

Режимы резания

ISO	Обрабатываемый материал	Покрытие	Пластина	Скорость резания Vc (м/мин)	Глубина резания ap (мм)	Подача fn (мм/об)
P	Сталь	SD2136	CNMG120404-BF	320 (280-440)	3.0 (1.0-4.0)	0.03 (0.2-0.6)
			CNMG120404-BM	320 (280-440)	3.0 (1.0-4.0)	0.03 (0.2-0.6)
			CNMG160612-GM	270 (150-330)	3.0 (2.0-5.0)	0.5 (0.3-1.0)
		SD5136	CNMG160612-GM	150 (100-200)	4.0 (1.3-8.0)	0.35 (0.25-0.7)
		SD5226	CNMG190608-GM	340 (280-440)	3.0 (2.0-5.0)	0.5 (0.3-1.0)
		SD5236	CNMG120408-GM	270 (180-360)	0.1 (0.05-0.2)	0.20 (0.1-0.4)
			CNMG160608-GR	150 (100-200)	4.0 (1.3-8.0)	0.35 (0.25-0.7)
			CNMG160616-GM	150 (100-200)	4.0 (1.3-8.0)	0.35 (0.25-0.7)
		YB6315	CNMG120408-ADF	400 (300-500)	1.0 (0.5-2.0)	0.12 (0.08-0.2)
		YBC152	CNMG090308-DF	400 (300-500)	1.0 (0.5-2.0)	0.1 (0.05-0.2)
			CNMG160616-DM	300 (200-400)	4.0 (1.0-5.0)	0.30 (0.20-0.5)
		YBC251 ²	CNMG120412-DM	260 (220-340)	3.0 (1.0-5.5)	0.25 (0.15-0.6)
			CNMG190608-PM	280 (240-360)	3.0 (1.0-6.0)	0.20 (0.10-0.5)
		YBC252	CNMG120404-PM	300 (260-380)	2.0 (0.5-3.0)	0.15 (0.05-0.3)
			CNMG120408-DM	280 (240-360)	2.0 (0.5-4.0)	0.20 (0.10-0.5)
			CNMG120408-DR	340 (240-360)	3.0 (1.0-5.0)	0.35 (0.25-0.7)
			CNMG120408-PM	340 (280-440)	2.0 (0.5-3.0)	0.25 (0.10-0.5)
			CNMG120416-DR	220 (180-300)	3.0 (1.0-5.5)	0.35 (0.25-0.7)
			CNMG160612-DM	260 (220-340)	4.0 (1.0-5.0)	0.25 (0.15-0.6)
			CNMG160612-PM	320 (260-400)	3.0 (1.0-5.5)	0.30 (0.20-0.5)
CNMG190612-DR	240 (200-320)		4.0 (1.0-7.5)	0.30 (0.20-0.5)		
CNMG190616-DR	200 (160-280)		4.0 (1.0-8.5)	0.35 (0.25-0.7)		
YBG302	CNMG120408-EM	240 (150-330)	4.0 (1.0-7.5)	0.20 (0.1-0.4)		
M	Нержавеющая сталь	YB9320	CNMG120408-ADF	200 (140-260)	1.0 (0.5-2.5)	0.15 (0.10-0.3)
		YBG205	CNMG120404-EF	220 (140-300)	1.0 (0.5-2.5)	0.1 (0.05-0.2)
			CNMG120408-EF	220 (150-300)	1.0 (0.2-2.0)	0.1 (0.05-0.2)
		YBG302	CNMG120408-EM	160 (80-220)	2.0 (1.0-3.0)	0.20 (0.10-0.3)
		YBM151	CNMG160612-ER	140 (100-240)	3.0 (2.0-6.0)	0.30 (0.20-0.6)
			CNMG160616-ER	140 (100-240)	3.0 (2.0-6.0)	0.30 (0.20-0.6)
		YBM253	CNMG120408-ER	180 (110-220)	2.0 (1.0-4.0)	0.20 (0.10-0.5)
			CNMG160616-ER	100 (80-160)	0.3 (0.20-0.6)	3.0 (2.0-6.0)
K	Чугун	YBD102	CNMG160612-DR	300(200-400)	4.0 (1.0-5.0)	0.20 (0.10-0.5)
		YBD152C	CNMG160612-TC	240 (180-300)	4.0 (1.0-5.0)	0.30 (0.20-0.6)