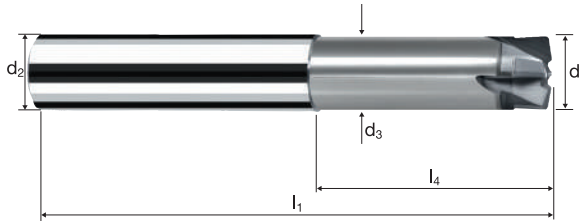


HFC Maró XFeed

Nyakalt, 3xd



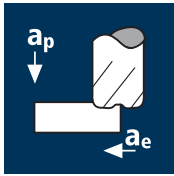
| | |
|----------|-----------------------------|
| HM XT | λ 0° γ 0° |
| | HFC |
| | |
| | |



| | | | | | | | | |
|-------------|----------------|-----------------|-----------------|--------------|--------------|-------------|----------------|--------------|
| Rm < 850 | Rm 850-1100 | Rm 1100-1300 | Rm 1300-1500 | HRC 48-56 | HRC 56-60 | HRC > 60 | Ti Titanium | HSS GG(G) |
|-------------|----------------|-----------------|-----------------|--------------|--------------|-------------|----------------|--------------|

| Példa: Rendelési szám | | | | | | | | | | | | X-AL |
|--------------------------|----------------------|----------------------|----------------|----------------|----------------|----------------|-------------------|--------------------|-------|---|--|-------|
| Bevonat | | | Cikkszám | | | Ø-Kód | | | | | | X7600 |
| X | | | 7600 | | | 100 | | | | | | |
| Ø Code | d ₁ e8 | d ₂ h6 | d ₃ | l ₁ | l ₃ | l ₄ | ap _{max} | R _{theo.} | α | z | | |
| 100 | 1.00 | 6.00 | 0.95 | 57 | 3.00 | 13.08 | 0.04 | 0.09 | 11.5° | 4 | | ● |
| 140 | 2.00 | 6.00 | 1.90 | 57 | 6.00 | 14.31 | 0.08 | 0.18 | 8.5° | 4 | | ● |
| 180 | 3.00 | 6.00 | 2.80 | 57 | 9.00 | 15.63 | 0.12 | 0.27 | 6.0° | 4 | | ● |
| 220 | 4.00 | 6.00 | 3.70 | 57 | 12.00 | 16.95 | 0.16 | 0.36 | 3.8° | 4 | | ● |
| 260 | 5.00 | 6.00 | 4.60 | 57 | 15.00 | 18.27 | 0.20 | 0.45 | 1.8° | 4 | | ● |
| 300 | 6.00 | 6.00 | 5.50 | 57 | 19.34 | 20.00 | 0.25 | 0.54 | 0.0° | 4 | | ● |
| 391 | 8.00 | 8.00 | 7.40 | 63 | 25.29 | 26.00 | 0.33 | 0.72 | 0.0° | 4 | | ● |
| 450 | 10.00 | 10.00 | 9.20 | 72 | 30.20 | 31.00 | 0.41 | 0.90 | 0.0° | 4 | | ● |
| 501 | 12.00 | 12.00 | 11.00 | 83 | 36.13 | 37.00 | 0.50 | 1.08 | 0.0° | 4 | | ● |
| 610 | 16.00 | 16.00 | 15.00 | 92 | 42.13 | 43.00 | 0.69 | 1.44 | 0.0° | 4 | | ● |
| | | | | | | | | | | | | |
| | | | | | | | | | | | | |
| | | | | | | | | | | | | |
| | | | | | | | | | | | | |
| | | | | | | | | | | | | |
| | | | | | | | | | | | | |
| | | | | | | | | | | | | |
| | | | | | | | | | | | | |
| | | | | | | | | | | | | |
| | | | | | | | | | | | | |
| | | | | | | | | | | | | |
| | | | | | | | | | | | | |
| | | | | | | | | | | | | |
| | | | | | | | | | | | | |

Alkalmazás



Alapanyag

Acél
850 - 1100 N/mm²



| d1 [mm] | z | v _r [m/min] | f _s [mm] | a _p [mm] | a _e [mm] | n [min ⁻¹] | v _r [mm/min] | Q [cm ³ /min] |
|---------|---|------------------------|---------------------|---------------------|---------------------|------------------------|-------------------------|--------------------------|
| 2.00 | 4 | 250 | 0.135 | 0.050 | 1.200 | 39790 | 21485 | 1.3 |
| 3.00 | 4 | 250 | 0.200 | 0.080 | 1.800 | 26525 | 21220 | 3.1 |
| 4.00 | 4 | 250 | 0.265 | 0.120 | 2.400 | 19895 | 21090 | 6.1 |
| 5.00 | 4 | 250 | 0.335 | 0.160 | 3.000 | 15915 | 21325 | 10.2 |
| 6.00 | 4 | 250 | 0.400 | 0.200 | 3.600 | 13265 | 21220 | 15.3 |
| 8.00 | 4 | 250 | 0.535 | 0.250 | 4.800 | 9945 | 21285 | 25.5 |
| 10.00 | 4 | 250 | 0.665 | 0.320 | 6.000 | 7960 | 21170 | 40.6 |
| 12.00 | 4 | 250 | 0.800 | 0.400 | 7.200 | 6630 | 21220 | 61.1 |
| 16.00 | 4 | 250 | 1.065 | 0.480 | 9.600 | 4975 | 21190 | 97.6 |

Acél
1100 - 1300 N/mm²



| | | | | | | | | |
|-------|---|-----|-------|-------|-------|-------|-------|------|
| 2.00 | 4 | 220 | 0.115 | 0.050 | 1.200 | 35015 | 16105 | 1.0 |
| 3.00 | 4 | 220 | 0.170 | 0.080 | 1.800 | 23345 | 15875 | 2.3 |
| 4.00 | 4 | 220 | 0.225 | 0.120 | 2.400 | 17505 | 15755 | 4.5 |
| 5.00 | 4 | 220 | 0.285 | 0.160 | 3.000 | 14005 | 15965 | 7.7 |
| 6.00 | 4 | 220 | 0.340 | 0.200 | 3.600 | 11670 | 15875 | 11.4 |
| 8.00 | 4 | 220 | 0.455 | 0.250 | 4.800 | 8755 | 15930 | 19.1 |
| 10.00 | 4 | 220 | 0.565 | 0.320 | 6.000 | 7005 | 15825 | 30.4 |
| 12.00 | 4 | 220 | 0.680 | 0.400 | 7.200 | 5835 | 15875 | 45.7 |
| 16.00 | 4 | 220 | 0.905 | 0.480 | 9.600 | 4375 | 15845 | 73.0 |

Acél
1300 - 1500 N/mm²



| | | | | | | | | |
|-------|---|-----|-------|-------|-------|-------|-------|------|
| 2.00 | 4 | 200 | 0.105 | 0.050 | 1.200 | 31830 | 13370 | 0.8 |
| 3.00 | 4 | 200 | 0.155 | 0.070 | 1.800 | 21220 | 13155 | 1.7 |
| 4.00 | 4 | 200 | 0.205 | 0.110 | 2.400 | 15915 | 13050 | 3.4 |
| 5.00 | 4 | 200 | 0.260 | 0.140 | 3.000 | 12730 | 13240 | 5.6 |
| 6.00 | 4 | 200 | 0.310 | 0.180 | 3.600 | 10610 | 13155 | 8.5 |
| 8.00 | 4 | 200 | 0.415 | 0.230 | 4.800 | 7960 | 13210 | 14.6 |
| 10.00 | 4 | 200 | 0.520 | 0.290 | 6.000 | 6365 | 13240 | 23.0 |
| 12.00 | 4 | 200 | 0.625 | 0.360 | 7.200 | 5305 | 13265 | 34.4 |
| 16.00 | 4 | 200 | 0.830 | 0.430 | 9.600 | 3980 | 13210 | 54.5 |

Edzett szerszámacél
48 - 52 HRC



| | | | | | | | | |
|-------|---|-----|-------|-------|-------|-------|------|------|
| 2.00 | 4 | 160 | 0.060 | 0.070 | 1.200 | 25465 | 6110 | 0.5 |
| 3.00 | 4 | 160 | 0.090 | 0.110 | 1.800 | 16975 | 6110 | 1.2 |
| 4.00 | 4 | 160 | 0.120 | 0.140 | 2.400 | 12730 | 6110 | 2.1 |
| 5.00 | 4 | 160 | 0.150 | 0.180 | 3.000 | 10185 | 6110 | 3.3 |
| 6.00 | 4 | 160 | 0.180 | 0.210 | 3.600 | 8490 | 6110 | 4.6 |
| 8.00 | 4 | 160 | 0.240 | 0.280 | 4.800 | 6365 | 6110 | 8.2 |
| 10.00 | 4 | 160 | 0.300 | 0.350 | 6.000 | 5095 | 6110 | 12.8 |
| 12.00 | 4 | 160 | 0.360 | 0.420 | 7.200 | 4245 | 6110 | 18.5 |
| 16.00 | 4 | 160 | 0.480 | 0.560 | 9.600 | 3185 | 6110 | 32.9 |

Edzett szerszámacél
52 - 56 HRC



| | | | | | | | | |
|-------|---|-----|-------|-------|-------|-------|------|------|
| 2.00 | 4 | 140 | 0.050 | 0.070 | 1.200 | 22280 | 4455 | 0.4 |
| 3.00 | 4 | 140 | 0.075 | 0.110 | 1.800 | 14855 | 4455 | 0.9 |
| 4.00 | 4 | 140 | 0.100 | 0.140 | 2.400 | 11140 | 4455 | 1.5 |
| 5.00 | 4 | 140 | 0.125 | 0.180 | 3.000 | 8915 | 4455 | 2.4 |
| 6.00 | 4 | 140 | 0.150 | 0.210 | 3.600 | 7425 | 4455 | 3.4 |
| 8.00 | 4 | 140 | 0.200 | 0.280 | 4.800 | 5570 | 4455 | 6.0 |
| 10.00 | 4 | 140 | 0.250 | 0.350 | 6.000 | 4455 | 4455 | 9.4 |
| 12.00 | 4 | 140 | 0.300 | 0.420 | 7.200 | 3715 | 4455 | 13.5 |
| 16.00 | 4 | 140 | 0.400 | 0.560 | 9.600 | 2785 | 4455 | 24.0 |

Edzett szerszámacél
56 - 60 HRC



| | | | | | | | | |
|-------|---|-----|-------|-------|-------|-------|------|-----|
| 2.00 | 4 | 100 | 0.030 | 0.060 | 1.200 | 15915 | 1910 | 0.1 |
| 3.00 | 4 | 100 | 0.045 | 0.090 | 1.800 | 10610 | 1910 | 0.3 |
| 4.00 | 4 | 100 | 0.060 | 0.120 | 2.400 | 7960 | 1910 | 0.6 |
| 5.00 | 4 | 100 | 0.075 | 0.150 | 3.000 | 6365 | 1910 | 0.9 |
| 6.00 | 4 | 100 | 0.090 | 0.180 | 3.600 | 5305 | 1910 | 1.2 |
| 8.00 | 4 | 100 | 0.120 | 0.240 | 4.800 | 3980 | 1910 | 2.2 |
| 10.00 | 4 | 100 | 0.150 | 0.300 | 6.000 | 3185 | 1910 | 3.4 |
| 12.00 | 4 | 100 | 0.180 | 0.360 | 7.200 | 2655 | 1910 | 5.0 |
| 16.00 | 4 | 100 | 0.240 | 0.480 | 9.600 | 1990 | 1910 | 8.8 |

Edzett szerszámacél
> 60 HRC



| | | | | | | | | |
|-------|---|----|-------|-------|-------|------|-----|-----|
| 2.00 | 4 | 60 | 0.020 | 0.050 | 1.200 | 9550 | 765 | 0.0 |
| 3.00 | 4 | 60 | 0.030 | 0.075 | 1.800 | 6365 | 765 | 0.1 |
| 4.00 | 4 | 60 | 0.040 | 0.100 | 2.400 | 4775 | 765 | 0.2 |
| 5.00 | 4 | 60 | 0.050 | 0.125 | 3.000 | 3820 | 765 | 0.3 |
| 6.00 | 4 | 60 | 0.060 | 0.150 | 3.600 | 3185 | 765 | 0.4 |
| 8.00 | 4 | 60 | 0.080 | 0.200 | 4.800 | 2385 | 765 | 0.7 |
| 10.00 | 4 | 60 | 0.100 | 0.250 | 6.000 | 1910 | 765 | 1.1 |
| 12.00 | 4 | 60 | 0.120 | 0.300 | 7.200 | 1590 | 765 | 1.7 |
| 16.00 | 4 | 60 | 0.160 | 0.400 | 9.600 | 1195 | 765 | 2.9 |

Acélötvény
GG(G)



| | | | | | | | | |
|-------|---|-----|-------|-------|-------|-------|-------|------|
| 2.00 | 4 | 250 | 0.135 | 0.050 | 1.200 | 39790 | 21485 | 1.3 |
| 3.00 | 4 | 250 | 0.200 | 0.080 | 1.800 | 26525 | 21220 | 3.1 |
| 4.00 | 4 | 250 | 0.265 | 0.120 | 2.400 | 19895 | 21090 | 6.1 |
| 5.00 | 4 | 250 | 0.335 | 0.160 | 3.000 | 15915 | 21325 | 10.2 |
| 6.00 | 4 | 250 | 0.400 | 0.200 | 3.600 | 13265 | 21220 | 15.3 |
| 8.00 | 4 | 250 | 0.535 | 0.250 | 4.800 | 9945 | 21285 | 25.5 |
| 10.00 | 4 | 250 | 0.665 | 0.320 | 6.000 | 7960 | 21170 | 40.6 |
| 12.00 | 4 | 250 | 0.800 | 0.400 | 7.200 | 6630 | 21220 | 61.1 |
| 16.00 | 4 | 250 | 1.065 | 0.480 | 9.600 | 4975 | 21190 | 97.6 |