

MALZEME	DEMİR DİŞİ METALLER ALAŞIMLI ÇELİKLER				
ÇAP	DEVİR	DEVİR (RPM)	ap (mm)	Vc	fz
0.5	27000~35000	180~380	0.009~0.022	42~53	0.003~0.005
1.0	19500~24500	250~700	0.045~0.090	60~75	0.006~0.014
1.5	13000~16000	250~780	0.070~0.135	59~73	0.010~0.025
2.0	10100~13000	250~780	0.090~0.180	63~79	0.012~0.031

GR55F,

MALZEME	ALAŞIMLI ÇELİKLER ISIYA DİRENÇLİ ÇELİKLER				
ÇAP	DEVİR	DEVİR (RPM)	ap (mm)	Vc	fz
0.5	19500~24500	80~300	0.009~0.022	30~38	0.002~0.006
1.0	14000~17500	170~520	0.045~0.090	42~53	0.006~0.015
1.5	9000~12000	170~520	0.070~0.135	42~54	0.009~0.022
2.0	7500~9000	170~520	0.090~0.180	44~56	0.011~0.028

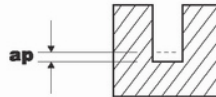


GR55B,

MALZEME	ALAŞIMLI ÇELİKLER ISIYA DİRENÇLİ ÇELİKLER				
ÇAP	DEVİR	DEVİR (RPM)	ap (mm)	Vc	fz
R0.3 x 0.6	26500~34500	190~550	0.027~0.054	50~64	0.004~0.008
R0.5 x 1.0	24800~31500	220~600	0.045~0.090	77~97	0.004~0.010
R0.75 x 1.5	16500~21000	220~680	0.070~0.135	75~97	0.007~0.016
R1.0 x 2.0	13500~16500	220~680	0.090~0.180	82~101	0.008~0.021

GR55B,

MALZEME	ALAŞIMLI ÇELİKLER ISIYA DİRENÇLİ ÇELİKLER				
ÇAP	DEVİR	DEVİR (RPM)	ap (mm)	Vc	fz
R0.3 x 0.6	19500~24500	95~320	0.027~0.054	36~46	0.002~0.006
R0.5 x 1.0	17800~22500	120~340	0.045~0.090	55~69	0.003~0.007
R0.75 x 1.5	11800~15100	120~340	0.070~0.135	54~70	0.005~0.011
R1.0 x 2.0	9800~11800	120~340	0.090~0.180	59~72	0.006~0.014



* Uzun boy takımlarda ilerleme %50 azaltılacaktır.