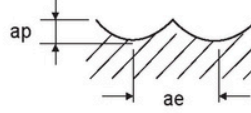


**GR405, GR415, GR425,
GR505, GR515, GR525, GR535, GR545, GR555,**

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MALZEME	ALAŞIMLI ÇELİKLER ALAŞIMSIZ ÇELİKLER TAKIM ÇELİKLERİ				ALAŞIMLI ÇELİKLER ISIYA DİRENÇLİ ÇELİKLER				PASLANMAZ ÇELİKLER			
ÇAP	DEVİR	İLERLEME	Vc	fz	DEVİR	İLERLEME	Vc	fz	DEVİR	İLERLEME	Vc	fz
R1.0 x 2.0	12400	660	80	0.026	9170	420	55	0.023	4020	130	25	0.016
R1.5 x 3.0	11450	585	105	0.025	8560	395	80	0.023	3820	130	35	0.016
R2.0 x 4.0	8980	645	110	0.035	7160	460	90	0.031	3650	160	45	0.021
R2.5 x 5.0	7850	710	125	0.045	6220	510	95	0.040	3140	160	50	0.024
R3.0 x 6.0	7300	880	135	0.060	5910	720	110	0.060	2730	170	50	0.030
R4.0 x 8.0	6150	1100	155	0.089	4920	795	125	0.080	2080	195	50	0.046
R5.0 x 10.0	5550	1340	170	0.122	4360	880	135	0.100	1780	195	55	0.054
R6.0 x 12.0	5050	1520	190	0.150	3960	960	150	0.120	1530	220	55	0.070
R7.0 x 14.0	4580	1510	200	0.165	3620	935	160	0.128	1350	220	55	0.081
R8.0 x 16.0	4110	1480	205	0.180	3220	920	160	0.141	1150	220	60	0.091
R9.0 x 18.0	3850	1440	215	0.188	3020	895	170	0.148	1080	220	60	0.100
R10.0 x 20.0	3600	1440	225	0.201	2820	895	175	0.158	980	220	60	0.111

ap : D1~D6=0.25mm
D8~D20=0.30mm
ae : 0.25D

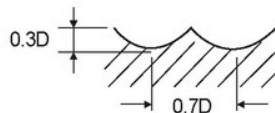


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**GR405, GR415, GR425,
GR505, GR515, GR525, GR535, GR545, GR555,**



MALZEME	DÖKME DEMİR				ALÜMİNYUM ALAŞIMLAR			
ÇAP	DEVİR	İLERLEME	Vc	fz	DEVİR	İLERLEME	Vc	fz
R1.0 x 2.0	10550	230	65	0.010	30900	400	195	0.006
R1.5 x 3.0	7100	240	65	0.016	20550	400	195	0.010
R2.0 x 4.0	5180	295	65	0.028	15450	400	195	0.013
R2.5 x 5.0	4200	335	65	0.040	1250	180	190	0.019
R3.0 x 6.0	3450	370	65	0.053	10350	480	195	0.023
R4.0 x 8.0	2550	480	65	0.092	7950	550	200	0.034
R5.0 x 10.0	2080	480	65	0.112	6200	550	195	0.044
R6.0 x 12.0	1790	480	65	0.131	5200	640	195	0.061
R7.0 x 14.0	1440	480	60	0.164	4350	640	190	0.073
R8.0 x 16.0	1350	480	65	0.177	3900	550	195	0.070
R9.0 x 18.0	1150	480	60	0.209	3450	550	190	0.079
R10.0 x 20.0	1100	430	65	0.200	2980	550	185	0.092



* Uzun boy takımlarda ilerleme %50 azaltılacaktır.

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