

		Metric	Imperial
RPM	Revolution per minute	-	-
F(R)	Feed per revolution	mm	inch
D	Diameter	mm	inch
S	Surface speed per minute	M	Feet
F(M)	Feed per minute	mm	inch
DC	Depth of cut	mm	inch
T	Machining time	-	-

Known Data	To Find	Metric	Imperial
Diameter Surface Speed	RPM	$\frac{S \times 1000}{D \times 3.142}$	$\frac{S \times 12}{D \times 3.142}$
Diameter RPM	S	$\frac{RPM \times D \times 3.142}{1000}$	$\frac{RPM \times D \times 3.142}{12}$
Diameter Surface Speed Feed/Minute	F(R)	$\frac{F(M) \times D \times 3.142}{S \times 1000}$	$\frac{RPM \times D \times 3.142}{S \times 12}$
RPM Feed/Minute	F(R)	$\frac{F(M)}{RPM}$	$\frac{F(M)}{RPM}$
Feed/Rev RPM	F(M)	RPM x F(R)	RPM x F(R)
Depth of cut Feed/minute	T	$\frac{DC}{F(M)}$	$\frac{DC}{F(M)}$