

Технические характеристики фрез концевых цельных

Рекомендуемые режимы резания (DМАН/ DМVН'RB)

Высокоскоростное фрезерование

Обрабатываемые материалы			~ 45HRC			~ 55HRC			~ 65HRC		
Режимы резания			Углеродистые, легированные стали, чугуны			Высоколегированные, инструментальные стали			Инструментальные, быстрорежущие стали		
ØD	R	ℓ2	Частота вращения n, об/мин	Подача S мин, мм/мин	Глубина резания t, мм	Частота вращения n, об/мин	Подача S мин, мм/мин	Глубина резания t, мм	Частота вращения n, об/мин	Подача S мин, мм/мин	Глубина резания t, мм
0.1	0.05	1	50,000	270	0.002	48,000	220	0.002	45,000	170	0.002
		2	50,000	220	0.001	48,000	180	0.001	45,000	140	0.001
0.2	0.1	1	40,000	360	0.003	40,000	300	0.003	40,000	300	0.002
		2	40,000	360	0.002	40,000	300	0.002	40,000	200	0.001
0.3	0.15	1	40,000	600	0.007	40,000	500	0.007	40,000	500	0.005
		2	40,000	600	0.003	40,000	500	0.003	40,000	500	0.002
		3	40,000	480	0.002	40,000	400	0.002	40,000	400	0.001
0.4	0.2	1	40,000	1,700	0.015	40,000	1,400	0.015	40,000	1,400	0.010
		2	40,000	1,200	0.010	40,000	1,000	0.010	40,000	1,000	0.006
		3	40,000	840	0.005	40,000	700	0.005	40,000	700	0.003
		4	40,000	720	0.003	40,000	600	0.003	40,000	600	0.002
		5	40,000	480	0.002	40,000	400	0.002	40,000	400	0.001
0.5	0.25	2	40,000	2,400	0.020	40,000	2,000	0.020	40,000	2,000	0.015
		3	40,000	1,400	0.015	40,000	1,200	0.015	40,000	1,200	0.010
		4	40,000	1,200	0.010	36,000	900	0.010	36,000	900	0.007
		5	40,000	930	0.007	36,000	700	0.007	36,000	700	0.005
		6	40,000	900	0.005	32,000	600	0.005	32,000	600	0.003
		8	40,000	600	0.003	32,000	400	0.003	32,000	400	0.002
		10	40,000	450	0.002	32,000	300	0.002	32,000	300	0.001
0.6	0.3	2	40,000	3,300	0.030	40,000	2,800	0.030	40,000	2,800	0.020
		4	40,000	2,600	0.020	36,000	2,000	0.020	36,000	2,000	0.015
		6	39,000	1,200	0.008	30,000	800	0.008	30,000	800	0.005
		8	39,000	900	0.006	30,000	600	0.006	30,000	600	0.005
		10	39,000	600	0.004	30,000	400	0.004	30,000	400	0.003
0.8	0.4	2	40,000	4,200	0.040	40,000	3,200	0.040	40,000	3,200	0.030
		4	40,000	3,600	0.020	40,000	3,000	0.020	40,000	3,000	0.015
		6	39,000	2,500	0.020	30,000	1,600	0.020	30,000	1,600	0.010
		8	33,000	1,600	0.010	25,000	1,000	0.010	25,000	1,000	0.007
		10	33,000	1,300	0.008	25,000	800	0.008	25,000	800	0.005
1.0	0.5	4	40,000	4,800	0.050	40,000	3,500	0.050	40,000	3,500	0.045
		6	40,000	2,800	0.040	35,000	2,000	0.040	35,000	2,000	0.035
		8	39,000	2,500	0.035	30,000	1,600	0.035	30,000	1,600	0.030
		10	33,000	1,900	0.030	25,000	1,200	0.030	25,000	1,200	0.025
		12	33,000	1,600	0.025	25,000	1,000	0.025	25,000	1,000	0.020
		16	26,000	1,000	0.025	20,000	700	0.025	20,000	600	0.020
		20	26,000	1,000	0.020	20,000	700	0.020	20,000	600	0.015
1.2	0.6	6	40,000	4,800	0.050	40,000	3,500	0.050	40,000	3,500	0.040
		8	40,000	3,600	0.050	40,000	3,000	0.050	27,000	2,000	0.040
		10	35,000	3,000	0.030	27,000	1,900	0.030	24,000	1,700	0.020
		12	25,000	1,800	0.030	16,000	1,000	0.030	16,000	1,000	0.020
		16	25,000	1,700	0.025	16,000	900	0.025	16,000	900	0.015
1.5	0.75	6	40,000	5,000	0.070	40,000	4,000	0.070	32,000	2,880	0.060
		8	40,000	5,000	0.070	40,000	3,500	0.070	28,000	2,200	0.060
		10	40,000	4,500	0.060	40,000	2,400	0.060	21,000	1,130	0.040
		12	36,000	3,400	0.040	32,000	2,000	0.040	19,000	1,050	0.035
		16	20,000	1,500	0.030	16,000	1,300	0.030	14,000	1,000	0.030
		20	20,000	1,300	0.020	16,000	1,000	0.020	14,000	790	0.025
		20	20,000	1,300	0.020	16,000	1,000	0.020	14,000	790	0.025
2.0	1.0	6	40,000	6,000	0.100	40,000	3,400	0.100	24,000	1,840	0.100
		8	40,000	5,000	0.100	40,000	3,000	0.100	24,000	1,620	0.100
		10	40,000	5,000	0.080	40,000	3,000	0.080	24,000	1,620	0.070
		12	40,000	5,000	0.080	40,000	2,600	0.080	24,000	1,400	0.050
		16	36,000	3,500	0.050	32,000	1,700	0.050	16,000	770	0.040
		20	22,000	1,600	0.040	16,000	1,200	0.040	12,000	810	0.030
		25	20,000	1,000	0.035	12,000	900	0.035	10,000	770	0.025
		30	20,000	700	0.030	10,000	700	0.030	10,000	630	0.020

