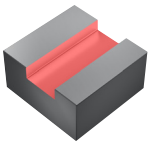
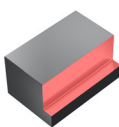
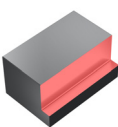


Kesme hızı tavsiyeleri

Optimize edilmiş - Ağır iş frezeleme için CoroMill® Plura yekpare karbür parmak freze

ISO	MC No.	CMC	Malzeme	HB									
					$a_e = 1.0 \times DC$	$a_p = 1.0 \times DC$		$a_e = 0.5 \times DC$	$a_p = 1.0 \times DC$		$a_e = 0.25 \times DC$	$a_p = 1.0 \times DC$	
					f_z	v_c m/dk	v_c ayak/dk	f_z	v_c m/dk	v_c ayak/dk	f_z	v_c m/dk	v_c ayak/dk
P	P1.2.Z.AN	01.2	Alaşımsız çelik	190	D01	195	639	D02	234	767	D03	325	1066
	P2.2.Z.AN	02.2	Düşük alaşımlı çelik	240	D04	156	511	D02	189	618	D03	260	1853
	P3.0.Z.HT	03.21	Yüksek alaşımlı çelikler	380	D04	88	288	D02	105	342	D03	149	487
M	P5.0.Z.AN	05.11	Feritik/martensitik paslanmaz çelik	200	D04	127	415	D02	154	505	D03	215	703
	M1.0.Z.AQ	05.21	Östenitik paslanmaz çelik	200	D04	104	341	D05	130	426	D06	182	597
	M3.2.Z.AQ	05.51	Dupleks (östenitik/feritik) paslanmaz çelik	260	D04	80	262	D08	95	311	D09	135	442
K	K1.1.C.NS	07.2	Temper dökme demir	200	D01	195	639	D02	234	767	D03	325	1066
	K2.1.C.UT	08.2	Gri dökme demir	180	D01	195	639	D02	234	767	D03	325	1066
	K3.2.C.UT	09.2	Sfero dökme demir	215	D01	208	682	D02	247	810	D03	351	1151
S	S2.0.Z.AG	20.22	Nikel bazlı süper alaşımlar	350	D07	20	65	D08	25	82	D09	32	104
	S4.2.Z.AN	23.22	Titanyum bazlı alaşımlar	320	D07	40	131	D08	50	164	D09	60	196

İlerleme tavsiyeleri

mm/dış
inç/dış

DC	2.000	3.000	4.000	6.000	6.350	7.938	8.000	9.525	10.000	12.000	12.700	14.000	15.875	16.000	19.050	20.000	25.000
	0.079	0.118	0.157	0.236	0.250	0.313	0.315	0.375	0.394	0.472	0.500	0.551	0.625	0.630	0.750	0.787	0.984
D01	0.020	0.024	0.028	0.035	0.036	0.042	0.043	0.048	0.050	0.057	0.059	0.063	0.070	0.070	0.080	0.083	0.100
	.0008	.0009	.0011	.0014	.0014	.0017	.0017	.0019	.0020	.0022	.0023	.0025	.0027	.0028	.0032	.0033	.0039
D02	0.024	0.030	0.036	0.047	0.049	0.058	0.059	0.067	0.070	0.080	0.084	0.090	0.099	0.100	0.115	0.120	0.145
	.0009	.0012	.0014	.0019	.0019	.0023	.0023	.0026	.0028	.0031	.0033	.0035	.0039	.0039	.0045	.0047	.0057
D03	0.028	0.035	0.041	0.054	0.056	0.067	0.067	0.077	0.080	0.093	0.098	0.107	0.119	0.120	0.140	0.147	0.180
	.0011	.0014	.0016	.0021	.0022	.0026	.0026	.0030	.0031	.0037	.0039	.0042	.0047	.0047	.0055	.0058	.0071
D04	0.020	0.023	0.025	0.030	0.031	0.035	0.035	0.039	0.040	0.047	0.049	0.053	0.060	0.060	0.070	0.073	0.090
	.0008	.0009	.0010	.0012	.0012	.0014	.0014	.0015	.0016	.0018	.0019	.0021	.0023	.0024	.0028	.0029	.0035
D05	0.020	0.023	0.025	0.037	0.040	0.051	0.052	0.063	0.067	0.076	0.079	0.084	0.093	0.093	0.107	0.111	0.133
	.0008	.0009	.0010	.0015	.0016	.0020	.0020	.0025	.0026	.0030	.0031	.0033	.0037	.0037	.0042	.0044	.0052
D06	0.020	0.023	0.026	0.044	0.047	0.061	0.062	0.076	0.008	0.090	0.094	0.100	0.109	0.110	0.125	0.130	0.200
	.0008	.0009	.0010	.0017	.0019	.0024	.0024	.0030	.0031	.0035	.0037	.0039	.0043	.0043	.0049	.0051	.0079
D07	0.020	0.020	0.020	0.020	0.021	0.027	0.028	0.033	0.035	0.038	0.040	0.042	0.045	0.045	0.050	0.052	0.060
	.0008	.0008	.0008	.0008	.0008	.0011	.0011	.0013	.0014	.0015	.0016	.0016	.0018	.0018	.0020	.0020	.0024
D08	0.024	0.026	0.029	0.033	0.034	0.037	0.038	0.041	0.042	0.048	0.050	0.054	0.060	0.060	0.069	0.072	0.087
	.0009	.0010	.0011	.0013	.0013	.0015	.0015	.0016	.0017	.0019	.0020	.0021	.0023	.0024	.0027	.0028	.0034
D09	0.030	0.033	0.035	0.040	0.041	0.045	0.045	0.049	0.050	0.070	0.077	0.091	0.110	0.111	0.142	0.152	0.203
	.0012	.0013	.0014	.0016	.0016	.0018	.0018	.0019	.0020	.0028	.0030	.0036	.0043	.0044	.0056	.0060	.0080

Optimize kesme verileri için bkz. CoroPlus® ToolGuide.