



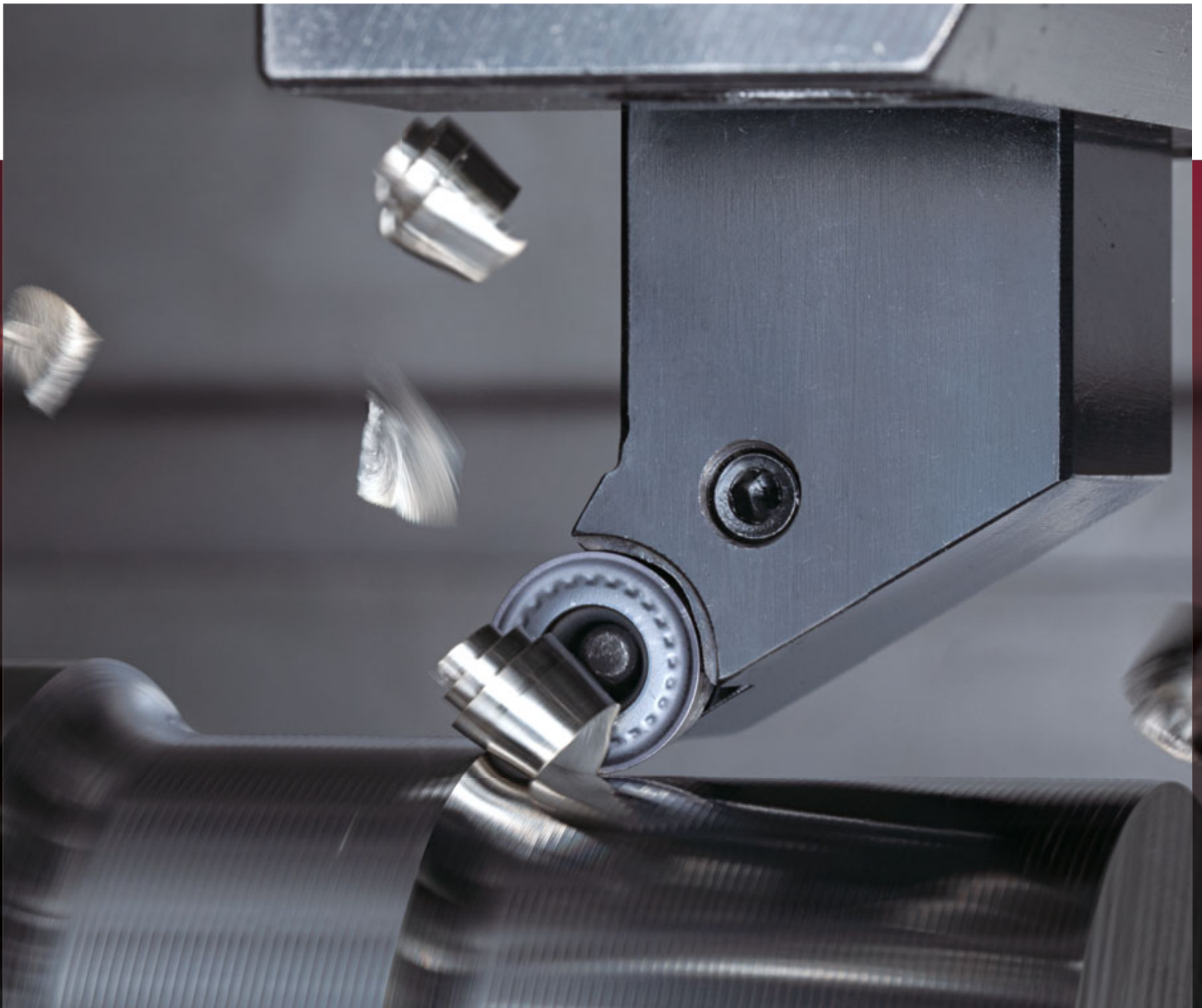
Więcej informacji

Gatunki do obróbki stopów żaroodpornych

# AH8000 SERIES

Tungaloy Report No. 437S2-G

## Zastosowanie łamacza RS oraz gatunków AH8000 we wszystkich płytkach RCMT do toczenia superstopów żaroodpornych



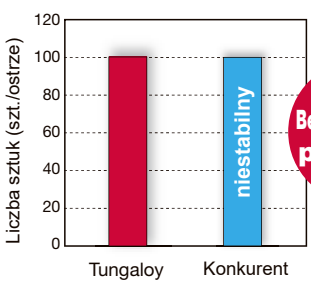






## STANDARDOWE PARAMETRY SKRAWANIA

ISO	Materiał obrabiany	Łamacz wióra	Rozmiar płytki	Głębokość skrawania ap (mm)	Posuw f (mm/obr.)	Prędkość skrawania: Vc (m/min.)	
						AH8005	AH8015
<b>M</b>	Stal nierdzewna SUS303, SUS304, etc. X10CrNiS18-9, X5CrNi18-9, etc.	<b>RS</b>	RCMT06...	0.5 - 2	0.2 - 0.6	100 - 220	90 - 200
			RCMT08...	0.5 - 2	0.2 - 0.6		
			RCMT10...	1 - 2.5	0.2 - 0.6		
			RCMT12...	1 - 2.5	0.2 - 0.6		
			RCMT16...	1.5 - 3	0.5 - 1		
			RCMT20...	1.5 - 3	0.5 - 1		
<b>S</b>	Superaloje Inconel718, etc.	<b>RS</b>	RCMT06...	0.5 - 2	0.2 - 0.6	40 - 100	20 - 80
			RCMT08...	0.5 - 2	0.2 - 0.6		
			RCMT10...	1 - 2.5	0.2 - 0.6		
			RCMT12...	1 - 2.5	0.2 - 0.6		
			RCMT16...	1.5 - 3	0.5 - 1		
			RCMT20...	1.5 - 3	0.5 - 1		
			RCMT25...	1.5 - 5	0.5 - 1		

## PRZYKŁADY PRAKTYCZNE

Rodzaj detalu		Kolnierz	Tarcza
Płytki		RCMT10T3M0-RS	RCMT1606M0-RS
Gatunek		AH8005	AH8015
Materiał obrabiany		Inconel 718	Ti-6Al-4V
		 <b>S</b>	 <b>S</b>
Parametry skrawania	Prędkość skrawania : Vc (m/min.)	85	30
	Posuw : f (mm/obr.)	0.25	0.5
	Głębokość skrawania: ap (mm)	1.25	3
	Chłodziwo	Na mokro	Na mokro
Wyniki		 <p><b>Bezpieczeństwo procesu!</b></p> <p>Połączenie gatunku AH8005 i łamacza RS wyeliminowało przedwczesną awarię.</p>	<p><b>Konkurent</b></p>  <p><b>AH8015</b> Łamacz RS</p>  <p><b>Bezpieczeństwo procesu!</b></p> <p>Połączenie gatunku AH8015 i łamacza -RS znacznie zmniejszyło zużycie w postaci karbu.</p>

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