


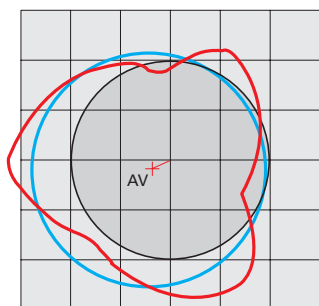
典型孔质量特征


1. 加工 42 CrMo 4 V, Ø 14.5 mm

HSS钻头, type N
Gühring no. 651 

vc = 25 m/min
f = 0.25 mm/rev.
+Rmax = 131.8 μm
-Rmax = -49.1 μm
实际D = 14.566 mm
dRmax = 103.5 μm
AV = 49.2 μm
Ra = 2.6 μm, Rz = 6.8 μm

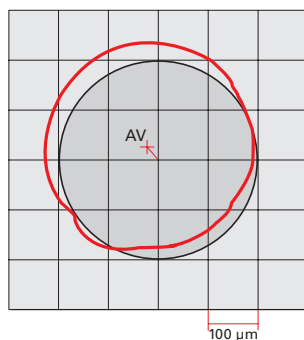
IT 12




RT钻头, type RT 80
Gühring no. 1171 

vc = 70 m/min
f = 0.25 mm/rev.
+Rmax = 42.7 μm
-Rmax = -29.6 μm
实际D = 14.515 mm
dRmax = 12.9 μm
AV = 35.3 μm
Ra = 1.4 μm, Rz = 4.31 μm

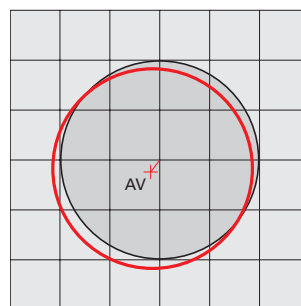
IT 9



RT钻头, type RT 100
Gühring no. 1181 

vc = 70 m/min
f = 0.25 mm/rev.
+Rmax = 26.7 μm
-Rmax = -17.2 μm
实际D = 14.509 mm
dRmax = 5.2 μm
AV = 22.8 μm
Ra = 1.04 μm, Rz = 3.2 μm

IT 8




黑圈表示标准跳动值 (dRmax)。红圈表示加工孔偏离中心的位置, AV表示偏离幅度。加工孔偏离中心的最大值用IT质量等级表示。

图表上的黑圈代表理想的加工孔。红圈代表实际加工后的孔。

红圈表示半径平均值, 如蓝圈表示平均直径。

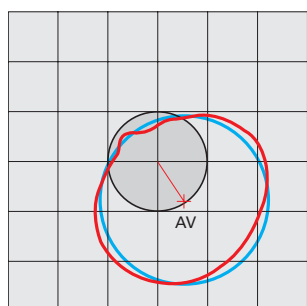
(RT钻头加工孔的平均值和实际加工后的孔径相同)。


2. 加工 GGG 40, Ø 10.0 mm

HSS钻头, type N
Gühring no. 651 

vc = 30 m/min
f = 0.2 mm/rev.
实际D = 10.077 mm
+Rmax = 106 μm
-Rmax = -28 μm
dRmax = 42 μm
AV = 68.5 μm
Ra = 3.7 μm, Rz = 17.2 μm

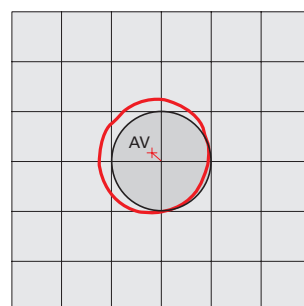
IT 12




RT钻头, type RT 100
Gühring no. 1181 

vc = 90 m/min
f = 0.3 mm/rev.
实际D = 10.027 mm
+Rmax = 34 μm
-Rmax = -9.2 μm
dRmax = 6.5 μm
AV = 22.5 μm
Ra = 2.2 μm, Rz = 11.5 μm

IT 9



RT钻头, type RT 150 GG
Gühring no. 768 

vc = 130 m/min
f = 0.2 mm/rev.
实际 D = 9.994 mm
+Rmax = 11.5 μm + Rmax = 11.5 μm
-Rmax = -18 μm
dRmax = 5 μm
AV = 14 μm
Ra = 1.99 μm, Rz = 11.2 μm

IT 8

