



EUROPA-TECHNICAL BOOK SERIES  
for the Metalworking Trades

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# Mechanical and Metal Trades Handbook

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The content of the chapter „Program structure of CNC machines according to PAL“ (page 412 to 424) complies with the publications of the PAL Prüfungs- und Lehrmittelentwicklungsstelle (Institute for the development of training and testing material) of the IHK Region Stuttgart (Chamber of Commerce and Industry of the Stuttgart region).

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All printings of this edition may be used concurrently in the classroom since they are unchanged, except for some corrections to typographical errors and slight changes in standards.

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## Preface

The Mechanical and Metal Trades Handbook is well-suited for shop reference, tooling, machine building, maintenance and as a general book of knowledge. It is also useful for educational purposes, especially in practical work or curricula and continuing education programs.

### Target Groups

- Industrial and trade mechanics
- Tool & die makers
- Machinists
- Millwrights
- Draftspersons
- Technical Instructors
- Apprentices in above trade areas
- Practitioners in trades and industry
- Mechanical Engineering students

### Notes for the user

The contents of this book include tables and formulae in eight chapters, including Tables of Contents, Subject Index and Standards Index.

The **tables** contain the most important guidelines, designs, types, dimensions and standard values for their subject areas.

Units are not specified in the legends for the **formulae** if several units are possible. However, the calculation examples for each formula use those units normally applied in practice.

The **Table of Contents** in the front of the book is expanded further at the beginning of each chapter in form of a partial Table of Contents.

The **Subject Index** at the end of the book (pages 435–444) is extensive.

The **Standards Index** (pages 425–434) lists all the current standards and regulations cited in the book. In many cases previous standards are also listed to ease the transition from older, more familiar standards to new ones.

### Changes in the 3<sup>rd</sup> edition

In the present edition, we have updated the cited standards and restructured, updated, enhanced or added the following chapters in line with new developments in engineering:

- |   |  |
|---|--|
| – Fundamentals of technical mathematics | – PAL programming system for NC turning and NC milling |
| – Strength of materials                 | – Steel types  |
| – Plastics                              | – Material testing                                     |
| – Production management                 | – Machining processes                                  |
| – Forming                               | – Injection molding (new)                              |
| – Welding                               | – GRAFCET  |

### Acknowledgement

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November 2012

Authors and publisher

### 1 Mathematics

9 – 28

**M**

### 2 Physics

29 – 50

**P**

### 3 Technical Drawing

51 – 110

**TD**

### 4 Material Science

111 – 200

**MS**

### 5 Machine Elements

201 – 268

**ME**

### 6 Production Engineering

269 – 366

**PE**

### 7 Automation and Information Technology

367 – 424

**A**

### 8 International Material Comparison Chart, Standards

425–434

**S**

# Table of Contents

<b>1 Mathematics (M)</b>		<b>9</b>
<p><b>1.1 Units of measurement</b></p> <p>SI base quantities and base units ..... 10</p> <p>Derived quantities and their units ..... 11</p> <p>Non-SI units ..... 12</p> <p><b>1.2 Formulas</b></p> <p>Formula symbols, mathematical symbols .. 13</p> <p>Formulas, equations, graphs ..... 14</p> <p>Transformation of formulas ..... 15</p> <p>Quantities and units ..... 16</p> <p>Calculation with quantities ..... 17</p> <p>Percentage and interest calculation ..... 17</p> <p><b>1.3 Angles and triangles</b></p> <p>Types of angles, sum of angles in a triangle ..... 18</p> <p>Theorem of intersecting lines, Pythagorean theorem ..... 18</p> <p>Functions of right triangles ..... 19</p> <p>Functions of oblique triangles ..... 19</p>	<p><b>1.4 Lengths</b></p> <p>Division of lengths ..... 20</p> <p>Spring wire lengths ..... 21</p> <p>Rough lengths ..... 21</p> <p><b>1.5 Areas</b></p> <p>Angular areas ..... 22</p> <p>Triangle, polygon, circle ..... 23</p> <p>Circular sector, circular segment ..... 24</p> <p>Ellipse ..... 24</p> <p><b>1.6 Volume and surface area</b></p> <p>Cube, cylinder, pyramid ..... 25</p> <p>Truncated pyramid, cone, Truncated cone, sphere ..... 26</p> <p>Volumes of composite solids ..... 27</p> <p><b>1.7 Mass</b></p> <p>General calculations ..... 27</p> <p>Linear mass density ..... 27</p> <p>Area mass density ..... 27</p> <p><b>1.8 Centroids</b></p> <p>Centroids of lines ..... 28</p> <p>Centroids of plane areas ..... 28</p>	
<b>2 Physics (P)</b>		<b>29</b>
<p><b>2.1 Motion</b></p> <p>Uniform and accelerated motion ..... 30</p> <p>Speeds on machines ..... 31</p> <p><b>2.2 Forces</b></p> <p>Representation, addition and resolution of forces ..... 32</p> <p>Types of forces ..... 33</p> <p>Torque and levers, torque in gear drives... 34</p> <p><b>2.3 Work, power, efficiency</b></p> <p>Mechanical work ..... 34</p> <p>Simple machines and energy ..... 35</p> <p>Potential and kinetic energy ..... 35</p> <p>Power and efficiency ..... 36</p> <p><b>2.4 Friction</b></p> <p>Friction force ..... 37</p> <p>Coefficients of friction ..... 37</p> <p>Coefficients of rolling friction ..... 37</p> <p><b>2.5 Pressure in liquids and gases</b></p> <p>Pressure, definition and types ..... 38</p> <p>Buoyancy ..... 38</p> <p>Hydraulic power transmission ..... 38</p> <p>Pressure intensification, flow velocity ..... 39</p> <p>Changes of state in gases ..... 39</p>	<p><b>2.6 Strength of materials</b></p> <p>Load cases, types of loading ..... 40</p> <p>Material properties, stress limits ..... 40</p> <p>Strength calculation, safety factors ..... 41</p> <p>Allowable stresses, modulus of elasticity ..... 41</p> <p>Tensile and compressive stress, surface pressure ..... 42</p> <p>Shear, bending and torsional stress ..... 43</p> <p>Moments of area, section moduli ..... 44</p> <p><b>2.7 Thermodynamics</b></p> <p>Temperature, linear expansion, shrinkage ..... 45</p> <p>Quantity of heat ..... 45</p> <p>Heat flux, heat of combustion ..... 46</p> <p>Net calorific values ..... 46</p> <p><b>2.8 Electricity</b></p> <p>Quantities and units ..... 47</p> <p>Ohm's law, electrical resistance ..... 47</p> <p>Current density, resistor circuit ..... 48</p> <p>Types of current ..... 49</p> <p>Electrical work and power ..... 50</p>	

**3 Technical Drawing (TD)****51**

<b>3.1 Graphs</b>		<b>3.6 Machine elements, representation</b>	
Cartesian coordinate system .....	52	Gear types .....	79
Graph types .....	53	Roller bearings .....	80
<b>3.2 Basic geometric constructions</b>		Seals .....	81
Lines and angles .....	54	Retaining rings, springs .....	82
Tangents, circular arcs .....	55	<b>3.7 Object elements</b>	
Inscribed circles, ellipses .....	56	Bosses, object edges .....	83
Cycloids, involute curves, parabolas .....	57	Thread runouts, thread undercuts .....	84
<b>3.3 Elements of drawing</b>		Threads, screw joints .....	85
Fonts .....	58	Center holes, knurls, undercuts .....	86
Preferred numbers, radii, scales .....	59	<b>3.8 Welding and soldering</b>	
Drawing layout, bills of materials .....	60	Graphical symbols .....	88
Line types .....	62	Dimensioning examples .....	91
<b>3.4 Representation</b>		<b>3.9 Surfaces</b>	
Projection methods .....	64	Hardness specifications in drawings .....	92
Views .....	66	Form deviations, roughness .....	93
Sectional views .....	68	Surface testing, surface indications .....	94
Hatching .....	70	<b>3.10 ISO tolerances and fits</b>	
<b>3.5 Dimensioning drawings</b>		Fundamentals .....	98
Dimensioning lines, dimension values .....	71	Basic hole system, basic shaft system .....	102
Dimensioning rules .....	72	General tolerances .....	106
Elements of drawing .....	73	Roller bearing fits .....	106
Tolerance specifications .....	75	Fit recommendations .....	107
Types of dimensioning .....	76	Geometric tolerancing .....	108
Simplified presentation in drawings .....	78		

**4 Materials Science (MS)****111**

<b>4.1 Materials</b>		<b>4.5 Heat treatment</b>	
Material characteristics of solids .....	112	Iron-carbon phase diagram .....	152
Material characteristics of liquids and gases .....	113	Heat treatment of steels .....	153
Periodic table of the elements .....	114	Hardening of aluminium alloys .....	156
<b>4.2 Steels, designation system</b>		<b>4.6 Cast iron materials</b>	
Definition and classification of steel .....	116	Designation and material codes .....	157
Standardization of steel products .....	117	Classification .....	158
Designation system for steels .....	118	Cast iron .....	159
<b>4.3 Steels, steel types</b>		Malleable cast iron, cast steel .....	160
Overview of steel products .....	123	<b>4.7 Foundry technology</b> .....	161
Unalloyed steels .....	126	<b>4.8 Light alloys</b>	
Case hardened steels, quenched & tempered steels .....	129	Overview of aluminum alloys .....	163
Nitriding steels, free cutting steels .....	131	Wrought aluminum alloys .....	165
Tool steels, stainless steels .....	132	Aluminum profiles .....	168
Steels for bright steel products .....	137	Magnesium and titanium alloys .....	171
<b>4.4 Steels, finished products</b>		<b>4.9 Heavy non-ferrous metals</b>	
Sheet and strip metal, tubes .....	138	Overview and designation system .....	172
Profiles .....	142	Copper and refined zinc alloys .....	174
Linear mass density and area mass density .....	151	<b>4.10 Other metallic materials</b> .....	176
		<b>4.11 Plastics</b>	
		Overview and designation .....	178
		Thermoset plastics .....	181
		Thermoplastics, elastomers .....	182
		Plastics processing, testing of plastics .....	186

<b>4.12 Material testing</b>		<b>4.13 Corrosion, hazardous materials</b>	
Overview, tensile test .....	189	Corrosion .....	196
Rotary bending test .....	192	Hazardous materials .....	197
Hardness test .....	193		
<b>5 Machine Elements (ME)</b>		<b>201</b>	
<b>5.1 Threads</b>		<b>5.6 Pins and clevis pins</b>	
Types of threads, overview .....	202	Overview .....	235
Metric ISO threads .....	202	Grooved pins, grooved drive studs, clevis pins .....	237
Other types of threads .....	205	<b>5.7 Shaft-hub connections</b>	
Thread tolerances .....	207	Keys, gib-head keys .....	238
<b>5.2 Bolts and screws</b>		Feather keys, splined shaft joints .....	239
Overview, designations, property classes	208	Metric tapers, morse tapers, steep tapers	240
Hexagon head bolts & screws .....	211	Tool holding fixtures .....	241
Other bolts & screws .....	214	<b>5.8 Other machine elements</b>	
Screw joint calculations .....	220	Tension, compression and disc springs .	242
Locking fasteners, bolt and screw drive systems .....	221	Grub screws, thrust pads, knobs .....	245
<b>5.3 Countersinks</b>		T-slots and accessories .....	247
Countersinks for countersunk head screws .....	223	Quick-release drilling fixture .....	248
Counterbores for cap screws .....	224	<b>5.9 Drive elements</b>	
<b>5.4 Nuts</b>		Belts .....	250
Overview .....	225	Gears .....	253
Designations, property classes .....	226	Transmission ratios .....	256
Hexagon nuts .....	228	<b>5.10 Bearings</b>	
Other nuts .....	230	Plain bearings, overview .....	257
<b>5.5 Washers</b>		Plain bearing bushings .....	258
Overview, flat washers .....	232	Antifriction bearings, overview .....	259
Washers for HV bolts .....	234	Ball bearings .....	261
		Roller bearings .....	262
		Sealing elements .....	266
		Lubricating oils .....	267
		Lubricating greases .....	268
<b>6 Production Engineering (PE)</b>		<b>269</b>	
<b>6.1 Quality management</b>		<b>6.4 Maintenance, repair &amp; overhaul (MRO)</b>	
Standards, terminology .....	270	Maintenance, inspection, repair, improvement .....	289
Quality planning, quality testing .....	272	MRO concepts .....	290
Statistical analysis .....	273	Documentation system .....	292
Statistical process control .....	275	<b>6.5 Machining processes</b>	
Quality management of processes .....	276	Overview; forces and power .....	293
<b>6.2 EC Machinery Directive</b>		Drilling .....	298
EC Machinery Directive .....	278	Turning .....	301
CE marking .....	279	Milling .....	305
<b>6.3 Production organization</b>		Indexable inserts .....	308
Overview; product breakdown structure .....	280	Cooling lubrication .....	311
Work planning .....	282	Cuttin tool materials .....	315
Cost accounting .....	286	Grinding, honing .....	317
		<b>6.6 Removal operations</b>	
		Electric discharge machining .....	323
		Process parameters in EDM erosion .....	324

<b>6.7 Separation by cutting</b>		<b>6.10 Joining</b>	
Cutting force .....	325	Welding processes .....	343
Cutting tool .....	326	Weld preparation .....	345
<b>6.8 Forming</b>		Gas-shielded welding .....	346
Bending .....	330	Arc welding .....	348
Deep drawing .....	334	Beam cutting .....	350
<b>6.9 Injection molding</b>		Gas cylinders, identification .....	352
Injection molding tools .....	338	Brazing, bonded joints .....	354
Shrinkage, cooling, batching .....	341	<b>6.11 Workplace and environmental protection</b>	
		Safety colors .....	359
		Warning signs, safety signs .....	360
		Sound and noise .....	366

## 7 Automation and Information Technology (A) 367

<b>7.1 Control engineering, basic terminology</b>		<b>7.5 Hydraulics, pneumatics</b>	
Basic terminology, code letters, symbols .....	368	Circuit symbols .....	393
Analog controllers .....	370	Proportional valves .....	395
Discontinuous and digital controllers .....	371	Circuit diagrams .....	396
Binary logic .....	372	Pneumatic control .....	397
Numbering systems .....	373	Electro-pneumatic control .....	398
Information processing .....	374	Electro-hydraulic control .....	399
<b>7.2 Electrical circuits</b>		Hydraulic fluids .....	400
Circuit symbols .....	375	Pneumatic cylinders .....	401
Designations in circuit plans .....	377	Hydraulic pumps .....	402
Circuit diagrams .....	378	Tubes .....	403
Sensors .....	379	<b>7.6 Handling and robot systems</b>	
Safety precautions .....	380	Coordinate systems and axes .....	404
<b>7.3 GRAFCET</b>		Robot designs .....	405
Important basic terms .....	382	Grippers, job safety .....	406
Steps, transitions .....	383	<b>7.7 CNC technology</b>	
Actions .....	384	Coordinate axes .....	407
Branchings .....	386	Program structure .....	408
<b>7.4 Programmable logical controllers PLC</b>		Tool offset and cutter compensation .....	409
PLC programming languages, overview ..	388	Program structure according to DIN .....	410
Ladder diagram (LD) .....	389	Program structure according to PAL .....	412
Instruction list (IL) .....	390	PAL functions for lathes .....	413
PLC programming languages, comparison .....	391	PAL cycles for lathes .....	414
Programming example .....	392	PAL functions for milling machines .....	417
		PAL cycles for milling machines .....	418

## 8 Material Chart, Standards (S) 425–434

<b>8.1 International material comparison chart</b> .....	425	<b>8.2 Index of cited standards and other regulations</b> .....	430
--	-----	---	-----

## Subject Index 435–444

## Standards and other Regulations

### Standardization and standards terms

Standardization is the systematic achievement of uniformity of material and non-material objects, such as components, calculation methods, process flows and services for the benefit of the general public.

Standards term	Example	Explanation
Standard	DIN 7157	A standard is the published work of standardization, e.g. the selection of particular fits in DIN 7157.
Part	DIN 30910-2	Standards can comprise several parts associated with each other. The part numbers are appended to the main standard number with hyphens. DIN 30910-2 describes sintered materials for filters for example, whereas Part 3 and 4 deal with sintered materials for bearings and formed parts.
Supplement	DIN 743 Suppl. 1	A supplement contains information for a standard, however no additional specifications. The supplement DIN 743 Suppl. 1, for example, contains application examples of load capacity calculations for shafts and axles described in DIN 743.
Draft	E DIN 743 (2008-10)	Draft standards are made available to the public for examination and commenting. The planned new version of DIN 743 on load-bearing calculations of shafts and axles, for example, has been published since October 2008 as Draft E DIN 743.
Preliminary standard	DIN V 66304 (1991-04)	A preliminary standard contains the results of standardization, which have not been released as a standard because of certain provisos. DIN V 66304, for example, discusses a format for exchange of standard part data for computer-aided design.
Issue date	DIN 76-1 (2004-06)	Date of publication which is made public in the DIN publication guide; this is the date at which time the standard becomes valid. DIN 76-1, which sets undercuts for metric ISO threads has been valid since June 2004 for example.

### Types of standards and regulations (selection)

Type	Abbreviation	Explanation	Purpose and contents
International Standards (ISO standards)	ISO	International Organization for Standardization, Geneva (O and S are reversed in the abbreviation)	Simplifies the international exchange of goods and services, as well as cooperation in scientific, technical and economic areas.
European Standards (EN standards)	EN	European Committee for Standardization (Comité Européen de Normalisation), Brussels	Technical harmonization and the associated reduction of trade barriers for the advancement of the European market and the coalescence of Europe.
German Standards (DIN standards)	DIN	Deutsches Institut für Normung e.V., Berlin (German Institute for Standardization)	National standardization facilitates rationalization, quality assurance, environmental protection and common understanding in economics, technology, science, management and public relations.
	DIN EN	European standard for which the German version has attained the status of a German standard.	
	DIN ISO	German standard for which an international standard has been adopted without change.	
	DIN EN ISO	European standard for which an international standard has been adopted unchanged and the German version has the status of a German standard.	
	DIN VDE	Printed publication of the VDE, which has the status of a German standard.	
VDI Guidelines	VDI	Verein Deutscher Ingenieure e.V., Düsseldorf (Association of German Engineers)	These guidelines give an account of the current state of the art in specific subject areas and contain, for example, concrete procedural guidelines for the performing calculations or designing processes in mechanical or electrical engineering.
VDE printed publications	VDE	Verband Deutscher Elektrotechniker e.V., Frankfurt (Association for Electrical, Electronic & Information Technologies)	
DGQ publications	DGQ	Deutsche Gesellschaft für Qualität e.V., Frankfurt (German Society for Quality)	Recommendations in the area of quality technology.
REFA sheets	REFA	Association for Work Design, Industrial Organization and Corporate Development REFA e.V., Darmstadt	Recommendations in the area of production and work planning.



# 1 Mathematics

M

Quantity	Symbol	Unit	
		Name	Symbol
Lengths	$l$	meter	m

**1.1 Units of measurement**  
 SI base quantities and base units . . . . . 10  
 Derived quantities and their units . . . . . 11  
 Non-SI units . . . . . 12

**Surface area**

$$A_s = \pi \cdot d \cdot h + 2 \cdot \frac{\pi \cdot d^2}{4}$$

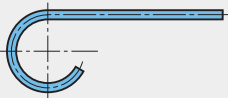
**Lateral surface area**

$$A_M = \pi \cdot d \cdot h$$

**1.2 Formulas**  
 Formula symbols, mathematical symbols . . . . . 13  
 Formulas, equations, graphs . . . . . 14  
 Transformation of formulas . . . . . 15  
 Quantities and units . . . . . 16  
 Calculation with quantities . . . . . 17  
 Percentage and interest calculation . . . . . 17

<b>sine</b>	=	$\frac{\text{opposite side}}{\text{hypotenuse}}$
<b>cosine</b>	=	$\frac{\text{adjacent side}}{\text{hypotenuse}}$
<b>tangent</b>	=	$\frac{\text{opposite side}}{\text{adjacent side}}$

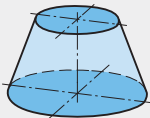
**1.3 Angels and triangel**  
 Types of angels, sum of angels in a triangle . . . . . 18  
 Theorem of intersecting lines . . . . . 18  
 Functions of right triangles . . . . . 19  
 Functions of oblique triangles . . . . . 19



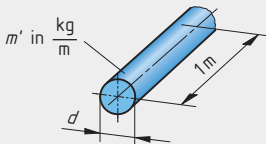
**1.4 Lengths**  
 Division of lengths . . . . . 20  
 Spring wire lengths . . . . . 21  
 Rough lengths . . . . . 21



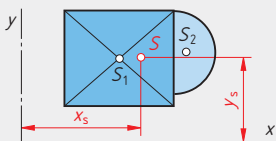
**1.5 Areas**  
 Angular areas . . . . . 22  
 Triangle, polygon, circle . . . . . 23  
 Circular sector, circular segment . . . . . 24  
 Ellipse . . . . . 24



**1.6 Volume and surface area**  
 Cube, cylinder, pyramid . . . . . 25  
 Truncated pyramid, cone, truncated cone, sphere . . . . . 26  
 Volumes of composite solids . . . . . 27



**1.7 Mass**  
 General calculations . . . . . 27  
 Linear mass density . . . . . 27  
 Area mass density . . . . . 27



**1.8 Centroids**  
 Centroids of lines . . . . . 28  
 Centroids of plane areas . . . . . 28

## Units of measurement

### SI<sup>1)</sup> Base quantities and base units

cf. DIN 1301-1 (2010-10), -2 (1978-02), -3 (1979-10)

Base quantity	Length	Mass	Time	Electric current	Thermo-dynamic temperature	Amount of substance	Luminous intensity
Base units	meter	kilo-gram	second	ampere	kelvin	mole	candela
Unit symbol	m	kg	s	A	K	mol	cd

<sup>1)</sup> The units for measurement are defined in the International System of Units SI (Système International d'Unités). It is based on the seven basic units (SI units), from which other units are derived.

### Base quantities, derived quantities and their units

Quantity	Symbol	Unit		Relationship	Remarks Examples of application
		Name	Symbol		
<b>Length, Area, Volume, Angle</b>					
Length	<i>l</i>	meter	m	1 m = 10 dm = 100 cm = 1000 mm 1 mm = 1000 μm 1 km = 1000 m	1 inch = 25.4 mm In aviation and nautical applications the following applies: 1 international nautical mile = 1852 m
Area	<i>A, S</i>	square meter are hectare	m <sup>2</sup> a ha	1 m <sup>2</sup> = 10 000 cm <sup>2</sup> = 1 000 000 mm <sup>2</sup> 1 a = 100 m <sup>2</sup> 1 ha = 100 a = 10 000 m <sup>2</sup> 100 ha = 1 km <sup>2</sup>	Symbol <i>S</i> only for cross-sectional areas Are and hectare only for land
Volume	<i>V</i>	cubic meter liter	m <sup>3</sup> l, L	1 m <sup>3</sup> = 1000 dm <sup>3</sup> = 1 000 000 cm <sup>3</sup> 1 l = 1 L = 1 dm <sup>3</sup> = 10 dl = 0.001 m <sup>3</sup> 1 ml = 1 cm <sup>3</sup>	Mostly for fluids and gases
Plane angle (angle)	<i>α, β, γ ...</i>	radian  degrees  minutes  seconds	rad  °  '  "	1 rad = 1 m/m = 57.2957...° = 180°/π 1° = $\frac{\pi}{180}$ rad = 60' 1' = 1°/60 = 60" 1" = 1'/60 = 1°/3600	1 rad is the angle formed by the intersection of a circle around the center of 1 m radius with an arc of 1 m length. In technical calculations instead of $\alpha = 33^\circ 17' 27.6''$ , better use is $\alpha = 33.291^\circ$ .
Solid angle	<i>Ω</i>	steradian	sr	1 sr = 1 m <sup>2</sup> /m <sup>2</sup>	An object whose extension measures 1 rad in one direction and perpendicularly to this also 1 rad, covers a solid angle of 1 sr.
<b>Mechanics</b>					
Mass	<i>m</i>	kilogram gram  megagram metric ton	kg g  Mg t	1 kg = 1000 g 1 g = 1000 mg  1 metric t = 1000 kg = 1 Mg 0.2 g = 1 ct	Mass in the sense of a scale result or a weight is a quantity of the type of mass (unit kg).  Mass for precious stones in carat (ct).
Linear mass density	<i>m'</i>	kilogram per meter	kg/m	1 kg/m = 1 g/mm	For calculating the mass of bars, profiles, pipes.
Area mass density	<i>m''</i>	kilogram per square meter	kg/m <sup>2</sup>	1 kg/m <sup>2</sup> = 0.1 g/cm <sup>2</sup>	To calculate the mass of sheet metal.
Density	<i>ρ</i>	kilogram per cubic meter	kg/m <sup>3</sup>	1000 kg/m <sup>3</sup> = 1 metric t/m <sup>3</sup> = 1 kg/dm <sup>3</sup> = 1 g/cm <sup>3</sup> = 1 g/ml = 1 mg/mm <sup>3</sup>	The density is a quantity independent of location.

## Units of measurement

## Quantities and Units (continued)

Quantity	Symbol	Unit		Relationship	Remarks Examples of application
		Name	Symbol		
<b>Mechanics</b>					
Moment of inertia, 2nd Moment of mass	$J$	kilogram x square meter	$\text{kg} \cdot \text{m}^2$	The following applies for a homogenous body: $J = \rho \cdot r^2 \cdot V$	The moment of inertia (2nd moment of mass) is dependent upon the total mass of the body as well as its form and the position of the axis of rotation.
Force	$F$	newton	N	$1 \text{ N} = 1 \frac{\text{kg} \cdot \text{m}}{\text{s}^2} = 1 \frac{\text{J}}{\text{m}}$	The force 1 N effects a change in velocity of 1 m/s in 1 s in a 1 kg mass.
Weight	$F_G, G$			$1 \text{ MN} = 10^3 \text{ kN} = 1\,000\,000 \text{ N}$	
Torque Bending mom. Torsional mom.	$M$ $M_b$ $T$	newton x meter	$\text{N} \cdot \text{m}$	$1 \text{ N} \cdot \text{m} = 1 \frac{\text{kg} \cdot \text{m}^2}{\text{s}^2}$	$1 \text{ N} \cdot \text{m}$ is the moment that a force of 1 N effects with a lever arm of 1 m.
Momentum	$p$	kilogram x meter per second	$\text{kg} \cdot \text{m/s}$	$1 \text{ kg} \cdot \text{m/s} = 1 \text{ N} \cdot \text{s}$	The momentum is the product of the mass times velocity. It has the direction of the velocity.
Pressure Mechanical stress	$p$ $\sigma, \tau$	pascal newton per square millimeter	Pa $\text{N/mm}^2$	$1 \text{ Pa} = 1 \text{ N/m}^2 = 0.01 \text{ mbar}$ $1 \text{ bar} = 100\,000 \text{ N/m}^2 = 10 \text{ N/cm}^2 = 10^5 \text{ Pa}$ $1 \text{ mbar} = 1 \text{ hPa}$ $1 \text{ N/mm}^2 = 10 \text{ bar} = 1 \text{ MN/m}^2 = 1 \text{ MPa}$ $1 \text{ daN/cm}^2 = 0.1 \text{ N/mm}^2$	Pressure refers to the force per unit area. For gage pressure the symbol $p_g$ is used (DIN 1314). $1 \text{ bar} = 14.5 \text{ psi}$ (pounds per square inch)
Second moment of area	$I$	meter to the fourth power centimeter to the fourth power	$\text{m}^4$ $\text{cm}^4$	$1 \text{ m}^4 = 100\,000\,000 \text{ cm}^4$	Previously: Geometrical moment of inertia
Energy, Work, Quantity of heat	$E, W$	joule	J	$1 \text{ J} = 1 \text{ N} \cdot \text{m} = 1 \text{ W} \cdot \text{s} = 1 \text{ kg} \cdot \text{m}^2/\text{s}^2$	Joule for all forms of energy, $\text{kW} \cdot \text{h}$ preferred for electrical energy.
Power Heat flux	$P$ $\Phi$	watt	W	$1 \text{ W} = 1 \text{ J/s} = 1 \text{ N} \cdot \text{m/s} = 1 \text{ V} \cdot \text{A} = 1 \text{ m}^2 \cdot \text{kg/s}^3$	Power describes the work which is achieved within a specific time.
<b>Time</b>					
Time, Time span, Duration	$t$	<b>seconds</b> minutes hours day year	s min h d a	$1 \text{ min} = 60 \text{ s}$ $1 \text{ h} = 60 \text{ min} = 3600 \text{ s}$ $1 \text{ d} = 24 \text{ h} = 86\,400 \text{ s}$	3 h means a time span (3 hrs.), $3^{\text{h}}$ means a point in time (3 o'clock). If points in time are written in mixed form, e.g. $3^{\text{h}}24^{\text{m}}10^{\text{s}}$ , the symbol min can be shortened to m.
Frequency	$f, \nu$	hertz	Hz	$1 \text{ Hz} = 1/\text{s}$	$1 \text{ Hz} \approx 1$ cycle in 1 second.
Rotational speed, Rotational frequency	$n$	1 per second 1 per minute	1/s 1/min	$1/\text{s} = 60/\text{min} = 60 \text{ min}^{-1}$ $1/\text{min} = 1 \text{ min}^{-1} = \frac{1}{60 \text{ s}}$	The number of revolutions per unit of time gives the revolution frequency, also called rpm.
Velocity	$v$	meters per second meters per minute kilometers per hour	m/s m/min km/h	$1 \text{ m/s} = 60 \text{ m/min} = 3.6 \text{ km/h}$ $1 \text{ m/min} = \frac{1 \text{ m}}{60 \text{ s}}$ $1 \text{ km/h} = \frac{1 \text{ m}}{3.6 \text{ s}}$	Nautical velocity in knots (kn): $1 \text{ kn} = 1.852 \text{ km/h}$ miles per hour = 1 mile/h = 1 mph $1 \text{ mph} = 1.60934 \text{ km/h}$
Angular-velocity	$\omega$	1 per second radians per second	1/s rad/s	$\omega = 2\pi \cdot n$	For a rpm of $n = 2/\text{s}$ the angular velocity $\omega = 4\pi/\text{s}$ .
Acceleration	$a, g$	meters per second squared	$\text{m/s}^2$	$1 \text{ m/s}^2 = \frac{1 \text{ m/s}}{1 \text{ s}}$	Symbol g only for acceleration due to gravity. $g = 9.81 \text{ m/s}^2 \approx 10 \text{ m/s}^2$

## Units of measurement

### Quantities and units (continued)

Quantity	Sym- bol	Unit Name	Sym- bol	Relationship	Remarks Examples of application
<b>Electricity and Magnetism</b>					
Electric current Electromotive force Electrical resistance Electrical conductance	$I$	<b>ampere</b>	A	$1 \text{ V} = 1 \text{ W}/1 \text{ A} = 1 \text{ J}/\text{C}$	The motion of an electrical charge is called current. The electromotive force is equal to the potential difference between two points in an electric field. The reciprocal of the electrical resistance is called the electrical conductivity.
	$E$	volt	V	$1 \Omega = 1 \text{ V}/1 \text{ A}$	
	$R$	ohm	$\Omega$	$1 \text{ S} = 1 \text{ A}/1 \text{ V} = 1/\Omega$	
Specific resistance Conductivity	$\rho$	ohm x meter	$\Omega \cdot \text{m}$	$10^{-6} \Omega \cdot \text{m} = 1 \Omega \cdot \text{mm}^2/\text{m}$	$\rho = \frac{1}{\kappa} \text{ in } \frac{\Omega \cdot \text{mm}^2}{\text{m}}$ $\kappa = \frac{1}{\rho} \text{ in } \frac{\text{m}}{\Omega \cdot \text{mm}^2}$
	$\gamma, \kappa$	siemens per meter	S/m		
Frequency	$f$	hertz	Hz	$1 \text{ Hz} = 1/\text{s}$ $1000 \text{ Hz} = 1 \text{ kHz}$	Frequency of public electric utility: EU 50 Hz, USA/Canada 60 Hz
Electrical energy	$W$	joule	J	$1 \text{ J} = 1 \text{ W} \cdot \text{s} = 1 \text{ N} \cdot \text{m}$ $1 \text{ kW} \cdot \text{h} = 3.6 \text{ MJ}$ $1 \text{ W} \cdot \text{h} = 3.6 \text{ kJ}$	In atomic and nuclear physics the unit eV (electron volt) is used.
Phase difference	$\varphi$	–	–	for alternating current: $\cos \varphi = \frac{P}{U \cdot I}$	The angle between current and voltage in inductive or capacitive load.
Elect. field strength Elect. charge Elect. capacitance inductance	$E$ $Q$ $C$ $L$	volts per meter coulomb farad henry	V/m C F H	$1 \text{ C} = 1 \text{ A} \cdot 1 \text{ s}; 1 \text{ A} \cdot \text{h} = 3.6 \text{ kC}$ $1 \text{ F} = 1 \text{ C}/\text{V}$ $1 \text{ H} = 1 \text{ V} \cdot \text{s}/\text{A}$	$E = \frac{F}{Q}, C = \frac{Q}{U}, Q = I \cdot t$
Power Effective power	$P$	watt	W	$1 \text{ W} = 1 \text{ J}/\text{s} = 1 \text{ N} \cdot \text{m}/\text{s}$ $= 1 \text{ V} \cdot \text{A}$	In electrical power engineering: Apparent power $S$ in $\text{V} \cdot \text{A}$
Quantity	Sym- bol	Unit Name	Sym- bol	Relationship	Remarks Examples of application
<b>Electricity and Magnetism</b>					
Thermo- dynamic temperature Celsius temperature	$T, \theta$	<b>kelvin</b>	K	$0 \text{ K} = -273.15 \text{ }^\circ\text{C}$	Kelvin (K) and degrees Celsius ( $^\circ\text{C}$ ) are used for temperatures and temperature differences. $t = T - T_0; T_0 = 273.15 \text{ K}$ degrees Fahrenheit ( $^\circ\text{F}$ ): $1.8 \text{ }^\circ\text{F} = 1 \text{ }^\circ\text{C}$
	$t, \vartheta$	degrees Celsius	$^\circ\text{C}$	$0 \text{ }^\circ\text{C} = 273.15 \text{ K}$ $0 \text{ }^\circ\text{C} = 32 \text{ }^\circ\text{F}$ $0 \text{ }^\circ\text{F} = -17.77 \text{ }^\circ\text{C}$	
Quantity of heat	$Q$	joule	J	$1 \text{ J} = 1 \text{ W} \cdot \text{s} = 1 \text{ N} \cdot \text{m}$ $1 \text{ kW} \cdot \text{h} = 3600000 \text{ J} = 3,6 \text{ MJ}$	$1 \text{ kcal} \approx 4.1868 \text{ kJ}$
Net calorific value	$H_u$	joule per kilogram Joule per cubic meter	J/kg J/m <sup>3</sup>	$1 \text{ MJ}/\text{kg} = 1000000 \text{ J}/\text{kg}$ $1 \text{ MJ}/\text{m}^3 = 1000000 \text{ J}/\text{m}^3$	Thermal energy released per kg fuel minus the heat of vaporization of the water vapor contained in the exhaust gases.
<b>Non-SI units</b>					
Length	Area	Volume	Mass	Energy, Power	
1 inch (in) = 25.4 mm	1 sq.in = 6.452 cm <sup>2</sup>	1 cu.in = 16.39 cm <sup>3</sup>	1 oz = 28.35 g	1 PSh = 0.735 kWh	
1 foot (ft) = 0.3048 m	1 sq.ft = 9.29 dm <sup>2</sup>	1 cu.ft = 28.32 dm <sup>3</sup>	1 lb = 453.6 g	1 PS = 735 W	
1 yard (yd) = 0.9144 m	1 sq.yd = 0.8361 m <sup>2</sup>	1 cu.yd = 764.6 dm <sup>3</sup>	1 t = 1000 kg	1 kcal = 4186.8 Ws	
1 nautical mile = 1.852 km	1 acre = 4046.856 m <sup>2</sup>	1 gallon (US) = 3.785 l	1 short ton = 907.2 kg	1 kcal = 1.166 Wh	
1 mile = 1.6093 km	<b>Pressure</b>	1 gallon (UK) = 4.546 l	1 Karat = 0.2 g	1 kpm/s = 9.807 W	
	1 bar = 14.5 pound/in <sup>2</sup>	1 barrel = 158.8 l	1 pound/in <sup>3</sup> = 27.68 g/cm <sup>3</sup>	1 Btu = 1055 Ws	
	1 N/mm <sup>2</sup> = 145.038 pound/in <sup>2</sup>			1 hp = 745.7 W	

## Formula symbols, Mathematical symbols

### Formula symbols

cf. DIN 1304-1 (1994-03)

Formula symbol	Meaning	Formula symbol	Meaning	Formula symbol	Meaning
<b>Length, Area, Volume, Angle</b>					
$l$	Length	$r, R$	Radius	$\alpha, \beta, \gamma$	Planar angle
$w$	Width	$d, D$	Diameter	$\Omega$	Solid angle
$h$	Height	$A, S$	Area, Cross-sectional area	$\lambda$	Wave length
$s$	Linear distance	$V$	Volume		
<b>Mechanics</b>					
$m$	Mass	$F$	Force	$G$	Shear modulus
$m'$	Linear mass density	$F_W, W$	Gravitational force, Weight	$\mu, f$	Coefficient of friction
$m''$	Area mass density	$M$	Torque	$W$	Section modulus
$\rho$	Density	$T$	Torsional moment	$I$	Second moment of an area
$J$	Moment of inertia	$M_b$	Bending moment	$W, E$	Work, Energy
$p$	Pressure	$\sigma$	Normal stress	$W_p, E_p$	Potential energy
$p_{abs}$	Absolute pressure	$\tau$	Shear stress	$W_k, E_k$	Kinetic energy
$p_{amb}$	Ambient pressure	$\varepsilon$	Normal strain	$P$	Power
$p_g$	Gage pressure	$E$	Modulus of elasticity	$\eta$	Efficiency
<b>Time</b>					
$t$	Time, Duration	$f, \nu$	Frequency	$a$	Acceleration
$T$	Cycle duration	$v, u$	Velocity	$g$	Gravitational acceleration
$n$	Revolution frequency, Speed	$\omega$	Angular velocity	$\alpha$	Angular acceleration
				$Q, V, q_v$	Volumetric flow rate
<b>Electricity</b>					
$Q$	Electric charge, Quantity of electricity	$L$	Inductance	$X$	Reactance
$E$	Electromotive force	$R$	Resistance	$Z$	Impedance
$C$	Capacitance	$\rho$	Specific resistance	$\varphi$	Phase difference
$I$	Electric current	$\gamma, \kappa$	Electrical conductivity	$N$	Number of turns
<b>Heat</b>					
$T, \Theta$	Thermodynamic temperature	$Q$	Heat, Quantity of heat	$\Phi, \dot{Q}$	Heat flow
$\Delta T, \Delta t, \Delta \delta$	Temperature difference	$\lambda$	Thermal conductivity	$a$	Thermal diffusivity
$t, \delta$	Celsius temperature	$\alpha$	Heat transition coefficient	$c$	Specific heat
$\alpha_1, \alpha$	Coefficient of linear expansion	$k$	Heat transmission coefficient	$H_{net}$	Net calorific value
<b>Light, Electromagnetic radiation</b>					
$E$	Illuminance	$f$	Focal length	$I$	Luminous intensity
		$n$	Refractive index	$Q, W$	Radiant energy
<b>Acoustics</b>					
$p$	Acoustic pressure	$L_p$	Acoustic pressure level	$N$	Loudness
$c$	Acoustic velocity	$I$	Sound intensity	$L_N$	Loudness level
<b>Mathematical symbols</b>					
cf. DIN 1302 (1999-12)					
Math. symbol	Spoken	Math. symbol	Spoken	Math. symbol	Spoken
$\approx$	approx. equals, around, about	$\sim$	proportional	$\log$	logarithm (general)
$\doteq$	equivalent to	$\sqrt{\quad}$	a to the n-th power, the n-th power of a	$\lg$	common logarithm
$\dots$	and so on, etc.	$\sqrt[n]{\quad}$	square root of	$\ln$	natural logarithm
$\infty$	infinity		n-th root of	$e$	Euler number (e = 2.718281...)
$=$	equal to	$ x $	absolute value of x	$\sin$	sine
$\neq$	not equal to	$\perp$	perpendicular to	$\cos$	cosine
$\stackrel{\text{def}}{=}$	is equal to by definition	$\parallel$	is parallel to	$\tan$	tangent
$<$	less than	$\uparrow \uparrow$	parallel in the same direction	$\cot$	cotangent
$\leq$	less than or equal to	$\uparrow \downarrow$	parallel in the opposite direction	$( ), [ ], \{ }$	parentheses, brackets open and closed
$>$	greater than	$\sphericalangle$	angle	$\pi$	pi (circle constant = 3.14159 ...)
$\geq$	greater than or equal to	$\triangle$	triangle		
$+$	plus	$\cong$	congruent to		
$-$	minus	$\Delta x$	delta x (difference between two values)	$\overline{AB}$	line segment AB
$\cdot$	times, multiplied by	$\%$	percent, of a hundred	$\overset{\frown}{AB}$	arc AB
$-, /, :, \div$	over, divided by, per, to	$\text{‰}$	per mil, of a thousand	$a', a''$	a prime, a double prime
$\Sigma$	sigma (summation)			$a_1, a_2$	a sub 1, a sub 2

# Formulas, Equations, Graphs

## Formulas

In most cases, the calculation of physical quantities is done with the help of formulas. They consist of:

- Formula symbols, e.g.  $v_c$  for cutting velocity,  $d$  for diameter,  $n$  for speed
- Operators (calculation rules), e.g.  $\cdot$  for multiplication,  $+$  for addition,  $-$  for subtraction and  $-$  (fraction line) for division
- Constants, e.g.  $\pi$  (pi) = 3.14159 ...
- Numbers, e.g. 10, 15 ...

The formula symbols (page 13) are wildcards for quantities. When solving mathematical problems, the known quantities with their units are filled in the formulas. Before or during the calculation process, the units are converted in a way that

- the calculation becomes feasible or
- the result comprises the required unit.

Most quantities and units are standardized (page 10).

The **result** is always a **numerical value** accompanied by a **unit**, e.g. 4.5 m, 15 s

### Example:

What is the cutting velocity  $v_c$  in m/min for  $d = 200$  mm and  $n = 630$ /min?

$$v_c = \pi \cdot d \cdot n = \pi \cdot 200 \text{ mm} \cdot 630 \frac{1}{\text{min}} = \pi \cdot 200 \text{ mm} \cdot \frac{1 \text{ m}}{1000 \text{ mm}} \cdot 630 \frac{1}{\text{min}} = 395.84 \frac{\text{m}}{\text{min}}$$

### Formula for cutting velocity

$$v_c = \pi \cdot d \cdot n$$

## Numerical value equations

Numerical value equations or numerical equations are formulas in which the typical conversions of units have already been integrated. The following should be noted when using equations:

The numerical values of the individual quantities may only be used in combination with the designated unit.

- The units are not carried along in the calculation.
- The unit of the quantity to be obtained is predetermined.

### Example:

What is the torque  $M$  of an electrical motor with a driving power of  $P = 15$  kW and a speed of  $n = 750$ /min?

$$M = \frac{9550 \cdot P}{n} = \frac{9550 \cdot 15}{750} \text{ N} \cdot \text{m} = 191 \text{ N} \cdot \text{m}$$

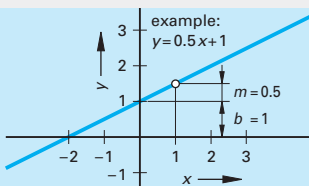
### Numerical value equation for torque

$$M = \frac{9550 \cdot P}{n}$$

Designated unit	
Designation	Unit
$M$	Torque N · m
$P$	Power kW
$n$	Speed 1/min

## Equations and graphs

In functional equations,  $y$  is the function of  $x$ , with  $x$  as an independent and  $y$  as a dependent variable. The number pairs  $(x, y)$  of a value table form a graph in the  $x$ - $y$  system of coordinates.



### 1<sup>st</sup> example:

$$y = 0.5x + 1$$

$x$	-2	0	2	3
$y$	0	1	2	2.5

### 2<sup>nd</sup> example:

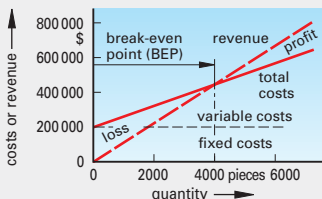
#### Cost function and revenue function

$$C_t = 60 \text{ \$/piece} \cdot Q + 200000 \text{ \$}$$

$$R = 110 \text{ \$/piece} \cdot Q$$

$Q$	0	4000	6000
$C_t$	200000	440000	560000
$R$	0	440000	660000

- $C_t$  total costs  $\rightarrow$  dependent variable
- $Q$  quantity  $\rightarrow$  independent variable
- $C_f$  fixed costs  $\rightarrow$  y coordinate section
- $C_v$  variable costs  $\rightarrow$  gradient of the function
- $R$  revenue  $\rightarrow$  dependent variable



### Assigned function

$$y = f(x)$$

### Linear function

$$y = m \cdot x + b$$

### Examples:

#### Cost function

$$C_t = C_v \cdot Q + C_f$$

#### Revenue function

$$R = R/\text{piece} \cdot Q$$

## Transformation of formulas

### Transformation of formulas

Formulas and numerical equations are transformed so that the quantity to be obtained stands alone on the left side of the equation. The value of the left side and right side of the formula must not change during the transformation. The following rule applies to all steps of the formula transformation.

Changes applied to the left formula side

= Changes applied to the right formula side

*Formula*

$$P = \frac{F \cdot s}{t}$$

left side of the formula	right side of the formula
--------------------------	---------------------------

To be able to trace each step of the transformation, it is useful to mark it to the right next to the formula:

$\cdot t$  → both sides of the formula are multiplied by  $t$ .

$: F$  → both sides of the formula are divided by  $F$ .

### Transformations of sums

**Example:** formula  $L = l_1 + l_2$ , transformation to find  $l_2$

$\boxed{1} L = l_1 + l_2$ $ -l_1$ subtract $l_1$	$\boxed{3} L - l_1 = l_2$ invert both sides
$\boxed{2} L - l_1 = l_1 + l_2 - l_1$ perform subtraction	$\boxed{4} l_2 = L - l_1$ transformed formula

### Transformations of products

**Example:** formula  $A = l \cdot b$ , transformation to find  $l$

$\boxed{1} A = l \cdot b$ $ \div b$ divide by $b$	$\boxed{3} \frac{A}{b} = l$ invert both sides
$\boxed{2} \frac{A}{b} = \frac{l \cdot b}{b}$ cancel $b$	$\boxed{4} l = \frac{A}{b}$ transformed formula

### Transformations of fractions

**Example:** formula  $n = \frac{l}{l_1 + s}$ , transformation to find  $s$

$\boxed{1} n = \frac{l}{l_1 + s}$ $ \cdot (l_1 + s)$ multiply by $(l_1 + s)$	$\boxed{4} n \cdot l_1 - n \cdot l_1 + n \cdot s = l - n \cdot l_1$ $ \div n$ subtract divide by $n$
$\boxed{2} n \cdot (l_1 + s) = \frac{l \cdot (l_1 + s)}{(l_1 + s)}$ cancel $(l_1 + s)$ on the right side solve the term in brackets	$\boxed{5} \frac{s \cdot n}{n} = \frac{l - n \cdot l_1}{n}$ cancel $n$
$\boxed{3} n \cdot l_1 + n \cdot s = l$ $ -n \cdot l_1$ subtract $-n \cdot l_1$	$\boxed{6} s = \frac{l - n \cdot l_1}{n}$ transformed formula

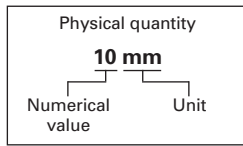
### Transformations of roots

**Example:** formula  $c = \sqrt{a^2 + b^2}$ , transformation to find  $a$

$\boxed{1} c = \sqrt{a^2 + b^2}$ $ \cdot ()^2$ square equation	$\boxed{4} a^2 = c^2 - b^2$ $ \sqrt{\quad}$ extract the root
$\boxed{2} c^2 = a^2 + b^2$ $ -b^2$ subtract $b^2$	$\boxed{5} \sqrt{a^2} = \sqrt{c^2 - b^2}$ simplify the expression
$\boxed{3} c^2 - b^2 = a^2 + b^2 - b^2$ subtract, invert both sides	$\boxed{6} a = \sqrt{c^2 - b^2}$ transformed formula

# Quantities and units

## Numerical values and units



Physical quantities, e.g. 125 mm, consist of a

- **numerical value**, which is determined by measurement or calculation, and a
- **unit**, e.g. m, kg

Units are standardized in accordance with DIN 1301-1 (page 10).

Very large or very small numerical values may be represented in a simplified way as decimal multiples or factors with the help of prefixes, e.g. 0.004 mm = 4  $\mu$ m.

## Decimal multiples or factors of units

cf. DIN 1301-1 (2004-10)

Symbol	Prefix Name	Power of ten	Mathematical designation	Examples
T	tera	$10^{12}$	trillion	12 000 000 000 000 N = $12 \cdot 10^{12}$ N = 12 TN (teranewtons)
G	giga	$10^9$	billion	45 000 000 000 W = $45 \cdot 10^9$ W = 45 GW (gigawatts)
M	mega	$10^6$	million	8 500 000 V = $8.5 \cdot 10^6$ V = 8.5 MV (megavolts)
k	kilo	$10^3$	thousand	12 600 W = $12.6 \cdot 10^3$ W = 12.6 kW (kilowatts)
h	hecto	$10^2$	hundred	500 l = $5 \cdot 10^2$ l = 5 hl (hectoliters)
da	deca	$10^1$	ten	32 m = $3.2 \cdot 10^1$ m = 3.2 dam (decameters)
–	–	$10^0$	one	1.5 m = $1.5 \cdot 10^0$ m
d	deci	$10^{-1}$	tenth	0.5 l = $5 \cdot 10^{-1}$ l = 5 dl (deciliters)
c	centi	$10^{-2}$	hundredth	0.25 m = $25 \cdot 10^{-2}$ m = 25 cm (centimeters)
m	milli	$10^{-3}$	thousandth	0.375 A = $375 \cdot 10^{-3}$ A = 375 mA (milliamperes)
$\mu$	micro	$10^{-6}$	millionth	0.000 052 m = $52 \cdot 10^{-6}$ m = 52 $\mu$ m (micrometers)
n	nano	$10^{-9}$	billionth	0.000 000 075 m = $75 \cdot 10^{-9}$ m = 75 nm (nanometers)
p	pico	$10^{-12}$	trillionth	0.000 000 000 006 F = $6 \cdot 10^{-12}$ F = 6 pF (picofarads)

## Conversion of units

Calculations with physical units are only possible if these units refer to the same base in this calculation. When solving mathematical problems, units often must be converted to basic units, e.g. mm to m, s to h,  $\text{mm}^2$  to  $\text{m}^2$ . This is done with the help of conversion factors that represent the value 1 (coherent units).

## Conversion factors for units (excerpt)

Quantity	Conversion factors, e.g.	Quantity	Conversion factors, e.g.
Length	$1 = \frac{10 \text{ mm}}{1 \text{ cm}} = \frac{1000 \text{ mm}}{1 \text{ m}} = \frac{1 \text{ m}}{1000 \text{ mm}} = \frac{1 \text{ km}}{1000 \text{ m}}$	Time	$1 = \frac{60 \text{ min}}{1 \text{ h}} = \frac{3600 \text{ s}}{1 \text{ h}} = \frac{60 \text{ s}}{1 \text{ min}} = \frac{1 \text{ min}}{60 \text{ s}}$
Area	$1 = \frac{100 \text{ mm}^2}{1 \text{ cm}^2} = \frac{100 \text{ cm}^2}{1 \text{ dm}^2} =$	Angle	$1 = \frac{60'}{1^\circ} = \frac{60''}{1'} = \frac{3600''}{1^\circ} = \frac{1^\circ}{60 \text{ s}}$
Volume	$1 = \frac{1000 \text{ mm}^3}{1 \text{ cm}^3} = \frac{1000 \text{ cm}^3}{1 \text{ dm}^3} =$	Inch	1 inch = 25.4 mm; 1 mm = $\frac{1}{25.4}$ inches

### 1<sup>st</sup> example:

Convert volume  $V = 3416 \text{ mm}^3$  to  $\text{cm}^3$ .

Volume  $V$  is multiplied by a conversion factor. Its numerator has the unit  $\text{cm}^3$  and its denominator the unit  $\text{mm}^3$ .

$$V = 3416 \text{ mm}^3 = \frac{1 \text{ cm}^3 \cdot 3416 \text{ mm}^3}{1000 \text{ mm}^3} = \frac{3416 \text{ cm}^3}{1000} = 3.416 \text{ cm}^3$$

### 2<sup>nd</sup> example:

The angle size specification  $\alpha = 42^\circ 16'$  is to be expressed in degrees ( $^\circ$ ).

The partial angle  $16'$  must be converted to degrees ( $^\circ$ ). The value is multiplied by a conversion factor, the numerator of which has the unit degree ( $^\circ$ ) and the denominator the unit minute ( $'$ ).

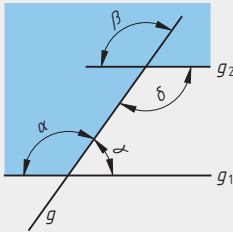
$$\alpha = 42^\circ + 16' \cdot \frac{1^\circ}{60'} = 42^\circ + \frac{16 \cdot 1^\circ}{60} = 42^\circ + 0.267^\circ = 42.267^\circ$$





Types of angles, Theorem of intersecting lines, Angles in a triangle, Pythagorean theorem

Types of angles



- $g$  straight line
- $g_1, g_2$  parallel straight lines
- $\alpha, \beta$  corresponding angles
- $\beta, \delta$  opposite angles
- $\alpha, \delta$  alternate angles
- $\alpha, \gamma$  adjacent angles

If two parallels are intersected by a straight line, there are geometrical interrelationships between the resulting angles.

Corresponding angles

$$\alpha = \beta$$

Opposite angles

$$\beta = \delta$$

Alternate angles

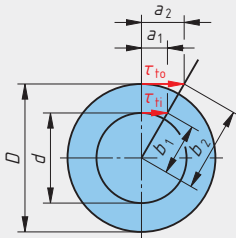
$$\alpha = \delta$$

Adjacent angles

$$\alpha + \gamma = 180^\circ$$

Theorem of intersecting lines

$\tau_{to}$  outer torsional stress  
 $\tau_{ti}$  inner torsional stress



If two intersecting lines are intercepted by a pair of parallels, the resulting segments form equal ratios.

Example:

$D = 40 \text{ mm}, d = 30 \text{ mm},$   
 $\tau_{ta} = 135 \text{ N/mm}^2; \tau_{ti} = ?$

$$\frac{\tau_{ti}}{\tau_{to}} = \frac{d}{D} \Rightarrow \tau_{ti} = \frac{\tau_{to} \cdot d}{D}$$

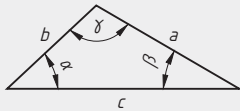
$$= \frac{135 \text{ N/mm}^2 \cdot 30 \text{ mm}}{40 \text{ mm}} = 101.25 \text{ N/mm}^2$$

Theorem of intersecting lines

$$\frac{a_1}{a_2} = \frac{b_1}{b_2} = \frac{d}{D}$$

$$\frac{a_1}{b_1} = \frac{a_2}{b_2} \quad \frac{b_1}{d} = \frac{b_2}{D}$$

Sum of angles in a triangle



- $a, b, c$  sides of the triangle
- $\alpha, \beta, \gamma$  angles in the triangle

Example:

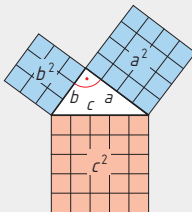
$\alpha = 21^\circ, \beta = 95^\circ, \gamma = ?$   
 $\gamma = 180^\circ - \alpha - \beta = 180^\circ - 21^\circ - 95^\circ = 64^\circ$

Sum of angles in a triangle

$$\alpha + \beta + \gamma = 180^\circ$$

In every triangle, the sum of the interior angles equals  $180^\circ$ .

Pythagorean theorem



In a **right triangle** the square on the hypotenuse is equal to the sum of the squares on the sides meeting the right angle.

- $a$  side
- $b$  side
- $c$  hypotenuse

1<sup>st</sup> example:

$c = 35 \text{ mm}; a = 21 \text{ mm}; b = ?$   
 $b = \sqrt{c^2 - a^2} = \sqrt{(35 \text{ mm})^2 - (21 \text{ mm})^2} = 28 \text{ mm}$

2<sup>nd</sup> example:

CNC programm with  $R = 50 \text{ mm}$  and  $I = 25 \text{ mm}$ .  
 $K = ?$   
 $c^2 = a^2 + b^2$   
 $R^2 = I^2 + K^2$   
 $K = \sqrt{R^2 - I^2} = \sqrt{50^2 \text{ mm}^2 - 25^2 \text{ mm}^2}$   
 $K = 43.3 \text{ mm}$

Length of the hypotenuse

$$c^2 = a^2 + b^2$$

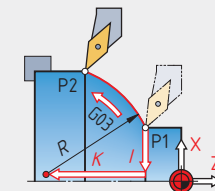
Square on the hypotenuse

$$c = \sqrt{a^2 + b^2}$$

Length of the sides meeting the right angle

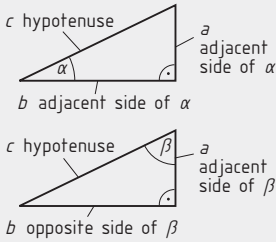
$$a = \sqrt{c^2 - b^2}$$

$$b = \sqrt{c^2 - a^2}$$



# Functions of triangles

## Functions of right triangles (trigonometric functions)



$c$  hypotenuse (longest side)  
 $a, b$  sides,  
 -  $b$  is the adjacent side of  $\alpha$   
 -  $a$  is the opposite side of  $\alpha$   
 $\alpha, \beta, \gamma$  angles in the triangle,  $\gamma = 90^\circ$   
 $\sin$  notation of sine  
 $\cos$  notation of cosine  
 $\tan$  notation of tangent  
 $\sin \alpha$  sine of angle  $\alpha$

### Trigonometric functions

<b>sine</b>	=	<b>opposite side</b>	<b>hypotenuse</b>
<b>cosine</b>	=	<b>adjacent side</b>	<b>hypotenuse</b>
<b>tangent</b>	=	<b>opposite side</b>	<b>adjacent side</b>

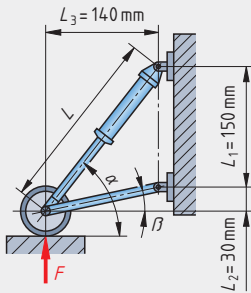
Relations applying to angle  $\alpha$ :

$\sin \alpha = \frac{a}{c}$	$\cos \alpha = \frac{b}{c}$	$\tan \alpha = \frac{a}{b}$
-----------------------------	-----------------------------	-----------------------------

Relations applying to angle  $\beta$ :

$\sin \beta = \frac{b}{c}$	$\cos \beta = \frac{a}{c}$	$\tan \beta = \frac{b}{a}$
----------------------------	----------------------------	----------------------------

The calculation of an angle in degrees ( $^\circ$ ) or as a circular measure (rad) is done with the help of inverse trigonometric functions, e. g. arcsine.



### 1<sup>st</sup> example

$L_1 = 150 \text{ mm}$ ,  $L_2 = 30 \text{ mm}$ ,  $L_3 = 140 \text{ mm}$ ;  
 angle  $\alpha = ?$

$$\tan \alpha = \frac{L_1 + L_2}{L_3} = \frac{180 \text{ mm}}{140 \text{ mm}} = 1.286$$

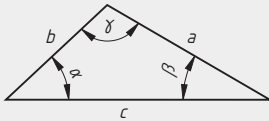
**Angle  $\alpha = 52^\circ$**

### 2<sup>nd</sup> example

$L_1 = 150 \text{ mm}$ ,  $L_2 = 30 \text{ mm}$ ,  $\alpha = 52^\circ$ ;  
 Length of the shock absorber  $L = ?$

$$L = \frac{L_1 + L_2}{\sin \alpha} = \frac{180 \text{ mm}}{\sin 52^\circ} = \mathbf{228.42 \text{ mm}}$$

## Functions of oblique triangles (law of sines, law of cosines)



According to the law of sines, the ratios of the sides correspond to the sine of their opposite angles in the triangle. If one side and two angles are known, the other values can be calculated with the help of this function.

Side  $a \rightarrow$  opposite angle  $\sin \alpha$   
 Side  $b \rightarrow$  opposite angle  $\sin \beta$   
 Hypotenuse  $c \rightarrow$  opposite angle  $\sin \gamma$

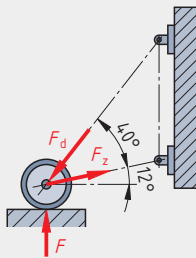
### Law of sines

$$a : b : c = \sin \alpha : \sin \beta : \sin \gamma$$

$$\frac{a}{\sin \alpha} = \frac{b}{\sin \beta} = \frac{c}{\sin \gamma}$$

There are many transformation options:

$a = \frac{b \cdot \sin \alpha}{\sin \beta} = \frac{c \cdot \sin \alpha}{\sin \gamma}$
$b = \frac{a \cdot \sin \beta}{\sin \alpha} = \frac{c \cdot \sin \beta}{\sin \gamma}$
$c = \frac{a \cdot \sin \gamma}{\sin \alpha} = \frac{b \cdot \sin \gamma}{\sin \beta}$



### Example:

$F = 800 \text{ N}$ ,  $\alpha = 40^\circ$ ,  $\beta = 38^\circ$ ;  $F_z = ?$ ,  $F_d = ?$

The forces are calculated with the help of the forces diagram.

$$\frac{F}{\sin \alpha} = \frac{F_z}{\sin \beta} \Rightarrow F_z = \frac{F \cdot \sin \beta}{\sin \alpha}$$

$$F_z = \frac{800 \text{ N} \cdot \sin 38^\circ}{\sin 40^\circ} = \mathbf{766.24 \text{ N}}$$

$$\frac{F}{\sin \alpha} = \frac{F_d}{\sin \gamma} \Rightarrow F_d = \frac{F \cdot \sin \gamma}{\sin \alpha}$$

$$F_d = \frac{800 \text{ N} \cdot \sin 102^\circ}{\sin 40^\circ} = \mathbf{1217.38 \text{ N}}$$

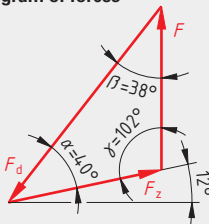
### Law of cosines

$$a^2 = b^2 + c^2 - 2 \cdot b \cdot c \cdot \cos \alpha$$

$$b^2 = a^2 + c^2 - 2 \cdot a \cdot c \cdot \cos \beta$$

$$c^2 = a^2 + b^2 - 2 \cdot a \cdot b \cdot \cos \gamma$$

Diagram of forces



The calculation of an angle in degrees ( $^\circ$ ) or as a circular measure (rad) is done with the help of inverse trigonometric functions, e. g. arcsine.

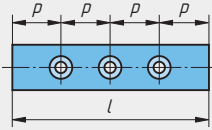
Transformation, e. g.

$$\cos \alpha = \frac{b^2 + c^2 - a^2}{2 \cdot b \cdot c}$$

## Division of lengths, Arc length, Composite length

### Sub-dividing lengths

**Edge distance = spacing**



$l$  total length       $n$  number of holes  
 $p$  spacing

**Spacing**

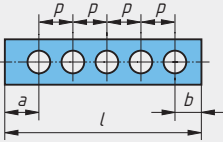
$$p = \frac{l}{n+1}$$

**Example:**

$l = 2 \text{ m}; n = 24 \text{ holes}; p = ?$

$$p = \frac{l}{n+1} = \frac{2000 \text{ mm}}{24+1} = 80 \text{ mm}$$

**Edge distance  $\neq$  spacing**



$l$  total length       $n$  number of holes  
 $p$  spacing       $a, b$  edge distances

**Spacing**

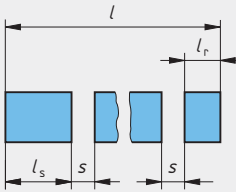
$$p = \frac{l - (a + b)}{n - 1}$$

**Example:**

$l = 1950 \text{ mm}; a = 100 \text{ mm}; b = 50 \text{ mm};$   
 $n = 25 \text{ holes}; p = ?$

$$p = \frac{l - (a + b)}{n - 1} = \frac{1950 \text{ mm} - 150 \text{ mm}}{25 - 1} = 75 \text{ mm}$$

**Subdividing into pieces**



$l$  bar length       $s$  saw cutting width  
 $z$  number of pieces       $l_r$  remaining length  
 $l_s$  piece length

**Number of pieces**

$$z = \frac{l}{l_s + s}$$

**Example:**

$l = 6000 \text{ mm}; l_s = 230 \text{ mm}; s = 1.2 \text{ mm}; z = ?; l_r = ?$

$$z = \frac{l}{l_s + s} = \frac{6000 \text{ mm}}{230 \text{ mm} + 1.2 \text{ mm}} = 25.95 = 25 \text{ pieces}$$

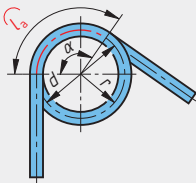
**Remaining length**

$$l_r = l - z \cdot (l_s + s)$$

$$l_r = l - z \cdot (l_s + s) = 6000 \text{ mm} - 25 \cdot (230 \text{ mm} + 1.2 \text{ mm}) = 220 \text{ mm}$$

### Arc length

**Example: Torsion spring**



$l_a$  arc length       $\alpha$  angle at center  
 $r$  radius       $d$  diameter

**Arc length**

$$l_a = \frac{\pi \cdot r \cdot \alpha}{180^\circ}$$

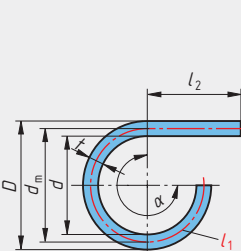
**Example:**

$r = 36 \text{ mm}; \alpha = 120^\circ; l_a = ?$

$$l_a = \frac{\pi \cdot r \cdot \alpha}{180^\circ} = \frac{\pi \cdot 36 \text{ mm} \cdot 120^\circ}{180^\circ} = 75.36 \text{ mm}$$

$$l_a = \frac{\pi \cdot d \cdot \alpha}{360^\circ}$$

### Composite length



$D$  outside diameter       $d$  inside diameter  
 $d_m$  mean diameter       $t$  thickness  
 $l_1, l_2$  section lengths       $L$  composite length  
 $\alpha$  angle at center

**Example (composite length, picture left):**

$D = 360 \text{ mm}; t = 5 \text{ mm}; \alpha = 270^\circ; l_2 = 70 \text{ mm};$   
 $d_m = ?; L = ?$

$$d_m = D - t = 360 \text{ mm} - 5 \text{ mm} = 355 \text{ mm}$$

$$L = l_1 + l_2 = \frac{\pi \cdot d_m \cdot \alpha}{360} + l_2$$

$$= \frac{\pi \cdot 355 \text{ mm} \cdot 270^\circ}{360^\circ} + 70 \text{ mm} = 906.45 \text{ mm}$$

**Composite length**

$$L = l_1 + l_2 + \dots$$