

Řezné podmínky pro CoroReamer™ 835

Metrické rozměry

CoroReamer™ 835 - PF				Ø mm						
ISO	Č. MC	Materiál	N/mm ²	Aplikační data	< 5.00	5.00 - 6.20	6.20 - 8.00	8.00 - 12.00	12.00 - 16.00	16.00 - 20.00
P	Nelegovaná ocel				180					
	P1.1.Z.AN	C=0.10-0.25%	428	v_c m/min f_n mm/ot Sklad	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20
	P1.2.Z.AN	Kalená a popuštěná ocel	639	v_c m/min f_n mm/ot Sklad	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20
	P1.2.Z.AN	C=0.25-0.55%	639	v_c m/min f_n mm/ot Sklad	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20
	P1.2.Z.HT		708	v_c m/min f_n mm/ot Sklad	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20
	P1.3.Z.AN	C=0.55-0.80%	639	v_c m/min f_n mm/ot Sklad	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20
	P1.3.Z.HT		991	v_c m/min f_n mm/ot Sklad	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20
	Nizkolegovaná ocel				180					
	P2.1.Z.AN	Nezušlechtěná	591	v_c m/min f_n mm/ot Sklad	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20
	P2.2.Z.AN	Žíhaná	811	v_c m/min f_n mm/ot Sklad	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20
	P2.3.Z.AN		867	v_c m/min f_n mm/ot Sklad	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20
	P2.5.Z.HT	Kalená a popuštěná ocel	961	v_c m/min f_n mm/ot Sklad	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20
	Ocel na odlitky				180					
	P1.5.C.UT	Nelegovaná ocel	503	v_c m/min f_n mm/ot Sklad	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20
P2.6.C.UT	Nizkolegovaná (obsah legujících prvků ≤ 5%)	674	v_c m/min f_n mm/ot Sklad	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20	
Vysokolegovaná ocel				180						
P3.0.Z.AN	Žíhaná	674	v_c m/min f_n mm/ot Sklad	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20	
P3.0.Z.HT		1282	v_c m/min f_n mm/ot Sklad	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20	
P3.1.Z.AN	Žíhaná HSS	839	v_c m/min f_n mm/ot Sklad	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20	
P5.0.Z.HT		1114	v_c m/min f_n mm/ot Sklad	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20	

Řezné podmínky pro CoroReamer™ 835

Palcové rozměry

CoroReamer™ 835 - PF				Ø inch							
ISO	Č. MC	Materiál	N/mm ²	Aplikační data	< .197	.197 - .244	.244 - .315	.315 - .472	.472 - .630	.630 - .787	
P	Nelegovaná ocel										
	P1.1.Z.AN	C=0.10-0.25%	428	v_c ft/min f_i inch/ot Sklad	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008	
	P1.1.Z.AN	Kalená a popuštěná ocel	639	v_c ft/min f_i inch/ot Sklad	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008	
	P1.2.Z.AN	C=0.25-0.55%	639	v_c ft/min f_i inch/ot Sklad	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008	
	P1.2.Z.HT		708	v_c ft/min f_i inch/ot Sklad	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008	
	P1.3.Z.AN	C=0.55-0.80%	639	v_c ft/min f_i inch/ot Sklad	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008	
	P1.3.Z.HT		991	v_c ft/min f_i inch/ot Sklad	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008	
	Nizkolegovaná ocel										
	P2.1.Z.AN	Nezušlechťená	591	v_c ft/min f_i inch/ot Sklad	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008	
	P2.2.Z.AN	Žíhaná	811	v_c ft/min f_i inch/ot Sklad	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008	
	P2.3.Z.AN		867	v_c ft/min f_i inch/ot Sklad	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008	
	P2.5.Z.HT	Kalená a popuštěná ocel	961	v_c ft/min f_i inch/ot Sklad	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008	
Ocel na odlitky											
P1.5.C.UT	Nelegovaná ocel	503	v_c ft/min f_i inch/ot Sklad	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008		
P2.6.C.UT	Nizkolegovaná (obsah legujících prvků ≤ 5%)	674	v_c ft/min f_i inch/ot Sklad	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008		
Vysokolegovaná ocel											
P3.0.Z.AN	Žíhaná	674	v_c ft/min f_i inch/ot Sklad	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008		
P3.0.Z.HT		1282	v_c ft/min f_i inch/ot Sklad	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008		
P3.1.Z.AN	Žíhaná HSS	839	v_c ft/min f_i inch/ot Sklad	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008		
P5.0.Z.HT		1114	v_c ft/min f_i inch/ot Sklad	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008		

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Metrické rozměry

CoroReamer™ 835 - PF					Ø mm							
ISO	Č. MC	Materiál	N/mm ²	Aplikační data	< 5.00	5.00 - 6.20	6.20 - 8.00	8.00 - 12.00	12.00 - 16.00	16.00 - 20.00		
K	K1.1.C.NS	Temperovaná litina	428	v_c m/min	90							
		Feritická/Perlitická		f_n mm/ot	0.30	0.40	0.60	1.00	1.30	1.80		
				Skład	0.10	0.10	0.15	0.20	0.20	0.30		
	K2.1.C.UT	Šedá litina Nizká pevnost v tahu	639	v_c m/min	110							
				f_n mm/ot	0.30	0.40	0.60	1.00	1.30	1.80		
	K2.2.C.UT	Vysoká pevnost v tahu	639	v_c m/min	150							
				f_n mm/ot	0.30	0.40	0.60	1.00	1.30	1.80		
	K2.3.C.UT		708	v_c m/min	90							
				f_n mm/ot	0.30	0.40	0.60	1.00	1.30	1.80		
	K	K3.1.C.UT	Nodulární litina Feritická	639	v_c m/min	90						
						f_n mm/ot	0.30	0.40	0.60	1.00	1.30	1.80
						Skład	0.10	0.10	0.15	0.20	0.20	0.30
		K3.2.C.UT	Perlitická	991	v_c m/min	90						
					f_n mm/ot	0.30	0.40	0.60	1.00	1.30	1.80	
		K3.3.C.UT	Perlitická	503	v_c m/min	90						
f_n mm/ot					0.30	0.40	0.60	1.00	1.30	1.80		
K3.5.C.UT			591	v_c m/min	90							
				f_n mm/ot	0.30	0.40	0.60	1.00	1.30	1.80		
					Skład	0.10	0.10	0.15	0.20	0.20	0.30	

Palcové rozměry

CoroReamer™ 835 - PF					Ø inch							
ISO	Č. MC	Materiál	N/mm ²	Aplikační data	< .197	.197 - .244	.244 - .315	.315 - .472	.472 - .630	.630 - .787		
K	K1.1.C.NS	Temperovaná litina	428	v_c ft/min	295							
		Feritická/Perlitická		f_n inch/ot	.012	.016	.024	.039	.051	.071		
				Skład	.004	.004	.006	.008	.008	.012		
	K2.1.C.UT	Šedá litina Nizká pevnost v tahu	639	v_c ft/min	361							
				f_n inch/ot	.012	.016	.024	.039	.051	.071		
	K2.2.C.UT	Vysoká pevnost v tahu	639	v_c ft/min	492							
				f_n inch/ot	.012	.016	.024	.039	.051	.071		
	K2.3.C.UT		708	v_c ft/min	295							
				f_n inch/ot	.012	.016	.024	.039	.051	.071		
	K	K3.1.C.UT	Nodulární litina Feritická	639	v_c ft/min	295						
						f_n inch/ot	.012	.016	.024	.039	.051	.071
						Skład	.004	.004	.006	.008	.008	.012
		K3.2.C.UT	Perlitická	991	v_c ft/min	295						
					f_n inch/ot	.012	.016	.024	.039	.051	.071	
		K3.3.C.UT	Perlitická	503	v_c ft/min	295						
f_n inch/ot					.012	.016	.024	.039	.051	.071		
K3.5.C.UT			591	v_c ft/min	295							
				f_n inch/ot	.012	.016	.024	.039	.051	.071		
					Skład	.004	.004	.006	.008	.008	.012	

Řezné podmínky pro CoroReamer™ 835

Metrické rozměry

CoroReamer™ 835 -MF				Ø mm							
ISO	č. MC	Materiál	N/mm ²	Aplikační data	< 5.00	5.00 - 6.20	6.20 - 8.00	8.00 - 12.00	12.00 - 16.00	16.00 - 20.00	
P	P5.0.Z.PH	Nelegovaná ocel	503	v_c m/min	30						
				f_n mm/ot	0.10	0.15	0.30	0.40	0.50	0.60	
				Sklad	0.05	0.10	0.10	0.10	0.20	0.20	
M	M1.0.Z.AQ	Austenitická	811	v_c m/min	40						
				f_n mm/ot	0.10	0.15	0.30	0.40	0.50	0.60	
					Sklad	0.05	0.10	0.10	0.10	0.20	0.20
	M2.0.Z.AQ	Superaustenitická	961	v_c m/min	40						
				f_n mm/ot	0.10	0.15	0.30	0.40	0.50	0.60	
					Sklad	0.05	0.10	0.10	0.10	0.20	0.20
	M3.1.Z.AQ			674	v_c m/min	30					
					f_n mm/ot	0.10	0.15	0.30	0.40	0.50	0.60
					Sklad	0.05	0.10	0.10	0.10	0.20	0.20
	M3.2.Z.AQ	Duplexní (austeniticko-feritická)	674	v_c m/min	30						
f_n mm/ot				0.10	0.15	0.30	0.40	0.50	0.60		
				Sklad	0.05	0.10	0.10	0.10	0.20	0.20	
M1.0.C.UT			674	v_c m/min	40						
				f_n mm/ot	0.10	0.15	0.30	0.40	0.50	0.60	
				Sklad	0.05	0.10	0.10	0.10	0.20	0.20	
M2.0.C.AQ			674	v_c m/min	40						
				f_n mm/ot	0.10	0.15	0.30	0.40	0.50	0.60	
				Sklad	0.05	0.10	0.10	0.10	0.20	0.20	
M3.1.C.AQ			1114	v_c m/min	30						
				f_n mm/ot	0.20	0.30	0.50	0.80	1.10	1.50	
				Sklad	0.10	0.10	0.10	0.15	0.20	0.20	

Palcové rozměry

CoroReamer™ 835 -MF				Ø inch							
ISO	č. MC	Materiál	N/mm ²	Aplikační data	< .197	.197 - .244	.244 - .315	.315 - .472	.472 - .630	.630 - .787	
P	P5.0.Z.PH	Nelegovaná ocel	503	v_c ft/min	98						
				f_n inch/ot	.004	.006	.012	.016	.020	.024	
				Sklad	.002	.004	.004	.004	.008	.008	
M	M1.0.Z.AQ	Austenitická	811	v_c ft/min	131						
				f_n inch/ot	.004	.006	.012	.016	.020	.024	
					Sklad	.002	.004	.004	.004	.008	.008
	M2.0.Z.AQ	Superaustenitická	961	v_c ft/min	131						
				f_n inch/ot	.004	.006	.012	.016	.020	.024	
					Sklad	.002	.004	.004	.004	.008	.008
	M3.1.Z.AQ			674	v_c ft/min	98					
					f_n inch/ot	.004	.006	.012	.016	.020	.024
					Sklad	.002	.004	.004	.004	.008	.008
	M3.2.Z.AQ	Duplexní (austeniticko-feritická)	674	v_c ft/min	98						
f_n inch/ot				.004	.006	.012	.016	.020	.024		
				Sklad	.002	.004	.004	.004	.008	.008	
M1.0.C.UT			674	v_c ft/min	131						
				f_n inch/ot	.004	.006	.012	.016	.020	.024	
				Sklad	.002	.004	.004	.004	.008	.008	
M2.0.C.AQ			674	v_c ft/min	131						
				f_n inch/ot	.004	.006	.012	.016	.020	.024	
				Sklad	.002	.004	.004	.004	.008	.008	
M3.1.C.AQ			1114	v_c ft/min	98						
				f_n inch/ot	.008	.012	.020	.031	.043	.059	
				Sklad	.004	.004	.004	.006	.008	.008	