

# Radial Chip Thinning

Actual Feed per Tooth									
	.004	0.005	0.006	0.007	0.008	0.009	.010	0.011	0.012
WOC/Dia.	Adjusted Feedrate for Actual Chip Load								
.005	0.0280	0.0350	0.0420	0.0490	0.0560	0.0630	0.0700	0.0770	0.0840
.010	0.0200	0.0250	0.0300	0.0350	0.0400	0.0450	0.0500	0.0550	0.0600
.015	0.0164	0.0205	0.0246	0.0287	0.0328	0.0369	0.0410	0.0451	0.0492
.020	0.0140	0.0175	0.0210	0.0245	0.0280	0.0315	0.0350	0.0385	0.0420
.025	0.0128	0.0160	0.0192	0.0224	0.0256	0.0288	0.0320	0.0352	0.0384
.030	0.0116	0.0145	0.0174	0.0203	0.0232	0.0261	0.0290	0.0319	0.0348
.035	0.0108	0.0135	0.0162	0.0189	0.0216	0.0243	0.0270	0.0297	0.0324
.040	0.0100	0.0125	0.0150	0.0175	0.0200	0.0225	0.0250	0.0275	0.0300
.060	0.0084	0.0105	0.0126	0.0147	0.0168	0.0189	0.0210	0.0231	0.0252
.080	0.0072	0.0090	0.0108	0.0126	0.0144	0.0162	0.0180	0.0198	0.0216
.120	0.0060	0.0075	0.0090	0.0105	0.0120	0.0135	0.0150	0.0165	0.0180
.200	0.0052	0.0065	0.0078	0.0091	0.0104	0.0117	0.0130	0.0143	0.0156
.300	0.0044	0.0055	0.0066	0.0077	0.0088	0.0099	0.0110	0.0121	0.0132