

# ŘEZNÉ PODMÍNKY

Řezní rychlosti Vc m/min

Obráběný materiál	Material No. VDI 3323	Tvrдость HB	Řezná rychlost vrtání	Řezná rychlost soustružení, vyvrtávání
Low carbon steel ( $\leq 0.25\% \text{ C}$ )	1	~150	130-240	150-270
Carbon steel ( $\geq 0.25\% \text{ C}$ )	2	150-250	90-160	100-180
Low alloy steel	6	~180	120-210	140-230
Medium alloy steel	7	200-250	70-140	80-160
High alloy steel	8, 9	250-350	50-100	60-120
Martensitic stainless steel	12	200	110-180	130-200
Austenitic stainless steel	14	200	90-160	100-180
Grey cast iron	17, 18	180-220	110-180	1200-200
Ductile cast iron	15, 16	200-240	90-160	100-180
Aluminum alloy	21-24	60-130	100-500	150-600
Copper alloy	26-28	90-100	100-400	100-500

Insert	Způsob obrábění	hloubka řezu $a_p$ (mm)	posuv na otáčku $f$ (mm/rev)
XCMT 040104	External Turning	0.6 (0.2-1.8)	0.05 (0.02-0.15)
	Drilling	-	0.06 (0.02-0.10)
XCMT 050204	External Turning	0.8 (0.2-2.5)	0.08 (0.02-0.15)
	Face Turning	0.6 (0.2-1.7)	0.06 (0.02-0.13)
	Drilling	-	0.05 (0.02-0.10)
XCMT 060204	External Turning	1.0 (0.2-3.0)	0.10 (0.03-0.20)
	Face Turning	0.8 (0.2-2.5)	0.07 (0.03-0.15)
	Drilling	-	0.05 (0.02-0.10)
XCMT 070304	External Turning	1.3 (0.3-3.5)	0.12 (0.03-0.20)
	Face Turning	1.0 (0.25-3.0)	0.10 (0.03-0.18)
	Drilling	-	0.06 (0.03-0.12)
XCMT 0803..	Face Turning	1.5 (0.35-4.0)	0.14 (0.06-0.25)
	External Turning	1.2 (0.3-3.5)	0.12 (0.06-0.24)
	Drilling	-	0.08 (0.05-0.16)
XCMT 10T304	External Turning	1.8 (0.5-3.5)	0.12 (0.06-0.30)
	Drilling	-	0.08 (0.03-0.15)
XCMT 10T308	External Turning	1.8 (0.5-3.5)	0.20 (0.10-0.40)
	Drilling	-	0.08 (0.03-0.15)
XCMT 130404	External Turning	2.0 (0.6-4.3)	0.15 (0.07-0.32)
	Drilling	-	0.08 (0.03-0.15)
XCMT 130408	External Turning	2.0 (0.6-4.3)	0.20 (0.10-0.40)
	Drilling	-	0.08 (0.03-0.15)
XCMT 170508	External Turning	3.0 (0.7-5.3)	0.22 (0.10-0.40)
	Drilling	-	0.08 (0.03-0.15)

Cutting parameters are for 2.25xD steel shank.

Internal coolant supply is recommended.