

# VFR

ŠÍŘKA VÝROBY  
VYKONÁVÁNÍ  
PŘEDVÝHODA



**DIAEDGE**

 MITSUBISHI MATERIALS

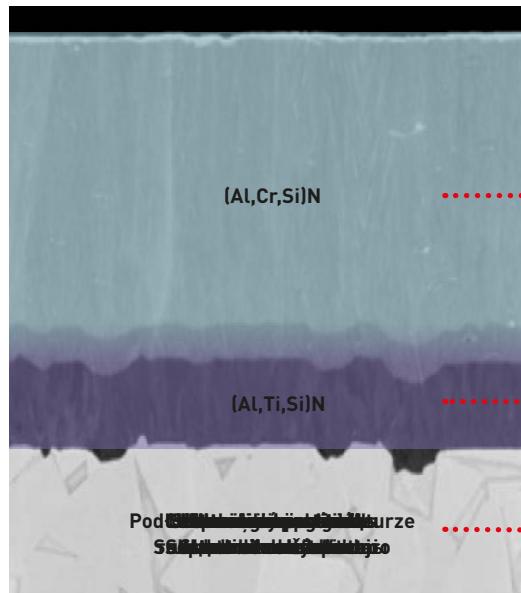


# VFR

## ŠTANDARDNÉ VÝROBKY A VÝROBNÉ RÄMENIE VÝROBKY VÝKONOVÉ A VÝKONOVÉ VERSIA

### NEVÝHODA VÝKONOVÉHO VÝROBKA

Najčastejšou výhodou výkonového výroby je vysoká tvrdosť, ktorá je v súčasnosti už iba výnimkou. Výkonové výrobky sú výrobky s vysokou tvrdosťou, ale iba do 70 HRC. Výkonové výrobky sú výrobky s vysokou tvrdosťou, ale iba do 70 HRC.



- Výkonové výrobky sú výrobky s vysokou tvrdosťou
- Výkonové výrobky sú výrobky s vysokou tvrdosťou

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- Výkonové výrobky sú výrobky s vysokou tvrdosťou

# VFR4MB

**PROJETO DE INVESTIMENTO NA INDÚSTRIA  
DE MANUFATURA E CONSTRUÇÃO**

# BNEBIEARBEITUNG

**EL TECNICO DE MANTENIMIENTO MECANIZADO MANTIENE BUEÑAS AGARRES SUPERFICIALES.**

KÜRZERE BEARBEITUNGSZEITEN BEI KONSTANT GUTEN OBERFLÄCHEN



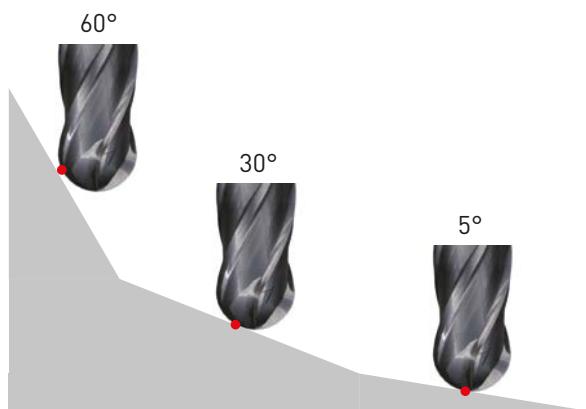
## **CONCEPTION DE LA FRAISE HÉMISPHÉRIQUE À 4 DENTS: CONCEPTION ET PRÉPARATION**

### ZASTOSOWANIA

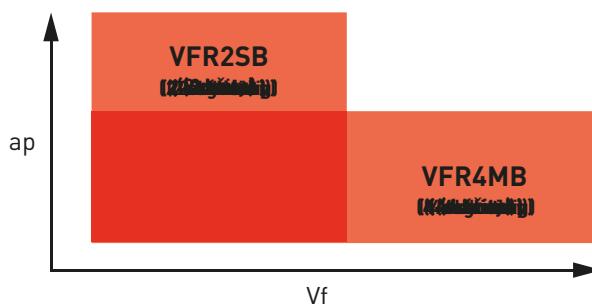
**ZASTOSUJOWANIE**  
Kiedy jest konieczne zmiany w kierunku bieguna głowicy, gru-  
pu i rurki nie może być dokonane jednocześnie, bo wówczas przed  
zakończeniem jednej operacji nie będzie już możliwości podjęcia  
decydującej o kolejności kolejnych operacji. W tym celu należy  
zadbać o taką ustawienie głowicy, aby zmiany kierunku głowicy  
i zmiany położenia głowicy i rurki nie wpływały na warunki  
przebiegu kolejnych operacji. W tym celu należy zawsze  
zajmować się zmianami kierunku głowicy przed zmianami po-  
łożenia głowicy i rurki, a zmianami położenia głowicy i rurki przed zmianami kierunku głowicy.



#### **ÁLBUM DE LA EXPOSICIÓN**



KOMPLETTENDE KÄRTE DER GEOMETRIE

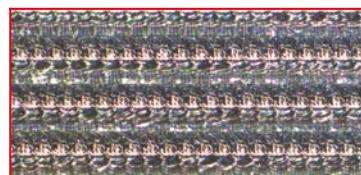


# VFR4MB

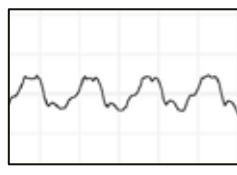
## Резец для обработки трубы

Резец VFR4MB разработан для обработки трубы из стали HSS-E 50.1200 (62HRC).

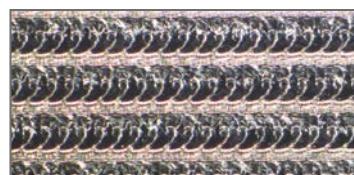
Сравнение с резцом VFR4MB показывает, что обработка трубы VFR4MB имеет лучшую производительность и меньшую стоимость.



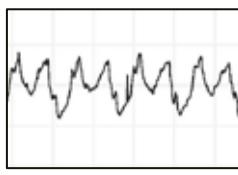
VFR4MB



Ra: 0.27 / Rz: 1.01



VFR4MB

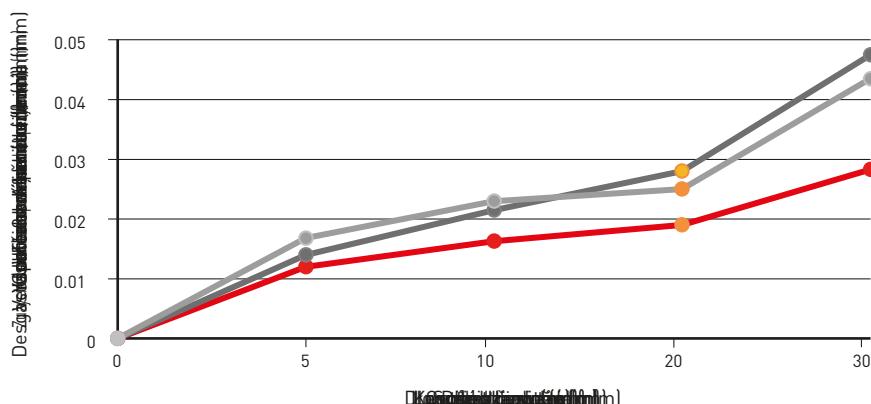


Ra: 0.32 / Rz: 1.62

Материал обрабатываемой трубы	HSS-E 50.1200 (62HRC)
Вид обработки	VFR4MBR0400 / DC=8 mm
n (об/мин)	12000
f (мм/драйв)	3600
ap (мм)	0.2
ae (мм)	0.8
Dиаметр резания (для каждого драйва) (мм)	20
Материал инструмента	Сталь высокотвердая
Направление обработки	Поверхность вспомогательной

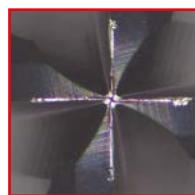
Резец VFR4MB разработан для обработки трубы из стали PMHS 77-711 (69HRC).

Сравнение с резцами VFR4MB показывает, что обработка трубы VFR4MB имеет лучшую производительность и меньшую стоимость.



Материал обрабатываемой трубы	PMHS 77-711 (69HRC)
Вид обработки	VFR4MBR0100 / DC=2mm
n (об/мин)	16000
f (мм/драйв)	1200
ap (мм)	0.06
ae (мм)	0.2
Dиаметр резания (для каждого драйва) (мм)	17
Материал инструмента	Сталь высокотвердая
Направление обработки	Поверхность вспомогательной
Модуль прочности	Динамическая прочность

Дополнительные фотографии обработки трубы диаметром 20 м



VFR4MB



инструмент А



инструмент В

# VFR2XLB

ЭЛЕКТРОННЫЕ СРЕДСТВА УПРАВЛЕНИЯ И ПРОГНОЗИРОВАНИЯ РАБОТЫ

Wysokość skrawania powinna wynosić co najmniej 10% głębokości skrawania, aby zapewnić stabilną pracę freza.



## PERFEKTE KUGELKOPFGEOMETRIE

Mittlere Schleifentfernung mit stark  
gezähnter Fließrichtung und tiefen Kavitäten  
Hinweis auf die Anwendungsfälle für die  
Schlichtbearbeitung in tiefen Kavitäten.

**Wszelkie prawa zastrzeżone. Wydanie: 2024-01-01. Wydawca: SIEBIEGIA**

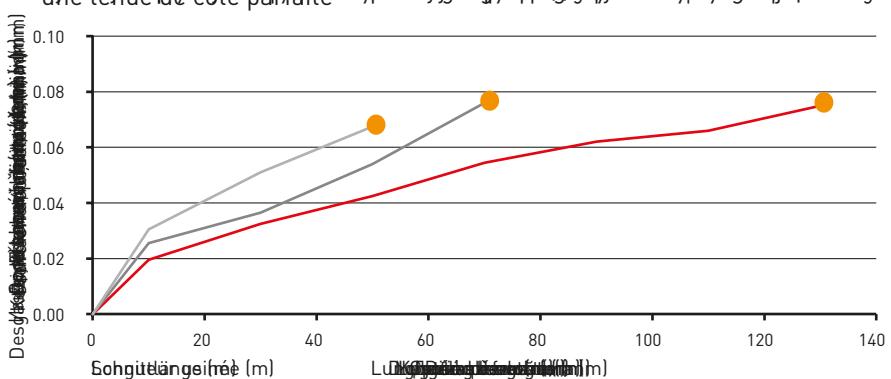
Bei komplexen Projekt mit 2 Schichten  
**Datums** (Menge) und **Wert** (Wert) je Schicht  
Kontrolliert die **Qualität** der **Produkte**  
Von **Qualitätsmanagement** übernommen.  
Die **Qualität** wird **extern** überprüft.  
Schlichtbearbeitung von Oberflächen.

**WILHELM WÖHLER & CO. LTD., NEW YORK**

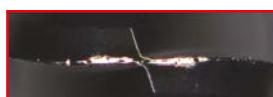
**Ergebnisse der Befragung** Die Ergebnisse der Befragungen sind in den folgenden Kapiteln dargestellt.

# RENDIMIENTO DE CORTE PERFORMANCES D'USINAGE

**RENDIMIENTO DE CORTE / PERFORMANCES D'USINAGE** verhindert Vibrationen speziell bei Anwendung in tiefen Schnitttiefen und langen Auskragungen.  
HRC: comparacion de la resistencia al desgaste. Usage d'acier rapide HS6-5-3 (62HRC) – Comparaison de la résistance à l'usure. HS6-5-3 es un acero rápido que resiste para un mecanizado de alta velocidad de corte y una duración de vida elevada. La resistencia a la usura es particularmente importante para el mecanizado de alta velocidad de corte para una duración de vida elevada. Una tendencia a la corrosión se ha eliminado.



<b>Materiales utilizados para la pieza</b>	1.3344 (62HRC)
<b>Velocidad de corte</b>	VFR2XLBR0100N120
<b>n (min⁻¹)</b>	1600
<b>f (mm/min)</b>	1600
<b>fz (mm/zarzo)</b>	0.05
<b>ap (mm)</b>	0.05 x 10
<b>ae (mm)</b>	0.1 x 10
<b>Alcance de corte (mm)</b>	18
<b>Tipo de herramienta</b>	SEGMUND Härtskärtme
<b>Máximo catenoso</b>	PAHL 1000 (https://www.pahl.com/produkte/pahl-1000/)



VFR2XLB



CEH-0916-K1-YCLX-JL-WAAA



CEH-004-K-11-CEM-0000-BBB

# VFR

## ÖVRÄSCHIKATE ÖPNC

Produkt- detal Kopčia	Tvar hrotu	DC						Icon
			P	H	M	S	N	
<b>KRÁTKÝ HROTEK VFR</b>								
<b>NEW</b> VFR4MB	Pravový hrot s vysokou precízne štvorcovou stopkou, ktorá je výhodou pre výrobu	1-12	○	○				7
VFR2XLB	Krátke hroty s vysokou precízne štvorcovou stopkou, ktorá je výhodou pre výrobu	0.2-6	○	○				9
VFR2SSB	Štandardné hroty s vysokou precízne štvorcovou stopkou	1-12	○	○				15
VFR2SB	štandardné hroty s vysokou precízne štvorcovou stopkou	0.2-20	○	○				17
VFR2SBF	Sferičný hrot s vysokou precízne štvorcovou stopkou, ktorá je výhodou pre výrobu	1-6	○	○				21
<b>ŠTANDARDNÉ HROTY VFR NAROŽA</b>								
VFRPSRB	štandardné hroty s vysokou precízne štvorcovou stopkou	0.5-12	○	○				23

# VFR4MB

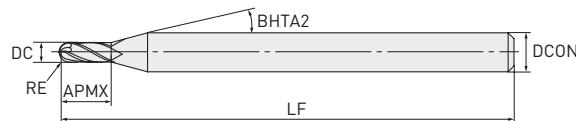


**KŁĘCZAKI DO WYKONYWANIA DŁUGICH, GŁĘBOKICH, WYSOKO PRECZYSTYCH DŁUŻEŃ,**  
**DŁUŻEŃ Z WYSOKĄ JEDNOLIŚCI**

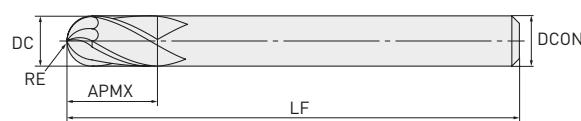
H



1



2



RE

±0.010



DCON = 6   8 &lt; DCON &lt; 10   DCON = 12

0	0	0
- 0.008	- 0.009	- 0.011

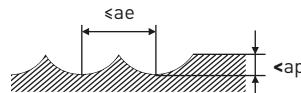
- **Skuteczny i efektywny do wykonywania głębokich, długich i gęstych skrawów.** Wykonanie głębokich skrawów z dużą dokładnością i efektywnością hoher Effizienz.

Numer modelu	Wysokość Długość	RE	DC	APMX	LF	BHTA2	DCON	ZEFP	Typ
VFR4MBR0050	●	0.5	1	2.5	50	15	6	4	1
VFR4MBR0100	●	1	2	6	60	15	6	4	1
VFR4MBR0150	●	1.5	3	8	70	15	6	4	1
VFR4MBR0200	●	2	4	8	70	15	6	4	1
VFR4MBR0250	●	2.5	5	12	80	15	6	4	1
VFR4MBR0300	●	3	6	12	80	—	6	4	2
VFR4MBR0400	●	4	8	14	90	—	8	4	2
VFR4MBR0500	●	5	10	18	100	—	10	4	2
VFR4MBR0600	●	6	12	22	110	—	12	4	2

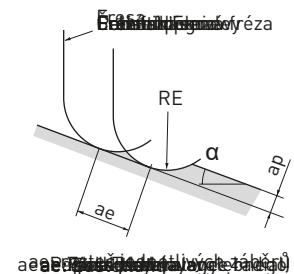
# VFR4MB

**ŽE SE BĚHOM VÝKONU VÝROBY MĚŘÍME VÝROBENÉ KVALITNÍ STAVY**

Materiał obrabiany	RE	$\alpha \leq 15^\circ$		$\alpha > 15^\circ$		ap	ae
		n	f	n	f		
Stal narzędziowa, głik (45-55 HRC)	0.5	40000	8000	40000	3800	0.06	0.10
	1.0	40000	9600	40000	5600	0.11	0.20
	1.5	40000	12000	32000	5600	0.13	0.30
	2.0	32000	11000	24000	4700	0.15	0.40
	2.5	25000	9000	19000	3800	0.20	0.50
	3.0	21000	8400	15000	3400	0.25	0.60
	4.0	16000	6400	12000	2600	0.30	0.80
	5.0	13000	5200	9600	2200	0.50	1.00
	6.0	9000	3600	7200	1700	0.50	1.20
	0.5	40000	5600	40000	3100	0.05	0.10
H. Stal narzędziowa, głik (55-65 HRC)	1.0	40000	8000	28000	3100	0.10	0.20
	1.5	32000	7700	19000	2900	0.12	0.30
	2.0	24000	6200	14000	2500	0.13	0.40
	2.5	19000	5300	12000	2200	0.15	0.50
	3.0	16000	4800	9600	2000	0.20	0.60
	4.0	12000	3600	7200	1600	0.20	0.80
	5.0	10000	3200	5800	1300	0.20	1.00
	6.0	7000	2200	4300	940	0.30	1.20
	0.5	40000	4700	32000	1700	0.03	0.10
	1.0	24000	5000	16000	1200	0.06	0.20
Stal narzędziowa, głik (65-70 HRC)	1.5	16000	4200	11000	1100	0.07	0.30
	2.0	12000	3100	8000	1000	0.08	0.40
	2.5	9600	2700	6000	780	0.08	0.50
	3.0	8000	2300	5000	780	0.09	0.60
	4.0	6000	1900	4000	620	0.09	0.80
	5.0	4800	1500	3000	550	0.10	1.00
	6.0	3600	1100	2200	400	0.10	1.20



1. **Qualità e durata**: I prodotti della **Wacker Chemie** sono rinomati per la loro qualità superiore e durata. La gamma di prodotti copre una vasta gamma di applicazioni, dalla costruzione all'industria chimica.
  2. **Sostenibilità**: La **Wacker Chemie** è un leader nel settore dell'innovazione e della sostenibilità. I suoi prodotti sono progettati per ridurre l'impatto ambientale e le emissioni di CO<sub>2</sub>.
  3. **Collegamenti internazionali**: La **Wacker Chemie** ha uffici e impianti di produzione in tutto il mondo, compreso l'Europa, l'Asia e l'America del Nord.

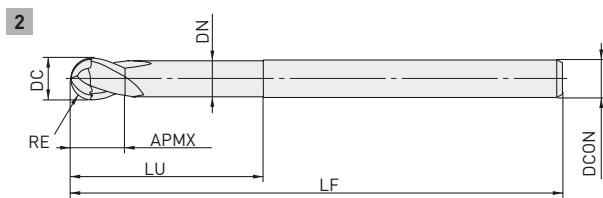
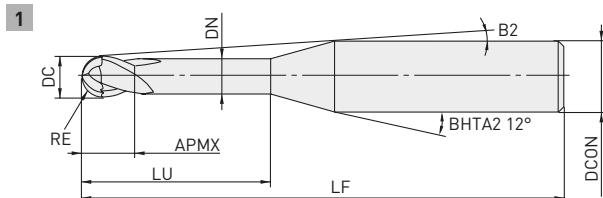


# VFR2XLB



BALL NOSE END MILL VFR2XLB 20° B20° BHTA2 12° CHANCE DONGA

H



RE &lt; 3

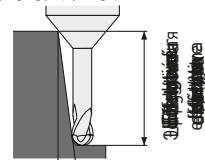
 $\pm 0.005$ 

4 &lt; DCON &lt; 6

0

- 0.005

Longitudinal tolerance  
indicated by the  
dimensions of the hole  
pepper.



Angle of 12° between the axis and the base plane.

- Pełny zakres głębokości obróbki jest uzyskany poprzez zmianę kąta nachylenia głębokości obróbki (BHTA) i kąta nachylenia głębokości obróbki (ZEFP) na czole freza.

Nazwa produktu	RE	DC	APMX	LU	DN	LF	DCON	B2	ZEFP	Długość głębokości obróbki pepper. 4.5° 5.5° 6.5° 7.5°					
										Time	0.5°	1°	2°	3°	
VFR2XLBR0010N005	●	0.1	0.2	0.15	0.5	0.18	50	4	11.5°	2	1	0.5	0.5	0.6	0.7
VFR2XLBR0010N010	●	0.1	0.2	0.15	1	0.18	50	4	10.9°	2	1	1	1.1	1.2	1.3
VFR2XLBR0015N010	●	0.15	0.3	0.24	1	0.28	50	4	10.9°	2	1	1	1.1	1.2	1.3
VFR2XLBR0015N015	●	0.15	0.3	0.24	1.5	0.28	50	4	10.4°	2	1	1.6	1.6	1.8	2
VFR2XLBR0015N020	●	0.15	0.3	0.24	2	0.28	50	4	9.9°	2	1	2.1	2.2	2.4	2.6
VFR2XLBR0020N010	●	0.2	0.4	0.3	1	0.37	50	4	11°	2	1	1	1.1	1.2	1.3
VFR2XLBR0020N015	●	0.2	0.4	0.3	1.5	0.37	50	4	10.4°	2	1	1.5	1.6	1.7	1.9
VFR2XLBR0020N020	●	0.2	0.4	0.3	2	0.37	50	4	9.9°	2	1	2.1	2.2	2.3	2.6
VFR2XLBR0020N025	●	0.2	0.4	0.3	2.5	0.37	50	4	9.5°	2	1	2.6	2.7	2.9	3.3
VFR2XLBR0020N030	●	0.2	0.4	0.3	3	0.37	50	4	9.1°	2	1	3.1	3.2	3.5	3.9
VFR2XLBR0020N040	●	0.2	0.4	0.3	4	0.37	50	4	8.4°	2	1	4.2	4.3	4.7	5.2
VFR2XLBR0025N015	●	0.25	0.5	0.37	1.5	0.47	50	4	10.4°	2	1	1.5	1.6	1.7	1.9
VFR2XLBR0025N020	●	0.25	0.5	0.37	2	0.47	50	4	9.9°	2	1	2.1	2.1	2.3	2.6
VFR2XLBR0025N025	●	0.25	0.5	0.37	2.5	0.47	50	4	9.5°	2	1	2.6	2.7	2.9	3.2
VFR2XLBR0025N030	●	0.25	0.5	0.37	3	0.47	50	4	9.1°	2	1	3.1	3.2	3.5	3.9
VFR2XLBR0025N040	●	0.25	0.5	0.37	4	0.47	50	4	8.3°	2	1	4.1	4.3	4.7	5.2
VFR2XLBR0030N020	●	0.3	0.6	0.45	2	0.57	50	4	9.9°	2	1	2.1	2.2	2.4	2.6
VFR2XLBR0030N020S06	●	0.3	0.6	0.45	2	0.57	50	6	10.6°	2	1	2.1	2.2	2.4	2.6
VFR2XLBR0030N030	●	0.3	0.6	0.45	3	0.57	50	4	9°	2	1	3.1	3.3	3.6	4
VFR2XLBR0030N030S06	●	0.3	0.6	0.45	3	0.57	50	6	9.9°	2	1	3.1	3.3	3.6	4

1. ~~Pełny zakres głębokości obróbki jest uzyskany poprzez zmianę kąta nachylenia głębokości obróbki (BHTA) i kąta nachylenia głębokości obróbki (ZEFP) na czole freza.~~

12 Vc

● ~~Pełny zakres głębokości obróbki jest uzyskany poprzez zmianę kąta nachylenia głębokości obróbki (BHTA) i kąta nachylenia głębokości obróbki (ZEFP) na czole freza.~~

9

**VFR2XLB - DANE DLA WYKONANIA KONTROLNYCH TESTÓW NA DŁUŻEJ DYSTANSIE**

Dane konstrukcyjne i techniczne samochodu	Dane dotyczące warunków jazdy i warunków testowania	Typ	Dane dotyczące parametrów pojazdu w warunkach jazdy na drogach brukowanych												
			RE	DC	APMX	LU	DN	LF	DCON	B2	ZEFF	0.5°	1°	2°	3°
VFR2XLBR0030N040	●	0.3	0.6	0.45	4	0.57	50	4	8.2°	2	1	4.2	4.4	4.8	5.3
VFR2XLBR0030N050	●	0.3	0.6	0.45	5	0.57	50	4	7.6°	2	1	5.2	5.5	6	6.6
VFR2XLBR0030N060	●	0.3	0.6	0.45	6	0.57	50	4	7.1°	2	1	6.3	6.6	7.2	7.9
VFR2XLBR0040N030	●	0.4	0.8	0.6	3	0.77	50	4	8.9°	2	1	3.1	3.3	3.6	3.9
VFR2XLBR0040N040	●	0.4	0.8	0.6	4	0.77	50	4	8.2°	2	1	4.2	4.4	4.8	5.2
VFR2XLBR0040N060	●	0.4	0.8	0.6	6	0.77	50	4	6.9°	2	1	6.3	6.5	7.2	7.9
VFR2XLBR0040N080	●	0.4	0.8	0.6	8	0.77	50	4	6°	2	1	8.4	8.7	9.5	10.6
VFR2XLBR0050N030	●	0.5	1	0.75	3	0.96	50	4	8.7°	2	1	3.2	3.4	3.7	4.1
VFR2XLBR0050N030S06	●	0.5	1	0.75	3	0.96	50	6	9.8°	2	1	3.2	3.4	3.7	4.1
VFR2XLBR0050N040	●	0.5	1	0.75	4	0.96	50	4	7.9°	2	1	4.3	4.5	4.9	5.4
VFR2XLBR0050N040S06	●	0.5	1	0.75	4	0.96	50	6	9.2°	2	1	4.3	4.5	4.9	5.4
VFR2XLBR0050N060	●	0.5	1	0.75	6	0.96	50	4	6.7°	2	1	6.3	6.5	7.2	7.9
VFR2XLBR0050N060S06	●	0.5	1	0.75	6	0.96	50	6	8.2°	2	1	6.3	6.5	7.2	7.9
VFR2XLBR0050N080	●	0.5	1	0.75	8	0.96	50	4	5.8°	2	1	8.5	8.9	9.7	10.7
VFR2XLBR0050N100	●	0.5	1	0.75	10	0.96	50	4	5.1°	2	1	10.6	11.1	12.1	13.4
VFR2XLBR0050N120	●	0.5	1	0.75	12	0.96	50	4	4.6°	2	1	12.7	13.2	14.5	16
VFR2XLBR0075N060	●	0.75	1.5	1.1	6	1.44	50	4	6.3°	2	1	6.3	6.6	7.2	7.9
VFR2XLBR0075N060S06	●	0.75	1.5	1.1	6	1.44	50	6	8°	2	1	6.3	6.6	7.2	7.9
VFR2XLBR0075N080	●	0.75	1.5	1.1	8	1.44	50	4	5.4°	2	1	8.4	8.8	9.6	10.6
VFR2XLBR0075N080S06	●	0.75	1.5	1.1	8	1.44	50	6	7.2°	2	1	8.4	8.8	9.6	10.6
VFR2XLBR0075N100	●	0.75	1.5	1.1	10	1.44	50	4	4.7°	2	1	10.5	11	12	13.2
VFR2XLBR0075N120	●	0.75	1.5	1.1	12	1.44	50	4	4.2°	2	1	12.6	13.1	14.4	15.9
VFR2XLBR0075N140	●	0.75	1.5	1.1	14	1.44	50	4	3.8°	2	1	14.7	15.3	16.8	18.5
VFR2XLBR0075N160	●	0.75	1.5	1.1	16	1.44	60	4	3.4°	2	1	16.8	17.5	19.2	21.2
VFR2XLBR0100N060	●	1	2	1.5	6	1.94	50	4	5.8°	2	1	6.3	6.6	7.1	7.8
VFR2XLBR0100N060S06	●	1	2	1.5	6	1.94	50	6	7.8°	2	1	6.3	6.6	7.1	7.8
VFR2XLBR0100N080	●	1	2	1.5	8	1.94	50	4	4.8°	2	1	8.4	8.8	9.5	10.5
VFR2XLBR0100N080S06	●	1	2	1.5	8	1.94	50	6	6.9°	2	1	8.4	8.8	9.5	10.5
VFR2XLBR0100N100	●	1	2	1.5	10	1.94	50	4	4.2°	2	1	10.5	10.9	11.9	13.1
VFR2XLBR0100N100S06	●	1	2	1.5	10	1.94	50	6	6.2°	2	1	10.5	10.9	11.9	13.1
VFR2XLBR0100N120	●	1	2	1.5	12	1.94	50	4	3.6°	2	1	12.6	13.1	14.3	15.8
VFR2XLBR0100N120S06	●	1	2	1.5	12	1.94	50	6	5.6°	2	1	12.6	13.1	14.3	15.8
VFR2XLBR0100N160	●	1	2	1.5	16	1.94	60	4	2.9°	2	1	16.8	17.5	19.1	*
VFR2XLBR0100N160S06	●	1	2	1.5	16	1.94	60	6	4.7°	2	1	16.8	17.5	19.1	21.1
VFR2XLBR0100N200	●	1	2	1.5	20	1.94	60	4	2.4°	2	1	20.9	21.8	23.9	*
VFR2XLBR0100N200S06	●	1	2	1.5	20	1.94	60	6	4°	2	1	20.9	21.8	23.9	26.4
VFR2XLBR0125N100	●	1.25	2.5	1.9	10	2.4	60	4	3.5°	2	1	10.4	10.8	11.8	12.9
VFR2XLBR0125N150	●	1.25	2.5	1.9	15	2.4	60	4	2.5°	2	1	15.6	16.3	17.8	*
VFR2XLBR0150N100	●	1.5	3	2.3	10	2.9	60	6	5.5°	2	1	10.4	10.8	11.7	12.9
VFR2XLBR0150N120	●	1.5	3	2.3	12	2.9	60	6	4.9°	2	1	12.5	13	14.1	15.5
VFR2XLBR0150N160	●	1.5	3	2.3	16	2.9	70	6	4°	2	1	16.7	17.3	18.9	20.8
VFR2XLBR0150N200	●	1.5	3	2.3	20	2.9	70	6	3.4°	2	1	20.8	21.7	23.7	26.1
VFR2XLBR0150N250	●	1.5	3	2.3	25	2.9	70	6	2.8°	2	1	26.1	27.2	29.7	*
VFR2XLBR0150N300	●	1.5	3	2.3	30	2.9	70	6	2.5°	2	1	31.3	32.6	35.7	*

1. Wszystkie dane techniczne i parametry pojazdu podane w tabeli dotyczą pojazdu VFR.

\* Dostępny na żądanie.

**VFR2XLB - DANE DLA WYKONANIA RĘCZNEGO PLANU ESCAPE**

Dane techniczne samochodu	Typ	Dane operacyjne samochodu										
		0.5°	1°	2°	3°							
RE	DC	APMX	LU	DN	LF	DCON	B2	ZEFF				
VFR2XLBR0200N100	●	2	4	3	10	3.9	70	6	4.5°	2	1	10.4
VFR2XLBR0200N120	●	2	4	3	12	3.9	70	6	3.9°	2	1	12.5
VFR2XLBR0200N160	●	2	4	3	16	3.9	70	6	3.1°	2	1	16.6
VFR2XLBR0200N200	●	2	4	3	20	3.9	70	6	2.6°	2	1	20.8
VFR2XLBR0200N250	●	2	4	3	25	3.9	70	6	2.1°	2	1	26
VFR2XLBR0200N300	●	2	4	3	30	3.9	70	6	1.8°	2	1	31.2
VFR2XLBR0250N200	●	2.5	5	3.8	20	4.9	70	6	1.5°	2	1	20.8
VFR2XLBR0250N250	●	2.5	5	3.8	25	4.9	70	6	1.2°	2	1	26
VFR2XLBR0300N180	●	3	6	6	18	5.85	80	6	—	2	2	*
VFR2XLBR0300N300	●	3	6	6	30	5.85	80	6	—	2	2	*

1. Wszystkie dane techniczne samochodu pochodzą z modelu VFR2XLBR0200N200. Wszystkie dane operacyjne samochodu VFR.

\* Wykonanie ręczne doza



# VFR2XLB

~~ÖZEL İŞLETİMİNDE KULLANILMAK İSTENEN İŞLEMLER~~

**Materyale**

RE	LU	n	f	ap	ae
0.1	0.5	40000	300	0.003	0.01
0.1	1	40000	300	0.002	0.01
0.15	1	40000	500	0.007	0.015
0.15	1.5	40000	500	0.005	0.015
0.15	2	40000	500	0.003	0.015
0.2	1	40000	1400	0.015	0.02
0.2	1.5	40000	1000	0.01	0.02
0.2	2	40000	1000	0.01	0.02
0.2	2.5	40000	700	0.005	0.02
0.2	3	40000	700	0.005	0.02
0.2	4	40000	600	0.004	0.02
0.25	1.5	40000	2000	0.02	0.025
0.25	2	40000	2000	0.02	0.025
0.25	2.5	40000	1500	0.015	0.025
0.25	3	40000	1200	0.015	0.025
0.25	4	36000	900	0.1	0.025
0.3	2	40000	2800	0.03	0.03
0.3	3	40000	2800	0.03	0.03
0.3	4	35000	2000	0.02	0.03
0.3	5	30000	1000	0.01	0.03
0.3	6	30000	800	0.008	0.03
0.4	3	40000	3000	0.04	0.04
0.4	4	40000	3000	0.02	0.04
0.4	6	30000	1600	0.02	0.04
0.4	8	25000	1000	0.01	0.04
0.5	3	40000	4000	0.05	0.05
0.5	4	40000	4000	0.05	0.05
0.5	6	35000	2000	0.03	0.05
0.5	8	30000	1600	0.02	0.05
0.5	10	20000	1000	0.01	0.05
0.5	12	20000	1000	0.01	0.05
0.75	6	40000	5000	0.07	0.075
0.75	8	40000	5000	0.07	0.075
0.75	10	40000	4500	0.06	0.075
0.75	12	32000	3400	0.04	0.075
0.75	14	16000	1500	0.04	0.075
0.75	16	13000	1200	0.03	0.075
1	6	40000	6000	0.1	0.1
1	8	40000	5000	0.1	0.1
1	10	40000	5000	0.08	0.1
1	12	40000	5000	0.08	0.1
1	16	32000	3500	0.05	0.1
1	20	10000	1000	0.04	0.1
1.25	10	36000	5000	0.12	0.25
1.25	15	36000	4600	0.08	0.25
1.5	10	32000	5100	0.15	0.3
1.5	12	32000	5100	0.13	0.3

H Sertleştirilmiş çelik  
[45-55 HRC])

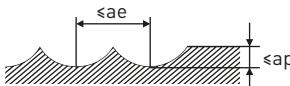
**VFR2XLB**

<b>Metal Tipi</b>	<b>RE</b>	<b>LU</b>	<b>n</b>	<b>f</b>	<b>ap</b>	<b>ae</b>
H Sertlestirilmis celik [45-55 HRC]	1.5	16	32000	4500	0.1	0.3
	1.5	20	27000	3800	0.1	0.3
	1.5	25	21000	2700	0.08	0.3
	1.5	30	9000	1000	0.08	0.3
	2	10	24000	4800	0.2	0.4
	2	12	24000	4800	0.2	0.4
	2	16	24000	3800	0.15	0.4
	2	20	24000	3800	0.15	0.4
	2	25	24000	3800	0.15	0.4
	2	30	24000	3000	0.1	0.4
	2.5	20	19000	3400	0.2	0.5
	2.5	25	19000	3400	0.2	0.5
	3	18	16000	3500	0.25	0.6
	3	30	16000	3500	0.2	0.6
	0.1	0.5	40000	300	0.002	0.01
H Sertlestirilmis celik [55-70 HRC]	0.1	1	40000	300	0.002	0.01
	0.15	1	40000	500	0.005	0.015
	0.15	1.5	40000	500	0.003	0.015
	0.15	2	40000	500	0.002	0.015
	0.2	1	40000	1400	0.01	0.02
	0.2	1.5	40000	1000	0.006	0.02
	0.2	2	40000	1000	0.006	0.02
	0.2	2.5	40000	700	0.003	0.02
	0.2	3	40000	700	0.003	0.02
	0.2	4	40000	500	0.003	0.02
	0.25	1.5	40000	2000	0.015	0.025
	0.25	2	40000	2000	0.015	0.025
	0.25	2.5	40000	1500	0.01	0.025
	0.25	3	40000	1200	0.01	0.025
	0.25	4	36000	900	0.007	0.025
H Sertlestirilmis celik [70-80 HRC]	0.3	2	40000	2800	0.02	0.03
	0.3	3	40000	2800	0.02	0.03
	0.3	4	35000	2000	0.015	0.03
	0.3	5	30000	1000	0.007	0.03
	0.3	6	30000	800	0.005	0.03
	0.4	3	40000	3000	0.03	0.04
	0.4	4	40000	3000	0.015	0.04
	0.4	6	30000	1600	0.01	0.04
	0.4	8	25000	1000	0.007	0.04
	0.5	3	40000	4000	0.04	0.05
	0.5	4	40000	4000	0.04	0.05
	0.5	6	35000	2000	0.02	0.05
	0.5	8	30000	1600	0.01	0.05
	0.5	10	20000	1000	0.01	0.05
	0.5	12	20000	800	0.008	0.05
H Sertlestirilmis celik [80-90 HRC]	0.75	6	40000	4000	0.06	0.075
	0.75	8	40000	3500	0.06	0.075
	0.75	10	40000	2400	0.06	0.075
	0.75	12	32000	2000	0.04	0.075
	0.75	14	16000	1200	0.03	0.075

## VFR2XLB

Materyale	RE	LU	n	f	ap	ae
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H Sertlestirilmis celik (55-70 HRC)	0.75	16	13000	1200	0.02	0.075
	1	6	40000	3400	0.1	0.1
	1	8	40000	3000	0.1	0.1
	1	10	40000	3000	0.07	0.1
	1	12	40000	2600	0.05	0.1
	1	16	32000	1700	0.03	0.1
	1	20	10000	1000	0.03	0.1
	1.25	10	36000	2600	0.11	0.25
	1.25	15	36000	2000	0.075	0.25
	1.5	10	32000	2200	0.15	0.3
	1.5	12	32000	2200	0.13	0.3
	1.5	16	32000	1800	0.1	0.3
	1.5	20	27000	1600	0.06	0.3
	1.5	25	21000	1200	0.06	0.3
	1.5	30	9000	700	0.05	0.3
	2	10	24000	2200	0.2	0.4
	2	12	24000	2200	0.2	0.4
	2	16	24000	1500	0.15	0.4
	2	20	24000	1500	0.15	0.4
	2	25	24000	1100	0.1	0.4
	2	30	24000	1100	0.08	0.4
	2.5	20	19000	1400	0.2	0.5
	2.5	25	19000	1400	0.2	0.5
	3	18	16000	1000	0.2	0.6
	3	30	16000	1000	0.2	0.6



1. ~~El eje de rotación se ha establecido en el punto de la pieza que se considera más apropiado para el desarrollo de la velocidad de avance.~~
2. ~~El eje de rotación se ha establecido en el punto de la pieza que se considera más apropiado para el desarrollo de avance.~~
3. ~~El eje de rotación se ha establecido en el punto de la pieza que se considera más apropiado para el desarrollo de avance.~~

# VFR2SSB

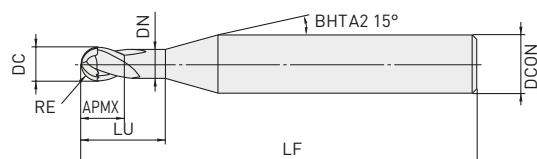


~~BRD 2018/2019~~ ~~BRD 2019/2020~~ ~~BRD 2020/2021~~ ~~BRD 2021/2022~~ ~~BRD 2022/2023~~ ~~BRD 2023/2024~~

H

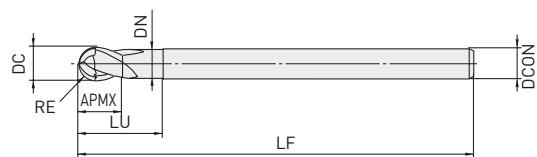


1

 $RE \leq 6$  $\pm 0.005$  $4 \leq DCON \leq 6 \quad 8 \leq DCON \leq 10 \quad DCON = 12$ 

0	0	0
- 0.005	- 0.006	- 0.008

2

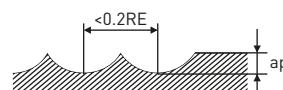


Typ przedmiotu	Wymiary	RE	DC	APMX	LU	DN	LF	DCON	ZEFP	TYP
VFR2SSBR0050S04	●	0.5	1	1	2	0.94	40	4	2	1
VFR2SSBR0050	●	0.5	1	1	2	0.94	40	6	2	1
VFR2SSBR0075S04	●	0.75	1.5	1.5	3	1.44	40	4	2	1
VFR2SSBR0075	●	0.75	1.5	1.5	3	1.44	40	6	2	1
VFR2SSBR0100	●	1	2	2	4	1.9	45	6	2	1
VFR2SSBR0150	●	1.5	3	3	6	2.9	45	6	2	1
VFR2SSBR0200	●	2	4	4	8	3.9	45	6	2	1
VFR2SSBR0250	●	2.5	5	5	10	4.9	50	6	2	1
VFR2SSBR0300	●	3	6	6	12	5.85	50	6	2	2
VFR2SSBR0400	●	4	8	8	14	7.85	60	8	2	2
VFR2SSBR0500	●	5	10	10	18	9.7	70	10	2	2
VFR2SSBR0600	●	6	12	12	22	11.7	75	12	2	2

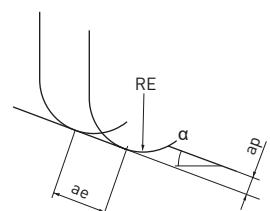
# VFR2SSB

## ÖZEL İŞLEMLERDE İLGİLİ İŞLEM parametresi

Materyale	RE	Aşağıda verilen $\alpha < 15^\circ$		Aşağıda verilen $\alpha > 15^\circ$		ap	ae
		n	f	n	f		
H Sertleştirilmiş çelik (45–55 HRC)	R 0.5	40000	8000	40000	3200	0.06	0.10
	R 0.75	40000	9600	40000	4000	0.09	0.15
	R 1	40000	9600	39000	4700	0.11	0.20
	R 1.5	40000	12000	27000	4300	0.13	0.30
	R 2	32000	10880	20000	3600	0.15	0.40
	R 2.5	25000	9000	16000	2900	0.20	0.50
	R 3	21000	8400	13000	2600	0.25	0.60
	R 4	16000	6400	10000	2000	0.30	0.80
	R 5	13000	5200	8000	1700	0.50	1.00
	R 6	9000	3600	6000	1300	0.50	1.20
H Sertleştirilmiş çelik (55–62 HRC)	R 0.5	40000	5600	40000	2400	0.05	0.10
	R 0.75	40000	7200	32000	2500	0.075	0.15
	R 1	40000	8000	24000	2400	0.1	0.20
	R 1.5	32000	7700	16000	2200	0.12	0.30
	R 2	24000	6200	12000	1900	0.13	0.40
	R 2.5	19000	5300	9600	1700	0.15	0.50
	R 3	16000	4800	8000	1600	0.2	0.60
	R 4	12000	3600	6000	1200	0.2	0.80
	R 5	10000	3200	4800	960	0.2	1.00
	R 6	7000	2200	3600	720	0.3	1.20
H Sertleştirilmiş çelik (62–70 HRC)	R 0.5	40000	3600	32000	1300	0.04	0.10
	R 0.75	32000	4500	21000	1200	0.05	0.15
	R 1	24000	3800	16000	1000	0.07	0.20
	R 1.5	16000	3200	11000	880	0.09	0.30
	R 2	12000	2400	8000	800	0.1	0.40
	R 2.5	9600	2100	6000	600	0.1	0.50
	R 3	8000	1700	5000	600	0.11	0.60
	R 4	6000	1400	4000	480	0.11	0.80
	R 5	4800	1100	3000	420	0.12	1.00
	R 6	3600	860	2200	310	0.12	1.20



- $\alpha < 15^\circ$  için  $ap \leq 0.2RE$  olmalıdır.
- $\alpha > 15^\circ$  için  $ap$  değeri azaltılarak veya biraz daha küçük bir RE değerinin kullanıldığından  $ap$  değeri azaltılmalıdır.



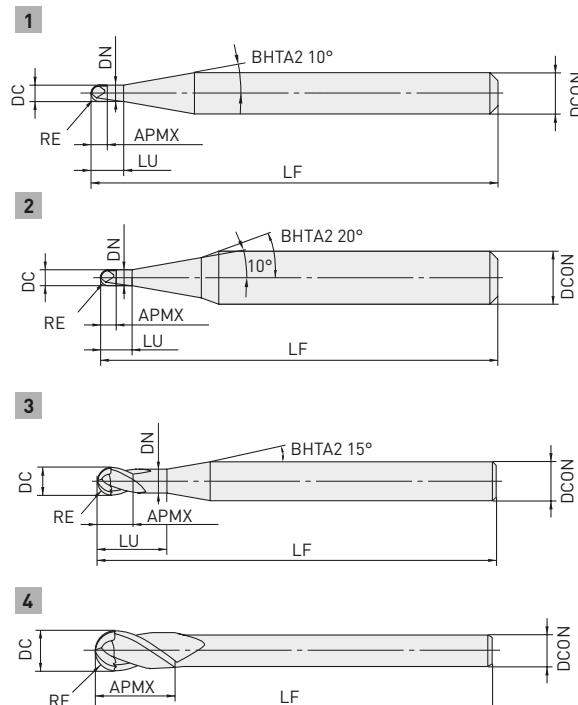
# VFR2SB



~~БЫСТРЫЙ ВРЕМЯ ОБРАБОТКИ И ВЫСОКАЯ ТВЕРДОСТЬ~~

~~КОМПАКТНЫЙ ДИЗАЙН И ВЫСОКАЯ ПРОДУКТИВНОСТЬ~~

H



RE ≤ 6

±0.005 ±0.010



DCON = 3 4 ≤ DCON ≤ 6 8 ≤ DCON ≤ 10 DCON = 12,16 DCON = 20

0 - 0.004	0 - 0.005	0 - 0.006	0 - 0.008	0 - 0.009
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Spawalniczy	Wykonanie	RE	DC	APMX	LU	DN	LF	DCON	ZEPF	Typ
VFR2SBR0010	●	0.1	0.2	0.2	0.4	0.17	45	4	2	1
VFR2SBR0010S06	●	0.1	0.2	0.2	0.4	0.17	50	6	2	2
VFR2SBR0015	●	0.15	0.3	0.3	0.6	0.27	45	4	2	1
VFR2SBR0015S06	●	0.15	0.3	0.3	0.6	0.27	50	6	2	2
VFR2SBR0020	●	0.2	0.4	0.4	0.8	0.36	45	4	2	1
VFR2SBR0020S06	●	0.2	0.4	0.4	0.8	0.36	50	6	2	2
VFR2SBR0030	●	0.3	0.6	0.6	1.2	0.56	45	4	2	3
VFR2SBR0030S06	●	0.3	0.6	0.6	1.2	0.56	50	6	2	3
VFR2SBR0040	●	0.4	0.8	0.8	1.6	0.76	45	4	2	3
VFR2SBR0040S06	●	0.4	0.8	0.8	1.6	0.76	50	6	2	3
VFR2SBR0050	●	0.5	1	1	2	0.94	45	4	2	3
VFR2SBR0050S06	●	0.5	1	1	2	0.94	50	6	2	3
VFR2SBR0060	●	0.6	1.2	1.2	2.4	1.14	45	4	2	3
VFR2SBR0060S06	●	0.6	1.2	1.2	2.4	1.14	50	6	2	3

**VFR2SB - [REDACTED] - [REDACTED]**

<b>Symbolikum</b>	<b>Hesztat</b>	<b>Disponibilită</b>	<b>RE</b>	<b>DC</b>	<b>APMX</b>	<b>LU</b>	<b>DN</b>	<b>LF</b>	<b>DCON</b>	<b>ZEFP</b>	<b>Type</b>
VFR2SBR0070	●	0.7	1.4	1.4	2.8	1.34	45	4	2	3	
VFR2SBR0070S06	●	0.7	1.4	1.4	2.8	1.34	50	6	2	3	
VFR2SBR0075	●	0.75	1.5	1.5	3	1.44	45	4	2	3	
VFR2SBR0075S06	●	0.75	1.5	1.5	3	1.44	50	6	2	3	
VFR2SBR0080	●	0.8	1.6	1.6	3.2	1.54	45	4	2	3	
VFR2SBR0080S06	●	0.8	1.6	1.6	3.2	1.54	50	6	2	3	
VFR2SBR0090	●	0.9	1.8	1.8	3.6	1.74	45	4	2	3	
VFR2SBR0090S06	●	0.9	1.8	1.8	3.6	1.74	50	6	2	3	
VFR2SBR0100	●	1	2	2	4	1.9	50	4	2	3	
VFR2SBR0100S06	●	1	2	2	4	1.9	60	6	2	3	
VFR2SBR0125S06	●	1.25	2.5	2.5	5	2.4	60	6	2	3	
VFR2SBR0150S03	●	1.5	3	3	—	—	60	3	2	4	
VFR2SBR0150	●	1.5	3	3	6	2.9	70	6	2	3	
VFR2SBR0200S04	●	2	4	4	—	—	60	4	2	4	
VFR2SBR0200	●	2	4	4	8	3.9	70	6	2	3	
VFR2SBR0250	●	2.5	5	5	10	4.9	80	6	2	3	
VFR2SBR0300	●	3	6	12	—	—	80	6	2	4	
VFR2SBR0400	●	4	8	14	—	—	90	8	2	4	
VFR2SBR0500	●	5	10	18	—	—	100	10	2	4	
VFR2SBR0600	●	6	12	22	—	—	110	12	2	4	
VFR2SBR0800	●	8	16	30	—	—	140	16	2	4	
VFR2SBR1000	●	10	20	38	—	—	160	20	2	4	

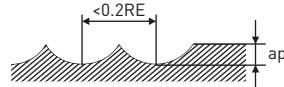
# VFR2SB

## ÖZEL İŞLEMLİ ÇELİKLERDE VFR İŞLEMLERİNİN İNDEKSİ

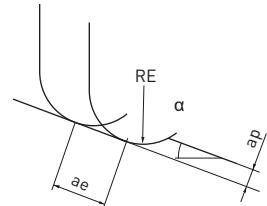
Materyale	RE	Ağır İşlemlerdeki $\alpha < 15^\circ$		Ağır İşlemlerdeki $\alpha > 15^\circ$		ap	ae
		n	f	n	f		
H Sertleştirilmiş çelik (45–55 HRC)	R 0.1	40000	320	40000	240	0.003	0.02
	R 0.15	40000	640	40000	560	0.01	0.03
	R 0.2	40000	1600	40000	1200	0.02	0.04
	R 0.3	40000	3200	40000	1600	0.03	0.06
	R 0.4	40000	6400	40000	2400	0.05	0.08
	R 0.5	40000	8000	40000	3200	0.06	0.10
	R 0.75	40000	9600	40000	4000	0.09	0.15
	R 1	40000	9600	39000	4700	0.11	0.20
	R 1.25	40000	10400	32000	4500	0.12	0.25
	R 1.5	40000	12000	27000	4300	0.13	0.30
	R 2	32000	10880	20000	3600	0.15	0.40
	R 2.5	25000	9000	16000	2900	0.20	0.50
	R 3	21000	8400	13000	2600	0.25	0.60
	R 4	16000	6400	10000	2000	0.30	0.80
	R 5	13000	5200	8000	1700	0.50	1.00
	R 6	9000	3600	6000	1300	0.50	1.20
	R 8	6000	2400	4000	1000	0.50	1.60
H Sertleştirilmiş çelik (55–62 HRC)	R10	4500	1800	3000	780	0.50	2.00
	R 0.1	40000	320	40000	160	0.003	0.02
	R 0.15	40000	640	40000	400	0.007	0.03
	R 0.2	40000	1400	40000	1000	0.015	0.04
	R 0.3	40000	2800	40000	1200	0.025	0.06
	R 0.4	40000	4000	40000	1600	0.04	0.08
	R 0.5	40000	5600	40000	2400	0.05	0.10
	R 0.75	40000	7200	32000	2500	0.075	0.15
	R 1	40000	8000	24000	2400	0.1	0.20
	R 1.25	37000	8100	19000	2300	0.11	0.25
	R 1.5	32000	7700	16000	2200	0.12	0.30
	R 2	24000	6200	12000	1900	0.13	0.40
	R 2.5	19000	5300	9600	1700	0.15	0.50
	R 3	16000	4800	8000	1600	0.2	0.60
	R 4	12000	3600	6000	1200	0.2	0.80
	R 5	10000	3200	4800	960	0.2	1.00
	R 6	7000	2200	3600	720	0.3	1.20
	R 8	5000	1600	2500	500	0.3	1.60
	R10	4000	1300	1800	360	0.3	2.00

## VFR2SB

Material	RE	Ángulo de avance menor que 15°		Ángulo de avance mayor que 15°		ap	ae
		n	f	n	f		
H Sertlestirilmis celik (62-70HRC)	R 0.1	40000	320	40000	160	0.002	0.02
	R 0.15	40000	640	40000	400	0.005	0.03
	R 0.2	40000	1200	40000	1000	0.01	0.04
	R 0.3	40000	2000	40000	1200	0.02	0.06
	R 0.4	40000	2800	40000	1600	0.03	0.08
	R 0.5	40000	3600	32000	1300	0.04	0.10
	R 0.75	32000	4500	21000	1200	0.05	0.15
	R 1	24000	3800	16000	1000	0.07	0.20
	R 1.25	19000	3400	13000	1000	0.08	0.25
	R 1.5	16000	3200	11000	880	0.09	0.30
	R 2	12000	2400	8000	800	0.1	0.40
	R 2.5	9600	2100	6000	600	0.1	0.50
	R 3	8000	1700	5000	600	0.11	0.60
	R 4	6000	1400	4000	480	0.11	0.80
	R 5	4800	1100	3000	420	0.12	1.00
	R 6	3600	860	2200	310	0.12	1.20
	R 8	2500	650	1500	240	0.15	1.60
	R10	1800	470	1000	160	0.15	2.00



1. ~~a) La velocidad de corte debe ser menor que la velocidad de la superficie mecanizada.~~
  2. ~~b) El ángulo de avance debe ser menor que 15°.~~
- ~~Para obtener una menor profundidad de corte se debe aumentar la velocidad de corte o el ángulo de avance o se debe elegir un menor radio de herramienta.~~ Oder eine geringere Schnitttiefe eingestellt werden.

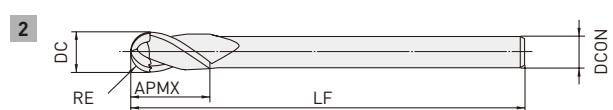
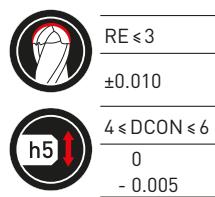
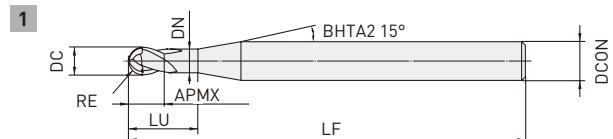


# VFR2SBF



~~ВІДКРИТИЙ ВІДПОВІДЬЮ НА ВІДКРИТИЙ ВІДПОВІДЬЮ  
ВІДКРИТИЙ ВІДПОВІДЬЮ~~

P H

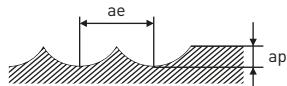


Spawalnicze dane techniczne	Herdniak	Dispozycja	RE	DC	APMX	LU	DN	LF	DCON	ZEFFP	Time
VFR2SBFR0050	●		0.5	1	1	2	0.94	45	4	2	1
VFR2SBFR0075	●		0.75	1.5	1.5	3	1.44	45	4	2	1
VFR2SBFR0100	●		1	2	2	4	1.9	60	6	2	1
VFR2SBFR0125	●		1.25	2.5	2.5	5	2.4	60	6	2	1
VFR2SBFR0150	●		1.5	3	3	6	2.9	70	6	2	1
VFR2SBFR0200	●		2	4	4	8	3.9	70	6	2	1
VFR2SBFR0250	●		2.5	5	5	10	4.9	80	6	2	1
VFR2SBFR0300	●		3	6	6	—	—	80	6	2	2

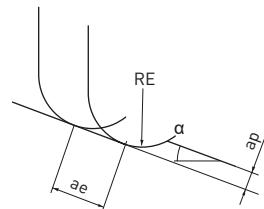
# VFR2SBF

**DESEJO MÁS ALGUMAS**

Материал	RE	Ángulo de inclinación $\alpha < 15^\circ$		Ángulo de inclinación $\alpha > 15^\circ$		ap	ae
		n	f	n	f		
Покованные сталь (40-62 HRC) Покованные сталь (40-62 HRC) Покованные сталь (40-62 HRC) Покованные сталь (40-62 HRC) Покованные сталь (40-62 HRC) Покованные сталь (40-62 HRC) Покованные сталь (40-62 HRC)	R 0.5	40000	800	40000	800	0.007	0.007
	R 0.75	40000	800	40000	800	0.009	0.009
	R 1.0	35000	1050	35000	1050	0.011	0.011
	R 1.25	35000	1050	35000	1050	0.013	0.013
	R 1.5	35000	1050	35000	1050	0.015	0.015
	R 2.0	25000	1000	25000	1000	0.017	0.017
	R 2.5	25000	1000	25000	1000	0.020	0.020
	R 3.0	25000	1000	25000	1000	0.020	0.020
Покованные сталь (42-70 HRC) Покованные сталь (42-70 HRC) Покованные сталь (42-70 HRC) Покованные сталь (42-70 HRC) Покованные сталь (42-70 HRC) Покованные сталь (42-70 HRC) Покованные сталь (42-70 HRC)	R 0.5	40000	560	40000	560	0.005	0.005
	R 0.75	40000	560	40000	560	0.007	0.007
	R 1.0	35000	700	35000	700	0.009	0.009
	R 1.25	35000	700	35000	700	0.011	0.011
	R 1.5	35000	700	35000	700	0.013	0.013
	R 2.0	25000	750	25000	750	0.015	0.015
	R 2.5	25000	750	25000	750	0.015	0.015
	R 3.0	25000	750	25000	750	0.015	0.015



1. **Distruggere** la vetrina con un martello e una piastra di acciaio. Il vetro si romperà in pezzi.
  2. **Applicare** sul vetro la miscela di cemento e calcestruzzo (VCA) e la busta blu di aceite.
  3. **Colpire** la vetrina con il martello sulla superficie meccanizzata.
  4. **Ritirare** la vetrina e pulire i pezzi di cemento e calcestruzzo (VCA) e la busta blu di aceite.

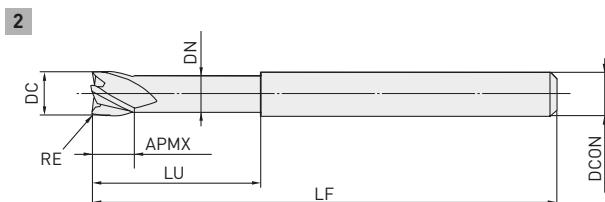
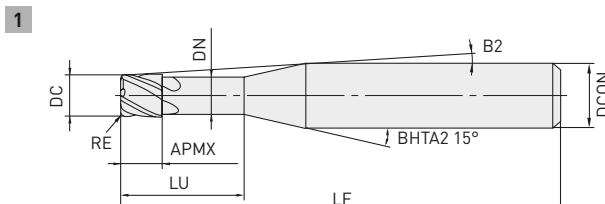


# VFRPSRB



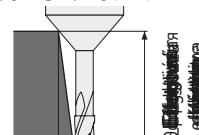
**KÖRÖSÖDŐ PÁLYÁK, KÉPZÉSI MÓDSZERÉK, TANÍTÁSI MÉRIKÉK ÉS KÉPZÉSI ÁPOLÓK  
ELHÜNTÉSÉSKORAI FEJLŐG**

H



	$0.5 \leq RE \leq 6$	$8 \leq RE$
	$\pm 0.005$	$\pm 0.007$
	$0.5 \leq DC \leq 6$	$8 \leq RE$
	0	0
	- 0.01	- 0.015
	$DCON = 6$	$8 \leq DCON \leq 10$
	0	0
	- 0.005	- 0.006
		- 0.008

¿Lo que te interesa es la  
época de la independencia



Análisis de la situación actual



Serie di misurazione	Durata	Parametri di misurazione										Lunghezza effettiva della struttura per interferometria			
		RE	DC	APMX	LU	DN	LF	DCON	B2	ZEFP	Time	30°	1°	2°	3°
VFRPSRBD0050R005N020	●	0.05	0.5	0.5	2	0.47	50	6	12.6	4	1	2.1	2.2	2.3	2.5
VFRPSRBD0050R010N020	●	0.1	0.5	0.5	2	0.47	50	6	12.7	4	1	2.1	2.2	2.3	2.5
VFRPSRBD0060R005N020	●	0.05	0.6	0.6	2	0.57	50	6	12.5	4	1	2.1	2.2	2.4	2.6
VFRPSRBD0060R010N020	●	0.1	0.6	0.6	2	0.57	50	6	12.5	4	1	2.1	2.2	2.3	2.6
VFRPSRBD0060R010N040	●	0.1	0.6	0.6	4	0.57	50	6	10.8	4	1	4.2	4.4	4.7	5.1
VFRPSRBD0060R020N020	●	0.2	0.6	0.6	2	0.57	50	6	12.6	4	1	2.1	2.2	2.2	2.6
VFRPSRBD0080R005N040	●	0.05	0.8	0.8	4	0.77	50	6	10.7	4	1	4.2	4.4	4.7	5.1
VFRPSRBD0080R010N040	●	0.1	0.8	0.8	4	0.77	50	6	10.7	4	1	4.2	4.4	4.7	5.1
VFRPSRBD0080R020N040	●	0.2	0.8	0.8	4	0.77	50	6	10.8	4	1	4.2	4.4	4.7	5.1
VFRPSRBD0080R030N040	●	0.3	0.8	0.8	4	0.77	50	6	10.8	4	1	4.2	4.4	4.7	5
VFRPSRBD0100R005N040	●	0.05	1	1	4	0.96	50	6	10.4	4	1	4.3	4.5	4.9	5.4
VFRPSRBD0100R010N040	●	0.1	1	1	4	0.96	50	6	10.4	4	1	4.3	4.5	4.9	5.4
VFRPSRBD0100R010N060	●	0.1	1	1	6	0.96	50	6	9.1	4	1	6.4	6.7	7.3	7.9
VFRPSRBD0100R020N040	●	0.2	1	1	4	0.96	50	6	10.5	4	1	4.3	4.5	4.7	5.3
VFRPSRBD0100R020N060	●	0.2	1	1	6	0.96	50	6	9.2	4	1	6.4	6.7	7.3	7.8
VFRPSRBD0100R030N040	●	0.3	1	1	4	0.96	50	6	10.5	4	1	4.3	4.5	4.6	5.3
VFRPSRBD0100R040N040	●	0.4	1	1	4	0.96	50	6	10.6	4	1	4.3	4.5	4.5	5.3
VFRPSRBD0150R010N040	●	0.1	1.5	1.5	4	1.42	50	6	10.2	4	1	4.2	4.4	4.8	5.2

VFRPSRB - VELIKOGRADSKA ŠKOLA ČAROBNIKA

Szybkość transferu	Długość	Liczba symboli										Liczba symboli			
		RE	DC	APMX	LU	DN	LF	DCON	B2	ZEFP	T	30°	1°	2°	3°
VFRPSRBD0150R010N060	●	0.1	1.5	1.5	6	1.42	50	6	8.8	4	1	6.3	6.6	7.1	7.7
VFRPSRBD0150R010N100	●	0.1	1.5	1.5	10	1.42	50	6	6.9	4	1	10.5	10.9	11.7	12.7
VFRPSRBD0150R020N040	●	0.2	1.5	1.5	4	1.42	50	6	10.2	4	1	4.2	4.4	4.6	5.2
VFRPSRBD0150R020N060	●	0.2	1.5	1.5	6	1.42	50	6	8.8	4	1	6.3	6.6	7.1	7.7
VFRPSRBD0150R020N100	●	0.2	1.5	1.5	10	1.42	50	6	7	4	1	10.5	10.9	11.7	12.6
VFRPSRBD0150R030N040	●	0.3	1.5	1.5	4	1.42	50	6	10.3	4	1	4.2	4.4	4.5	5.2
VFRPSRBD0150R030N060	●	0.3	1.5	1.5	6	1.42	50	6	8.9	4	1	6.3	6.6	7.1	7.6
VFRPSRBD0150R030N100	●	0.3	1.5	1.5	10	1.42	50	6	7	4	1	10.5	10.9	11.7	12.6
VFRPSRBD0150R050N040	●	0.5	1.5	1.5	4	1.42	50	6	10.5	4	1	4.2	4.4	4.3	5.1
VFRPSRBD0150R050N060	●	0.5	1.5	1.5	6	1.42	50	6	9	4	1	6.3	6.6	7.1	7.6
VFRPSRBD0150R050N100	●	0.5	1.5	1.5	10	1.42	50	6	7.1	4	1	10.5	10.9	11.7	12.6
VFRPSRBD0200R010N060	●	0.1	2	2	6	1.9	50	6	8.4	4	1	6.3	6.6	7.1	7.6
VFRPSRBD0200R010N100	●	0.1	2	2	10	1.9	50	6	6.5	4	1	10.5	10.9	11.7	12.6
VFRPSRBD0200R010N150	●	0.1	2	2	15	1.9	50	6	5.1	4	1	15.7	16.2	17.4	18.8
VFRPSRBD0200R020N060	●	0.2	2	2	6	1.9	50	6	8.4	4	1	6.3	6.6	7.1	7.6
VFRPSRBD0200R020N100	●	0.2	2	2	10	1.9	50	6	6.5	4	1	10.5	10.9	11.7	12.6
VFRPSRBD0200R020N150	●	0.2	2	2	15	1.9	50	6	5.1	4	1	15.7	16.2	17.4	18.8
VFRPSRBD0200R030N060	●	0.3	2	2	6	1.9	50	6	8.5	4	1	6.3	6.6	7	7.6
VFRPSRBD0200R030N100	●	0.3	2	2	10	1.9	50	6	6.6	4	1	10.5	10.8	11.6	12.6
VFRPSRBD0200R030N150	●	0.3	2	2	15	1.9	50	6	5.1	4	1	15.7	16.2	17.4	18.8
VFRPSRBD0200R030N200	●	0.3	2	2	20	1.9	60	6	4.2	4	1	20.8	21.5	23.1	25
VFRPSRBD0200R050N060	●	0.5	2	2	6	1.9	50	6	8.6	4	1	6.3	6.5	7	7.5
VFRPSRBD0200R050N100	●	0.5	2	2	10	1.9	50	6	6.6	4	1	10.5	10.8	11.6	12.5
VFRPSRBD0200R050N150	●	0.5	2	2	15	1.9	50	6	5.2	4	1	15.6	16.2	17.4	18.7
VFRPSRBD0200R050N200	●	0.5	2	2	20	1.9	60	6	4.2	4	1	20.8	21.5	23.1	24.9
VFRPSRBD0250R030N080	●	0.3	2.5	2.5	8	2.35	50	6	6.9	4	1	8.3	8.6	9.2	10
VFRPSRBD0250R030N150	●	0.3	2.5	2.5	15	2.35	50	6	4.7	4	1	15.6	16.1	17.3	18.7
VFRPSRBD0250R050N080	●	0.5	2.5	2.5	8	2.35	50	6	7	4	1	8.3	8.6	9.2	9.9
VFRPSRBD0250R050N150	●	0.5	2.5	2.5	15	2.35	50	6	4.7	4	1	15.6	16.1	17.3	18.6
VFRPSRBD0250R100N080	●	1	2.5	2.5	8	2.35	50	6	7.3	4	1	8.3	8.6	9.1	9.8
VFRPSRBD0300R010N100	●	0.1	3	3	10	2.85	60	6	5.5	4	1	10.4	10.8	11.6	12.5
VFRPSRBD0300R010N150	●	0.1	3	3	15	2.85	60	6	4.2	4	1	15.6	16.1	17.3	18.7
VFRPSRBD0300R020N100	●	0.2	3	3	10	2.85	60	6	5.5	4	1	10.4	10.8	11.6	12.5
VFRPSRBD0300R020N150	●	0.2	3	3	15	2.85	60	6	4.2	4	1	15.6	16.1	17.3	18.7
VFRPSRBD0300R020N200	●	0.2	3	3	20	2.85	60	6	3.4	4	1	20.7	21.5	23.1	24.9
VFRPSRBD0300R030N100	●	0.3	3	3	10	2.85	60	6	5.6	4	1	10.4	10.8	11.5	12.5
VFRPSRBD0300R030N150	●	0.3	3	3	15	2.85	60	6	4.2	4	1	15.6	16.1	17.3	18.7
VFRPSRBD0300R030N200	●	0.3	3	3	20	2.85	60	6	3.4	4	1	20.7	21.5	23	24.9
VFRPSRBD0300R050N100	●	0.5	3	3	10	2.85	60	6	5.6	4	1	10.4	10.7	11.5	12.4
VFRPSRBD0300R050N150	●	0.5	3	3	15	2.85	60	6	4.2	4	1	15.6	16.1	17.3	18.6
VFRPSRBD0300R050N200	●	0.5	3	3	20	2.85	60	6	3.4	4	1	20.7	21.4	23	24.8
VFRPSRBD0300R100N100	●	1	3	3	10	2.85	60	6	5.8	4	1	10.4	10.7	11.4	12.3
VFRPSRBD0300R100N150	●	1	3	3	15	2.85	60	6	4.3	4	1	15.5	16.1	17.2	18.5
VFRPSRBD0300R100N200	●	1	3	3	20	2.85	60	6	3.5	4	1	20.7	21.4	22.9	24.7
VFRPSRBD0400R010N120	●	0.1	4	4	12	3.85	60	6	3.6	4	1	12.5	12.9	13.9	15
VFRPSRBD0400R010N200	●	0.1	4	4	20	3.85	60	6	2.4	4	1	20.7	21.5	23.1	*
VFRPSRBD0400R020N120	●	0.2	4	4	12	3.85	60	6	3.7	4	1	12.5	12.9	13.9	15
VFRPSRBD0400R020N200	●	0.2	4	4	20	3.85	60	6	2.4	4	1	20.7	21.5	23.1	*
VFRPSRBD0400R030N120	●	0.3	4	4	12	3.85	60	6	3.7	4	1	12.5	12.9	13.8	15
VFRPSRBD0400R030N200	●	0.3	4	4	20	3.85	60	6	2.4	4	1	20.7	21.5	23	*

\* ~~Finality~~ ~~before~~ ~~area~~

Serie di misurazione	RE	DC	APMX	LU	DN	LF	DCON	B2	ZEFP	Time	Lunghezza effettiva				
											30°	1°	2°	3°	
VFRPSRBD0400R030N300	●	0.3	4	4	30	3.85	70	6	1.7	4	1	31.1	32.2	*	*
VFRPSRBD0400R050N120	●	0.5	4	4	12	3.85	60	6	3.7	4	1	12.5	12.9	13.8	14.9
VFRPSRBD0400R050N200	●	0.5	4	4	20	3.85	60	6	2.5	4	1	20.7	21.4	23	*
VFRPSRBD0400R050N300	●	0.5	4	4	30	3.85	70	6	1.7	4	1	31.1	32.1	*	*
VFRPSRBD0400R100N120	●	1	4	4	12	3.85	60	6	3.8	4	1	12.4	12.8	13.7	14.8
VFRPSRBD0400R100N200	●	1	4	4	20	3.85	60	6	2.5	4	1	20.7	21.4	22.9	*
VFRPSRBD0400R100N300	●	1	4	4	30	3.85	70	6	1.7	4	1	31.1	32.1	*	*
VFRPSRBD0500R050N150	●	0.5	5	5	15	4.85	60	6	1.7	4	1	15.6	16.1	*	*
VFRPSRBD0500R100N150	●	1	5	5	15	4.85	60	6	1.8	4	1	15.5	16.1	*	*
VFRPSRBD0600R010N180	●	0.1	6	9	18	5.85	70	6	—	4	2	*	*	*	*
VFRPSRBD0600R020N180	●	0.2	6	9	18	5.85	70	6	—	4	2	*	*	*	*
VFRPSRBD0600R030N180	●	0.3	6	9	18	5.85	70	6	—	4	2	*	*	*	*
VFRPSRBD0600R050N180	●	0.5	6	9	18	5.85	70	6	—	4	2	*	*	*	*
VFRPSRBD0600R100N180	●	1	6	9	18	5.85	70	6	—	4	2	*	*	*	*
VFRPSRBD0600R200N180	●	2	6	9	18	5.85	70	6	—	4	2	*	*	*	*
VFRPSRBD0800R020N240	●	0.2	8	12	24	7.85	90	8	—	4	2	*	*	*	*
VFRPSRBD0800R030N240	●	0.3	8	12	24	7.85	90	8	—	4	2	*	*	*	*
VFRPSRBD0800R050N240	●	0.5	8	12	24	7.85	90	8	—	4	2	*	*	*	*
VFRPSRBD0800R100N240	●	1	8	12	24	7.85	90	8	—	4	2	*	*	*	*
VFRPSRBD0800R200N240	●	2	8	12	24	7.85	90	8	—	4	2	*	*	*	*
VFRPSRBD1000R030N300	●	0.3	10	15	30	9.7	100	10	—	4	2	*	*	*	*
VFRPSRBD1000R050N300	●	0.5	10	15	30	9.7	100	10	—	4	2	*	*	*	*
VFRPSRBD1000R100N300	●	1	10	15	30	9.7	100	10	—	4	2	*	*	*	*
VFRPSRBD1000R200N300	●	2	10	15	30	9.7	100	10	—	4	2	*	*	*	*
VFRPSRBD1000R300N300	●	3	10	15	30	9.7	100	10	—	4	2	*	*	*	*
VFRPSRBD1200R050N360	●	0.5	12	18	36	11.7	110	12	—	4	2	*	*	*	*
VFRPSRBD1200R100N360	●	1	12	18	36	11.7	110	12	—	4	2	*	*	*	*
VFRPSRBD1200R200N360	●	2	12	18	36	11.7	110	12	—	4	2	*	*	*	*
VFRPSRBD1200R300N360	●	3	12	18	36	11.7	110	12	—	4	2	*	*	*	*

\*  **Qualitative**  **Quantitative**

# VFRPSRB

~~ØDEBLÆST PÅ NÍS VÆRDE PÅ 1000 ENDELESS~~

Materialer  
størrelse  
mm

	DC	RE	LU	n	f	ap	ae
	0.5	0.05	2	25000	1000	0.005	0.1
	0.5	0.1	2	25000	1000	0.008	0.1
	0.6	0.05	2	21000	1000	0.005	0.1
	0.6	0.1	2	21000	1000	0.008	0.1
	0.6	0.1	4	18000	890	0.006	0.1
	0.6	0.2	2	24000	1100	0.01	0.1
	0.8	0.05	4	16000	760	0.015	0.12
	0.8	0.1	4	16000	760	0.02	0.12
	0.8	0.2	4	20000	950	0.03	0.12
	0.8	0.3	4	20000	950	0.03	0.12
	1	0.05	4	13000	1000	0.015	0.15
	1	0.1	4	13000	1000	0.02	0.15
	1	0.1	6	11000	890	0.015	0.12
	1	0.2	4	16000	1300	0.03	0.15
	1	0.2	6	13000	1000	0.02	0.12
	1	0.3	4	16000	1300	0.03	0.15
	1	0.4	4	16000	1300	0.04	0.15
	1.5	0.1	4	14000	1700	0.025	0.23
	1.5	0.1	6	11000	1400	0.025	0.18
	1.5	0.1	10	11000	1400	0.025	0.18
	1.5	0.2	4	14000	1700	0.05	0.23
	1.5	0.2	6	11000	1400	0.05	0.18
	1.5	0.2	10	11000	1400	0.05	0.18
	1.5	0.3	4	16000	1900	0.075	0.23
	1.5	0.3	6	13000	1500	0.075	0.18
	1.5	0.3	10	13000	1500	0.075	0.18
	1.5	0.5	4	16000	1900	0.08	0.23
	1.5	0.5	6	13000	1500	0.08	0.18
	1.5	0.5	10	13000	1500	0.08	0.18
	2	0.1	6	11000	1700	0.025	0.3
	2	0.1	10	8600	1400	0.025	0.24
	2	0.1	15	6400	1000	0.02	0.18
	2	0.2	6	11000	1700	0.055	0.3
	2	0.2	10	86000	1400	0.055	0.24
	2	0.2	15	6400	1000	0.04	0.18
	2	0.3	6	12000	1900	0.08	0.3
	2	0.3	10	9500	1500	0.08	0.24
	2	0.3	15	7200	1100	0.065	0.18
	2	0.3	20	7200	1100	0.065	0.18
	2	0.5	6	12000	1900	0.085	0.3
	2	0.5	10	9500	1500	0.085	0.24
	2	0.5	15	7200	1100	0.07	0.18
	2	0.5	20	7200	1100	0.07	0.18
	2.5	0.3	8	9500	1900	0.08	0.38
	2.5	0.3	15	7600	1500	0.08	0.3
	2.5	0.5	8	9500	1900	0.09	0.38

H ~~ØDEBLÆST PÅ NÍS VÆRDE PÅ 1000 ENDELESS~~

**VFRPSRB****Materiale obrabiany****DC RE LU n f ap ae**

2.5	0.5	15	7600	1500	0.09	0.3
2.5	1	8	9500	1900	0.15	0.33
3	0.1	10	8100	1900	0.025	0.6
3	0.1	15	6500	1600	0.025	0.48
3	0.2	10	8100	1900	0.055	0.6
3	0.2	15	6500	1600	0.055	0.48
3	0.2	20	6500	1600	0.055	0.48
3	0.3	10	9000	2200	0.085	0.6
3	0.3	15	7200	1700	0.085	0.48
3	0.3	20	7200	1700	0.085	0.48
3	0.5	10	9000	2200	0.09	0.6
3	0.5	15	7200	1700	0.09	0.48
3	0.5	20	7200	1700	0.09	0.48
3	1	10	9000	2200	0.15	0.54
3	1	15	7200	1700	0.15	0.43
3	1	20	7200	2000	0.15	0.43
4	0.1	12	6100	1700	0.25	0.8
4	0.1	20	4900	1400	0.25	0.6
4	0.2	12	6100	1700	0.055	0.8
4	0.2	20	4900	1400	0.055	0.6
4	0.3	12	6800	1900	0.085	0.8
4	0.3	20	5400	1500	0.085	0.6
4	0.3	30	4100	1100	0.065	0.5
4	0.5	12	6800	1900	0.09	0.8
4	0.5	20	5400	1500	0.09	0.65
4	0.5	30	4100	1100	0.075	0.5
4	1	12	6800	1900	0.15	0.7
4	1	20	5400	1500	0.15	0.55
4	1	30	4100	1100	0.1	0.4
5	0.5	15	6400	1800	0.1	1.3
5	1	15	6400	1800	0.15	1.1
6	0.1	18	4800	1500	0.03	1.5
6	0.2	18	4800	1500	0.06	1.5
6	0.3	18	5300	1700	0.09	1.5
6	0.5	18	5300	1700	0.1	1.5
6	1	18	5300	1700	0.15	1.4
6	2	18	5300	1700	0.3	1.3
8	0.2	24	3600	1100	0.06	2
8	0.3	24	4000	1300	0.09	2
8	0.5	24	4000	1300	0.095	2
8	1	24	4000	1300	0.15	1.8
8	2	24	4000	1300	0.3	1.7
10	0.3	30	3200	1000	0.09	2.5
10	0.5	30	3200	1000	0.095	2.5
10	1	30	3200	1000	0.15	2.3
10	2	30	3200	1000	0.3	2.1
10	3	30	3200	1000	0.45	1.9
12	0.5	36	2700	950	0.1	3
12	1	36	2700	950	0.15	2.7
12	2	36	2700	950	0.3	2.6
12	3	36	2700	950	0.45	2.3

H [REDACTED] (Sektor obróbki RDC)

**VFRPSRB**

<b>Material Thickness</b>	<b>DC</b>	<b>RE</b>	<b>LU</b>	<b>n</b>	<b>f</b>	<b>ap</b>	<b>ae</b>
H <del>Alloy steel plate (S235JR, S355JR)</del>	0.5	0.05	2	19000	760	0.004	0.08
	0.5	0.1	2	19000	760	0.006	0.08
	0.6	0.05	2	16000	760	0.004	0.08
	0.6	0.1	2	16000	760	0.006	0.08
	0.6	0.1	4	16000	760	0.005	0.08
	0.6	0.2	2	19000	890	0.008	0.08
	0.8	0.05	4	12000	570	0.01	0.1
	0.8	0.1	4	12000	570	0.015	0.1
	0.8	0.2	4	16000	760	0.025	0.1
	0.8	0.3	4	16000	760	0.025	0.1
	1	0.05	4	9500	760	0.01	0.12
	1	0.1	4	9500	760	0.015	0.12
	1	0.1	6	6400	510	0.01	0.1
	1	0.2	4	9500	760	0.025	0.12
	1	0.2	6	6400	510	0.02	0.1
	1	0.3	4	9500	760	0.025	0.12
	1	0.4	4	9500	760	0.03	0.12
	1.5	0.1	4	11000	920	0.015	0.2
	1.5	0.1	6	9200	730	0.015	0.16
	1.5	0.1	10	9200	730	0.015	0.16
	1.5	0.2	4	11000	920	0.035	0.2
	1.5	0.2	6	9200	730	0.035	0.16
	1.5	0.2	10	9200	730	0.035	0.16
	1.5	0.3	4	13000	1000	0.05	0.2
	1.5	0.3	6	10000	810	0.05	0.16
	1.5	0.3	10	10000	810	0.05	0.16
	1.5	0.5	4	13000	1000	0.055	0.2
	1.5	0.5	6	10000	810	0.055	0.16
	1.5	0.5	10	10000	810	0.055	0.16
	2	0.1	6	8600	1000	0.02	0.28
	2	0.1	10	6900	830	0.02	0.22
	2	0.1	15	5200	620	0.015	0.17
	2	0.2	6	8600	1000	0.035	0.28
	2	0.2	10	6900	830	0.035	0.22
	2	0.2	15	5200	620	0.025	0.17
	2	0.3	6	6900	1100	0.055	0.28
	2	0.3	10	7600	920	0.055	0.22
	2	0.3	15	5700	690	0.045	0.17
	2	0.3	20	5700	690	0.045	0.17
	2	0.5	6	9500	1100	0.06	0.28
	2	0.5	10	7600	920	0.06	0.22
	2	0.5	15	5700	690	0.045	0.17
	2	0.5	20	5700	690	0.045	0.17
	2.5	0.3	8	7600	1400	0.055	0.35
	2.5	0.3	15	6100	1100	0.055	0.28
	2.5	0.5	8	7600	1400	0.06	0.35

**VFRPSRB**~~Materialy do obrabiany~~**DC RE LU n f ap ae**

2.5	0.5	15	6100	1100	0.06	0.28
2.5	1	8	7600	1400	0.09	0.31
3	0.1	10	6500	1200	0.02	0.55
3	0.1	15	5200	940	0.02	0.44
3	0.2	10	6500	1200	0.04	0.55
3	0.2	15	5200	940	0.04	0.44
3	0.2	20	5200	940	0.04	0.44
3	0.3	10	7200	1300	0.055	0.55
3	0.3	15	5800	1000	0.055	0.44
3	0.3	20	5800	1000	0.055	0.44
3	0.5	10	7200	1300	0.06	0.55
3	0.5	15	5800	1000	0.06	0.44
3	0.5	20	5800	1000	0.06	0.44
3	1	10	7200	1300	0.1	0.5
3	1	15	5800	1000	0.1	0.4
3	1	20	5800	1000	0.1	0.4
4	0.1	12	4900	970	0.02	0.74
4	0.1	20	3900	780	0.02	0.6
4	0.2	12	4900	970	0.04	0.74
4	0.2	20	3900	780	0.04	0.6
4	0.3	12	5400	1100	0.055	0.75
4	0.3	20	4300	870	0.055	0.6
4	0.3	30	3200	650	0.045	0.45
4	0.5	12	5400	1100	0.06	0.75
4	0.5	20	4300	870	0.06	0.6
4	0.5	30	4300	650	0.05	0.45
4	1	12	5400	1100	0.1	0.66
4	1	20	4300	870	0.1	0.53
4	1	30	3200	650	0.075	0.4
5	0.5	15	5100	1000	0.065	1.2
5	1	15	5100	1000	0.1	1
6	0.1	18	3800	920	0.02	1.4
6	0.2	18	3800	920	0.04	1.4
6	0.3	18	4200	1000	0.06	1.4
6	0.5	18	4200	1000	0.065	1.4
6	1	18	4200	1000	0.1	1.2
6	2	18	4200	1000	0.2	1.1
8	0.2	24	2900	690	0.04	1.8
8	0.3	24	3200	760	0.06	1.8
8	0.5	24	3200	760	0.065	1.8
8	1	24	3200	760	0.1	1.7
8	2	24	3200	760	0.2	1.6
10	0.3	30	2500	610	0.06	2.3
10	0.5	30	2500	610	0.065	2.3
10	1	30	2500	610	0.1	2.1
10	2	30	2500	610	0.2	2
10	3	30	2500	610	0.3	1.7
12	0.5	36	2100	510	0.065	2.8
12	1	36	2100	510	0.1	2.5
12	2	36	2100	510	0.2	2.4
12	3	36	2100	510	0.3	2.1

H ~~Przykładowe dane (bez ujemnych wartości)~~ (RC)

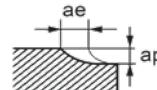
**VFRPSRB**

<b>Material obrábiamy</b>	<b>DC</b>	<b>RE</b>	<b>LU</b>	<b>n</b>	<b>f</b>	<b>ap</b>	<b>ae</b>
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H	0.5	0.05	2	13000	510	0.003	0.08
	0.5	0.1	2	13000	510	0.005	0.08
	0.6	0.05	2	11000	510	0.003	0.08
	0.6	0.1	2	11000	510	0.005	0.08
	0.6	0.1	4	11000	510	0.004	0.08
	0.6	0.2	2	16000	760	0.006	0.08
	0.8	0.05	4	7900	380	0.01	0.1
	0.8	0.1	4	7900	380	0.01	0.1
	0.8	0.2	4	12000	570	0.02	0.1
	0.8	0.3	4	12000	570	0.02	0.1
	1	0.05	4	6400	510	0.01	0.12
	1	0.1	4	6400	510	0.015	0.12
	1	0.1	6	6400	510	0.01	0.1
	1	0.2	4	6400	510	0.02	0.12
	1	0.2	6	6400	510	0.015	0.1
	1	0.3	4	6400	510	0.02	0.12
	1	0.4	4	6400	510	0.025	0.12
	1.5	0.1	4	7200	570	0.01	0.2
	1.5	0.1	6	5700	460	0.01	0.16
	1.5	0.1	10	5700	460	0.01	0.16
	1.5	0.2	4	7200	570	0.025	0.2
	1.5	0.2	6	5700	460	0.025	0.16
	1.5	0.2	10	5700	460	0.025	0.16
	1.5	0.3	4	8000	640	0.035	0.2
	1.5	0.3	6	6400	510	0.035	0.16
	1.5	0.3	10	6400	510	0.035	0.16
	1.5	0.5	4	8000	640	0.04	0.2
	1.5	0.5	6	6400	510	0.04	0.16
	1.5	0.5	10	6400	510	0.04	0.16
	2	0.1	6	5400	640	0.015	0.28
	2	0.1	10	4300	520	0.015	0.22
	2	0.1	15	3200	390	0.01	0.17
	2	0.2	6	5400	640	0.025	0.28
	2	0.2	10	4300	520	0.025	0.22
	2	0.2	15	3200	390	0.02	0.16
	2	0.3	6	6000	420	0.04	0.27
	2	0.3	10	4800	570	0.04	0.22
	2	0.3	15	3600	430	0.03	0.16
	2	0.3	20	3600	430	0.03	0.16
	2	0.5	6	6000	720	0.04	0.27
	2	0.5	10	4800	570	0.04	0.22
	2	0.5	15	3600	430	0.035	0.16
	2	0.5	20	3600	430	0.035	0.16
	2.5	0.3	8	4800	860	0.04	0.34
	2.5	0.3	15	3800	690	0.04	0.27
	2.5	0.5	8	4800	860	0.04	0.34
	2.5	0.5	15	3800	690	0.04	0.27
	2.5	1	8	4800	860	0.065	0.31
	3	0.1	10	4100	730	0.015	0.55
	3	0.1	15	3200	580	0.015	0.44
	3	0.2	10	4100	730	0.025	0.55

**VFRPSRB****Materiale obrabiany****DC RE LU n f ap ae**

H [REDACTED] (HRC)	3	0.2	15	3200	580	0.025	0.44
	3	0.2	20	3200	580	0.025	0.44
	3	0.3	10	4500	810	0.04	0.55
	3	0.3	15	3600	650	0.04	0.44
	3	0.3	20	3600	650	4	0.44
	3	0.5	10	4500	810	0.045	0.55
	3	0.5	15	3600	650	0.045	0.44
	3	0.5	20	3600	650	0.045	0.44
	3	1	10	4500	810	0.07	0.5
	3	1	15	3600	650	0.07	0.4
	3	1	20	3600	650	0.07	0.4
	4	0.1	12	3000	610	0.015	0.73
	4	0.1	20	2400	490	0.015	0.58
	4	0.2	12	3000	610	0.025	0.73
	4	0.2	20	2400	490	0.025	0.58
	4	0.3	12	3400	680	0.04	0.73
	4	0.3	20	2700	540	0.04	0.58
	4	0.3	30	2000	410	0.035	0.44
	4	0.5	12	3400	680	0.045	0.74
	4	0.5	20	2700	540	0.045	0.58
	4	0.5	30	2000	410	0.035	0.44
	4	1	12	3400	680	0.07	0.66
	4	1	20	2700	540	0.07	0.53
	4	1	30	2000	410	0.055	0.4
	5	0.5	15	3200	640	0.045	1.1
	5	1	15	3200	640	0.075	1
	6	0.1	18	2400	570	0.015	1.3
	6	0.2	18	2400	570	0.03	1.3
	6	0.3	18	2700	640	0.045	1.3
	6	0.5	18	2700	640	0.045	1.3
	6	1	18	2700	640	0.075	1.2
	6	2	18	2700	640	0.15	1.1
	8	0.2	24	1800	430	0.03	1.8
	8	0.3	24	2000	480	0.045	1.8
	8	0.5	24	2000	480	0.045	1.8
	8	1	24	2000	480	0.075	1.6
	8	2	24	2000	480	0.15	1.5
	10	0.3	30	1600	380	0.045	2.3
	10	0.5	30	1600	380	0.045	2.3
	10	1	30	1600	380	0.075	2
	10	2	30	1600	380	0.15	1.9
	10	3	30	1600	380	0.2	1.7
	12	0.5	36	1300	320	0.05	2.7
	12	1	36	1300	320	0.075	2.4
	12	2	36	1300	320	0.15	2.3
	12	3	36	1300	320	0.2	2



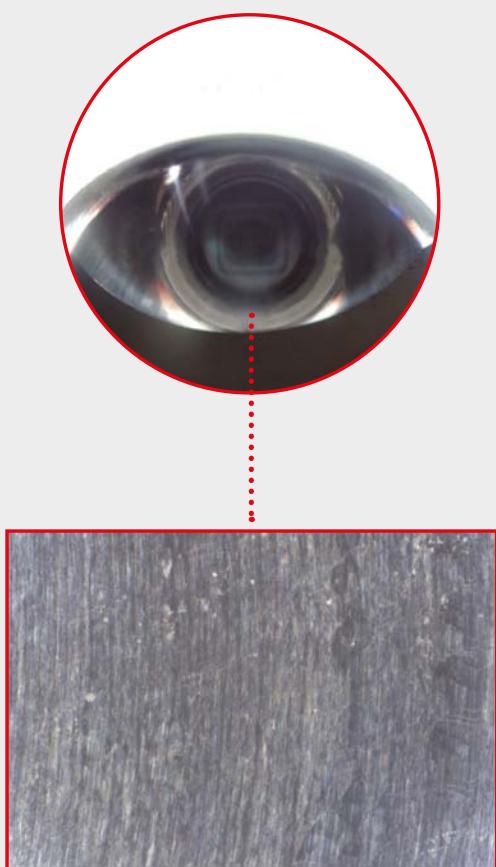
1. [REDACTED] (1) La velocidad de avance axial es la velocidad con la que se desplaza la herramienta en la dirección del eje de avance.
2. [REDACTED] (2) La velocidad de avance axial es igual a la velocidad de avance dividida por el factor de avance.
3. [REDACTED] (3) La velocidad de avance axial es igual a la velocidad de avance dividida por el factor de avance de profundidad.

# Účinky různých mazacích směsi na povrchové účinky

<b>Materiál</b>	1.2344 (52 HRC)
<b>Mazací směs</b>	VFR2SBFR0300
<b>n (min<sup>-1</sup>)</b>	32.000
<b>Vc (mm/min)</b>	603
<b>Vf (mm/min)</b>	1.280
<b>fz (mm)</b>	0.02
<b>ap (mm)</b>	0.02
<b>ae (mm)</b>	0.02
<b>Délka zákrutu (mm)</b>	15
<b>Přípravka (ml)</b>	35 (ml) 100 ml / litr
<b>Magnetický tensile</b>	Deformace magnetického stupnice (UKT-KRZ-E25)

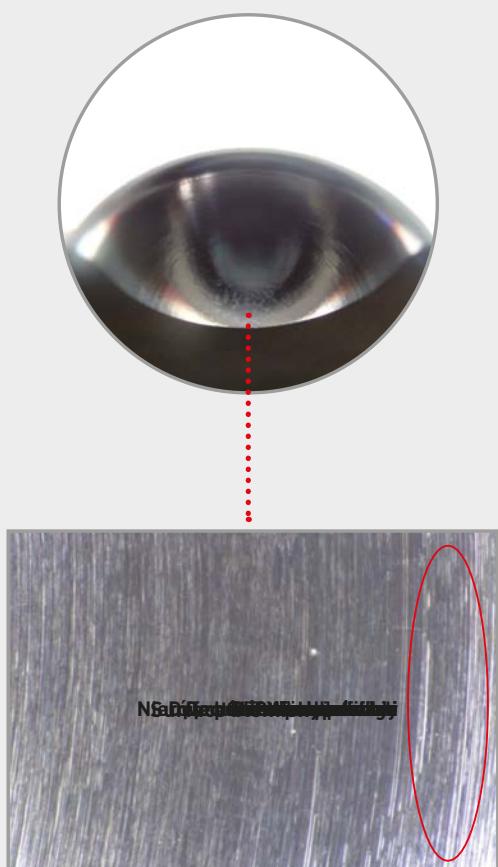
## Obrazový materiál získaný výškovým mikroskopem po obrábcích

VFR2SBF



Výrobek s mazací směs

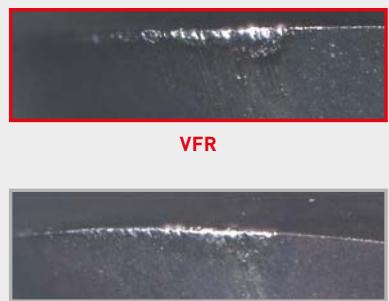
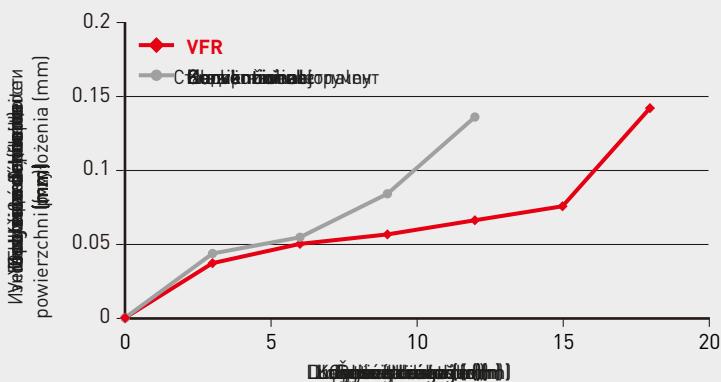
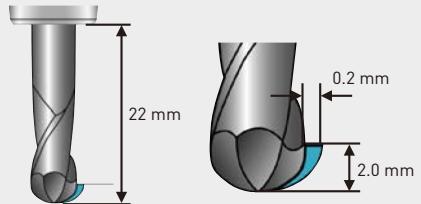
Kontrolní výrobek bez mazací směs



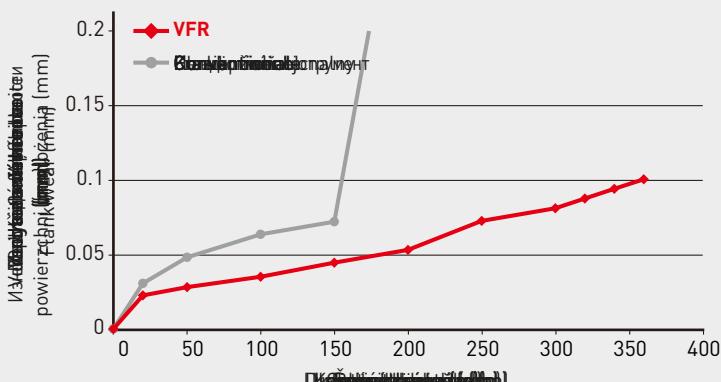
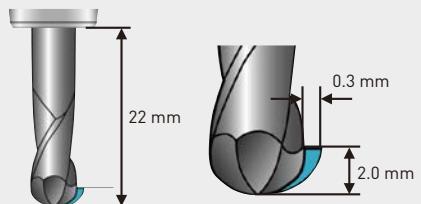
Násobek bez mazací směs

**BRÁNDY S POMERANÍEM**

<b>Materiale</b>	1.3343 [64 HRC]
<b>Vfijatura</b>	VFR2SBR0300
<b>n (min<sup>-1</sup>)</b>	5.400
<b>Vf (mm/min)</b>	540
<b>fz (mm/zad.)</b>	0.05
<b>ap (mm)</b>	2.0
<b>ae (mm)</b>	2.0
<b>Distanza (mm) laterale (mm)</b>	22
<b>Profondità taglio</b>	Profondità taglio
<b>Diametro testile</b>	Diametro testile



<b>Materiał</b>	1.2344 (52 HRC)
<b>Wykonawca</b>	VFR2SBR0300
<b>n (min<sup>-1</sup>)</b>	17.000
<b>Vf (mm/min)</b>	1.700
<b>fz (mm/ząb)</b>	0.05
<b>ap (mm)</b>	2.0
<b>ae (mm)</b>	0.3
<b>Pręt startowy (mm)</b>	22
<b>Pręt końcowy (mm)</b>	17.150
<b>Maksymalna tensja</b>	700 N/mm (1000 N/mm) (HDKSW-NSK-A63)



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Регистрационный номер: Р22/109, наделенство в Германии