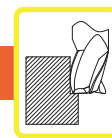
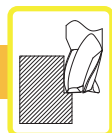
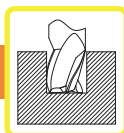




### Skärdata för EM4 - MBTF10

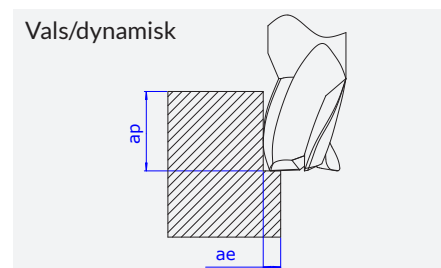
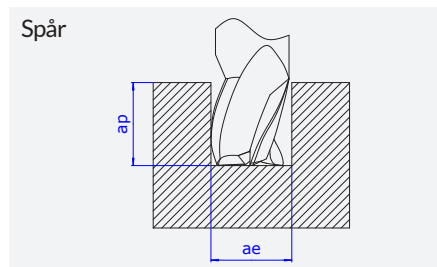


Materialgrupp	Materialnr	Brottgräns N/mm <sup>2</sup>	Svensk Standard	Skärh. Vc Spår	Skärh. Vc Vals/dynamisk
Olegerat stål	1,1	< 500 N/mm <sup>2</sup>	1311,1312,1350,1914,1922,1926,2101	120-145	180-280
	1,2	< 700 N/mm <sup>2</sup>	1432,1550,2132,2134,2216-04	115-132	180-280
Legerat stål	1,3	< 800 N/mm <sup>2</sup>	2172,2225,1650,2173,2511-00,2512-02,2244	110-130	180-280
	1,4	< 1100 N/mm <sup>2</sup>	1672-03,2140-02,2245-02,2258-02, HARDOX 400,TOLLOX 33,VANADIS 30,2541-03	80-120	110-160
	1,5	< 1400 N/mm <sup>2</sup>	2225-05, HARDOX 450, TOOLOX 44	65-100	110-160
Rostfritt Stål (Spår=Reducera ap15%)	2,1		2303,2304,2325	65-95	90-140
	2,2		2301,2302,2322,2330,2332,2340	55-80	60-100
	2,3		2320,2333,2337,2338,2343,2347,2348,2350,2377,SAF2205	50-75	60-100
Gjutjärn	3,1	< 190 HB	0717,0110-00,0115-00	110-140	130-200
	3,2	< 320 HB	0120-00,0125-00,0727,0727-02	100-130	110-180
	3,3		0135-00,0457-00,0737-01	70-100	100-160
Titan och titanlegeringar (Spår=Reducera ap25%) (Vals/dyn.=Reducera ae50%)	6,1	< 850 N/mm <sup>2</sup>	Ti1,Ti2,Ti3,Ti4	40-55	60-80
	6,2	< 1200 N/mm <sup>2</sup>		21-30	35-55
Ni- och Co legeringar (Spår=Reducera ap40%) (Vals/dyn.=Reducera ae80%)	7,1	< 900 N/mm <sup>2</sup>	Monel 400, Inconel 600, Hastelloy	20-35	25-45
	7,2	< 1300 N/mm <sup>2</sup>	Inconel 718, Nimonic	18-25	20-40



### Matning fz

Dia.	Spår ap=0,5xD ae=1,0xD	Vals/dynamisk ap=2xD ae=0,25-0,35xD
4	0,015-0,024	0,018-0,030
5	0,020-0,032	0,025-0,038
6	0,025-0,040	0,031-0,045
8	0,035-0,056	0,043-0,061
10	0,042-0,069	0,056-0,079
12	0,052-0,081	0,065-0,091
16	0,063-0,099	0,078-0,120
20	0,072-0,133	0,090-0,150



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

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

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

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

Parameter	Betydelse	Enhet
V <sub>f</sub>	Matning	mm/min
n	Varvtal	varv/min
V <sub>c</sub>	Skärhastighet	m/min
z	Antal skär	st
f <sub>z</sub>	Matning per tand	mm
d <sub>1</sub>	Verktysdiameter	mm