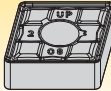
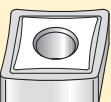
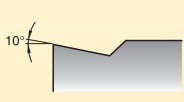
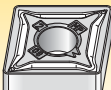
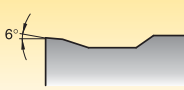
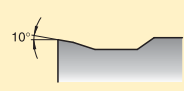
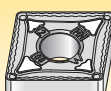
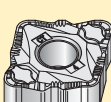
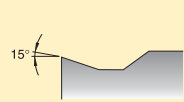
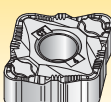
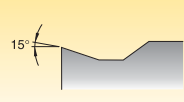
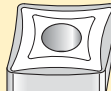
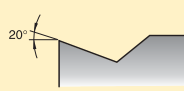
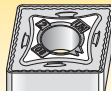
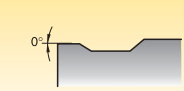


**■ Выбор геометрии на основании подачи и глубины резания**

|          |                    |
|----------|--------------------|
| <b>P</b> | Сталь              |
| <b>M</b> | Нержавеющая сталь  |
| <b>K</b> | Чугун              |
| <b>N</b> | Цветные металлы    |
| <b>S</b> | Жаропрочные сплавы |
| <b>H</b> | Закаленная сталь   |

| операция                          | применение<br>типа пластины                                                         | геометрия<br>пластины                                                               | профиль                                                                            | подача — мм/об       |       |      |          |         |     |      |     |     |          |         |  |  |  |
|-----------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|------------------------------------------------------------------------------------|----------------------|-------|------|----------|---------|-----|------|-----|-----|----------|---------|--|--|--|
|                                   |                                                                                     |                                                                                     |                                                                                    | 0,04                 | 0,063 | 0,01 | 0,16     | 0,25    | 0,4 | 0,63 | 1,0 | 1,6 | 2,5      | 5,0     |  |  |  |
|                                   |                                                                                     |                                                                                     |                                                                                    | 0,1                  | 0,16  | 0,25 | 0,4      | 0,63    | 1,0 | 1,6  | 2,5 | 4,0 | 6,3      | 10,0    |  |  |  |
|                                   |                                                                                     |                                                                                     |                                                                                    | глубина резания — мм |       |      |          |         |     |      |     |     |          |         |  |  |  |
| получистовая<br>обработка         | MG-UP                                                                               |    |   |                      |       |      |          | 0,2–0,6 |     |      |     |     |          | 1,0–6,4 |  |  |  |
|                                   |                                                                                     |                                                                                     |                                                                                    |                      |       |      |          |         |     |      |     |     |          |         |  |  |  |
|                                   |                                                                                     |                                                                                     |                                                                                    |                      |       |      |          |         |     |      |     |     |          |         |  |  |  |
|                                   | GP*                                                                                 |    |   |                      |       |      |          | 0,3–0,5 |     |      |     |     |          | 0,5–3,2 |  |  |  |
|                                   |                                                                                     |                                                                                     |                                                                                    |                      |       |      |          |         |     |      |     |     |          |         |  |  |  |
|                                   |                                                                                     |                                                                                     |                                                                                    |                      |       |      |          |         |     |      |     |     |          |         |  |  |  |
|                                   | MG-MP                                                                               |   |  |                      |       |      |          | 0,2–0,5 |     |      |     |     |          | 0,8–5,1 |  |  |  |
|                                   |                                                                                     |                                                                                     |                                                                                    |                      |       |      |          |         |     |      |     |     |          |         |  |  |  |
|                                   |                                                                                     |                                                                                     |                                                                                    |                      |       |      |          |         |     |      |     |     |          |         |  |  |  |
| MG-P                              |  |  |                                                                                    |                      |       |      | 0,15–0,5 |         |     |      |     |     | 0,75–5,0 |         |  |  |  |
|                                   |                                                                                     |                                                                                     |                                                                                    |                      |       |      |          |         |     |      |     |     |          |         |  |  |  |
|                                   |                                                                                     |                                                                                     |                                                                                    |                      |       |      |          |         |     |      |     |     |          |         |  |  |  |
| MG-MN                             |  |  |                                                                                    |                      |       |      | 0,2–0,5  |         |     |      |     |     | 0,5–5,1  |         |  |  |  |
|                                   |                                                                                     |                                                                                     |                                                                                    |                      |       |      |          |         |     |      |     |     |          |         |  |  |  |
|                                   |                                                                                     |                                                                                     |                                                                                    |                      |       |      |          |         |     |      |     |     |          |         |  |  |  |
| MG-CT<br>для наружного<br>точения |  |  |                                                                                    |                      |       |      | 0,13–0,5 |         |     |      |     |     | 1,0–3,0  |         |  |  |  |
|                                   |                                                                                     |                                                                                     |                                                                                    |                      |       |      |          |         |     |      |     |     |          |         |  |  |  |
|                                   |                                                                                     |                                                                                     |                                                                                    |                      |       |      |          |         |     |      |     |     |          |         |  |  |  |
| MG-CT<br>для подрезки<br>торца    |  |  |                                                                                    |                      |       |      | 0,25–0,5 |         |     |      |     |     | 0,25–1,0 |         |  |  |  |
|                                   |                                                                                     |                                                                                     |                                                                                    |                      |       |      |          |         |     |      |     |     |          |         |  |  |  |
|                                   |                                                                                     |                                                                                     |                                                                                    |                      |       |      |          |         |     |      |     |     |          |         |  |  |  |
| -MS<br>односторонняя              |  |  |                                                                                    |                      |       |      | 0,2–0,4  |         |     |      |     |     | 0,6–2,3  |         |  |  |  |
|                                   |                                                                                     |                                                                                     |                                                                                    |                      |       |      |          |         |     |      |     |     |          |         |  |  |  |
|                                   |                                                                                     |                                                                                     |                                                                                    |                      |       |      |          |         |     |      |     |     |          |         |  |  |  |
| MG-UN                             |  |  |                                                                                    |                      |       |      | 0,2–0,5  |         |     |      |     |     | 0,8–3,8  |         |  |  |  |
|                                   |                                                                                     |                                                                                     |                                                                                    |                      |       |      |          |         |     |      |     |     |          |         |  |  |  |
|                                   |                                                                                     |                                                                                     |                                                                                    |                      |       |      |          |         |     |      |     |     |          |         |  |  |  |

\*Пластины с углами 35° и 55° являются односторонними.