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theoretical example:

$D_c = 20 \text{ mm}$ ,  $v_c = 200$   
 $\text{m/min}$ ,  $n = 3184 \text{ rpm}$ ,

$f_n = 0.20 \text{ mm/r}$ , hole  
depth = 50 mm TL

(meters): 15 meters

TL (No. of holes):  $15 \times$

$1000/50 = 300$  holes

TL (min):  $15 \times 1000/v$

$f = 15 \times 1000/(f_n \times n)$

$= 15 \times 1000 / (0.20 \times$

$3184) = 23 \text{ min}$

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Drilling formulas and  
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What is the drilling  
time required for  
drilling a 30mm length  
hole in alloy steel (JIS  
SCM440) at a cutting  
speed of 50m/min and  
a feed 0.15mm/rev ?

$$\begin{aligned} \text{[Answer]} \quad n &= 50 \times 1000 \\ & \div (15 \times 3.14) = 1061.57 \\ \text{min}^{-1} \quad T_c &= (30 \times 1) \div (10 \\ & 61.57 \times 0.15) = 0.188 \end{aligned}$$

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Formula 2 PO, gpm =  
[3 (7 2 x 0.7854) S]

0.00411 x SPM where

D = liner diameter, in.

S = stroke length, in.

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SPM = strokes per  
minute Example:  
Determine the pump  
output, gpm, for a  
7-in, by 12-in, triplex  
pump at 80 strokes  
per minute: PO, gpm  
= [3 (72 x 0.7854) 12]  
0.00411 x 80 PO,  
gpm = 1385.4456 x  
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sometimes have constants, numbers that you will need to remember. The constant for this formula is 1029.4 to find the capacity of a given Diameter, remember it. We don't need to go into too much detail at this point, but what the 1029.4 does, is

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