

Расчет количества оборотов абразивного инструмента при окружной скорости в

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м/с.

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| Диаметр инструмента в мм. | Скорость инструмента в м/с. |        |        |        |        |        |        |        |         |
|---------------------------|-----------------------------|--------|--------|--------|--------|--------|--------|--------|---------|
|                           | 5                           | 6      | 8      | 10     | 12     | 16     | 20     | 25     | 32      |
| 6                         | 16 000                      | 19 100 | 25 500 | 31 900 | 38 200 | 51 000 | 64 000 | 80 000 | 102 000 |
| 8                         | 12 000                      | 14 400 | 19 100 | 24 000 | 29 000 | 38 200 | 48 000 | 60 000 | 76 500  |
| 10                        | 9 600                       | 11 500 | 15 300 | 19 100 | 23 000 | 30 600 | 38 200 | 48 000 | 61 200  |
| 13                        | 7 400                       | 8 850  | 11 800 | 14 700 | 17 700 | 23 550 | 29 500 | 35 600 | 47 100  |
| 16                        | 6 000                       | 7 200  | 9 550  | 11 950 | 14 350 | 19 100 | 23 900 | 29 850 | 38 200  |
| 20                        | 4 800                       | 5 750  | 7 650  | 9 550  | 11 500 | 15 300 | 19 100 | 23 900 | 30 600  |
| 25                        | 3 850                       | 4 600  | 6 150  | 7 650  | 9 200  | 12 300 | 15 300 | 19 100 | 24 500  |
| 32                        | 3 000                       | 3 600  | 4 800  | 6 000  | 7 200  | 9 550  | 11 950 | 14 950 | 19 100  |
| 40                        | 2 400                       | 2 900  | 3 850  | 4 800  | 5 750  | 7 650  | 9 550  | 11 950 | 15 300  |
| 50                        | 1 950                       | 2 300  | 3 100  | 3 850  | 4 600  | 6 150  | 7 650  | 9 550  | 12 250  |
| 63                        | 1 550                       | 1 850  | 2 450  | 3 050  | 3 650  | 4 850  | 6 100  | 7 600  | 9 750   |
| 80                        | 1 200                       | 1 450  | 1 950  | 2 400  | 2 900  | 3 850  | 4 800  | 6 000  | 7 650   |
| 100                       | 960                         | 1 150  | 1 550  | 1 950  | 2 300  | 3 100  | 3 850  | 4 800  | 6 150   |
| 115                       | 8 30                        | 1 000  | 1 350  | 1 700  | 2 000  | 2 700  | 3 350  | 4 200  | 5 350   |
| 125                       | 770                         | 920    | 1 250  | 1 550  | 1 850  | 2 450  | 3 100  | 3 850  | 4 900   |
| 150                       | 640                         | 770    | 1 050  | 1 300  | 1 550  | 2 050  | 2 550  | 3 200  | 4 100   |
| 180                       | 530                         | 640    | 850    | 1 100  | 1 300  | 1 700  | 2 150  | 2 700  | 3 400   |
| 200                       | 480                         | 580    | 765    | 955    | 1 150  | 1 550  | 1 950  | 2 400  | 3 100   |
| 230                       | 420                         | 500    | 665    | 830    | 1 000  | 1 350  | 1 700  | 2 100  | 2 700   |
| 250                       | 380                         | 460    | 615    | 765    | 920    | 1 250  | 1 550  | 1 950  | 2 450   |
| 300                       | 320                         | 380    | 510    | 640    | 765    | 1 050  | 1 300  | 1 600  | 2 050   |

| Диаметр инструмента в мм. | Скорость инструмента в м/с. |         |         |         |         |         |         |         |         |
|---------------------------|-----------------------------|---------|---------|---------|---------|---------|---------|---------|---------|
|                           | 35                          | 40      | 50      | 63      | 80      | 100     | 125     | 140     | 160     |
| 6                         | 112 000                     | 128 000 | 160 000 | 201 000 |         |         |         |         |         |
| 8                         | 84 000                      | 95 500  | 120 000 | 150 500 | 191 000 |         |         |         |         |
| 10                        | 67 000                      | 76 500  | 95 500  | 120 500 | 153 000 | 191 000 |         |         |         |
| 13                        | 51 500                      | 58 800  | 73 500  | 92 600  | 118 000 | 147 000 | 184 000 | 206 000 |         |
| 16                        | 41 800                      | 47 800  | 59 700  | 75 200  | 95 500  | 120 000 | 150 000 | 168 000 | 191 000 |
| 20                        | 33 500                      | 38 200  | 47 800  | 60 200  | 76 500  | 95 500  | 120 000 | 134 000 | 153 000 |
| 25                        | 26 800                      | 30 600  | 38 200  | 48 200  | 61 200  | 76 500  | 95 500  | 107 000 | 123 000 |
| 32                        | 20 900                      | 23 900  | 30 000  | 37 600  | 48 000  | 60 000  | 75 000  | 84 000  | 95 500  |
| 40                        | 16 750                      | 19 100  | 23 900  | 30 100  | 38 200  | 47 200  | 59 700  | 67 000  | 76 500  |
| 50                        | 13 400                      | 15 300  | 19 100  | 24 100  | 30 600  | 38 200  | 47 750  | 53 500  | 61 200  |
| 63                        | 10 650                      | 12 150  | 15 200  | 19 100  | 24 300  | 30 250  | 37 900  | 42 500  | 48 500  |
| 80                        | 8 400                       | 9 550   | 12 000  | 15 100  | 19 100  | 23 900  | 29 850  | 33 500  | 38 200  |
| 100                       | 6 700                       | 7 650   | 9 550   | 12 100  | 15 300  | 19 100  | 23 900  | 26 800  | 30 600  |
| 115                       | 5 850                       | 6 650   | 8 350   | 10 500  | 13 300  | 16 650  | 20 800  | 23 250  | 26 600  |
| 125                       | 5 350                       | 6 150   | 7 650   | 9 650   | 12 250  | 15 300  | 19 100  | 21 400  | 24 500  |
| 150                       | 4 500                       | 5 100   | 6 400   | 8 050   | 10 200  | 12 700  | 16 000  | 17 850  | 20 400  |
| 180                       | 3 750                       | 4 250   | 5 350   | 6 700   | 8 500   | 10 650  | 13 300  | 14 900  | 17 000  |
| 200                       | 3 350                       | 3 850   | 4 800   | 6 050   | 7 650   | 9 550   | 11 950  | 13 400  | 15 300  |
| 230                       | 2 950                       | 3 350   | 4 200   | 5 250   | 6 650   | 8 350   | 10 400  | 11 650  | 13 300  |
| 250                       | 2 700                       | 3 100   | 3 850   | 4 850   | 6 150   | 7 650   | 9 550   | 10 700  | 12 250  |
| 300                       | 2 250                       | 2 550   | 3 200   | 4 050   | 5 100   | 6 400   | 8 000   | 8 950   | 10 200  |