

# Lead Angle Effect

## Chip Thickness Formula

Desired IPT / cos lead angle = Adjusted feed rate

Lead Angle	LAE	Actual Feed per Tooth								
		.004	0.005	0.006	0.007	0.008	0.009	.010	0.011	0.012
		Adjusted Feedrate for Actual Chip Load								
15	0.960	0.0042	0.0052	0.0063	0.0073	0.0083	0.0094	0.0104	0.0115	0.0125
20	0.940	0.0043	0.0053	0.0064	0.0074	0.0085	0.0096	0.0106	0.0117	0.0128
30	0.860	0.0047	0.0061	0.0070	0.0081	0.0093	0.0105	0.0116	0.0128	0.0140
45	0.707	0.0057	0.0075	0.0085	0.0099	0.0113	0.0127	0.0141	0.0156	0.0170

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Formula