungsten heavy alloys and cemented carbides in comparison with a boring bar made of steel.
- Formulas for metal removal rate and for calculating tangential and axial forces.
- Establishes power constant values for most commonly used work materials.

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