

РЕКОМЕНДУЕМЫЕ РЕЖИМЫ ОБРАБОТКИ

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

GMJ27 СЕРИЯ		4 ЗУБА - БОКОВОЕ ФРЕЗЕРОВАНИЕ				Диаметр (Ø)										
ISO	VDI 3323	Материал	Ae (мм)	Ap (мм)	Параметр	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	0.1D	1.0D	Vc	72	83	94	97	104	103	101	102	108	108	107
					fz	0.003	0.005	0.009	0.012	0.015	0.021	0.023	0.022	0.024	0.024	
					RPM	11,400	8,800	7,450	6,200	5,500	4,100	3,200	2,700	2,450	2,150	1,700
	5	0.1D	1.0D	Vc	47	52	57	58	62	63	61	64	66	68	66	
				fz	0.003	0.005	0.010	0.012	0.016	0.019	0.019	0.018	0.018	0.019	0.018	
				RPM	7,450	5,500	4,550	3,700	3,300	2,500	1,950	1,700	1,500	1,350	1,050	
	6-7	Низколегирован. сталь	0.1D	1.0D	Vc	72	83	94	97	104	103	101	102	108	108	107
					fz	0.003	0.005	0.009	0.012	0.015	0.021	0.023	0.022	0.024	0.024	
					RPM	11,400	8,800	7,450	6,200	5,500	4,100	3,200	2,700	2,450	2,150	1,700
	8-9	0.1D	1.0D	Vc	47	52	57	58	62	63	61	64	66	68	66	
				fz	0.003	0.005	0.010	0.012	0.016	0.019	0.019	0.018	0.018	0.019	0.018	
				RPM	7,450	5,500	4,550	3,700	3,300	2,500	1,950	1,700	1,500	1,350	1,050	
10	Высоколегир. сталь	0.1D	1.0D	Vc	72	83	94	97	104	103	101	102	108	108	107	
				fz	0.003	0.005	0.009	0.012	0.015	0.021	0.023	0.022	0.024	0.024		
				RPM	11,400	8,800	7,450	6,200	5,500	4,100	3,200	2,700	2,450	2,150	1,700	
11.1 11.2	0.1D	1.0D	Vc	47	52	57	58	62	63	61	64	66	68	66		
			fz	0.003	0.005	0.010	0.012	0.016	0.019	0.019	0.018	0.018	0.019	0.018		
			RPM	7,450	5,500	4,550	3,700	3,300	2,500	1,950	1,700	1,500	1,350	1,050		
M	14.1	Нержавеющая сталь	0.1D	1.0D	Vc	39	43	48	49	52	53	53	51	53	55	50
					fz	0.003	0.004	0.009	0.012	0.015	0.021	0.021	0.021	0.023	0.023	0.023
					RPM	6,200	4,550	3,800	3,100	2,750	2,100	1,700	1,350	1,200	1,100	800
K	15-20	Серый чугун Высокопрочный чугун Ковкий чугун	0.1D	1.5D	Vc	68	66	67	66	64	64	68	64	66	63	66
					fz	0.009	0.013	0.017	0.022	0.033	0.046	0.058	0.076	0.090	0.112	0.142
					RPM	10,800	7,000	5,300	4,200	3,400	2,550	2,150	1,700	1,500	1,250	1,050
H	38.1	Закаленная сталь	0.1D	1.0D	Vc	47	52	57	58	62	63	61	64	66	68	66
					fz	0.003	0.005	0.010	0.012	0.016	0.019	0.019	0.018	0.018	0.019	0.018
					RPM	7,450	5,500	4,550	3,700	3,300	2,500	1,950	1,700	1,500	1,350	1,050
40	Отбеленный чугун	0.1D	1.0D	Vc	47	52	57	58	62	63	61	64	66	68	66	
				fz	0.003	0.005	0.010	0.012	0.016	0.019	0.019	0.018	0.018	0.019	0.018	
				RPM	7,450	5,500	4,550	3,700	3,300	2,500	1,950	1,700	1,500	1,350	1,050	
FEED						80	100	175	175	205	185	145	120	110	100	75