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## **cs\_mill.txt**

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All data are in SFM - surface feet per minute.

If you have metric data divide it by 3.28

1 m = 3.28 ft

**==== EXAMPLE ====**

**Bronze**

**C22600, C65100, C65500, C67500**

**55**

**1.5**

**=====**

4 lines for each material

line 1: Name

line 2: description

line 3: Speed in SFM

line 4: power constant - to calculate needed HorsePower  
and then again 1, 2, 3, 4

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## **cs\_lathe.txt**

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All data are in SFM - surface feet per minute.

If you have metric data divide it by 3.28

1 m = 3.28 ft

**==== EXAMPLE ====**

**Brass**

**C35600, C37700, C36000, C33200, C34200, C35300**

**320**

**1200**

**7**

**=====**

5 lines for each material

line 1: Name

line 2: Description

line 3: Speed in SFM for HSS tool

line 4: Speed in SFM for Carbide tool

line 5: power constant - to calculate needed HorsePower  
and then again 1, 2, 3, 4, 5

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## **cs\_drill.txt**

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All data are in SFM - surface feet per minute.  
If you have metric data divide it by 3.28  
1 m = 3.28 ft

```
==== EXAMPLE ====
Cast Iron ASTM Class
20, 25, 30, 35, 40
90
60
=====
```

4 lines for each material  
line 1: Name  
line 2: Description  
line 3: Speed in SFM for drilling  
line 4: Speed in SFM for reaming  
and then again 1, 2, 3, 4

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## **f\_lathe.txt**

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feed per revolution f in IPR (inch per revolution)  
If you have metric data divide it with 25.4

```
==== EXAMPLE ====
Low Carbon Steel
0.015
0.005
0.020
0.008
=====
```

5 lines for each material  
line 1: Name  
line 2: Roughing with HSS  
line 3: Finishing with HSS  
line 4: Roughing with Carbide  
line 5: Finishing with Carbide

and then again 1, 2, 3, 4, 5

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## **f\_mill.txt**

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feed per tooth f in IPR (inch per revolution)

If you have metric data divide it with 25.4

**==== EXAMPLE ====**

**Carbon Steel 1018,A36**

**0.006**

**0.010**

**0.014**

**0.018**

**=====**

5 lines for each material

line 1: Name

line 2: for diameter 1/4 or 6 mm

line 3: for diameter 1/2 or 12 mm

line 4: for diameter 3/4 or 18 mm

line 5: for diameter 1 or 24 mm

Carbon Steel 1018,A36

0.006

0.010

0.014

0.018

Stainless Steel 303,304,416

0.005

0.007

0.009

0.012

Aluminum 6061,7075

0.008

0.012

0.017

0.020

Titanium 2,5

0.004

0.006

0.008

0.010