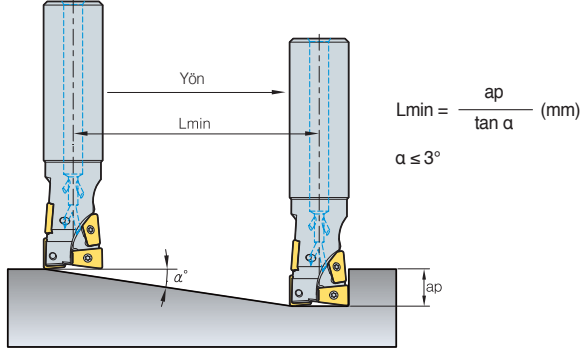
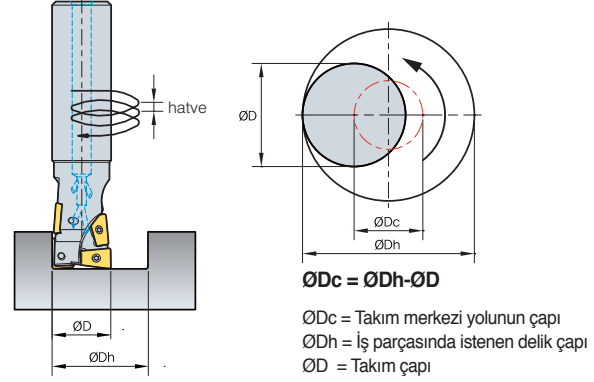




## 1. Rampalama



## 2. Helisel Kesim



## Rampalama ve Helisel İşleme için Kesme Koşulu

İş parçası	Sertlik	Kalite	Kesme Hızı vc (m/dak)	Ø16, 17				Ø20, 21				Ø25, 26				Ø32, 33				Ø35				Ø40				Ø50			
				ØDh	ap	fz	Maks hatve	ØDh	ap	fz	Maks hatve	ØDh	ap	fz	Maks hatve	ØDh	ap	fz	Maks hatve	ØDh	ap	fz	Maks hatve	ØDh	ap	fz	Maks hatve	ØDh	ap	fz	Maks hatve
P Yumuşak çelik, Düşük Karbonlu çelik (SS400)	≤ 200HB	PC3500	200 (150-250)	19	0.5D	0.15	0.35	23	0.5D	0.18	0.35	29	0.5D	0.2	0.46	37	0.5D	0.25	0.58	41	0.5D	0.28	0.69	47	0.5D	0.3	0.81	58	0.5D	0.35	0.92
			180 (120-220)	19	0.5D	0.15	0.26	23	0.5D	0.16	0.26	29	0.5D	0.18	0.35	37	0.5D	0.2	0.44	41	0.5D	0.22	0.53	47	0.5D	0.25	0.61	58	0.5D	0.28	0.70
M Karbon çeliği, Alasimli çelik (SM50C, SCM440)	≤ 100HB	PC3500	180 (120-220)	19	0.5D	0.15	0.26	23	0.5D	0.16	0.26	29	0.5D	0.18	0.35	37	0.5D	0.2	0.44	41	0.5D	0.22	0.53	47	0.5D	0.25	0.61	58	0.5D	0.28	0.70
K Paslanmaz çelik (STS)	≤ 270HB	PC5300	160 (120-200)	19	0.2D	0.13	0.18	23	0.2D	0.15	0.18	29	0.2D	0.18	0.24	37	0.2D	0.2	0.24	41	0.2D	0.22	0.36	47	0.2D	0.25	0.42	58	0.2D	0.28	0.48
H Dökme demir (GC, GCD)	≤ 350N/mm <sup>2</sup>	PC5300	200 (150-250)	19	0.7D	0.17	0.43	23	0.7D	0.2	0.42	29	0.7D	0.2	0.57	37	0.7D	0.25	0.71	41	0.7D	0.28	0.86	47	0.7D	0.3	1.0	58	0.7D	0.35	1.14
H Sertleştirilmiş çelik	40-55HrC	PC5300	80 (50-120)	19	0.2D	0.1	0.18	23	0.2D	0.12	0.18	29	0.2D	0.13	0.24	37	0.2D	0.15	0.30	41	0.2D	0.17	0.36	47	0.2D	0.18	0.42	58	0.2D	0.2	0.48

## Dik Kenar İşleme için Kesme Koşulu

İş parçası	Sertlik	Kalite	Kesme Hızı vc (m/dak)	Ø16,17			Ø20,21			Ø25,26			Ø32,33			Ø35			Ø40			Ø50		
				Maks ap (mm)	maks ae (mm)	Maks fz (mm/diş)	Maks ap (mm)	maks ae (mm)	Maks fz (mm/diş)	Maks ap (mm)	maks ae (mm)	Maks fz (mm/diş)	Maks ap (mm)	maks ae (mm)	Maks fz (mm/diş)	Maks ap (mm)	maks ae (mm)	Maks fz (mm/diş)	Maks ap (mm)	maks ae (mm)	Maks fz (mm/diş)	Maks ap (mm)	maks ae (mm)	Maks fz (mm/diş)
P Yumuşak çelik, Düşük Karbonlu çelik (SS400)	≤ 200HB	PC3500	200 (150-250)	17	8	0.25	22	10	0.3	27	13	0.35	35	16	0.4	40	18	0.45	44	20	0.5	55	25	0.6
			180 (120-220)	17	8	0.2	22	10	0.25	27	13	0.3	35	16	0.35	40	18	0.4	44	20	0.4	55	25	0.5
M Karbon çeliği, Alasimli çelik (SM50C, SCM440)	≤ 100HB	PC3500	180 (120-220)	17	8	0.2	22	10	0.25	27	13	0.3	35	16	0.35	40	18	0.4	44	20	0.4	55	25	0.5
K Paslanmaz çelik (STS)	≤ 270HB	PC5300	160 (120-200)	17	8	0.2	22	10	0.25	27	13	0.3	35	16	0.35	40	18	0.4	44	20	0.4	55	25	0.5
H Dökme demir (GC, GCD)	≤ 350N/mm <sup>2</sup>	PC5300	200 (150-250)	17	8	0.25	22	10	0.3	27	13	0.35	35	16	0.4	40	18	0.45	44	20	0.5	55	25	0.6
H Sertleştirilmiş çelik	40-55HrC	PC5300	80 (50-120)	17	5	0.15	22	6	0.2	27	7	0.22	35	8	0.25	40	9	0.3	44	10	0.3	55	14	0.35

## Kanal Açma için Kesme Koşulu

İş parçası	Sertlik	Kalite	Kesme Hızı vc (m/dak)	Ø16,17		Ø20,21		Ø25,26		Ø32,33		Ø35		Ø40		Ø50	
				Maks ap (mm)	Maks fz (mm/diş)	Maks ap (mm)	Maks fz (mm/diş)	Maks ap (mm)	Maks fz (mm/diş)	Maks ap (mm)	Maks fz (mm/diş)	Maks ap (mm)	Maks fz (mm/diş)	Maks ap (mm)	Maks fz (mm/diş)		
P Yumuşak çelik, Düşük Karbonlu çelik (SS400)	≤ 200HB	PC3500	200 (150-250)	17	0.15	22	0.18	27	0.2	35	0.25	40	0.27	44	0.3	55	0.35
			180 (120-220)	17	0.15	22	0.15	27	0.18	35	0.2	40	0.22	44	0.25	55	0.3
M Karbon çeliği, Alasimli çelik (SM50C, SCM440)	≤ 100HB	PC3500	180 (120-220)	17	0.15	22	0.15	27	0.18	35	0.2	40	0.22	44	0.25	55	0.3
K Paslanmaz çelik (STS)	≤ 270HB	PC5300	160 (120-200)	17	0.15	22	0.15	27	0.18	35	0.2	40	0.22	44	0.25	55	0.3
H Dökme demir (GC, GCD)	≤ 350N/mm <sup>2</sup>	PC5300	200 (150-250)	17	0.15	22	0.18	27	0.2	35	0.25	40	0.27	44	0.3	55	0.35
H Sertleştirilmiş çelik	40-55HrC	PC5300	80 (50-120)	12	0.1	14	0.12	17	0.15	22	0.15	25	0.18	28	0.18	35	0.22

