

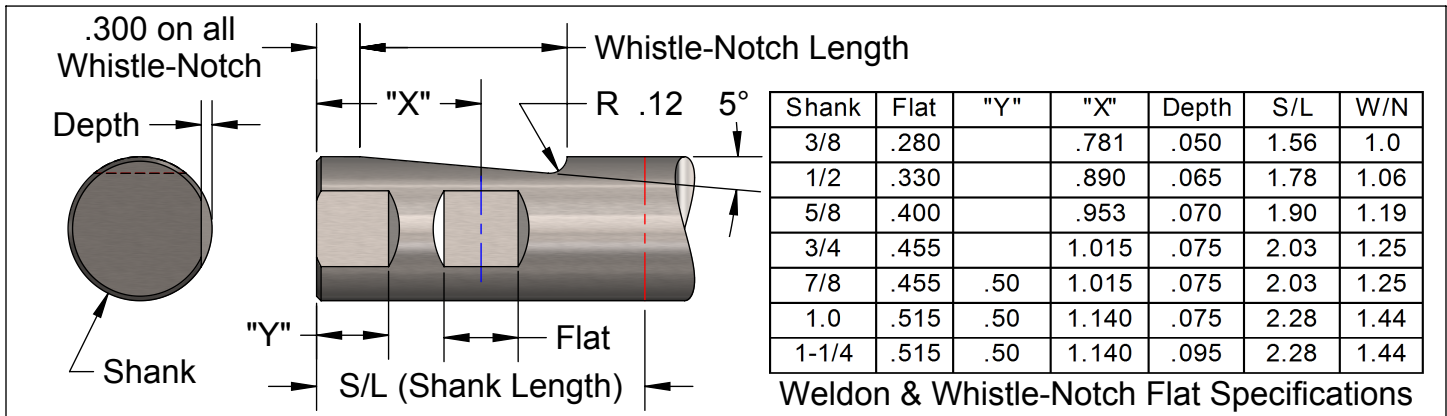
## Speed/Feed Formulas, and Shank Flat Data

SFM = RPM X .262 X Tool Diameter  
 RPM = SFM X 3.82 / Tool Diameter  
 IPM = RPM X IPT X Number of Flutes

IPT = IPM / (RPM X Number of Flutes)  
 CIM = Width X Depth X IPM  
 HP = KW X 1.341

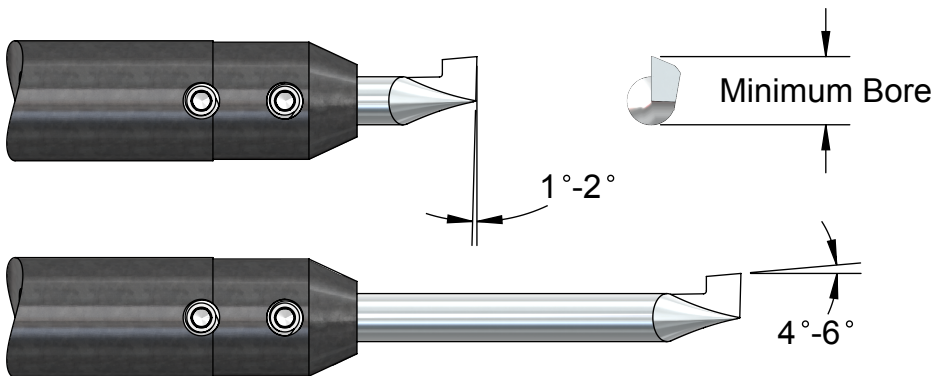
Comparative Estimates of CIM per HP for various part materials, (using carbide);  
 Cold Rolled Steel (1018)..... 1 CIM per HP  
 Aluminum, Magnesium, Plastics, Graphite..... 4 to 6 CIM per HP  
 Cast Iron, 303..... .7 to .8 CIM per HP  
 Tool Steel, Alloy Steel, 304-316, 17-4PH, 6AL-4V.. .4 to .6 CIM per HP  
 Inconel and other High Temperature Alloys..... .2 to .4 CIM per HP

Suggested SFM and IPT are shown in *Italics* on each page with each Cutter Style.



Note: We suggest using the depths shown as minimums to avoid screw damage.

## Accu-Bores



Solid Carbide boring tools.  
 (Micro-grain Heads silver soldered  
 on Solid Carbide Shanks). They can  
 be set to any bore depth with  
 maximum rigidity.

Not intended for  
 boring head use.

Number	Min. Bore	Shank	OAL	Price	
				No-Coat	AlTiN
ACB-130	.130	3/32	2.06	\$50.	\$53.
ACB-180	.180	1/8	2.12	\$55.	\$59.
ACB-245	.245	3/16	2.62	\$60.	\$64.
ACB-355	.355	1/4	3.18	\$65.	\$71.

Number	Min. Bore	Shank	OAL	Price	
				No-Coat	AlTiN
ACB-480	.480	3/8	3.68	\$75.	\$84.
ACB-630	.630	1/2	4.18	\$105.	\$118.
ACB630-6	.630	1/2	6.18	\$125.	\$142.

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If any product is not satisfactory  
 we will modify, replace or refund.

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