

РЕКОМЕНДУЕМЫЕ РЕЖИМЫ ОБРАБОТКИ

GM886 СЕРИЯ

С 2 ЗУБЬЯМИ, СФЕРИЧЕСКИЕ - ОБРАБОТКА РЕБЕР

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

ISO	VDI 3323	Материал	Параметр	Диаметр (Ø)					
				0.5	0.6	0.8	1.0	1.2	1.4
P	1-4	Нелегирован. сталь	Vc	49~63	58~75	78~101	91~115	90~115	92~114
			fz	0.003~0.006	0.004~0.008	0.004~0.008	0.004~0.010	0.005~0.013	0.006~0.015
			RPM	32550~42000	32550~42000	32550~42000	30450~38330	25200~32030	22050~27300
			FEED	185~515	235~660	235~660	265~735	265~820	265~820
			Ap	0.023~0.045	0.027~0.054	0.036~0.072	0.045~0.090	0.055~0.100	0.062~0.125
			Vc	35~45	42~54	57~72	64~82	64~81	66~79
	5	Низколегир. сталь	Vc	49~63	58~75	78~101	91~115	90~115	92~114
			fz	0.003~0.006	0.004~0.008	0.004~0.008	0.004~0.010	0.005~0.013	0.006~0.015
			RPM	32550~42000	32550~42000	32550~42000	30450~38330	25200~32030	22050~27300
			FEED	185~515	235~660	235~660	265~735	265~820	265~820
			Ap	0.023~0.045	0.027~0.054	0.036~0.072	0.045~0.090	0.055~0.100	0.062~0.125
			Vc	35~45	42~54	57~72	64~82	64~81	66~79
6-7	Низколегир. сталь	Vc	49~63	58~75	78~101	91~115	90~115	92~114	
		fz	0.003~0.006	0.004~0.008	0.004~0.008	0.004~0.010	0.005~0.013	0.006~0.015	
		RPM	32550~42000	32550~42000	32550~42000	30450~38330	25200~32030	22050~27300	
		FEED	185~515	235~660	235~660	265~735	265~820	265~820	
		Ap	0.023~0.045	0.027~0.054	0.036~0.072	0.045~0.090	0.055~0.100	0.062~0.125	
		Vc	35~45	42~54	57~72	64~82	64~81	66~79	
8-9	Низколегир. сталь	Vc	49~63	58~75	78~101	91~115	90~115	92~114	
		fz	0.003~0.006	0.004~0.008	0.004~0.008	0.004~0.010	0.005~0.013	0.006~0.015	
		RPM	32550~42000	32550~42000	32550~42000	30450~38330	25200~32030	22050~27300	
		FEED	185~515	235~660	235~660	265~735	265~820	265~820	
		Ap	0.023~0.045	0.027~0.054	0.036~0.072	0.045~0.090	0.055~0.100	0.062~0.125	
		Vc	35~45	42~54	57~72	64~82	64~81	66~79	
10	Высоколегир. сталь	Vc	49~63	58~75	78~101	91~115	90~115	92~114	
		fz	0.003~0.006	0.004~0.008	0.004~0.008	0.004~0.010	0.005~0.013	0.006~0.015	
		RPM	32550~42000	32550~42000	32550~42000	30450~38330	25200~32030	22050~27300	
		FEED	185~515	235~660	235~660	265~735	265~820	265~820	
		Ap	0.023~0.045	0.027~0.054	0.036~0.072	0.045~0.090	0.055~0.100	0.062~0.125	
		Vc	35~45	42~54	57~72	64~82	64~81	66~79	
11.1 - 11.2	Высоколегир. сталь	Vc	49~63	58~75	78~101	91~115	90~115	92~114	
		fz	0.003~0.006	0.004~0.008	0.004~0.008	0.004~0.010	0.005~0.013	0.006~0.015	
		RPM	32550~42000	32550~42000	32550~42000	30450~38330	25200~32030	22050~27300	
		FEED	185~515	235~660	235~660	265~735	265~820	265~820	
		Ap	0.023~0.045	0.027~0.054	0.036~0.072	0.045~0.090	0.055~0.100	0.062~0.125	
		Vc	35~45	42~54	57~72	64~82	64~81	66~79	
K	15-20	Серый чугу Высокопрочный чугу Ковкий чугу	Vc	49~63	58~75	78~101	91~115	90~115	92~114
			fz	0.003~0.006	0.004~0.008	0.004~0.008	0.004~0.010	0.005~0.013	0.006~0.015
			RPM	32550~42000	32550~42000	32550~42000	30450~38330	25200~32030	22050~27300
			FEED	185~515	235~660	235~660	265~735	265~820	265~820
			Ap	0.023~0.045	0.027~0.054	0.036~0.072	0.045~0.090	0.055~0.100	0.062~0.125
			Vc	35~45	42~54	57~72	64~82	64~81	66~79
H	38.1 - 38.2	Закаленная сталь	Vc	22~28	27~34	36~45	41~51	41~52	41~51
			fz	0.003~0.005	0.004~0.006	0.004~0.006	0.005~0.008	0.006~0.009	0.007~0.011
			RPM	15020~18900	15020~18900	15020~18900	13650~17120	11340~14390	9870~12290
			FEED	90~185	115~235	115~235	130~265	130~265	130~265
			Ap	0.005~0.009	0.005~0.011	0.007~0.014	0.009~0.018	0.010~0.022	0.012~0.025
			Vc	35~45	42~54	57~72	64~82	64~81	66~79
	40	Отбелен. чугу	Vc	22~28	27~34	36~45	41~51	41~52	41~51
			fz	0.003~0.005	0.004~0.006	0.004~0.006	0.005~0.008	0.006~0.009	0.007~0.011
			RPM	15020~18900	15020~18900	15020~18900	13650~17120	11340~14390	9870~12290
			FEED	90~185	115~235	115~235	130~265	130~265	130~265
			Ap	0.005~0.009	0.005~0.011	0.007~0.014	0.009~0.018	0.010~0.022	0.012~0.025
			Vc	35~45	42~54	57~72	64~82	64~81	66~79
41	Закален. чугу	Vc	22~28	27~34	36~45	41~51	41~52	41~51	
		fz	0.003~0.005	0.004~0.006	0.004~0.006	0.005~0.008	0.006~0.009	0.007~0.011	
		RPM	15020~18900	15020~18900	15020~18900	13650~17120	11340~14390	9870~12290	
		FEED	90~185	115~235	115~235	130~265	130~265	130~265	
		Ap	0.005~0.009	0.005~0.011	0.007~0.014	0.009~0.018	0.010~0.022	0.012~0.025	
		Vc	35~45	42~54	57~72	64~82	64~81	66~79	

▶ ДАЛЕЕ

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С 2 ЗУБЬЯМИ, СФЕРИЧЕСКИЕ - ОБРАБОТКА РЕБЕР

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fz = мм/зуб
RPM = об./мин.
FEED = мм/мин.
Ap = мм

VDI 3323		Материал	Параметр	Диаметр (Ø)							
				1.5	1.6	1.8	2.0	3.0	4.0	5.0	6.0
P	1-4	Нелегирован. сталь	Vc	90~113	90~118	96~122	97~119	99~123	107~138	107~138	107~138
			fz	0.007~0.016	0.007~0.017	0.007~0.018	0.008~0.021	0.012~0.030	0.015~0.035	0.018~0.044	0.022~0.053
			RPM	19950~25200	18900~24680	17850~22580	16280~19950	11030~13650	8930~11550	7140~9240	5990~7670
			FEED	265~820	265~820	265~820	265~820	265~820	265~820	265~820	265~820
			Ap	0.070~0.135	0.075~0.145	0.080~0.160	0.090~0.180	0.135~0.270	0.180~0.360	0.225~0.450	0.270~0.540
			Vc	64~82	66~83	68~85	69~85	66~85	73~98	72~97	74~98
	5	Низколегир. сталь	Vc	90~113	90~118	96~122	97~119	99~123	107~138	107~138	107~138
			fz	0.007~0.016	0.007~0.017	0.007~0.018	0.008~0.021	0.012~0.030	0.015~0.035	0.018~0.044	0.022~0.053
			RPM	19950~25200	18900~24680	17850~22580	16280~19950	11030~13650	8930~11550	7140~9240	5990~7670
			FEED	265~820	265~820	265~820	265~820	265~820	265~820	265~820	265~820
			Ap	0.070~0.135	0.075~0.145	0.080~0.160	0.090~0.180	0.135~0.270	0.180~0.360	0.225~0.450	0.270~0.540
			Vc	64~82	66~83	68~85	69~85	66~85	73~98	72~97	74~98
6-7	Низколегир. сталь	Vc	90~113	90~118	96~122	97~119	99~123	107~138	107~138	107~138	
		fz	0.007~0.016	0.007~0.017	0.007~0.018	0.008~0.021	0.012~0.030	0.015~0.035	0.018~0.044	0.022~0.053	
		RPM	19950~25200	18900~24680	17850~22580	16280~19950	11030~13650	8930~11550	7140~9240	5990~7670	
		FEED	265~820	265~820	265~820	265~820	265~820	265~820	265~820	265~820	
		Ap	0.070~0.135	0.075~0.145	0.080~0.160	0.090~0.180	0.135~0.270	0.180~0.360	0.225~0.450	0.270~0.540	
		Vc	64~82	66~83	68~85	69~85	66~85	73~98	72~97	74~98	
8-9	Низколегир. сталь	Vc	90~113	90~118	96~122	97~119	99~123	107~138	107~138	107~138	
		fz	0.007~0.016	0.007~0.017	0.007~0.018	0.008~0.021	0.012~0.030	0.015~0.035	0.018~0.044	0.022~0.053	
		RPM	19950~25200	18900~24680	17850~22580	16280~19950	11030~13650	8930~11550	7140~9240	5990~7670	
		FEED	265~820	265~820	265~820	265~820	265~820	265~820	265~820	265~820	
		Ap	0.070~0.135	0.075~0.145	0.080~0.160	0.090~0.180	0.135~0.270	0.180~0.360	0.225~0.450	0.270~0.540	
		Vc	64~82	66~83	68~85	69~85	66~85	73~98	72~97	74~98	
10	Высоколегир. сталь	Vc	90~113	90~118	96~122	97~119	99~123	107~138	107~138	107~138	
		fz	0.007~0.016	0.007~0.017	0.007~0.018	0.008~0.021	0.012~0.030	0.015~0.035	0.018~0.044	0.022~0.053	
		RPM	19950~25200	18900~24680	17850~22580	16280~19950	11030~13650	8930~11550	7140~9240	5990~7670	
		FEED	265~820	265~820	265~820	265~820	265~820	265~820	265~820	265~820	
		Ap	0.070~0.135	0.075~0.145	0.080~0.160	0.090~0.180	0.135~0.270	0.180~0.360	0.225~0.450	0.270~0.540	
		Vc	64~82	66~83	68~85	69~85	66~85	73~98	72~97	74~98	
11.1 - 11.2	Высоколегир. сталь	Vc	90~113	90~118	96~122	97~119	99~123	107~138	107~138	107~138	
		fz	0.007~0.016	0.007~0.017	0.007~0.018	0.008~0.021	0.012~0.030	0.015~0.035	0.018~0.044	0.022~0.053	
		RPM	19950~25200	18900~24680	17850~22580	16280~19950	11030~13650	8930~11550	7140~9240	5990~7670	
		FEED	265~820	265~820	265~820	265~820	265~820	265~820	265~820	265~820	
		Ap	0.070~0.135	0.075~0.145	0.080~0.160	0.090~0.180	0.135~0.270	0.180~0.360	0.225~0.450	0.270~0.540	
		Vc	64~82	66~83	68~85	69~85	66~85	73~98	72~97	74~98	
K	15-20	Серый чугу Высокопрочный чугу Ковкий чугу	Vc	90~113	90~118	96~122	97~119	99~123	107~138	107~138	107~138
			fz	0.007~0.016	0.007~0.017	0.007~0.018	0.008~0.021	0.012~0.030			