

F C-Max için Teknik Bilgi

(Bakır)

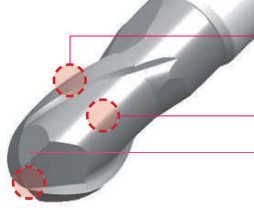
Elektrod işlemede daha uzun takım ömrü ve daha kaliteli yüzey

C-Max

Bakır

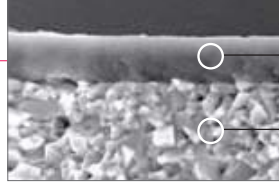
- Korloy Gümüş kaplama ve optimum iç yapı sayesinde üstün yağlama, aşınma direnci & çapaklanma direnci
- Bakır ve demir-dışı metallerin işlenmesi için optimum
- Çok çeşitli tip (küresel, düz, köşe radyüslü & uzun boyunlu tip)

Özellikler



Bakır ve demir-dışı metallerin işlenmesi için optimum kesme kenarı

Kesme kenarının yüksek hassasiyetinden dolayı yüksek kalite



PC210C

Kaplama tabakası (Korloy Gümüş)
: Aşınma direnci ve yağlama

İç Yapı
: Aşınma ve çapaklanma direnci için optimum

Performans değerlendirme

- İş Parçası Cu, Elektrod işleme
- Kesme koşulu vc (m/dak) = 70, fz (mm/diş) = 0.083, ap (mm) = 0.6, ae (mm) = 3.0
- Takımlar CRE4100-070-R10



CRE

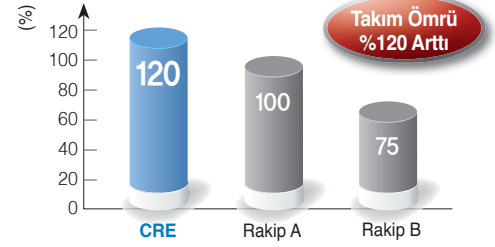


Rakip A



Rakip B

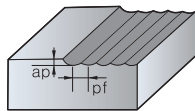
Test sonucu



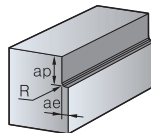
Önerilen Kesme Koşulu

İş Parçası	CBE/CBNE		CFE/CFNE		CRE/CRNE	
	Bakır Alaşımları					
Koşullar Çap (Ø)	Devir n (dak ⁻¹)	İlerleme vf (mm/dak)	Devir n (dak ⁻¹)	İlerleme vf (mm/dak)	Devir n (dak ⁻¹)	İlerleme vf (mm/dak)
0.5	40,000	2,600	40,000	1,800	-	-
1	40,000	2,800	40,000	2,000	40,000	2,000
1.5	40,000	3,200	40,000	2,400	30,000	2,400
2	40,000	3,600	30,000	1,800	30,000	1,800
3	40,000	4,000	23,000	1,380	20,000	1,380
4	32,000	3,200	15,000	900	15,000	900
5	25,000	2,500	12,000	750	12,000	750
6	21,000	2,100	10,000	600	10,000	600
8	16,000	1,600	8,000	480	8,000	480
10	13,000	1,300	6,400	384	6,400	384
12	9,000	900	5,400	324	5,400	324

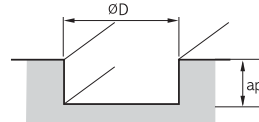
Uygulama



- $ap = 0.1D$
- $pf = 0.2D$



- $ap = 1.5D$
- $ae = 0.1D$



- $ap \leq 1.5D$

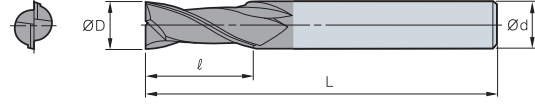
* İş parçası sertçe bağlanmalı. Eğer vibrasyon oluşursa, lütfen devir ve ilerlemeyi aynı oranda azaltın



F Parmak Frezeler



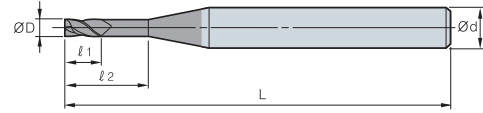
CFE2000 (Düz)



ØD	Tolerans
Ø0.5~Ø6	0.00~0.01
Ø8~Ø12	0.00~0.02

(mm)					
Kod	ØD	Ød	l	L	
CFE					
2010-040	1	4	2.5	40	
2015-040	1.5	4	4	40	
2020-045	2	4	5	45	
2030-045	3	6	8	45	
2040-050	4	6	11	50	
2050-060	5	6	13	60	
2060-060	6	6	13	60	
2080-060	8	8	19	60	
2100-070	10	10	22	70	
2120-075	12	12	26	75	

CFNE2000 (Uzun Boyunlu Düz)



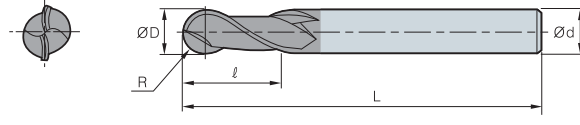
ØD	Tolerans
Ø0.5~Ø6	0.00~0.01
Ø8~Ø12	0.00~0.02

(mm)						
Kod	ØD	Ød	l ₁	l ₂	L	
CFNE						
2005-045-N2	0.5	4	0.8	2	45	
2005-045-N4	0.5	4	0.8	4	45	
2005-045-N6	0.5	4	0.8	6	45	
2005-050-N8	0.5	4	0.8	8	50	
2010-045-N4	1	4	1.5	4	45	
2010-045-N6	1	4	1.5	6	45	
2010-050-N8	1	4	1.5	8	50	
2010-050-N10	1	4	1.5	10	50	
2015-045-N6	1.5	4	2.3	6	45	
2015-050-N8	1.5	4	2.3	8	50	
2015-050-N10	1.5	4	2.3	10	50	
2015-050-N12	1.5	4	2.3	12	50	
2020-045-N6	2	4	3	6	45	
2020-050-N8	2	4	3	8	50	
2020-050-N10	2	4	3	10	50	
2020-055-N12	2	4	3	12	50	
2030-050-N10	3	4	4.5	10	50	
2030-050-N12	3	4	4.5	12	50	
2030-060-N14	3	4	4.5	14	60	
2030-060-N16	3	4	4.5	16	60	
2040-050-N12	4	6	6	12	50	
2040-050-N16	4	6	6	16	50	
2040-060-N20	4	6	6	20	60	



F C-Max (Bakır)

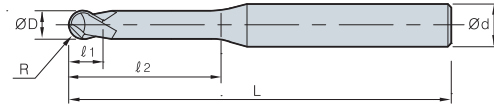
CBE2000 (Küresel)



ØD	Tolerans	R Tolerans
Ø0.5~Ø6	0.00~0.01	±0.005
Ø8~Ø12	0.00~0.02	±0.005

Kod	R	ØD	Ød	l	L
CBE					
2010-050	0.5	1	4	2.5	50
2015-050	0.75	1.5	4	4	50
2020-050	1	2	4	5	50
2030-060	1.2	3	6	8	60
2040-070	2	4	6	8	70
2050-080	2.5	5	6	10	80
2060-080	3	6	6	12	80
2080-090	4	8	8	14	90
2100-100	5	10	10	18	100
2120-110	6	12	12	22	110

CBNE2000 (Uzun Boyunlu Küresel)



ØD	Tolerans
Ø0.5~Ø6	0.00~0.01
Ø8~Ø12	0.00~0.02

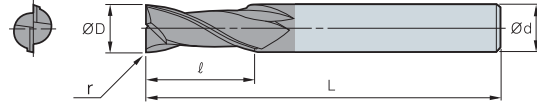
Kod	R	ØD	Ød	l1	l2	L
CBNE						
2005-045-N2	0.25	0.5	4	0.5	2	45
2005-045-N4	0.25	0.5	4	0.5	4	45
2005-045-N6	0.25	0.5	4	0.5	6	45
2005-050-N8	0.25	0.5	4	0.5	8	50
2010-045-N4	0.5	1	4	1	4	45
2010-045-N6	0.5	1	4	1	6	45
2010-050-N8	0.5	1	4	1	8	50
2010-050-N10	0.5	1	4	1	10	50
2015-050-N8	0.75	1.5	4	1.5	8	50
2015-050-N10	0.75	1.5	4	1.5	10	50
2015-050-N12	0.75	1.5	4	1.5	12	50
2015-055-N14	0.75	1.5	4	1.5	14	55
2020-050-N8	1	2	4	2	8	50
2020-050-N10	1	2	4	2	10	50
2020-050-N12	1	2	4	2	12	50
2020-055-N14	1	2	4	2	14	55
2030-050-N10	1.5	3	4	3	10	50
2030-050-N12	1.5	3	4	3	12	50
2030-055-N14	1.5	3	4	3	14	55
2030-055-N16	1.5	3	4	3	16	60
2040-060-N16	2	4	6	4	16	60
2040-060-N20	2	4	6	4	20	60
2040-070-N25	2	4	6	4	25	70
2040-070-N30	2	4	6	4	30	70



F Parmak Frezeler



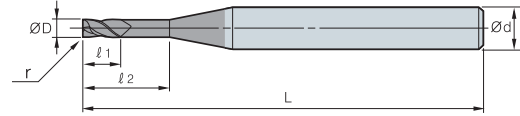
CRE2000 (Köşe Radyüslü)



ØD	Tolerans	R Tolerans
Ø0.5~Ø6	0.00~0.01	±0.005
Ø8~Ø12	0.00~0.02	±0.005

(mm)						
Kod	r	ØD	Ød	l	L	
CRE 2020-045-R05	0.5	2	4	5	45	
2030-045-R05	0.5	3	6	8	45	
2040-050-R05	0.5	4	6	11	50	
2050-060-R05	0.5	5	6	13	60	
2060-060-R05	0.5	6	6	13	60	
2080-060-R10	1	8	8	19	60	
2100-070-R10	1	10	10	22	70	
2120-075-R10	1	12	12	26	75	

CRNE2000 (Uzun Boyunlu Köşe Radyüslü)



ØD	Tolerans	R Tolerans
Ø0.5~Ø6	0.00~0.01	±0.005
Ø8~Ø12	0.00~0.02	±0.005

(mm)						
Kod	r	ØD	Ød	l1	l2	L
CRNE 2010-045-R02N4	0.2	1	4	1.5	4	45
2010-045-R02N6	0.2	1	4	1.5	6	45
2010-050-R02N8	0.2	1	4	1.5	8	50
2010-050-R02N10	0.2	1	4	1.5	10	50
2015-045-R02N6	0.2	1.5	4	2.3	6	45
2015-050-R02N8	0.2	1.5	4	2.3	8	50
2015-050-R02N10	0.2	1.5	4	2.3	10	50
2015-050-R02N12	0.2	1.5	4	2.3	12	50
2020-045-R05N6	0.5	2	4	3	6	45
2020-050-R05N8	0.5	2	4	3	8	50
2020-050-R05N10	0.5	2	4	3	10	50
2020-055-R05N12	0.5	2	4	3	12	50
2030-050-R05N10	0.5	3	4	4.5	10	50
2030-050-R05N12	0.5	3	4	4.5	12	50
2030-060-R05N14	0.5	3	4	4.5	14	60
2030-060-R05N16	0.5	3	4	4.5	16	60
2040-050-R05N12	0.5	4	6	6	12	50
2040-050-R05N16	0.5	4	6	6	16	50
2040-060-R05N20	0.5	4	6	6	20	60

