для заказа - kyocera@kyocera-tools.ru

Inch / Metric Conversion Chart

• Cutting Speed (Vc)

Cutting Speed (Vc)	
SFM	m/min
300	91
600	183
900	274

SFM = (0.262 x rpm) x dia.(inch)
3.28feet/min (SFM) = 1m/min

SFM (Surface Feet per Minute)

• D.O.C. (ap)

D.O.C. (ap)	
inch	mm
0.02	0.5
0.04	1.0
0.08	2.0

1inch = 25.4mm
0.04inch = 1mm

• IPR Feed Rate (f)

Feed Rate (f)	
ipr	m/min
0.002	0.05
0.004	0.1
0.008	0.2

1ipr = 25.4mm/rev
0.004ipr = 0.1mm/rev

ipr (Inch per Revolution)
mm/rev (mm per Revolution)

• IPT Feed Rate (fz)

Feed Rate (fz)	
ipt	mm/t
0.002	0.05
0.004	0.1
0.008	0.2

1ipt = 25.4mm/t
0.004ipt = 0.1mm/t

ipt (Inch per Tooth)
mm/t (mm per Tooth)

• Torque

lbft	Nm
0.738	1

lbft (Pound x Feet)
Nm (Newton x Meter)

SI Derived Units Conversion Chart

(Extracted from JIS Handbook "Iron & Steel")

• Force

N	kgf	dyn
1	$1.019\ 72X10^{-1}$	$1X10^{5}$
9.806 65	1	$9.806\ 65X10^{5}$
$1X10^{-5}$	$1.019\ 72X10^{-6}$	1

• Stress

Pa or N/m^2	MPa or N/mm^2	kgf/mm^2	kgf/cm^2	kgf/m^2
1	$1X10^{-6}$	$1.019\ 72X10^{-7}$	$1.019\ 72X10^{-5}$	$1.019\ 72X10^{-1}$
$1X10^{6}$	1	$1.019\ 72X10^{-1}$	1.019 72X10	$1.019\ 72X10^{5}$
$9.806\ 65X10^{6}$	9.806 65	1	$1X10^{-2}$	$1X10^{-6}$
$9.806\ 65X10^{4}$	$9.806\ 65X10^{-2}$	$1X10^{-2}$	1	$1X10^{-4}$
9.806 65	$9.806\ 65X10^{-6}$	$1X10^{-6}$	$1X10^{-4}$	1

• Pressure

Pa	kPa	MPa	bar	kgf/cm2
1	$1X10^{-3}$	$1X10^{-6}$	$1X10^{-5}$	$1.019\ 72X10^{-5}$
$1X10^{3}$	1	$1X10^{-3}$	$1X10^{-2}$	$1.019\ 72X10^{-2}$
$1X10^{6}$	$1X10^{3}$	1	1X10	1.019 72X10
$1X10^{5}$	$1X10^{2}$	$1X10^{-1}$	1	1.019 72
$9.806\ 65X10^{4}$	9.806 65X10	$9.806\ 65X10^{-2}$	$9.806\ 65X10^{-1}$	1

• Power

W	kW	kgf · m/s	PS	kcal/h
1	$1X10^{-3}$	$1.019\ 72X10^{-1}$	$1.359\ 62X10^{-3}$	$8.600\ 00X10^{-1}$
$1X10^{3}$	1	$1.019\ 72X10^{-2}$	1.359 62	$8.600\ 00X10^{2}$
9.806 65	$9.806\ 65X10^{-3}$	1	$1.333\ 33X10^{-2}$	8.433 71
$7.355X10^{2}$	$7.355X10^{-1}$	7.5X10	1	$6.325\ 29X10^{2}$
1.162 79	$1.162\ 79X10^{-3}$	$1.185\ 72X10^{-1}$	$1.580\ 95X10^{-3}$	1

• Revolution

min^{-1}	s^{-1}	r.p.m.
1	0.0167	1
60	1	60

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