

Longitudinal Feed [0.001 inches]									
Range	Gear	Distance Traveled per Spindle Revolution		Distance Traveled per Minute [0.001"]					
		mm	in	Spindle Speeds in RPM					
				500	1,000	1,500	2,000	2,500	3,000
1	1	0.500	0.0197	9.843	19.685	29.528	39.370	49.213	59.055
1	2	0.437	0.0172	8.593	17.185	25.778	34.370	42.963	51.555
1	3	0.39	0.0153	7.638	15.276	22.913	30.551	38.189	45.827
1	4	0.35	0.0137	6.870	13.740	20.610	27.480	34.350	41.220
1	5	0.32	0.0125	6.240	12.480	18.720	24.961	31.201	37.441
1	6	0.29	0.0115	5.728	11.457	17.185	22.913	28.642	34.370
1	7	0.269	0.0106	5.285	10.571	15.856	21.142	26.427	31.713
2	1	0.250	0.0098	4.921	9.843	14.764	19.685	24.606	29.528
2	2	0.218	0.0086	4.296	8.593	12.889	17.185	21.481	25.778
2	3	0.194	0.0076	3.819	7.638	11.457	15.276	19.094	22.913
2	4	0.175	0.0069	3.435	6.870	10.305	13.740	17.175	20.610
2	5	0.159	0.0062	3.120	6.240	9.360	12.480	15.600	18.720
2	6	0.146	0.0057	2.864	5.728	8.593	11.457	14.321	17.185
2	7	0.134	0.0053	2.643	5.285	7.928	10.571	13.214	15.856
3	1	0.125	0.0049	2.461	4.921	7.382	9.843	12.303	14.764
3	2	0.109	0.0043	2.148	4.296	6.444	8.593	10.741	12.889
3	3	0.097	0.0038	1.909	3.819	5.728	7.638	9.547	11.457
3	4	0.087	0.0034	1.718	3.435	5.153	6.870	8.588	10.305
3	5	0.079	0.0031	1.560	3.120	4.680	6.240	7.800	9.360
3	6	0.073	0.0029	1.432	2.864	4.296	5.728	7.160	8.593
3	7	0.067	0.0026	1.321	2.643	3.964	5.285	6.607	7.928

Cross Feed [0.001 inches]									
Range	Gear	Distance Traveled per Spindle Revolution		Distance Traveled per Minute [0.001"]					
		mm	in	Spindle Speeds in RPM					
				500	1,000	1,500	2,000	2,500	3,000
1	1	0.157	0.0062	3.091	6.181	9.272	12.362	15.453	18.543
1	2	0.138	0.0054	2.707	5.413	8.120	10.827	13.533	16.240
1	3	0.122	0.0048	2.402	4.803	7.205	9.606	12.008	14.409
1	4	0.110	0.0043	2.165	4.331	6.496	8.661	10.827	12.992
1	5	0.100	0.0039	1.969	3.937	5.906	7.874	9.843	11.811
1	6	0.092	0.0036	1.811	3.622	5.433	7.244	9.055	10.866
1	7	0.085	0.0033	1.673	3.346	5.020	6.693	8.366	10.039
2	1	0.079	0.0031	1.545	3.091	4.636	6.181	7.726	9.272
2	2	0.069	0.0027	1.353	2.707	4.060	5.413	6.767	8.120
2	3	0.061	0.0024	1.201	2.402	3.602	4.803	6.004	7.205
2	4	0.055	0.0022	1.083	2.165	3.248	4.331	5.413	6.496
2	5	0.050	0.0020	0.984	1.969	2.953	3.937	4.921	5.906
2	6	0.046	0.0018	0.906	1.811	2.717	3.622	4.528	5.433
2	7	0.043	0.0017	0.837	1.673	2.510	3.346	4.183	5.020
3	1	0.039	0.0015	0.773	1.545	2.318	3.091	3.863	4.636
3	2	0.034	0.0014	0.677	1.353	2.030	2.707	3.383	4.060
3	3	0.031	0.0012	0.600	1.201	1.801	2.402	3.002	3.602
3	4	0.028	0.0011	0.541	1.083	1.624	2.165	2.707	3.248
3	5	0.025	0.0010	0.492	0.984	1.476	1.969	2.461	2.953
3	6	0.023	0.0009	0.453	0.906	1.358	1.811	2.264	2.717
3	7	0.021	0.0008	0.418	0.837	1.255	1.673	2.092	2.510