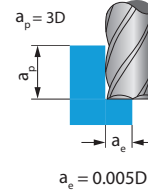
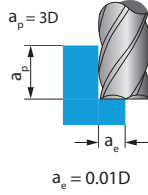
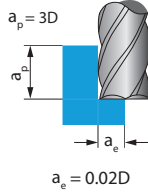


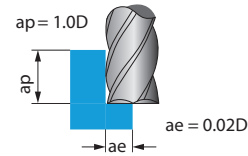
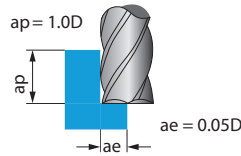
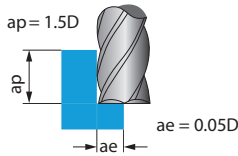
## SZ Series For Long Version

Malzeme	Alařımlı elikler, Döküm elikler		Alařımlı Temperlenmiř elikler		Sert elikler		Yüksek Sertlikteki elikler	
Sertlik	- HRC30		HRC30 - HRC45		HRC50 - HRC60		HRC50 - HRC65	
Cekme	-850 N/mm <sup>2</sup>		850-1600 N/mm <sup>2</sup>		1600-2000 N/mm <sup>2</sup>		2000 N/mm <sup>2</sup> -	
ap	RPM (rev/min)	Feed (mm/min)	RPM (rev/min)	Feed (mm/min)	RPM (rev/min)	Feed (mm/min)	RPM (rev/min)	Feed (mm/min)
6	2400	500	1700	360	1400	250	1110	200
8	1800	460	1300	340	1100	240	850	180
10	1400	430	1000	300	900	230	680	160
12	1150	400	900	280	700	210	580	150
14	1025	375	775	260	625	190	515	140
16	900	350	650	240	550	170	450	130
18	800	325	557	220	500	160	390	125
20	700	300	500	200	450	150	330	120



## SZ Series High Speed

Malzeme	Sert elikler Temperlenmiř		Sert elikler		Yüksek Sertlikteki elikler	
Sertlik	- HRC50		HRC50 - HRC60		HRC60 - HRC65	
Cekme	-1600 N/mm <sup>2</sup>		1600-2000 N/mm <sup>2</sup>		2000 N/mm <sup>2</sup> -	
ap	RPM (rev/min)	Feed (mm/min)	RPM (rev/min)	Feed (mm/min)	RPM (rev/min)	Feed (mm/min)
6	17000	6100	8400	3000	4200	1500
8	13000	6100	6300	3000	3200	1500
10	10000	6000	5000	3000	2500	1500
12	8400	5000	4200	2500	2100	1300
14	7350	4500	3700	2200	1850	1150
16	6300	4000	3200	1900	1600	1000
18	5650	3550	2850	1685	1450	900
20	5000	3100	2500	1470	1300	800



Devir Sayısı

$$n = \frac{1000 \times V_c}{\pi \times d_1}$$

İlerleme

$$V_f = n \times f_z \times f_n$$

n : Devir Sayısı (rpm)

V<sub>c</sub> : Kesme Hızı (m/dk)

d<sub>1</sub> : Kesici Freze apı (mm)

f<sub>z</sub> : Diř Bařı İlerleme (mm/diř)

f<sub>n</sub> : Diř Sayısı