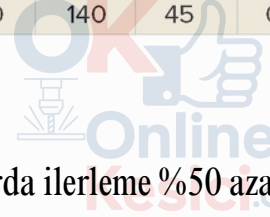
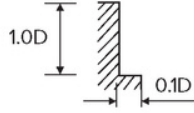


MALZEME	ALAŞIMLI ÇELİKLER ALAŞIMSIZ ÇELİKLER TAKIM ÇELİKLERİ				ALAŞIMLI ÇELİKLER ISIYA DİRENÇLİ ÇELİKLER				PASLANMAZ ÇELİKLER			
ÇAP	DEVİR	İLERLEME	Vc	fz	DEVİR	İLERLEME	Vc	fz	DEVİR	İLERLEME	Vc	fz
1.0	18600	160	55	0.002	10350	95	30	0.002	8750	85	25	0.002
1.0	18600	160	55	0.002	10350	95	30	0.002	8750	85	25	0.002
1.5	12200	225	55	0.005	7150	120	35	0.004	7150	130	35	0.004
2.0	9950	250	60	0.006	6550	150	40	0.006	5450	130	35	0.006
3.0	7850	290	70	0.009	4850	180	45	0.009	4050	155	35	0.009
4.0	6650	500	80	0.019	4150	310	50	0.019	3450	250	40	0.018
5.0	5550	520	85	0.024	3350	320	50	0.024	2850	260	40	0.024
6.0	4950	580	90	0.029	2950	360	55	0.031	2500	290	45	0.029
8.0	3650	620	90	0.043	2250	330	55	0.038	1950	310	45	0.042
10.0	2850	530	85	0.047	1850	260	55	0.038	1500	260	45	0.044
12.0	2450	450	90	0.047	1550	225	55	0.037	1250	210	45	0.045
14.0	2250	410	90	0.047	1400	210	55	0.038	1100	195	45	0.045
16.0	1900	360	95	0.047	1200	180	60	0.037	1000	180	50	0.045
20.0	1550	280	90	0.047	950	145	55	0.038	750	140	45	0.046

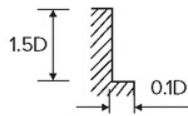
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GR450, GR451, GR452, GR453, GR456
GR550, GR551, GR552, GR553, GR556,

Uzun boy takımlarda ilerleme %50 azaltılacaktır

MALZEME	DÖKME DEMİR				ALÜMİNYUM ALAŞIMLAR				BAKIR - PRİNC DEMİR DİŞİ METALLER			
ÇAP	DEVİR	İLERLEME	Vc	fz	DEVİR	İLERLEME	Vc	fz	DEVİR	İLERLEME	Vc	fz
1.0	18800	630	60	0.008	44500	1100	140	0.006	24800	610	80	0.006
1.5	12150	630	55	0.013	28000	1180	130	0.011	20400	920	95	0.011
2.0	9450	650	60	0.017	22500	1350	140	0.015	16600	1040	105	0.016
3.0	6100	650	55	0.026	15500	1350	145	0.021	11100	1040	105	0.024
4.0	4750	650	60	0.035	11100	1350	140	0.030	8900	1040	110	0.029
5.0	3700	650	55	0.044	9200	1350	145	0.036	6900	1040	105	0.038
6.0	3050	775	55	0.065	7700	1440	145	0.047	5800	1120	105	0.048
8.0	2250	825	55	0.093	5800	1440	145	0.063	4500	1120	110	0.063
10.0	1950	875	60	0.116	4700	1440	145	0.078	3500	1120	105	0.081
12.0	1550	920	55	0.155	3800	1440	140	0.095	2900	1120	105	0.096
14.0	1350	950	55	0.182	3400	1440	145	0.108	2500	1120	105	0.115
16.0	1150	980	55	0.220	2900	1440	145	0.125	2300	1120	110	0.125
20.0	950	1040	55	0.288	2250	1440	140	0.163	1750	1120	105	0.162



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* Uzun boy takımlarda ilerleme %50 azaltılacaktır.