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Cover Sheet for a Hanford Historical Document
Released for Public Availability

Released 1995

Prepared for the U.S. Department of Energy
under Contract DE-AC06-76RLO 1830

Pacific Northwest Laboratory
Operated for the U.S. Department of Energy
by Battelle Memorial Institute

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On February 17th I stopped at Baker Brothers Machine Company in Toledo to get the latest information on machining speeds and feeds and to determine the validity of their reported three pieces per hour per machine. Baker Brothers report that the three pieces per hour figure is an average given for estimated delivery dates and allows for machining shapes other than a straight cylinder. They now recommend a speed of 360 R.P.M. for turning with a .001 feed. They are using two cuts but are of the opinion that a single cut will be satisfactory if the equipment can be kept in shape. With the feeds and speeds recommended and allowing for 25% down time, their theoretical production rate is 5 pieces per hour. Their present experience indicates that they can do only 72% of this or approximately 6 pieces per hour. This lack of efficiency is largely due to the necessity for straightening and aligning rods in the machine.

Baker Brothers recommended the use of a 6-7 degree tool angle and an open cut. They also recommend that the coolant be mixed at a concentration of 50-1 rather than the 20-1 recommended by the coolant manufacturer. They have added bushings to the head stock of their lathes and recommended an additional collet at the back end of the head stock.

We have found that we can use somewhat higher speeds than recommended by Baker with good results. It is still necessary to use two cuts. For any production piece, it would seem best to follow Baker's experience rather than planning on an increase at Hanford.