

РЕКОМЕНДУЕМЫЕ РЕЖИМЫ ОБРАБОТКИ



Vc = м/мин.
fz = мм/зуб
RPM = об/мин.
FEED = мм/мин.

G9165 СЕРИЯ			2 ЗУБА - ОБРАБОТКА ПАЗОВ													
			RPM = об./мин. FEED = мм/мин.													
ISO	VDI 3323	Материал	Ae (мм)	Ap (мм)	Параметр	Диаметр (Ø)										
						2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0	14.0	16.0	20.0
P	1-4	Нелегированная сталь	1.0D	0.5D (Up to Ø3 : 0.2D)	Vc	52	60	68	71	75	75	72	74	79	80	75
					fz	0.005	0.007	0.013	0.016	0.020	0.029	0.032	0.032	0.032	0.031	0.033
					RPM	8,250	6,400	5,400	4,500	4,000	3,000	2,300	1,950	1,800	1,600	1,200
					FEED	85	95	135	140	160	175	145	125	115	100	80
	5		1.0D	0.5D (Up to Ø3 : 0.2D)	Vc	34	38	41	42	45	45	44	45	48	50	47
					fz	0.005	0.008	0.012	0.016	0.021	0.025	0.025	0.025	0.025	0.023	0.023
					RPM	5,400	4,000	3,300	2,700	2,400	1,800	1,400	1,200	1,100	1,000	750
					FEED	55	65	80	85	100	90	70	60	55	45	35
	6-7	Низколегирован. сталь	1.0D	0.5D (Up to Ø3 : 0.2D)	Vc	52	60	68	71	75	75	72	74	79	80	75
					fz	0.005	0.007	0.013	0.016	0.020	0.029	0.032	0.032	0.032	0.031	0.033
					RPM	8,250	6,400	5,400	4,500	4,000	3,000	2,300	1,950	1,800	1,600	1,200
					FEED	85	95	135	140	160	175	145	125	115	100	80
	8-9		1.0D	0.5D (Up to Ø3 : 0.2D)	Vc	34	38	41	42	45	45	44	45	48	50	47
					fz	0.005	0.008	0.012	0.016	0.021	0.025	0.025	0.025	0.025	0.023	0.023
					RPM	5,400	4,000	3,300	2,700	2,400	1,800	1,400	1,200	1,100	1,000	750
					FEED	55	65	80	85	100	90	70	60	55	45	35
	10	Высоколегир. сталь	1.0D	0.5D (Up to Ø3 : 0.2D)	Vc	52	60	68	71	75	75	72	74	79	80	75
					fz	0.005	0.007	0.013	0.016	0.020	0.029	0.032	0.032	0.032	0.031	0.033
					RPM	8,250	6,400	5,400	4,500	4,000	3,000	2,300	1,950	1,800	1,600	1,200
					FEED	85	95	135	140	160	175	145	125	115	100	80
	11.1 11.2		1.0D	0.5D (Up to Ø3 : 0.2D)	Vc	34	38	41	42	45	45	44	45	48	50	47
					fz	0.005	0.008	0.012	0.016	0.021	0.025	0.025	0.025	0.025	0.023	0.023
					RPM	5,400	4,000	3,300	2,700	2,400	1,800	1,400	1,200	1,100	1,000	750
					FEED	55	65	80	85	100	90	70	60	55	45	35
M	14.1	Нержавеющая сталь	1.0D	0.5D (Up to Ø3 : 0.2D)	Vc	28	31	35	35	39	38	38	38	40	38	38
K	15-20	Серый чугун Высокопрочный чугун Ковкий чугун	1.0D	1.0D	fz	0.004	0.008	0.013	0.016	0.020	0.027	0.029	0.030	0.031	0.030	0.029
					RPM	4,500	3,300	2,800	2,250	2,050	1,500	1,200	1,000	900	750	600
					FEED	40	55	70	70	80	80	70	60	55	45	35
					Vc	62	60	61	60	58	58	61	57	59	58	60
H	38.1 - 40	Закаленная сталь Отбелен. чугун	1.0D	0.5D (Up to Ø3 : 0.2D)	fz	0.006	0.009	0.012	0.015	0.021	0.030	0.037	0.050	0.061	0.074	0.095
					RPM	9,800	6,350	4,850	3,850	3,100	2,300	1,950	1,500	1,350	1,150	950
					FEED	115	115	115	115	130	140	145	150	165	170	180
					Vc	34	38	41	42	45	45	44	45	48	50	47
H			1.0D	0.5D (Up to Ø3 : 0.2D)	fz	0.005	0.008	0.012	0.016	0.021	0.025	0.025	0.025	0.025	0.023	0.023
					RPM	5,400	4,000	3,300	2,700	2,400	1,800	1,400	1,200	1,100	1,000	750
					FEED	55	65	80	85	100	90	70	60	55	45	35
					Vc	34	38	41	42	45	45	44	45	48	50	47

