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| ***Таблица 2*.3. ТОЧНОСТ И КАЧЕСТВО НА ПОВЪРХНИНИТЕ ПРИ ОБРАБОТВАНЕ**  **НА ВЪНШНИ ЦИЛИНДРИЧНИ ПОВЪРХНИНИ (извадка) [4]**   |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | | Техноло-  гичен  преход | Грапа-вост  Rz  Ra  μм | Дефе-  ктен  слой  μм | Клас  на точ-  ност | Технологичен допуск в μм на размера на обработваната  повърхнина, при номинален размер в mm | | | | | | | | | Степен  на  точност  БДС  5634 -  76 | Точност на форма и взаимно разположение μм, при номинален размер, mm | | | | | | Над  3  до  6 | Над  6  до  10 | Над  10  до  18 | Над  18  до  30 | Над  30  до  50 | Над  50  до  80 | Над  80  до  120 | Над  120  до  180 | Над  180  до  250 | До 6 | Над  6  до  18 | Над  18  до  50 | Над  50  до  120 | Над  120  до  250 | | Обстъргване  грубо | Rz 160  50 | 120  60 | 14 |  |  |  |  | 620 | 740 | 870 | 1000 | 1150 | XI | 40-20 | 50-160 | 60-200 | 80-250 | 100-300 | | 12 | 120 | 150 | 180 | 210 | 250 | 300 | 350 | 400 | 460 | X | 25-80 | 30-100 | 40-120 | 50-100 | 60-200 | | получисто и  еднократно | Rz 50  12,5 | 50  20 | 12 | 120 | 150 | 180 | 210 | 200 | 300 | 350 | 400 | 460 | X | 16-50 | 20 - 60 | 25 - 80 | 30-100 | 40-120 | | 11 | 75 | 90 | 110 | 130 | 160 | 190 | 220 | 250 | 290 | IX | 10-30 | 12 - 40 | 16 -50 | 20-60 | 25-80 | | Чисто | Rz 50  Rа 1,6 | 30  20 | 10 | 48 | 58 | 70 | 84 | 100 | 120 | 140 | 160 | 185 | VIII | 6-20 | 8 – 25 | 10 - 30 | 12-40 | 16-50 | | 8 | 18 | 22 | 27 | 33 | 39 | 46 | 54 | 63 | 72 | VII | 4-12 | 5 – 15 | 6 – 20 | 8-25 | 10-30 | | Фино | 1,25  0,04 | 10  5 | 8 | 18 | 22 | 27 | 33 | 39 | 46 | 54 | 63 | 72 | VII | 6-20 | 8 – 25 | 10-30 | 12-40 | 16-50 | | 7 | 12 | 15 | 18 | 21 | 25 | 30 | 35 | 40 | 46 | VI | 4-12 | 5 - 15 | 6 -20 | 8-25 | 10-30 | | Шлифоване  Предварител-  но | 2,5  0,8 | 20 | 8 | 18 | 22 | 27 | 33 | 39 | 46 | 54 | 63 | 72 | VII | 6  20 | 6 - 20 | 8 – 25 | 12- 40 | 16-50 | | Чисто | 1,25  0,4 | 15  5 | 7  6 | 12  8 | 15  9 | 18  11 | 21  13 | 25  16 | 30  19 | 35  22 | 40  25 | 46  29 | VI | 4  12 | 4 – 12 | 6-20 | 8-25 | 10  30 | | Фино | 0,63  0,1 | 5 | 6  5 | 8  5 | 9  6 | 11  8 | 13  9 | 16  11 | 19  13 | 22  15 | 25  15 | 29  20 | V | 2,5 | 3 | 4 | 5 | 6 |   **ЗАБЕЛЕЖКИ;**  1. Данните се отнасят за стоманени заготовки. За детайли от чугун и цветни метали отклоненията са с една степен на точност по-висока.  2. Граничите отклонения за точност на форма и взаимно разположение μм важат за L/D≤2. При L/D = 2 ÷ 10 грешките се увеличават от 2 до 3 пъти.  3. Граничните отклонения за формат (нецилиндричност и некръглост) са дадени в числителя, а за биене – в знаменателя.  4. Степента на точност се отнася и за обработването на конусни повърхнини. |