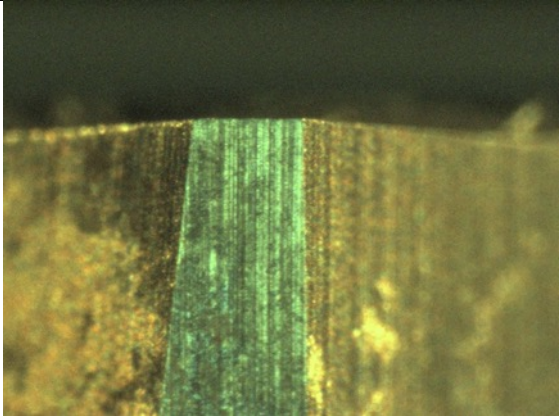
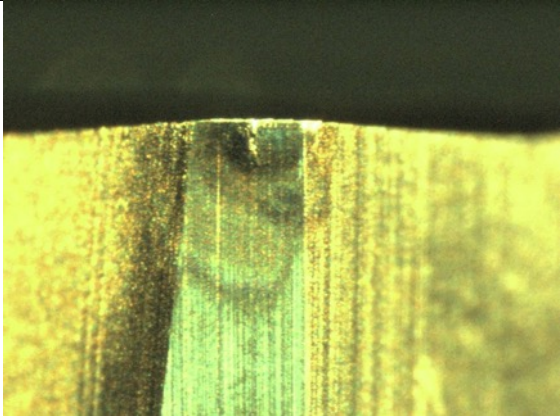
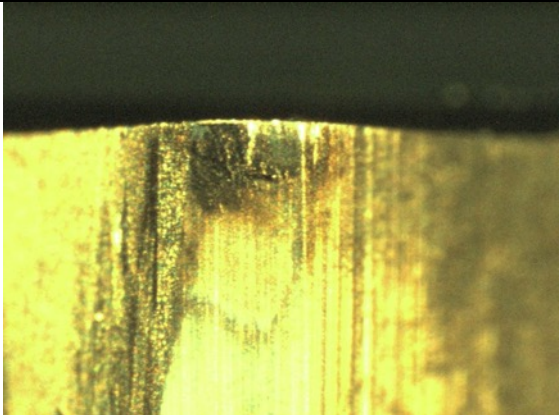
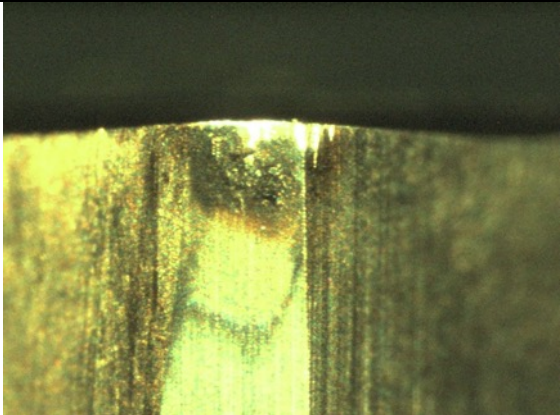
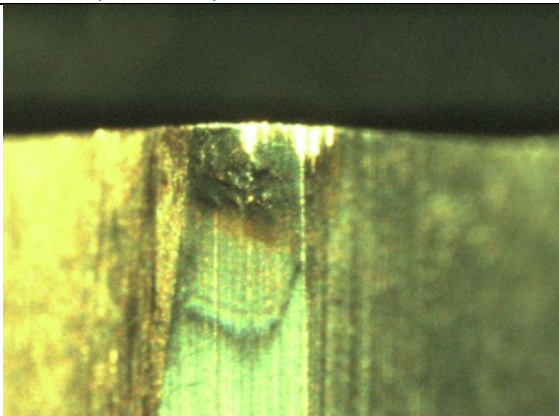
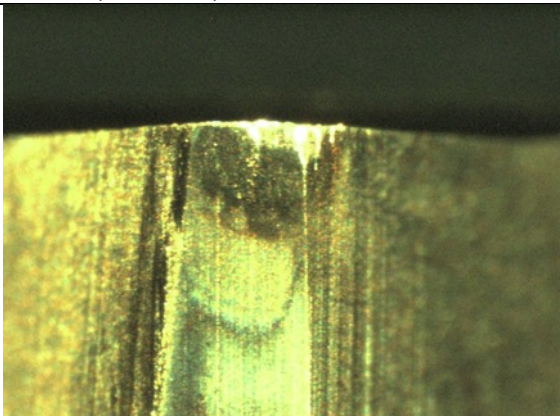


# PŘÍLOHA 2

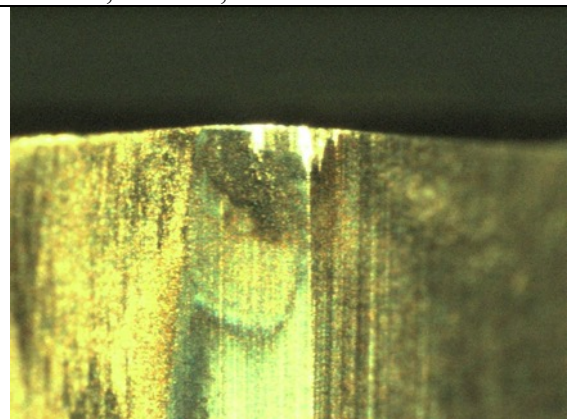
Cermet SC3

Řezná rychlost  $v_{cl} = 350 \text{ m} \cdot \text{min}^{-1}$

Zvětšení: 180x

VB = 0 mm; T = 0 min	VB = 0,014 mm; T = 15 min
	
VB = 0,041 mm; T = 45 min	VB = 0,104 mm; T = 74 min
	
VB = 0,112 mm; T = 88 min	VB = 0,137 mm; T = 102 min
	

VB = 0,156 mm; T = 116 min

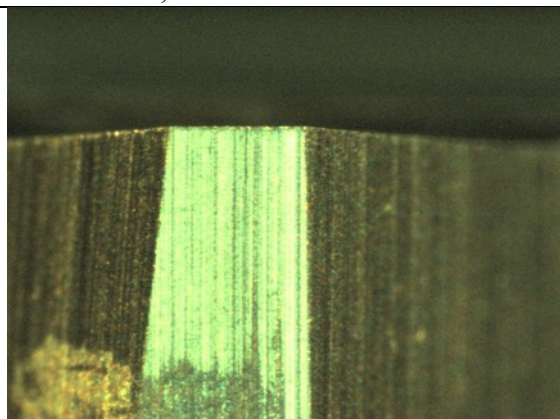


### Cermet SC3

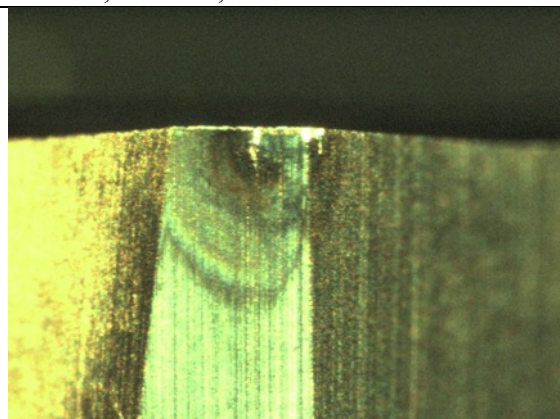
Řezná rychlost  $v_{c2} = 300 \text{ m} \cdot \text{min}^{-1}$

Zvětšení: 180x

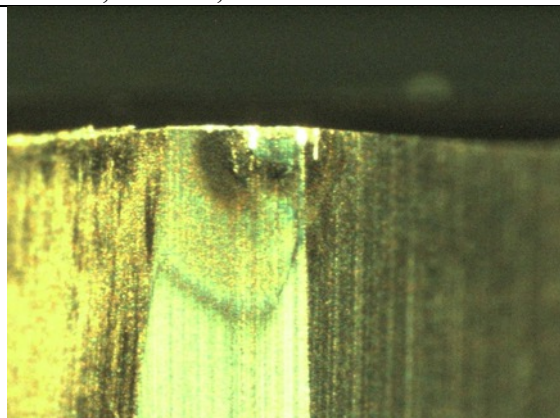
VB = 0 mm; T = 0 min



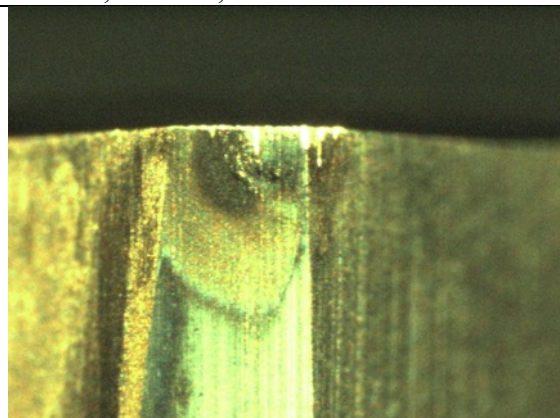
VB = 0,030 mm; T = 20 min



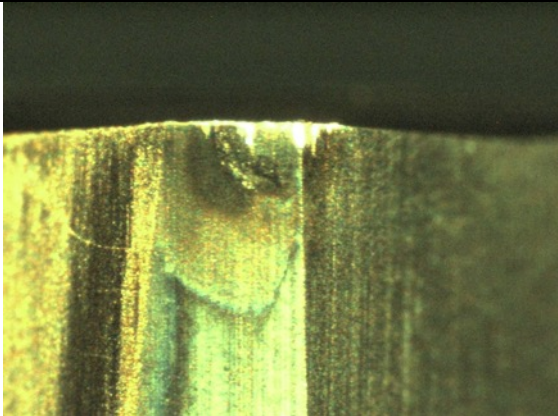
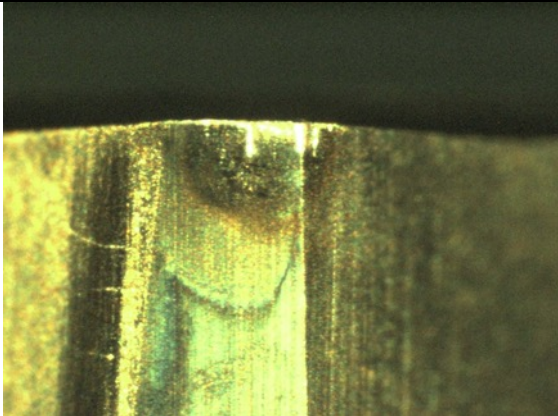
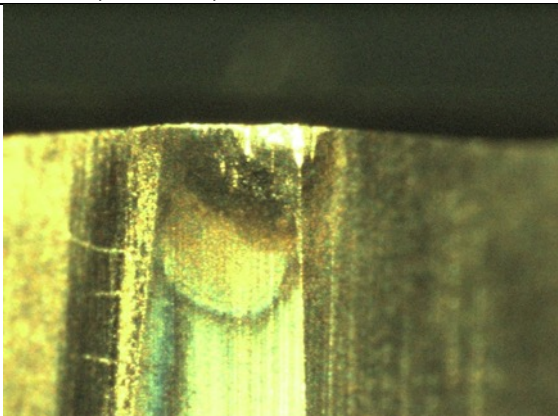
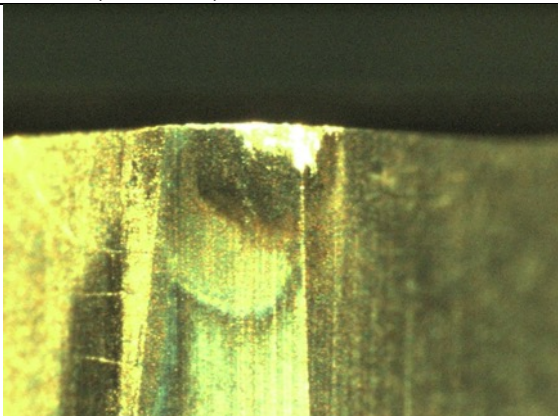
VB = 0,056 mm; T = 40 min



VB = 0,068 mm; T = 59 min



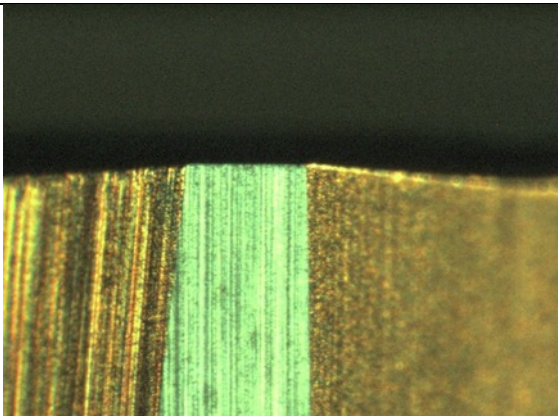
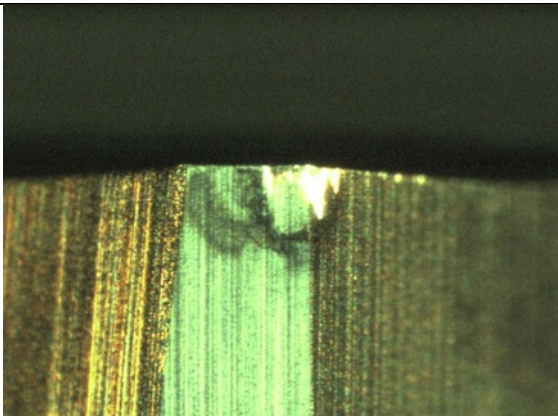


VB = 0,085 mm; T = 78 min	VB = 0,104 mm; T = 105 min
	
VB = 0,120 mm; T = 131 min	VB = 0,156 mm; T = 166 min
	

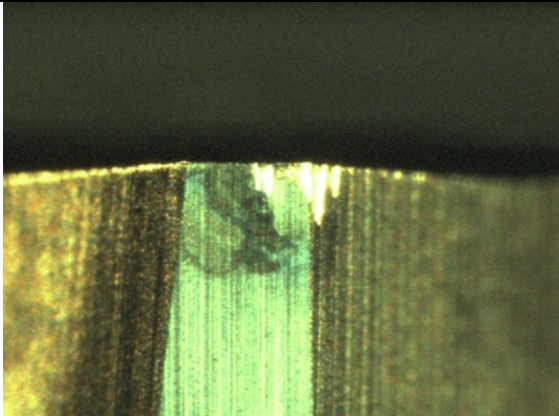
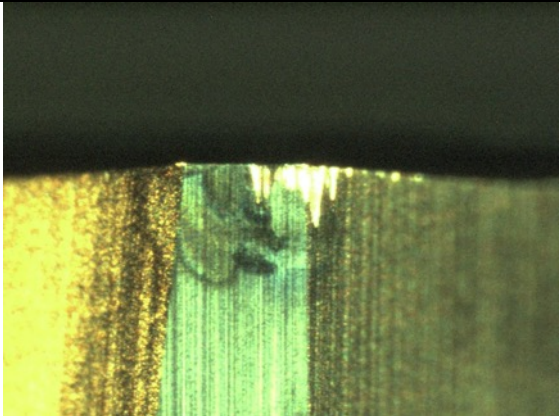
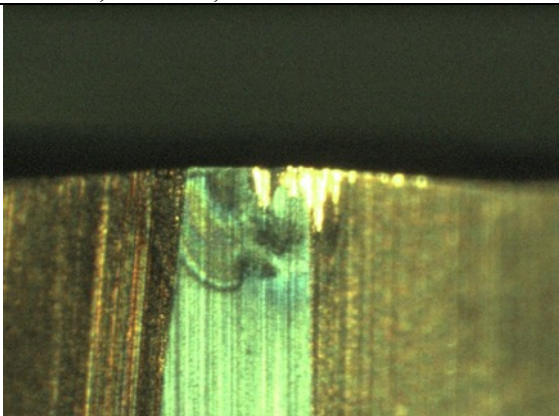
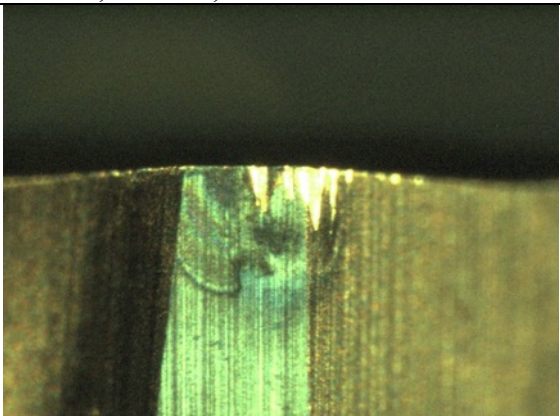
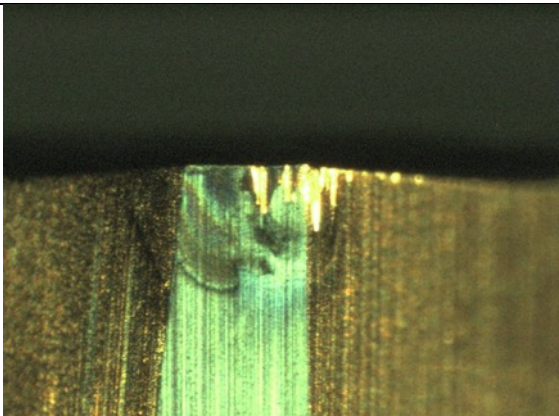
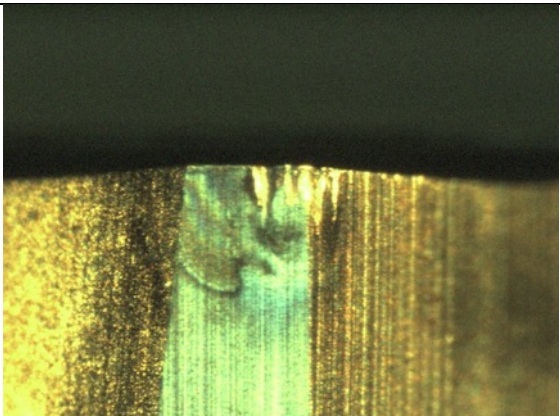
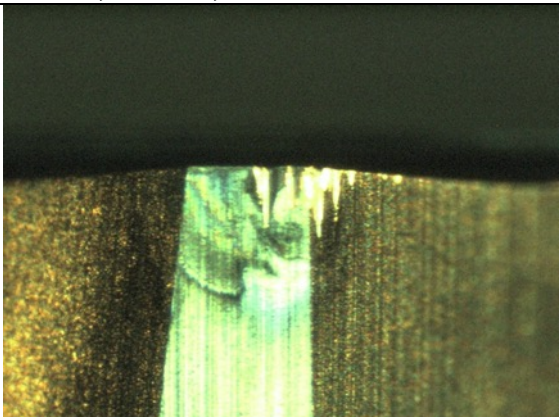
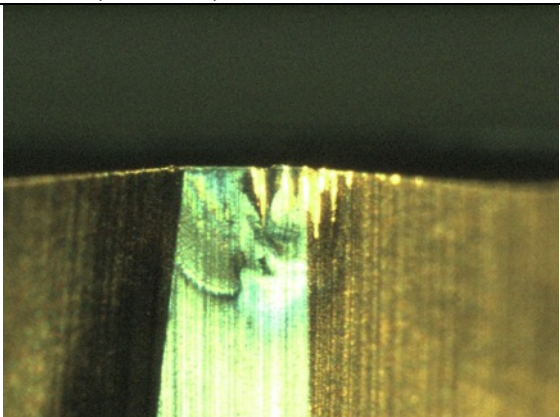
### Cermet SC3

Řezná rychlost  $v_{cs} = 80 \text{ m} \cdot \text{min}^{-1}$

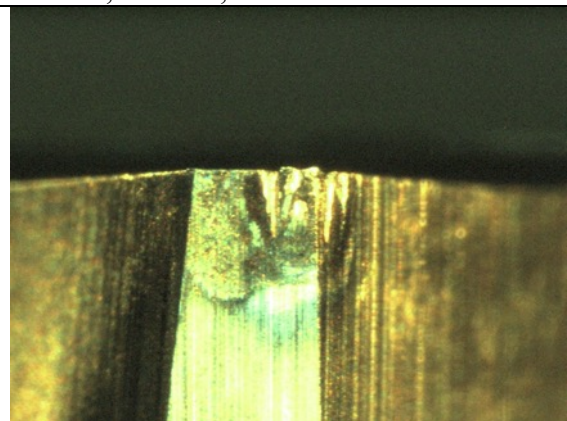
Zvětšení: 180x

VB = 0 mm; T = 0 min	VB = 0,089 mm; T = 12 min
	



VB = 0,095 mm; T = 24 min	VB = 0,133 mm; T = 36 min
	
VB = 0,137 mm; T = 49 min	VB = 0,149 mm; T = 61 min
	
VB = 0,160 mm; T = 73 min	VB = 0,178 mm; T = 85 min
	
VB = 0,189 mm; T = 97 min	VB = 0,200 mm; T = 109 min
	

VB = 0,224 mm; T = 121 min

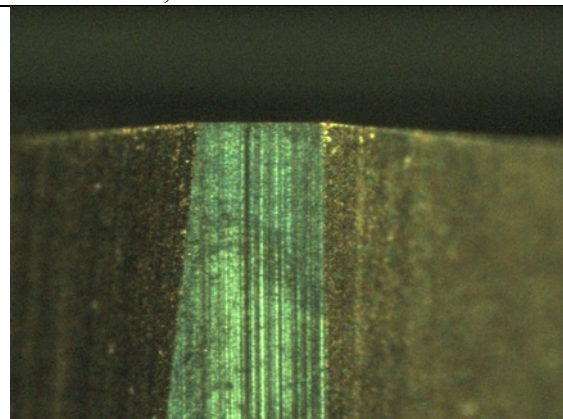


**Cermet SC8**

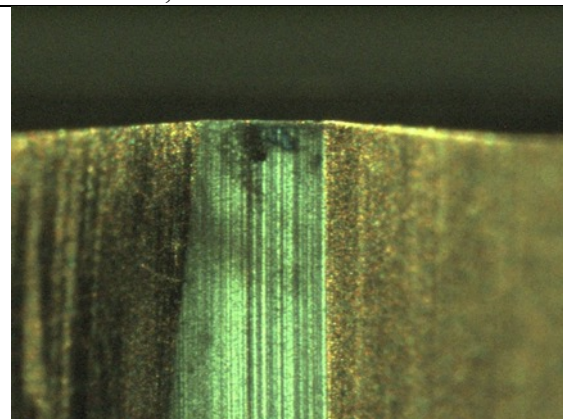
**Řezná rychlost  $v_{cl} = 350 \text{ m} \cdot \text{min}^{-1}$**

Zvětšení: 180x

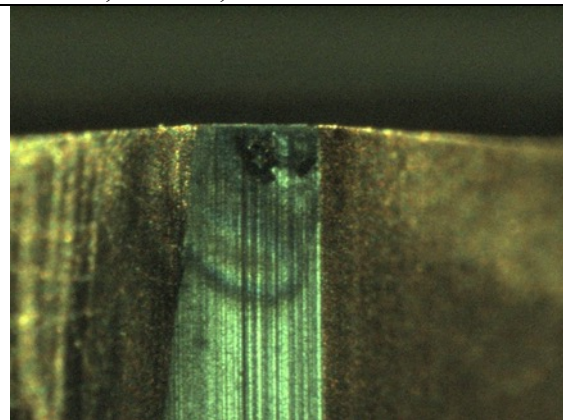
VB = 0 mm; T = 0 min



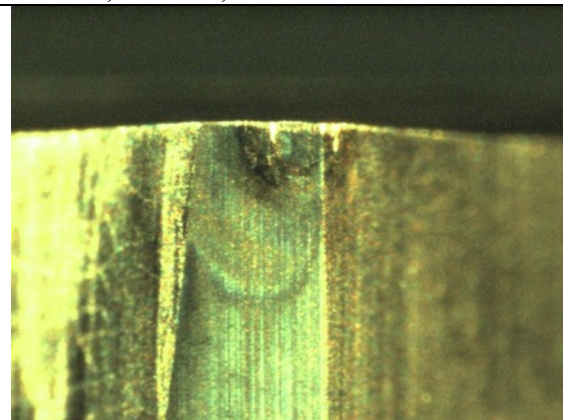
VB = 0 mm; T = 5 min



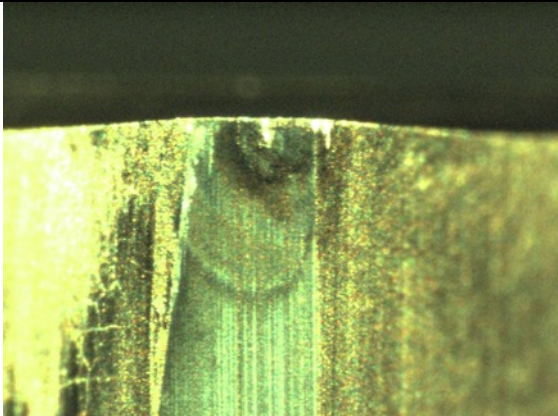
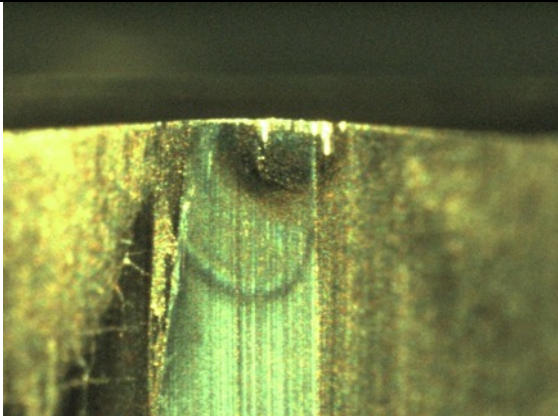
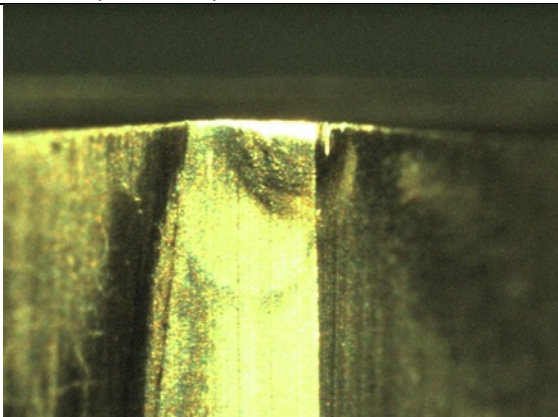
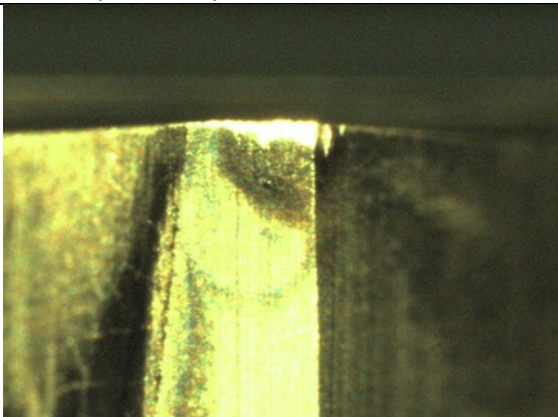
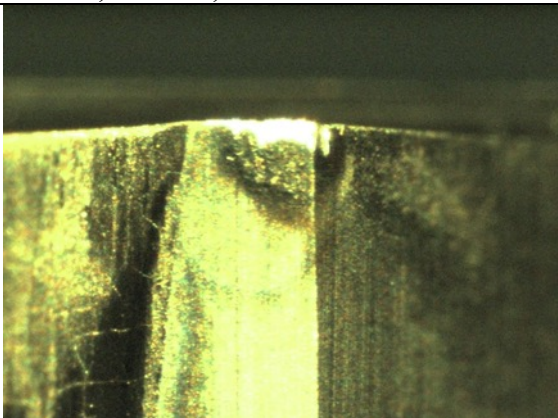
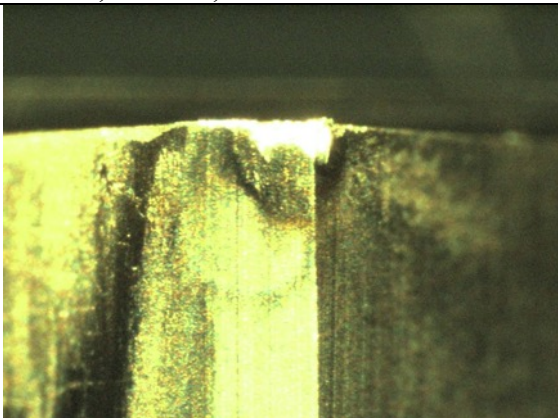
VB = 0,048 mm; T = 14 min



VB = 0,073 mm; T = 23 min



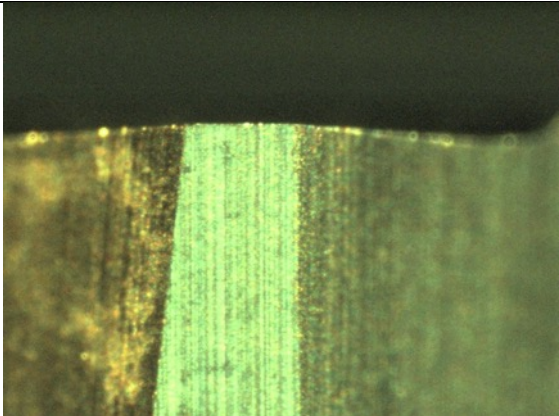
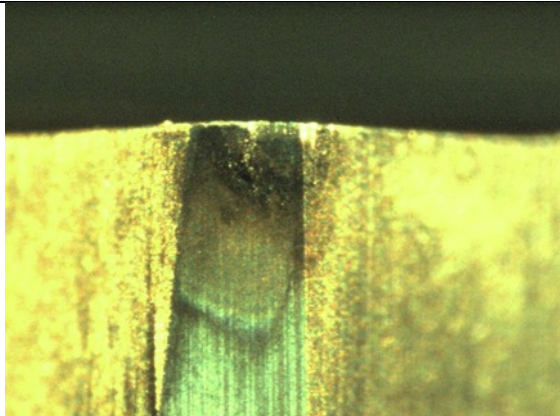
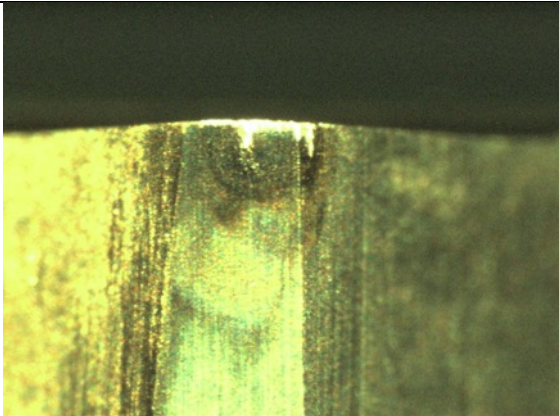
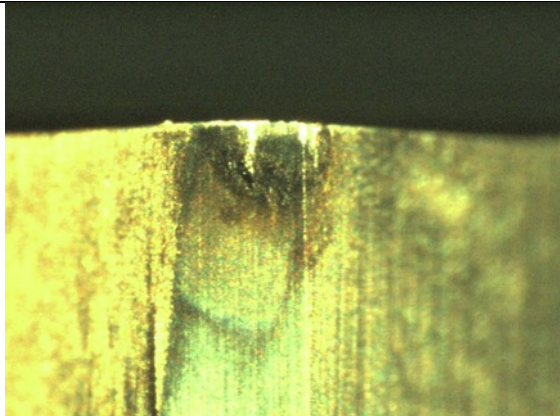
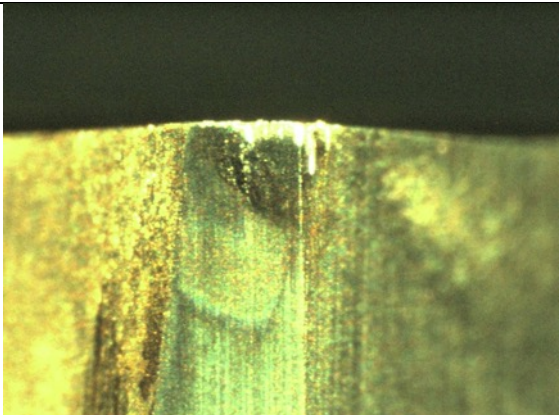
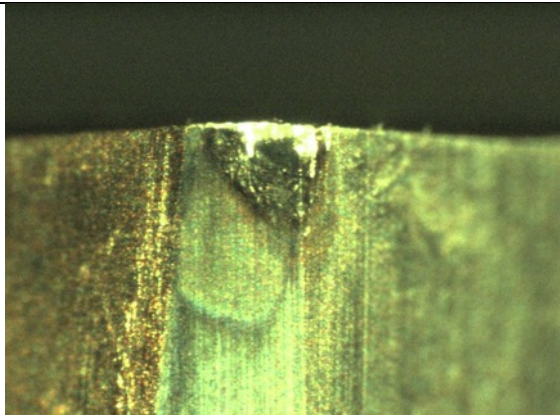


VB = 0,098 mm; T = 32 min	VB = 0,097 mm; T = 45 min
	
VB = 0,097 mm; T = 58 min	VB = 0,108 mm; T = 83 min
	
VB = 0,122 mm; T = 107 min	VB = 0,156 mm; T = 140 min
	

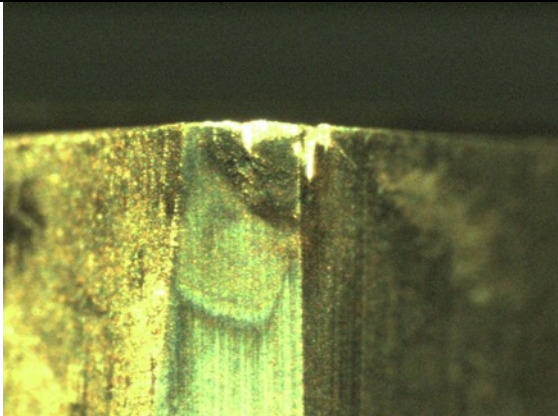
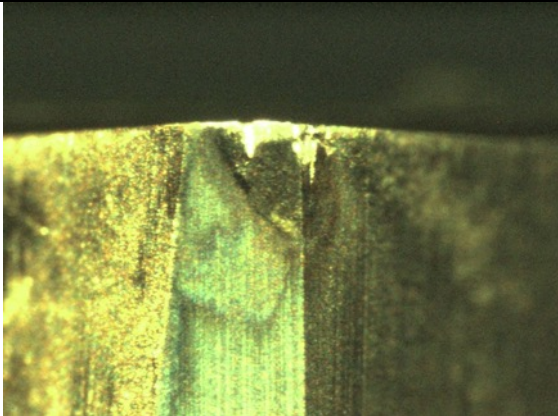
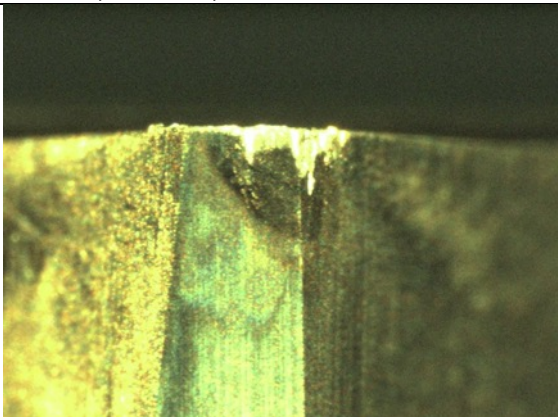
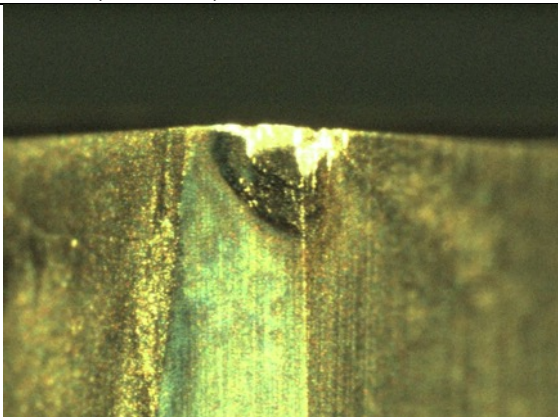
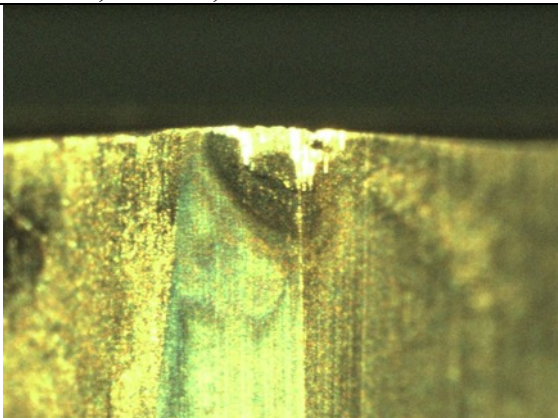
**Cermet SC8**

**Řezná rychlost  $v_{c2} = 300 \text{ m} \cdot \text{min}^{-1}$**

Zvětšení: 180x

VB = 0 mm; T = 0 min	VB = 0,027 mm; T = 20 min
	
VB = 0,044 mm; T = 45 min	VB = 0,058 mm; T = 85 min
	
VB = 0,083 mm; T = 117 min	VB = 0,091 mm; T = 147 min
	



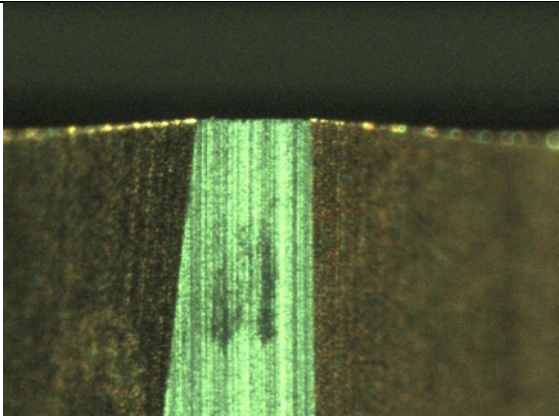
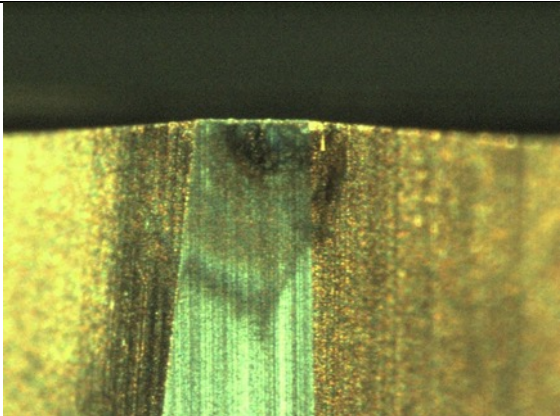
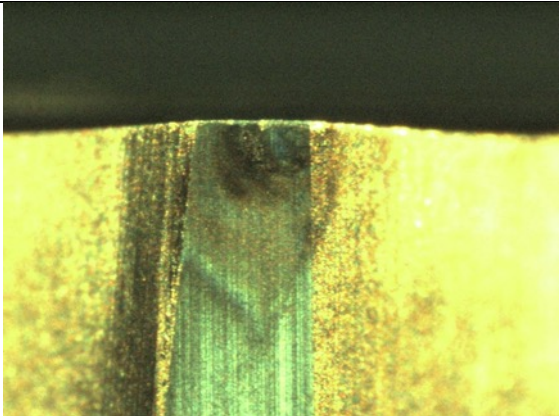
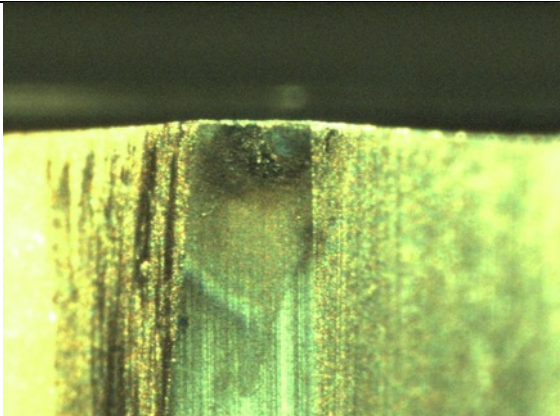
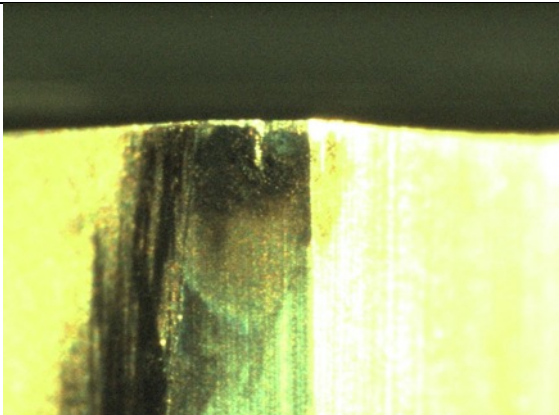
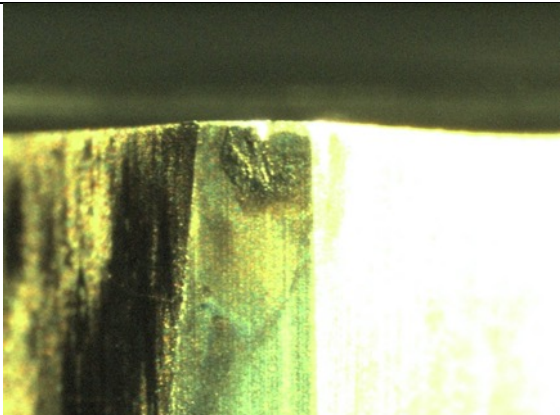
VB = 0,095 mm; T = 177 min	VB = 0,110 mm; T = 207 min
	
VB = 0,125 mm; T = 241 min	VB = 0,128 mm; T = 274 min
	
VB = 0,135 mm; T = 306 min	
	

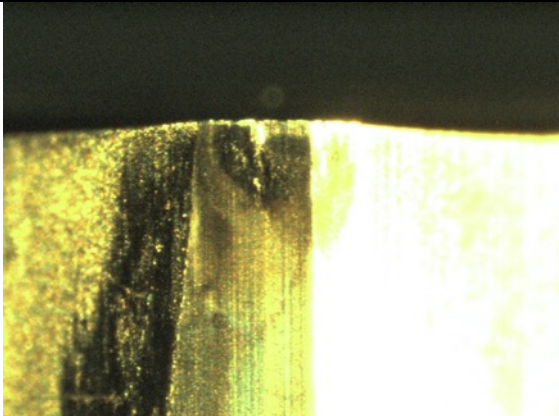
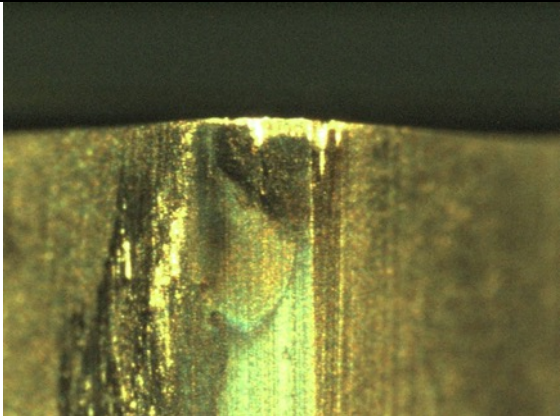
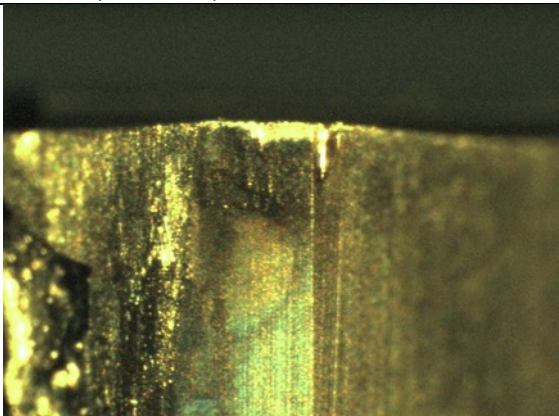


# Cermet SC8

Řezná rychlost  $v_{c3} = 240 \text{ m} \cdot \text{min}^{-1}$

Zvětšení: 180x

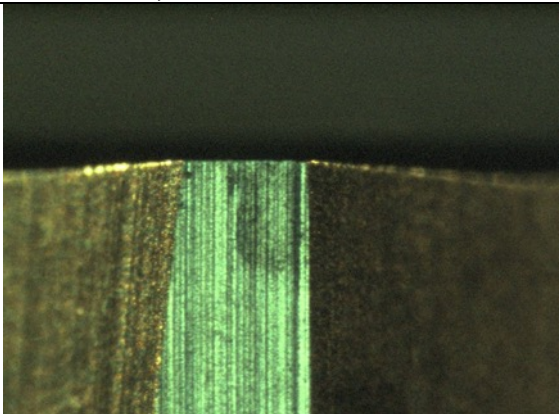
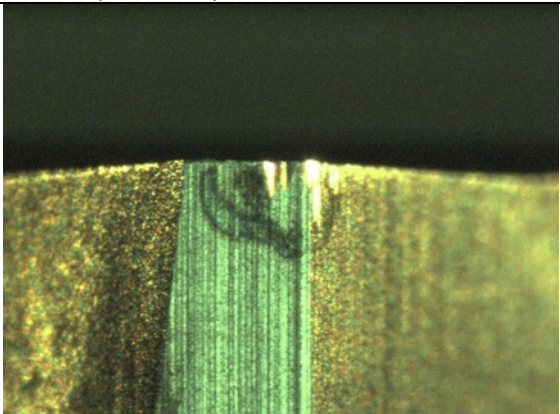
VB = 0 mm; T = 0 min	VB = 0,019 mm; T = 18 min
	
VB = 0,035 mm; T = 27 min	VB = 0,037 mm; T = 44 min
	
VB = 0,046 mm; T = 78 min	VB = 0,073 mm; T = 111 min
	

VB = 0,075 mm; T = 143 min	VB = 0,081 mm; T = 182 min
	
VB = 0,085 mm; T = 220 min	
	

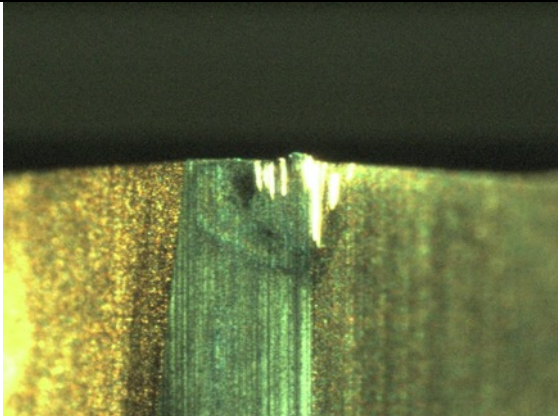
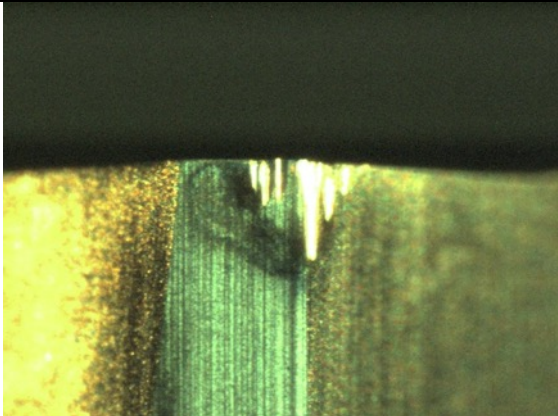
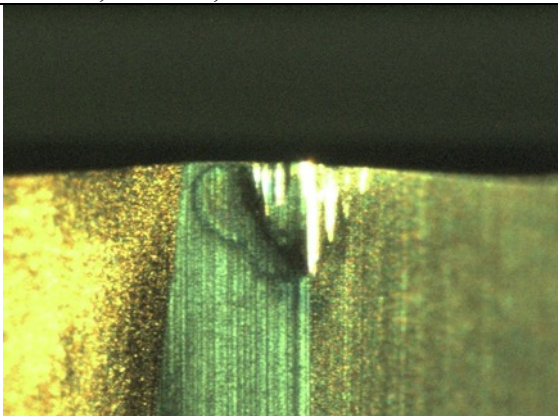
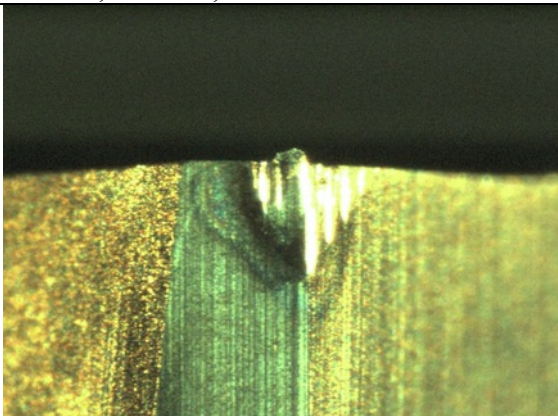
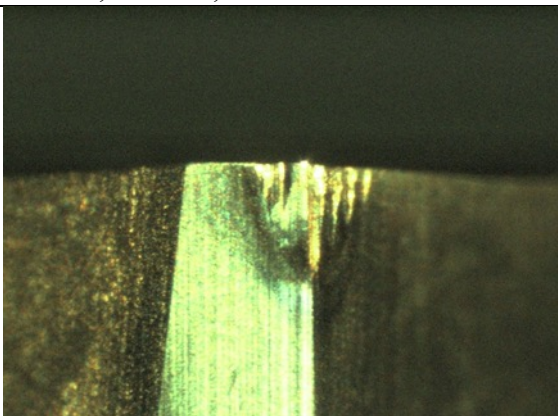
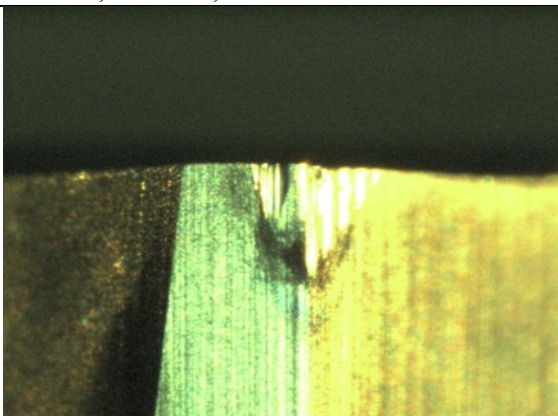
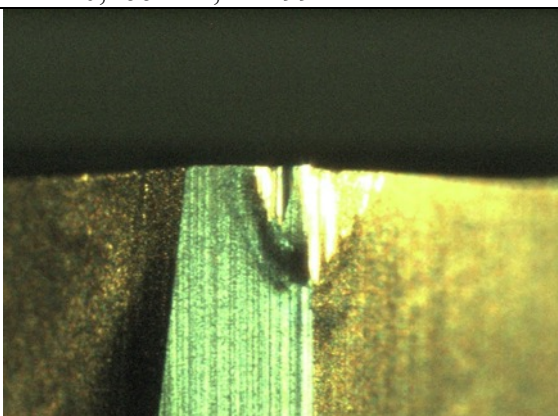
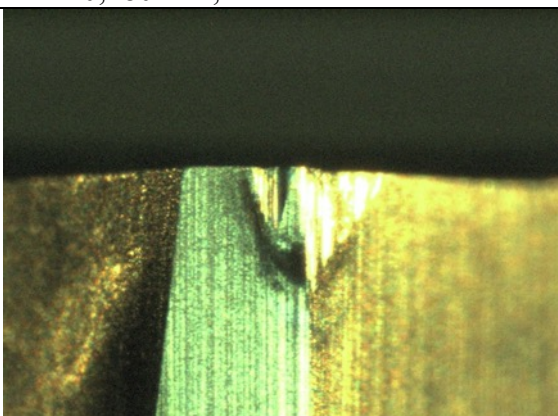
### Cermet SC8

Řezná rychlost  $v_{cs} = 80 \text{ m} \cdot \text{min}^{-1}$

Zvětšení: 180x

VB = 0 mm; T = 0 min	VB = 0,098 mm; T = 13 min
	



VB = 0,149 mm; T = 26 min	VB = 0,185 mm; T = 38 min
	
VB = 0,191 mm; T = 50 min	VB = 0,218 mm; T = 62 min
	
VB = 0,220 mm; T = 75 min	VB = 0,245 mm; T = 87 min
	
VB = 0,266 mm; T = 99 min	VB = 0,280 mm; T = 112 min
	

VB = 0,326 mm; T = 124 min

