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(Hss)

E-mail: (eimanian2001@yahoo.com)

(Ck45)

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- - - :

lafdi,Mansori

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Mansori

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5X

[]

Zeiss

Sasada, Soda

Raytek

RayMX4PG

(transition metals)

Rc (CK45)

mm

[]

(d electron vacancies)

kragelskii

(interface)

[]

Ghosh, Muju

(a b)

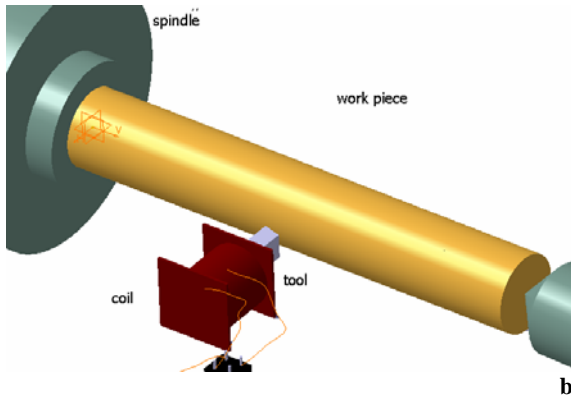
(DC)



a

[] []

(HSS)



b

MAT

TN50D

9257B

KITSLER

Dynoware

(b a)

N5404

()

$$2\varphi + \beta - \gamma = \frac{\pi}{2} \quad ()$$

: β mm/rev

: F_h / mm/rev /

: F_t

$$\text{tg } \varphi = r_c \cos \gamma / (1 - r_c \sin \gamma) \quad ()$$

: γ
 φ

(m/min)

()

(r(c))

(Bue)

$\gamma = 0$

$$\tan \beta = \frac{F_h}{F_t} \quad ()$$

HSS

1. M.EL .Mansori , K.lafdi ,D. Paulmier ,Matal cutting and High Speed Machining Kluwer Academic/Plenum Palisher ,New York,2002,P.301.
2. M.EL .Mansori , F.Pierron ,D. Paulmier ,Reduction of tool wear in metal cutting ...surface and coatings technology,163-164,2003,p 472-477.
3. N.Soda. and T.Sasada ,J.Lubr .Tech .,100(1978) 492.
4. I.V.Kragelskii , Friction and wear , Butter worths ,Washington ,D.C.,PP.8-12,1965
5. M.K.Muju;A.Ghosh,ASME Paper 75-PT-5-1975
6. M.K Muju ; A.Ghosh ; Wear 58(1980) 137.

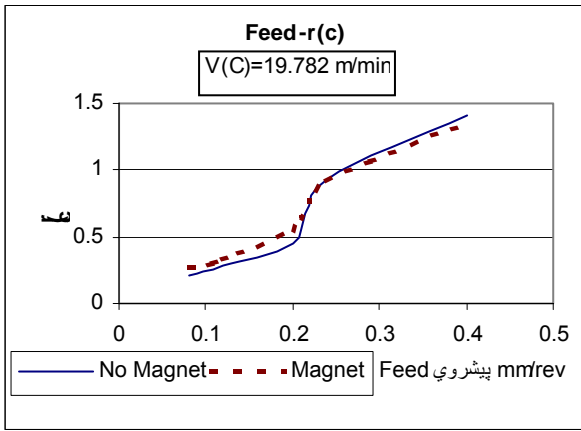
$$(a_p = 1mm, a_f = 0/12 mm/rev)$$

	/	/	/	m/min
/	/	/	/) ϕ
/	/	/	/	() ϕ

$$(a_p = 1mm, V_c = 16/782 mm/rev)$$

	/	/	/	mm/rev
/	/	/	/	() ϕ
/	/	/	/	() ϕ

m/min

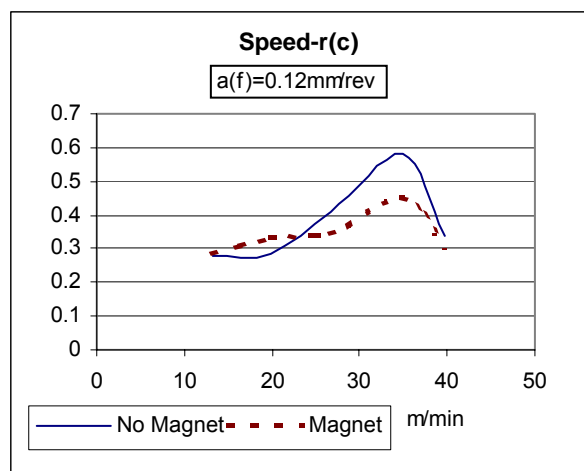
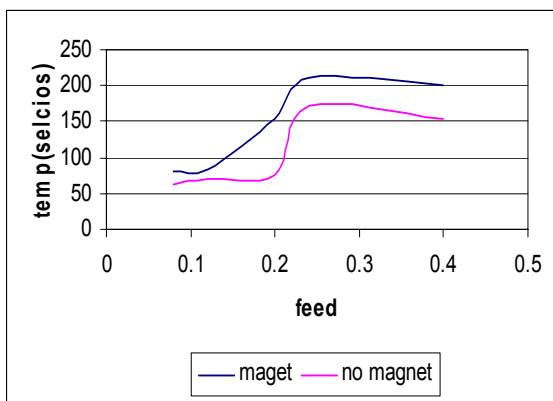
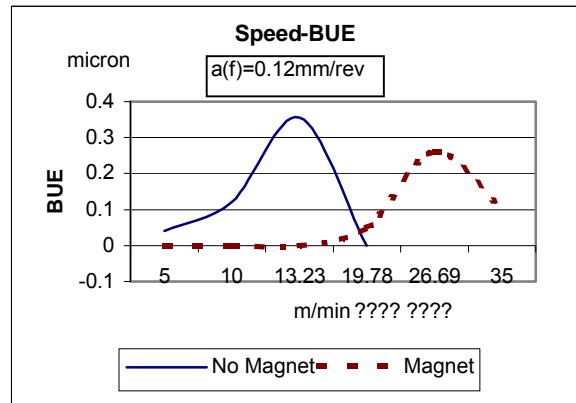
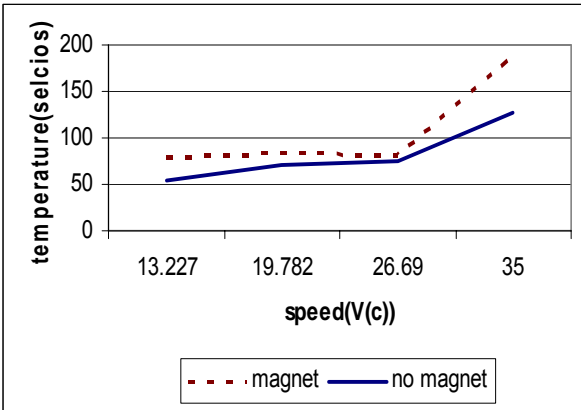


$(a_p = 1mm, a_f = 0.12mm/rev)$

	/	/	m/min
			(N)
			(N)

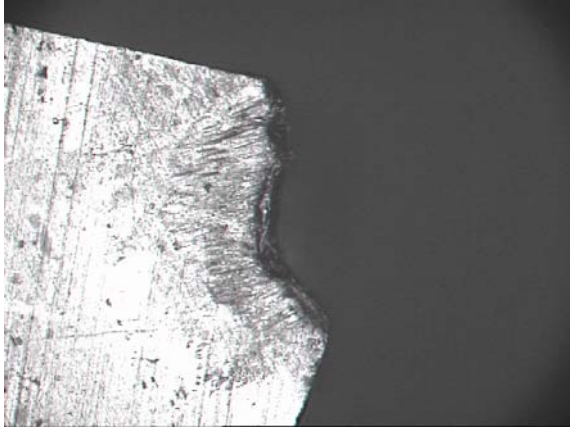
$(a_p = 1mm, v_c = 19.782mm/rev)$

/	/	/	mm/rev
			(N)
			(N)

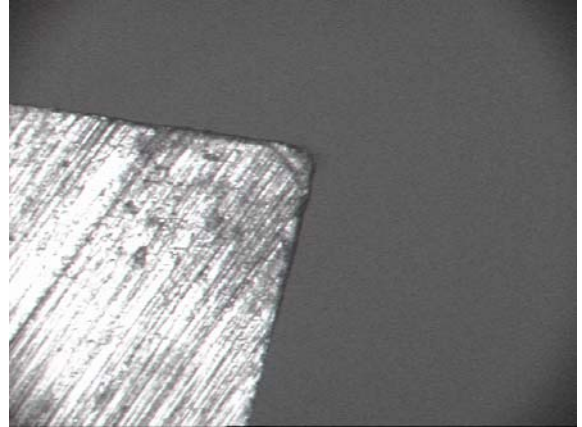


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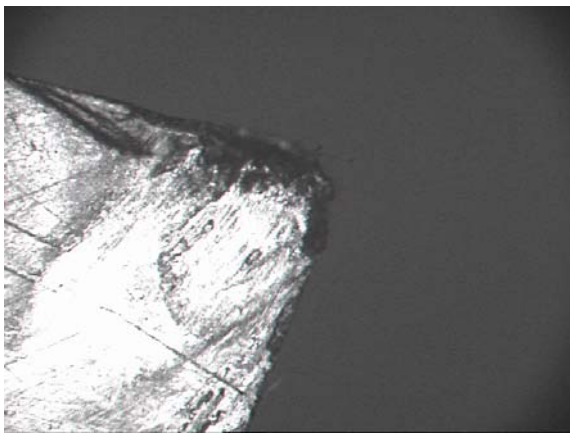
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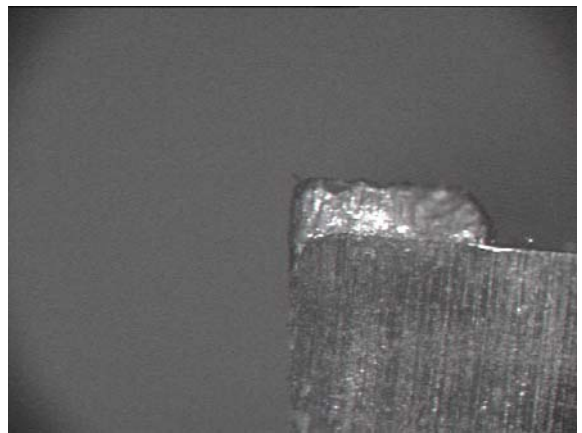
$V(c) = 35, a(f) = .12, a(p) = 1$



$V(c) = 13.227, a(f) = .12, a(p) = 1$



$V(c) = 35, (f) = .12, a(p) = 1$



$V(c) = 13.227, a(f) = .12, a(p) = 1$

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