STELLRAM

Calculation of the average chip thickness in relation with the a_e (Radial Engagement)

Formula: Programme Feed Rate (f_z)

$$f_z = h_m \times \sqrt{\frac{d}{a_e}}$$

h_m = Average chip thickness
a_e = Radial engagement
f_z = Feed per tooth
d = Cutter diameter

Formula: Average Chip Thickness (h_m)

$$h_m = f_z \times \sqrt{\frac{a_e}{d}}$$

7220VM Technical Information

Important
For a given f_Z (mm/tooth) feed rate, **the thickness of the chip h_m** (effective feed rate per tooth) **decreases with the radial depth of cut a_e.**

It is imperative that this parameter be taken into account when selecting the machine feed rate, calculated in accordance with the formula above:



