

Bartools BR55 sarkos marók forgácsolási paramétere

Workpiece material	Cast Iron ,Carbon Steel ,Alloy Steel -30HRC		Stainless steel		Pre-hardened steel and tempered steel -40HRC	
Diameter(mm)	Rotating (min ⁻¹)	Feed(mm/min)	Rotating (min ⁻¹)	Feed(mm/min)	Rotating (min ⁻¹)	Feed(mm/min)
1	20000	300	20000	108	20000	240
2	15000	480	11150	120	15000	420
3	14000	815	7500	145	10600	630
4	10800	840	5500	150	8000	645
5	8200	875	4500	150	6400	675
6	7000	900	3700	165	5300	690
8	5200	890	2800	165	4000	680
10	4200	875	2200	165	3200	675
12	3500	875	1850	165	2650	675
14	3000	815	1600	150	2300	630
16	2600	815	1400	145	2000	630
18	2300	805	1250	125	1800	620
20	2050	805	1100	125	1600	620

Workpiece material	Pre-hardened steel and tempered steel -50HRC		Hardened Steel -55HRC	
Diameter(mm)	Rotating (min ⁻¹)	Feed(mm/min)	Rotating (min ⁻¹)	Feed(mm/min)
1	20000	180	20000	135
2	13000	270	11140	195
3	8500	495	7430	360
4	6500	505	5570	370
5	5000	530	4460	390
6	4200	540	3710	390
8	3200	555	2785	405
10	2500	525	2230	375
12	2100	525	1855	375
14	1800	495	1590	360
16	1600	495	1390	360
18	1400	485	1240	350
20	1250	485	1115	350