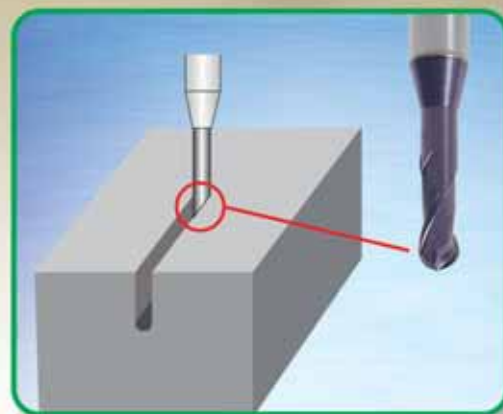
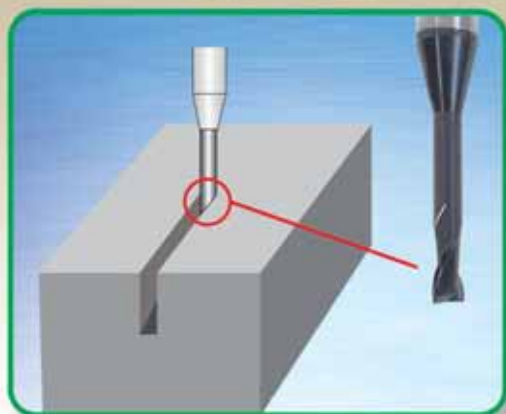


# RIBMILL

Обработка глубоких  
шпоночных пазов



# Номенклатура **RIBMILL**

RIF 2□□□



G98

- Плоский торец, 2 зуба, угол наклона спирали 30°
- Обработка глубоких шпоночных пазов

RIB 2□□□

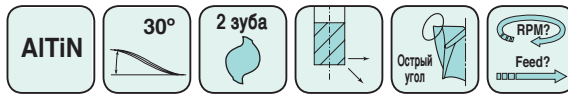


G100

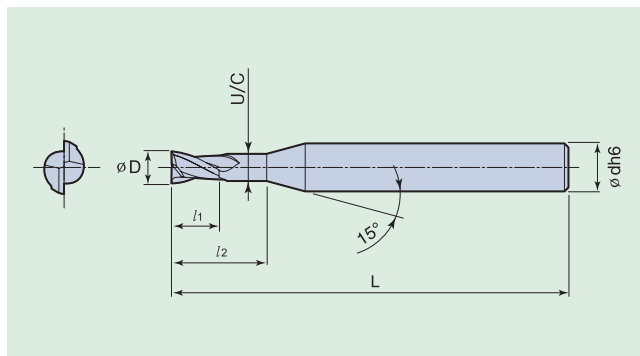
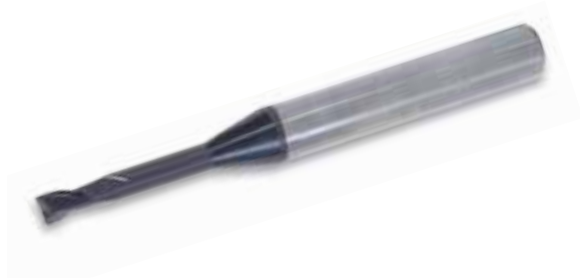
- Сферический торец, 2 зуба, угол наклона спирали 30°
- Обработка глубоких шпоночных пазов



## ■ RIF 2□□□



G102 →

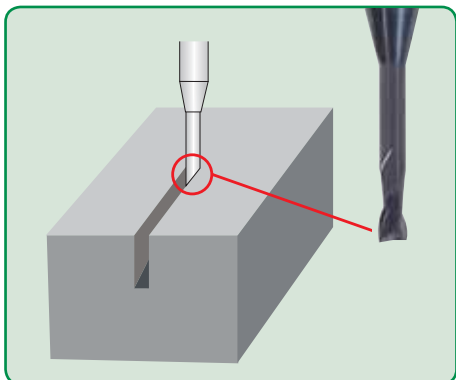


- Концевые фрезы для обработки глубоких шпоночных пазов
- Сплав: TT1040

| Допуск |            |
|--------|------------|
| D      | 0 - -0.015 |
| d      | 0 - -0.006 |

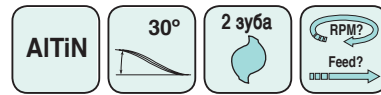
| Обозначение    | Размеры (мм) |    |       |       |      |   |
|----------------|--------------|----|-------|-------|------|---|
|                | D            | L  | $l_1$ | $l_2$ | u/c  | d |
| RIF 2004-0.6×4 | 0.4          | 45 | 0.6   | 4     | 0.37 | 4 |
| RIF 2004-0.6×5 | 0.4          | 45 | 0.6   | 5     | 0.37 | 4 |
| RIF 2005-0.7×4 | 0.5          | 45 | 0.7   | 4     | 0.45 | 4 |
| RIF 2005-0.7×6 | 0.5          | 45 | 0.7   | 6     | 0.45 | 4 |
| RIF 2005-0.7×8 | 0.5          | 45 | 0.7   | 8     | 0.45 | 4 |
| RIF 2006-0.9×6 | 0.6          | 45 | 0.9   | 6     | 0.55 | 4 |
| RIF 2006-0.9×8 | 0.6          | 45 | 0.9   | 8     | 0.55 | 4 |

- Производство сплава KT8600 прекращено, вместо него выпускается сплав TT1040

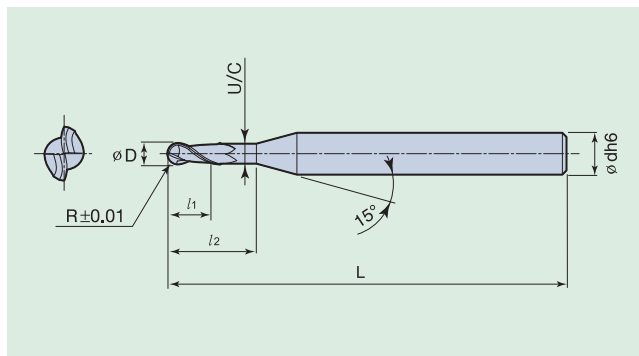


| Обозначение     | Размеры (мм) |    |       |       |      |   |
|-----------------|--------------|----|-------|-------|------|---|
|                 | D            | L  | $l_1$ | $l_2$ | u/c  | d |
| RIF 2008-1.2×4  | 0.8          | 45 | 1.2   | 4     | 0.75 | 4 |
| RIF 2008-1.2×6  | 0.8          | 45 | 1.2   | 6     | 0.75 | 4 |
| RIF 2008-1.2×8  | 0.8          | 45 | 1.2   | 8     | 0.75 | 4 |
| RIF 2008-1.2×10 | 0.8          | 45 | 1.2   | 10    | 0.75 | 4 |
| RIF 2010-1.5×6  | 1.0          | 45 | 1.5   | 6     | 0.97 | 4 |
| RIF 2010-1.5×8  | 1.0          | 45 | 1.5   | 8     | 0.95 | 4 |
| RIF 2010-1.5×10 | 1.0          | 45 | 1.5   | 10    | 0.95 | 4 |
| RIF 2010-1.5×12 | 1.0          | 45 | 1.5   | 12    | 0.93 | 4 |
| RIF 2010-1.5×16 | 1.0          | 50 | 1.5   | 16    | 0.93 | 4 |
| RIF 2012-1.8×6  | 1.2          | 45 | 1.8   | 6     | 1.17 | 4 |
| RIF 2012-1.8×8  | 1.2          | 45 | 1.8   | 8     | 1.15 | 4 |
| RIF 2012-1.8×10 | 1.2          | 45 | 1.8   | 10    | 1.15 | 4 |
| RIF 2012-1.8×16 | 1.2          | 50 | 1.8   | 16    | 1.13 | 4 |
| RIF 2015-2.3×6  | 1.5          | 45 | 2.3   | 6     | 1.47 | 4 |
| RIF 2015-2.3×8  | 1.5          | 45 | 2.3   | 8     | 1.45 | 4 |
| RIF 2015-2.3×10 | 1.5          | 45 | 2.3   | 10    | 1.45 | 4 |
| RIF 2015-2.3×12 | 1.5          | 45 | 2.3   | 12    | 1.43 | 4 |
| RIF 2015-2.3×16 | 1.5          | 50 | 2.3   | 16    | 1.41 | 4 |
| RIF 2015-2.3×20 | 1.5          | 55 | 2.3   | 20    | 1.41 | 4 |
| RIF 2016-2.4×10 | 1.6          | 45 | 2.4   | 10    | 1.55 | 4 |
| RIF 2016-2.4×16 | 1.6          | 50 | 2.4   | 16    | 1.53 | 4 |
| RIF 2018-2.7×12 | 1.8          | 45 | 2.7   | 12    | 1.73 | 4 |
| RIF 2018-2.7×16 | 1.8          | 50 | 2.7   | 16    | 1.71 | 4 |
| RIF 2020-3.0×8  | 2.0          | 45 | 3.0   | 8     | 1.95 | 4 |
| RIF 2020-3.0×10 | 2.0          | 45 | 3.0   | 10    | 1.95 | 4 |
| RIF 2020-3.0×12 | 2.0          | 45 | 3.0   | 12    | 1.93 | 4 |
| RIF 2020-3.0×16 | 2.0          | 50 | 3.0   | 16    | 1.91 | 4 |
| RIF 2025-3.7×12 | 2.5          | 45 | 3.7   | 12    | 2.40 | 4 |
| RIF 2025-3.7×16 | 2.5          | 55 | 3.7   | 16    | 2.40 | 4 |
| RIF 2030-4.5×14 | 3.0          | 50 | 4.5   | 14    | 2.85 | 6 |
| RIF 2030-4.5×18 | 3.0          | 55 | 4.5   | 18    | 2.85 | 6 |
| RIF 2030-4.5×20 | 3.0          | 60 | 4.5   | 20    | 2.85 | 6 |
| RIF 2030-4.5×25 | 3.0          | 65 | 4.5   | 25    | 2.85 | 6 |

## RIB 2□□□



G103 →

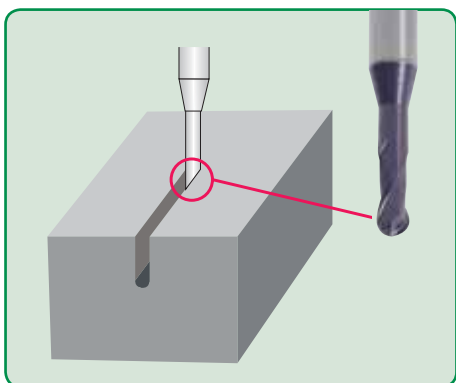


- Концевые фрезы для обработки глубоких шпоночных пазов
- Сплав: TT1040

| Допуск     |                 |
|------------|-----------------|
| $D \leq 3$ | -0.014 - -0.028 |
| $3 < D$    | -0.020 - -0.038 |

| Обозначение     | Размеры (мм) |    |       |       |      |   |
|-----------------|--------------|----|-------|-------|------|---|
|                 | D            | L  | $l_1$ | $l_2$ | u/c  | d |
| RIB 2004-0.6×3  | 0.4          | 45 | 0.6   | 3     | 0.36 | 4 |
| RIB 2005-0.7×4  | 0.5          | 45 | 0.7   | 4     | 0.45 | 4 |
| RIB 2005-0.7×6  | 0.5          | 45 | 0.7   | 6     | 0.45 | 4 |
| RIB 2005-0.7×8  | 0.5          | 45 | 0.7   | 8     | 0.45 | 4 |
| RIB 2006-0.9×2  | 0.6          | 45 | 0.9   | 2     | 0.55 | 4 |
| RIB 2006-0.9×4  | 0.6          | 45 | 0.9   | 4     | 0.55 | 4 |
| RIB 2006-0.9×6  | 0.6          | 45 | 0.9   | 6     | 0.55 | 4 |
| RIB 2006-0.9×8  | 0.6          | 45 | 0.9   | 8     | 0.55 | 4 |
| RIB 2008-1.2×4  | 0.8          | 45 | 1.2   | 4     | 0.75 | 4 |
| RIB 2008-1.2×6  | 0.8          | 45 | 1.2   | 6     | 0.75 | 4 |
| RIB 2008-1.2×8  | 0.8          | 45 | 1.2   | 8     | 0.75 | 4 |
| RIB 2008-1.2×10 | 0.8          | 45 | 1.2   | 10    | 0.75 | 4 |

- Производство сплава KT8600 прекращено, вместо него выпускается сплав TT1040



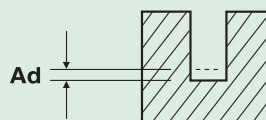
| Обозначение     | Размеры (мм) |    |       |       |      |   |
|-----------------|--------------|----|-------|-------|------|---|
|                 | D            | L  | $l_1$ | $l_2$ | u/c  | d |
| RIB 2010-1.5×4  | 1.0          | 45 | 1.5   | 4     | 0.97 | 4 |
| RIB 2010-1.5×6  | 1.0          | 45 | 1.5   | 6     | 0.97 | 4 |
| RIB 2010-1.5×8  | 1.0          | 45 | 1.5   | 8     | 0.95 | 4 |
| RIB 2010-1.5×10 | 1.0          | 45 | 1.5   | 10    | 0.95 | 4 |
| RIB 2010-1.5×12 | 1.0          | 45 | 1.5   | 12    | 0.93 | 4 |
| RIB 2012-1.8×4  | 1.2          | 45 | 1.8   | 4     | 1.15 | 4 |
| RIB 2012-1.8×8  | 1.2          | 45 | 1.8   | 8     | 1.17 | 4 |
| RIB 2012-1.8×12 | 1.2          | 45 | 1.8   | 12    | 1.13 | 4 |
| RIB 2015-2.3×8  | 1.5          | 45 | 2.3   | 8     | 1.45 | 4 |
| RIB 2015-2.3×10 | 1.5          | 45 | 2.3   | 10    | 1.45 | 4 |
| RIB 2015-2.3×12 | 1.5          | 45 | 2.3   | 12    | 1.43 | 4 |
| RIB 2015-2.3×16 | 1.5          | 50 | 2.3   | 16    | 1.41 | 4 |
| RIB 2015-2.3×20 | 1.5          | 55 | 2.3   | 20    | 1.39 | 4 |
| RIB 2020-3.0×6  | 2.0          | 45 | 3.0   | 6     | 1.95 | 4 |
| RIB 2020-3.0×8  | 2.0          | 45 | 3.0   | 8     | 1.95 | 4 |
| RIB 2020-3.0×10 | 2.0          | 45 | 3.0   | 10    | 1.93 | 4 |
| RIB 2020-3.0×12 | 2.0          | 50 | 3.0   | 12    | 1.93 | 4 |
| RIB 2020-3.0×16 | 2.0          | 50 | 3.0   | 16    | 1.91 | 4 |
| RIB 2020-3.0×20 | 2.0          | 55 | 3.0   | 20    | 1.89 | 4 |
| RIB 2030-4.5×10 | 3.0          | 50 | 4.5   | 10    | 2.85 | 6 |
| RIB 2030-4.5×12 | 3.0          | 50 | 4.5   | 12    | 2.85 | 6 |
| RIB 2030-4.5×16 | 3.0          | 55 | 4.5   | 16    | 2.85 | 6 |
| RIB 2030-4.5×20 | 3.0          | 60 | 4.5   | 20    | 2.85 | 6 |

## ■ RIF 2□□□

Скорость: об/мин, Подача: мм/мин

| Материал  | Сталь<br>Легированная сталь<br>Чугун |           |               | Легированная сталь<br>Жаропрочная сталь |           |               | Закалённая сталь             |          |               |
|-----------|--------------------------------------|-----------|---------------|---|-----------|---------------|------------------------------|----------|---------------|
|           | - HRC30                              |           |               | HRC30 - HRC45                           |           |               | HRC45 - HRC55                |          |               |
| Твёрдость |                                      |           |               |   |           |               |                              |          |               |
| Прочность | - 850Н/мм <sup>2</sup>               |           |               | 850 - 1600Н/мм <sup>2</sup>             |           |               | 1600 - 2000Н/мм <sup>2</sup> |          |               |
| Диаметр   | Скорость                             | Подача    | Ad(мм)        | Скорость                                | Подача    | Ad(мм)        | Скорость                     | Подача   | Ad(мм)        |
| 0.4       | 31000 - 40000                        | 200 - 440 | 0.007 - 0.018 | 22500 - 28000                           | 85 - 340  | 0.007 - 0.018 | 14300 - 17000                | 30 - 90  | 0.004 - 0.008 |
| 0.5       | 31000 - 40000                        | 200 - 440 | 0.009 - 0.022 | 22500 - 28000                           | 85 - 340  | 0.009 - 0.022 | 14300 - 17000                | 30 - 90  | 0.004 - 0.009 |
| 0.6       | 31000 - 40000                        | 250 - 570 | 0.011 - 0.026 | 22500 - 28000                           | 110 - 430 | 0.011 - 0.026 | 14300 - 17000                | 40 - 110 | 0.005 - 0.011 |
| 0.7       | 31000 - 40000                        | 250 - 570 | 0.012 - 0.031 | 22500 - 28000                           | 110 - 430 | 0.012 - 0.031 | 14300 - 17000                | 40 - 110 | 0.006 - 0.013 |
| 0.8       | 27000 - 35000                        | 280 - 630 | 0.014 - 0.035 | 19500 - 24500                           | 120 - 480 | 0.014 - 0.035 | 12500 - 14800                | 45 - 125 | 0.007 - 0.015 |
| 0.9       | 25000 - 31500                        | 280 - 720 | 0.030 - 0.060 | 17500 - 22500                           | 160 - 540 | 0.030 - 0.060 | 11000 - 12500                | 55 - 130 | 0.008 - 0.016 |
| 1         | 22500 - 28000                        | 280 - 810 | 0.045 - 0.090 | 15700 - 20000                           | 190 - 600 | 0.045 - 0.090 | 10000 - 12500                | 65 - 130 | 0.009 - 0.018 |
| 1.2       | 18500 - 22500                        | 280 - 900 | 0.055 - 0.100 | 13000 - 16500                           | 190 - 600 | 0.055 - 0.100 | 8300 - 10500                 | 65 - 130 | 0.010 - 0.022 |
| 1.4       | 16000 - 20000                        | 280 - 900 | 0.062 - 0.125 | 11500 - 14000                           | 190 - 600 | 0.062 - 0.125 | 7200 - 9000                  | 65 - 130 | 0.012 - 0.025 |
| 1.5       | 14500 - 18500                        | 280 - 900 | 0.070 - 0.135 | 10500 - 13500                           | 190 - 600 | 0.070 - 0.135 | 6700 - 8200                  | 65 - 130 | 0.014 - 0.028 |
| 1.6       | 14000 - 18000                        | 280 - 900 | 0.075 - 0.145 | 10200 - 12800                           | 190 - 600 | 0.075 - 0.145 | 6400 - 8000                  | 65 - 130 | 0.015 - 0.030 |
| 1.8       | 13000 - 16500                        | 280 - 900 | 0.080 - 0.160 | 9200 - 11500                            | 190 - 600 | 0.080 - 0.160 | 5700 - 7200                  | 65 - 130 | 0.016 - 0.032 |
| 2         | 12000 - 14500                        | 280 - 900 | 0.090 - 0.180 | 8300 - 10500                            | 190 - 600 | 0.090 - 0.180 | 5300 - 6600                  | 65 - 130 | 0.018 - 0.035 |
| 2.5       | 9500 - 12000                         | 280 - 900 | 0.112 - 0.235 | 6700 - 8500                             | 190 - 600 | 0.112 - 0.235 | 4300 - 5300                  | 65 - 130 | 0.022 - 0.045 |
| 3         | 8000 - 10000                         | 280 - 900 | 0.135 - 0.270 | 5500 - 7000                             | 190 - 600 | 0.135 - 0.270 | 3500 - 4400                  | 65 - 130 | 0.028 - 0.055 |

(глубина резания за проход)



## ■ RIB 2□□□

Скорость: об/мин, Подача: мм/мин

| Материал  | Сталь<br>Легированная сталь<br>Чугун |           |               | Легированная сталь<br>Жаропрочная сталь |           |               | Закалённая сталь             |           |               |
|-----------|--------------------------------------|-----------|---------------|---|-----------|---------------|------------------------------|-----------|---------------|
|           | - HRC30                              |           |               | HRC30 - HRC45                           |           |               | HRC45 - HRC55                |           |               |
| Твёрдость |                                      |           |               |   |           |               |                              |           |               |
| Прочность | - 850Н/мм <sup>2</sup>               |           |               | 850 - 1600Н/мм <sup>2</sup>             |           |               | 1600 - 2000Н/мм <sup>2</sup> |           |               |
| Диаметр   | Скорость                             | Подача    | Ad(мм)        | Скорость                                | Подача    | Ad(мм)        | Скорость                     | Подача    | Ad(мм)        |
| 0.4       | 31000 - 40000                        | 175 - 490 | 0.018 - 0.036 | 22500 - 28500                           | 88 - 270  | 0.018 - 0.036 | 14300 - 18000                | 88 - 175  | 0.004 - 0.007 |
| 0.5       | 31000 - 40000                        | 175 - 490 | 0.023 - 0.045 | 22500 - 28500                           | 88 - 270  | 0.023 - 0.045 | 14300 - 18000                | 88 - 175  | 0.005 - 0.009 |
| 0.6       | 31000 - 40000                        | 225 - 630 | 0.027 - 0.054 | 22500 - 28500                           | 110 - 350 | 0.027 - 0.054 | 14300 - 18000                | 110 - 225 | 0.005 - 0.011 |
| 0.8       | 31000 - 40000                        | 225 - 630 | 0.036 - 0.072 | 22500 - 28500                           | 110 - 350 | 0.036 - 0.072 | 14300 - 18000                | 110 - 225 | 0.007 - 0.014 |
| 1         | 29000 - 36500                        | 250 - 700 | 0.045 - 0.090 | 20500 - 26000                           | 125 - 390 | 0.045 - 0.090 | 13000 - 16300                | 125 - 250 | 0.009 - 0.018 |
| 1.2       | 24000 - 30500                        | 250 - 780 | 0.055 - 0.100 | 17000 - 21500                           | 125 - 390 | 0.055 - 0.100 | 10800 - 13700                | 125 - 250 | 0.010 - 0.022 |
| 1.4       | 21000 - 26000                        | 250 - 780 | 0.062 - 0.125 | 15000 - 18000                           | 125 - 390 | 0.062 - 0.125 | 9400 - 11700                 | 125 - 250 | 0.012 - 0.025 |
| 1.5       | 19000 - 24000                        | 250 - 780 | 0.070 - 0.135 | 13500 - 17500                           | 125 - 390 | 0.070 - 0.135 | 8700 - 10700                 | 125 - 250 | 0.014 - 0.028 |
| 1.6       | 18000 - 23500                        | 250 - 780 | 0.075 - 0.145 | 13200 - 16500                           | 125 - 390 | 0.075 - 0.145 | 8300 - 10400                 | 125 - 250 | 0.015 - 0.030 |
| 1.8       | 17000 - 21500                        | 250 - 780 | 0.080 - 0.160 | 12000 - 15000                           | 125 - 390 | 0.080 - 0.160 | 7400 - 9400                  | 125 - 250 | 0.016 - 0.032 |
| 2         | 15500 - 19000                        | 250 - 780 | 0.090 - 0.180 | 11000 - 13500                           | 125 - 390 | 0.090 - 0.180 | 6900 - 8600                  | 125 - 250 | 0.018 - 0.035 |
| 3         | 10500 - 13000                        | 250 - 780 | 0.135 - 0.270 | 7000 - 9000                             | 125 - 390 | 0.135 - 0.270 | 4600 - 5700                  | 125 - 250 | 0.028 - 0.055 |

(глубина резания за проход)

