

Технические характеристики фрез концевых цельных

Рекомендуемые режимы резания (DМАН/ DМVН'RF/ Обработка пазов)

Высокоскоростное фрезерование

Обрабатываемые материалы Режимы резания ØD ØD2		~ 45HRC			~ 55HRC			~ 65HRC		
		Углеродистые, легированные стали, чугуны			Высоколегированные, инструментальные стали			Инструментальные, быстрорежущие стали		
		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	1	35,000	175	0.009	28,000	100	0.006	23,000	80	0.003
	2	34,000	135	0.005	27,000	80	0.004	22,000	60	0.002
0.2	1	32,000	220	0.018	26,000	130	0.011	21,000	100	0.006
	2	30,000	180	0.011	24,000	100	0.009	19,000	80	0.004
0.3	1	32,000	330	0.030	26,000	190	0.016	21,000	150	0.008
	2	32,000	255	0.021	26,000	160	0.012	21,000	130	0.006
	3	30,000	250	0.016	24,000	140	0.009	19,000	110	0.004
0.4	1	32,000	480	0.044	26,000	270	0.024	21,000	220	0.012
	2	32,000	330	0.035	26,000	190	0.019	21,000	150	0.010
	3	30,000	240	0.026	24,000	140	0.015	19,000	110	0.007
	4	30,000	225	0.021	24,000	130	0.012	19,000	100	0.006
	5	28,000	165	0.016	22,000	90	0.009	17,000	70	0.004
0.5	2	30,000	310	0.049	24,000	170	0.027	19,000	140	0.014
	3	30,000	255	0.040	24,000	140	0.022	19,000	113	0.011
	4	28,000	230	0.026	23,000	130	0.015	18,000	110	0.007
	5	28,000	220	0.026	23,000	130	0.015	18,000	100	0.007
	6	27,000	205	0.021	22,000	120	0.012	17,000	90	0.006
	8	27,000	180	0.014	22,000	100	0.008	17,000	85	0.004
	10	27,000	170	0.009	22,000	100	0.005	17,000	80	0.002
0.6	2	30,000	330	0.060	24,000	185	0.033	19,000	150	0.016
	4	30,000	240	0.044	24,000	130	0.024	19,000	110	0.012
	6	28,000	210	0.032	23,000	120	0.017	18,000	100	0.009
	8	27,000	200	0.021	22,000	110	0.012	17,000	90	0.006
	10	27,000	200	0.016	22,000	110	0.009	17,000	90	0.004
0.8	2	30,000	540	0.070	24,000	300	0.039	19,000	240	0.019
	4	28,000	450	0.058	23,000	260	0.032	18,000	210	0.016
	6	27,000	380	0.042	22,000	220	0.023	17,000	170	0.012
	8	27,000	300	0.034	22,000	180	0.019	17,000	150	0.009
	10	25,000	280	0.025	20,000	160	0.014	16,000	130	0.007
1.0	4	28,000	890	0.062	23,000	510	0.034	18,000	410	0.017
	6	27,000	810	0.050	22,000	460	0.028	17,000	370	0.014
	8	27,000	600	0.040	22,000	340	0.022	17,000	270	0.011
	10	27,000	540	0.033	22,000	310	0.018	17,000	260	0.009
	12	22,000	420	0.026	20,000	280	0.014	16,000	220	0.007
	16	22,000	400	0.017	20,000	240	0.010	16,000	190	0.005
	20	22,000	380	0.012	20,000	210	0.007	16,000	170	0.003
1.2	6	23,000	800	0.067	18,000	440	0.037	14,000	350	0.018
	8	21,000	600	0.055	17,000	340	0.030	13,000	280	0.015
	10	21,000	600	0.049	17,000	340	0.027	13,000	270	0.014
	12	21,000	580	0.039	17,000	330	0.022	13,000	260	0.011
	16	17,000	400	0.028	16,000	220	0.016	12,000	180	0.008
1.5	6	16,000	680	0.093	13,000	390	0.056	10,000	310	0.028
	8	15,000	500	0.084	12,000	280	0.051	9,500	220	0.025
	10	15,000	500	0.068	12,000	280	0.041	9,500	220	0.020
	12	15,000	500	0.061	12,000	280	0.037	9,500	220	0.018
	16	14,000	420	0.045	11,000	230	0.027	8,500	190	0.013
	20	14,000	420	0.036	11,000	230	0.022	8,500	190	0.011
2.0	6	15,000	950	0.126	12,000	530	0.107	9,500	430	0.060
	8	15,000	950	0.113	12,000	530	0.096	9,500	430	0.054
	10	15,000	840	0.102	12,000	470	0.087	9,500	380	0.049
	12	14,000	770	0.092	11,000	420	0.078	8,500	340	0.044
	16	14,000	770	0.074	11,000	420	0.063	8,500	340	0.035
	20	14,000	770	0.060	11,000	420	0.051	8,500	340	0.029
	25	13,000	700	0.044	10,000	380	0.037	8,000	300	0.021
	30	13,000	700	0.036	10,000	380	0.031	8,000	300	0.017

