

BÖHLER TAKIM ÇELİKLERİ MAKİNE İŞLEME PAYLARI

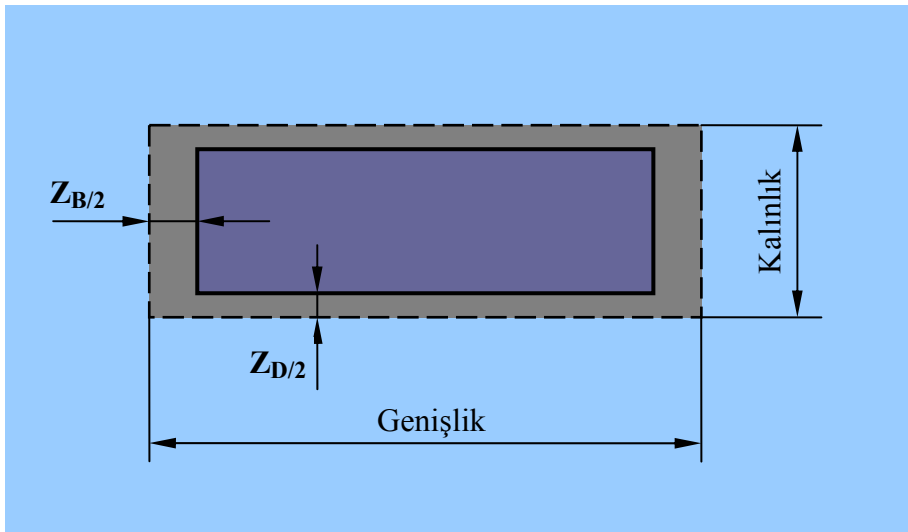
Dövülmüş veya haddelenmiş olarak üretilen malzemelerin yüzeylerinde, dekarbürizasyon (yüzeyde karbon kaybı) ve kılcal çatlaklar oluşur. Dekarbürizasyon, malzeme yüzeyinde yumuşak bölgelerin kalmasına neden olur. Kılcal çatlaklar ve yaraların ise, sertleştirme veya kullanım sırasında iç bölgelere ilerlemesi mümkündür.

Malzeme yüzeyinde istenilen sertliğin sağlanabilmesi ve beklenen formansın gerçekleşmesi için; yeterli miktarda talaş kaldırılarak bu yüzey tabakasının alınması gerekir.

Böhler tarafından üretilen yuvarlak kesitli çubuklar; üretim aşamasında, kabuk soyma ve tornalama işlemi gördüğünden işleme payları minimum miktardadır.

Böhler takım çeliklerinin, uluslararası standartlar dahilinde olan işleme paylarına ait tablolar aşağıda verilmiştir.

Ayrıca, detaylı bilgilere Teknik Destek bölümümüzden ulaşabilirsiniz.



SICAK HADDELENMİŞ ÇUBUKLAR İÇİN İŞLEME PAYLARI

Yuvarlak



Ölçü	> 12,5 - 25	> 25 – 63	> 63 - 100	> 100 - 160	> 160 - 250	> 250 - 315	> 315
İşleme Payı	0,50	0,80	1,00	1,50	2,50	3,00	2,50

Kare



Ölçü	> 13	> 13 - 26	> 26 - 35	> 35 - 51	> 51
İşleme Payı	0,85	1,50	2,00	2,50	3,20

Lama



Genişlik	İşleme Payı	Kalınlık							
		≤ 9	> 9 - 13	> 13 - 20	> 20 - 30	> 30 - 40	> 40 - 50	> 50 - 60	> 60
≤ 26	Z _B	1,8	1,8	2,0	2,0				
 Z _D	1,2	1,3	1,4	1,4				
> 26 – 50	Z _B	2,0	2,0	2,2	2,2	2,4	2,4		
 Z _D	1,2	1,2	1,4	1,6	1,8	2,0		
> 50 – 75	Z _B	2,2	2,2	2,4	2,4	2,6	2,6	2,8	3,0
 Z _D	1,4	1,4	1,6	1,8	2,0	2,2	2,4	2,6
> 75 – 100	Z _B	2,4	2,4	2,6	2,6	2,8	2,8	3,0	3,2
 Z _D	1,6	1,6	1,8	2,0	2,2	2,4	2,6	2,8
> 100 – 125	Z _B	2,6	2,6	2,8	2,8	3,0	3,0	3,2	3,4
 Z _D	1,6	1,8	2,0	2,2	2,2	2,4	2,6	2,8
> 125 – 150	Z _B	2,8	2,8	3,0	3,0	3,2	3,2	3,4	3,6
 Z _D	1,6	1,8	2,0	2,2	2,4	2,6	2,8	3,0
> 150 – 200	Z _B		3,0	3,2	3,2	3,4	3,4 2,6	3,6	3,8
 Z _D		1,8	2,0	2,4	2,4		2,8	3,0

DÖVÜLMÜŞ MALZEMELER İÇİN İŞLEME PAYLARI

Kare

Ölçü	22,0 - 40,0	40,1 - 63,0	63,1 - 80,0	80,1 - 100,0	100,1 - 125,0	125,1 - 142,0	142,1 - 210,0
İşleme Payı	3	4	5	6	7	8	10

210,1 - 250,0	250,1 - 315,0	315,1 - 400,0	400,1 - 500,0	500,1 - 630,0	630,1 - 770,0	>770,0
12	15	18	25	27	30	35

Lama

Genişlik mm	Genişlik B Kalınlık D	Kalınlık mm									
		3 - 5	> 5 - 7	> 7 - 10	> 10 - 15	> 15 - 20	> 20 - 25	> 25 - 35	> 35 - 50	> 50 - 75	> 75 - 100
≤ 16	B	2,0	2,0	2,0	2,0						
	D	1,0	1,5	2,0	2,0						
> 16 – 25	B	2,5	2,5	2,5	2,5	2,5	2,5				
	D	1,0	1,5	2,0	2,5	2,5	2,5				
> 25 – 30	B	3,0	3,0	3,0	3,0	3,0	3,0	3,0			
	D	1,0	2,0	2,5	2,5	2,5	3,0	3,0			
> 30 – 35	B	3,0	3,0	3,0	3,0	3,0	3,0	3,0			
	D	1,2	2,0	2,5	2,5	3,0	3,0	3,0			
> 35 – 50	B	3,5	3,5	3,5	3,5	3,5	3,5	3,5	3,5		
	D	1,2	2,0	2,5	3,0	3,0	3,0	3,0	3,5		
> 50 – 75	B	4,5	4,5	4,5	4,5	4,5	4,5	4,5	4,5	4,5	
	D	1,4	2,0	2,5	3,0	3,5	3,5	4,0	4,0	4,5	
> 75 – 100	B		6,0	6,0	6,0	6,0	6,0	6,0	6,0	6,0	6,0
	D		2,0	3,0	3,5	4,0	4,0	4,0	4,5	5,0	6,0
> 100 – 125	B			7,0	7,0	7,0	7,0	7,0	7,0	7,0	7,0
	D			3,0	4,0	4,5	5,0	5,0	5,5	6,0	6,5
> 125 – 150	B			9,0	9,0	9,0	9,0	9,0	9,0	9,0	9,0
	D			3,5	4,5	5,0	5,5	6,0	6,0	6,5	7,0
> 150 – 175	B				10,0	10,0	10,0	10,0	10,0	10,0	10,0
	D				5,0	5,5	6,0	6,0	6,5	7,0	8,0
> 175 – 200	B					11,0	11,0	11,0	11,0	11,0	11,0
	D					6,0	7,0	7,0	7,0	8,0	9,0
> 200 – 250	B					13,0	13,0	13,0	13,0	13,0	13,0
	D					6,0	7,0	8,0	8,5	9,0	9,5
> 250 – 315	B							16,0	16,0	16,0	16,0
	D							9,5	10,0	10,5	11,0
> 315 – 400	B							19,0	19,0	19,0	19,0
	D							11,5	12,0	12,5	13,0
> 400 – 630	B							25,0	25,0	25,0	25,0
	D							13,0	15,0	16,0	17,0
> 630 – 800	B								30,0	30,0	30,0
	D								19,0	21,0	22,0
> 800 – 1000	B									35,0	35,0
	D									25,0	25,0
> 1000	B										35,0
	D										25,0

Kalınlık												
> 100 - 125	> 125 - 150	> 150 - 200	> 200 - 250	> 250 - 300	> 300 - 350	> 350 - 400	> 400 - 450	> 450 - 500	> 500 - 550	> 550 - 600	> 600 - 650	> 650
7,0												
7,0												
9,0	9,0											
7,0	9,0											
10,0	10,0	10,0										
9,0	9,0	10,0										
11,0	11,0	11,0										
9,0	10,0	11,0										
13,0	13,0	13,0	13,0									
10,5	11,0	12,0	13,0									
16,0	16,0	16,0	16,0	16,0	16,0							
11,5	12,5	13,0	15,0	16,0	16,0							
19,0	19,0	19,0	19,0	19,0	19,0							
14,0	15,0	16,0	17,5	18,0	19,0							
25,0	25,0	25,0	25,0	25,0	25,0	25,0	25,0	25,0	25,0	25,0	25,0	
17,5	17,5	18,5	20,0	21,5	23,0	24,0	25,0	25,0	25,0	25,0	25,0	
30,0	30,0	30,0	30,0	30,0	30,0	30,0	30,0	30,0	30,0	30,0	30,0	30,0
22,5	23,5	25,0	25,0	25,0	25,0	25,0	25,0	25,5	27,0	28,0	30,0	30,0
35,0	35,0	35,0	35,0	35,0	35,0	35,0	35,0	35,0	35,0	35,0	35,0	35,0
25,0	25,0	25,0	25,0	25,0	26,5	28,0	29,0	30,0	30,0	30,0	30,5	32,0
35,0	35,0	35,0	35,0	35,0	35,0	35,0	35,0	35,0	35,0	35,0	35,0	35,0
25,5	26,5	27,0	28,5	30,0	30,0	30,0	31,0	32,5	34,0	35,0	35,0	35,0