

**Table 18: Feeds - Metric**

Type of machining	Roughing	Finishing	Unit
Turning	0.7	0.25	mm/rev
Boring	0.5	0.20	mm/rev
Parting	0.4	0.20	mm/rev

**GROOVING**

Orkot® materials can be readily grooved on a lathe, shaping, milling or boring machine with a 90° machining head. For most one off applications a lathe is adequate. A sharp high speed steel tool ground to the correct form should be clamped in a long boring bar with a three degree clearance ground on the side of the tool. No top clearance is required.

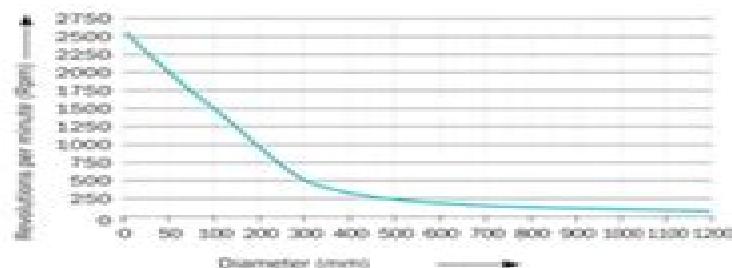


Figure 13: Machining Speeds as a function of Rpm and diameter (mm)

**Table 19: Feeds - Inch**

Type of machining	Roughing	Finishing	Unit
Turning	0.028	0.010	inch/rev
Boring	0.020	0.008	inch/rev
Parting	0.016	0.008	inch/rev

The chuck may be marked for the correctly spaced number of grooves and each groove shaped in turn. A 0.2 mm (0.008 inches) depth of cut should be used. For long bearings a steady may be required. The machine fast traverse, (with the spindle locked) can often be used. Linear speeds up to 10 m/min (30 ft/min) can be achieved.

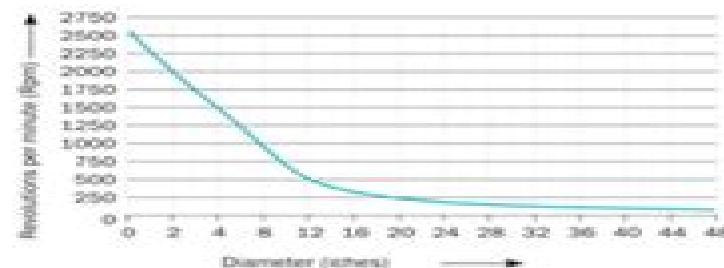


Figure 14: Machining Speeds as a function of Rpm and diameter (inches)

**Table 20: Speeds and Feeds by Drilling - Metric**

Drill Diameter mm	Speed Rpm	Feed mm/min
5	1600	300
10	800	400
15	600	400
20	400	400
25	350	400
30	300	400

**DEPTH OF CUT**

Roughing: 10 mm (0.4 inches)

Finishing: 3 mm (0.12 inches)

Smaller cuts may lead to tools rubbing, causing wear.

**Table 21: Speeds and Feeds by Drilling - Inch**

Drill Diameter inch	Speed Rpm	Feed inch/min
0.2	1600	1.2
0.4	800	1.6
0.6	600	1.6
0.8	400	1.6
1.0	350	1.6
1.2	300	1.6

which produces excessive heat build up in the finished part.

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**Didier Musso**

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