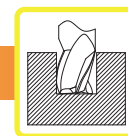
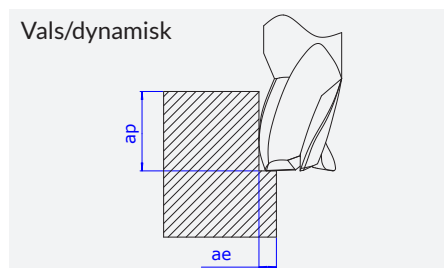
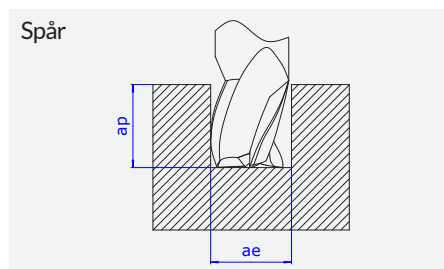
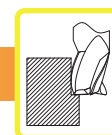
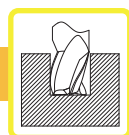


Skärdata för MBTF42



Materialgrupp	Materialnr	Brottgräns N/mm ²	Svensk Standard	Skärh. Vc Spår	Skärh. Vc Vals/dynamisk
Olegerat stål	1,1	< 500 N/mm ²	1311,1312,1350,1914,1922,1926,2101	120-145	270-320
	1,2	< 700 N/mm ²	1432,1550,2132,2134,2216-04	115-135	260-310
Legerat stål	1,3	< 800 N/mm ²	2172,2225,1650,2173,2511-00,2512-02,2244	110-130	260-310
	1,4	< 1100 N/mm ²	1672-03,2140-02,2245-02,2258-02, HARDOX 400,TOLLOX 33,VANADIS 30,2541-03	80-120	210-260
	1,5	< 1400 N/mm ²	2225-05, HARDOX 450, TOOLOX 44	65-100	150-190
Härdat Stål (Spår=Reducera ap50%) (Vals/dyn.=Reducera ae50%)	1,6	< 55HRC		45-70	90-140
	1,7	< 60HRC		20-30	50-90
Gjutjärn	3,1	< 180 HB	0717,0110-00,0115-00	110-140	190-250
	3,2	< 320 HB	0120-00,0125-00,0727,0727-02	100-130	150-220
	3,3		0135-00,0457-00,0737-01	70-100	110-175

Matning fz



Dia.	Spår ap=0,4xD ae=1,0xD	Vals/dynamisk ap=1,5xD ae=0,25xD	ap=2,5xD ae=0,1xD
8	0,028-0,045	0,043-0,061	0,062-0,100
10	0,034-0,055	0,056-0,079	0,080-0,125
12	0,042-0,065	0,065-0,091	0,092-0,150
16	0,051-0,080	0,078-0,120	0,111-0,200
20	0,058-0,091	0,090-0,150	0,127-0,250

$$V_c = \frac{d1 \cdot \pi \cdot n}{1000}$$

$$n = \frac{V_c \cdot 1000}{d1 \cdot \pi}$$

$$f_z = \frac{V_f}{n \cdot z}$$

$$V_f = f_z \cdot z \cdot n$$

Parameter	Betydelse	Enhet
Vf	Matning	mm/min
n	Varvtal	varv/min
Vc	Skärhastighet	m/min
z	Antal skär	st
fz	Matning per tand	mm
d1	Verktysdiameter	mm