





??????35-80m/min; ???1.5mm???0.15-0.25mm/r;

??????2—6????????8???

????????????“????”????????????????????????????????????????????????????????????????????????????????

??????

???????????

?1???????????????

????????????????????????????????????????????????????????????????????????????????HRC50????????????????????????????????

???CBN????????????HRC50????????????????????????????????BN-

S20??CBN????????????????CBN????/????????????????????????????????????????????????????????

?2?CBN???????????????

?????HRC55?65?????CBN?????????50?120m?min?????Vc=100?160m/min???????Vf=70?160mm/min??

??Vc=

60?130m/min?ap=0.1?0.2mm?f=0.07?0.2mm/r????

?CBN?????????????45HRC????????????????????????????????????70HRC?????????????60-80m/min;???????

1?0.3mm?????0.05?0.025mm/r????????????Ra0.3?0.6?m????????0.013mm????????????????????????????

????????????Ra0.3?m?????0.01mm????????????

?3????BN-S20?CBN????????????

A????????????ap?2.5mm???v?95m/min?

B?????? ??????ap?0.2mm ?v?120m/min?

????????????????????????????????????????????????????????????????????????????????????Ra

1.6????????30??

???

??????

??????????

????????????????????

??????BN-S20?CBN????????????--???????????? CBN??

??????????????

????????????????????????PCBN??2????????????????HRC35-79??

???HLCBN????????CBN??????