

LAMPIRAN 1
TABEL KECEPATAN POTONG DAN GERAK MAKAN PROSES
PEMESINAN

Tabel 1. Kecepatan Potong Proses Bubut Rata dan Proses Bubut Ulir Untuk Pahat HSS (Widarto, 2008)

MATERIAL	STRAIGHT TURNING SPEED		THREADING SPEED	
	FEET PER MINUTE	METERS PER MINUTE	FEET PER MINUTE	METERS PER MINUTE
LOW-CARBON STEEL	80-100	24.4-30.5	35-40	10.7-12.2
MEDIUM-CARBON STEEL	60-80	18.3-24.4	25-30	7.6-9.1
HIGH-CARBON STEEL	35-40	10.7-12.2	15-20	4.6-6.1
STAINLESS STEEL	40-50	12.2-15.2	15-20	4.6-6.1
ALUMINUM AND ITS ALLOYS	200-300	61.0-91.4	50-60	15.2-18.3
ORDINARY BRASS AND BRONZE	100-200	30.5-61.0	40-50	12.2-15.2
HIGH-TENSILE BRONZE	40-80	12.2-18.3	20-25	6.1-7.6
CAST IRON	50-80	15.2-24.4	20-25	6.1-7.6
COPPER	60-80	18.3-24.4	20-25	6.1-7.6

NOTE: Speeds for carbide-tipped bits can be 2 to 3 times the speed recommended for high-speed steel

Tabel 2. Gerak Makan Pada Mesin Bubut

THREADING INCH									FEEDING INCHES /)								
1	2	3	4	5	6	7	8		1	2	3	4	5	6	7	8	
A	4	4½	4¾	5	5½	6	6½	7	A	.1320	.1173	.1110	.1055	.0960	.0880	.0812	.0754
B	8	9	9½	10	11	12	13	14	B	.0660	.0585	.0555	.0527	.0480	.0440	.0406	.0377
C	16	18	19	20	22	24	26	28	C	.0330	.0293	.0277	.0263	.0240	.0220	.0203	.0188
D	32	36	38	40	44	48	52	56	D	.0165	.0146	.0138	.0131	.0120	.0110	.0101	.0094
E	64	72	76	80	88	96	104	112	E	.0082	.0073	.0069	.0065	.0060	.0055	.0050	.0047

Tabel 3. Putaran Mesin Bubut

CZ300 MODEL: CZ300 — 1
 SER NO. 940060
 MFG. DATE: 1994 — 7



THE PEOPLE'S REPUBLIC OF CHINA

	BACKGEAR DRIVE	50	75	100	120	165	220
	DIRECT DRIVE	300	410	550	655	900	200