

Příloha 1

				HIGH-SPEED STEEL TOOLS			CARBIDE TOOLS			
							Uncoated			
							Speed			
Material	Hardness	Condition	Cutting depth	Speed	Forward travel	Tool material	Brazed insert	Bit insert	Forward travel	Grade of Tool material
Ti	HB		mm	m/min	mm per tooth	ISO	m/min	m/min	mm per tooth	ISO
α alloys and α - β alloys	320÷370	Annealed	1	14	.075	S9 S11	44	49	.102	K10 M20
			4	11	.13	S9 S11	34	37	.15	K20 M30
			8	8	.18	S9 S11	24	29	.20	K30 M30
α alloys and α - β alloys	320÷380	Annealed	1	11	.075	S9 S11	37	40	.102	K10 M20
			4	8	.13	S9 S11	27	30	.15	K20 M30
			8	6	.18	S9 S11	20	24	.20	K20 M30
α alloys and α - β alloys	320÷380	Quenched and aged	1	17	.075	S9 S11	44	49	.102	K10 M20
			4	15	.13	S9 S11	34	37	.15	K20 M30
			8	12	.18	S9 S11	24	29	.20	K20 M30
α alloys and α - β alloys	375÷440	Quenched and aged	1	9	.050	S9 S11	30	32	.102	K10 M20
			4	8	.102	S9 S11	23	24	.15	K10 M20
			8	6	.15	S9 S11	15	18	.20	K20 M30
β alloys	275÷350	Annealed or quenched	1	12	.075	S9 S11	40	44	.102	K10 M20
			4	9	.13	S9 S11	30	34	.15	K10 M20
			8	6	.18	S9 S11	21	26	.20	K20 M30
β alloys	350÷440	Quenched and aged	1	9	.050	S9 S11	24	27	.102	K10 M20
			4	8	.102	S9 S11	18	20	.15	K10 M20
			8	6	.15	S9 S11	12	15	.20	K20 M30

(*) hloubka řezu je měřena rovnoběžně s osou řezu