

■ Due to changes of symbols indicating cutting conditions, changes are made as follows.

1) Turning

Item	New Symbol	(Previous Symbol)	Unit
Cutting Speed	Vc	V	m/min
Feed Rate	f	f	mm/rev
Depth of Cut	ap	d	mm
Edge Width	W	W	mm
Workpiece Dia.	Dm	D	mm
Cutting Power	Pc	Pkw	kW
Specific Cutting Force	kc	Ks	MPa
Theoretical Surface Roughness	h	Rz	μm
Corner Radius	rε	R	mm
Rotation Speed	n	N	min ⁻¹

Note) Pronunciation of rε: r-epsilon

2) Milling

Item	New Symbol	(Previous Symbol)	Unit
Cutting Speed	Vc	V	m/min
Feed Speed	Vf	F	mm/min
Feed per tooth	fz	f	mm/t
Feed Rate	f	f	mm/rev
Number of Edges	Z	Z	teeth
Axial Depth of Cut (Depth of Cut)	ap	d	mm
Radial Depth of Cut (Width of Cut)	ae	w	mm
Pick Feed	Pf	Pf	mm
Cutting Power	Pc	Pkw	kW
Specific Cutting Force	kc	Ks	MPa
Chip Evacuation Rate	Q	Q	cm ³ /min
Rotation Speed	n	N	min ⁻¹

3) Drilling

Item	New Symbol	(Previous Symbol)	Unit
Cutting Speed	Vc	V	m/min
Feed Speed	Vf	F	mm/min
Feed Rate	f	f	mm/rev
Diameter	Dc	D (Ds)	mm
Cutting Power	Pc	Pkw	kW
Specific Cutting Force	kc	Ks	MPa
Drilling Depth	H	d	mm
Rotation Speed	n	N	min ⁻¹