

14792—80

Parts and workpieces made by oxygen and plasma
arc cutting. Cut face accuracy and quality

14792—69

1980 . 1390

27

01.07.81

1986 .

21.02.86

01.07.91

1.

,

5—100

(

)

5—60

2.

3.

4.

, 1.

. 1.

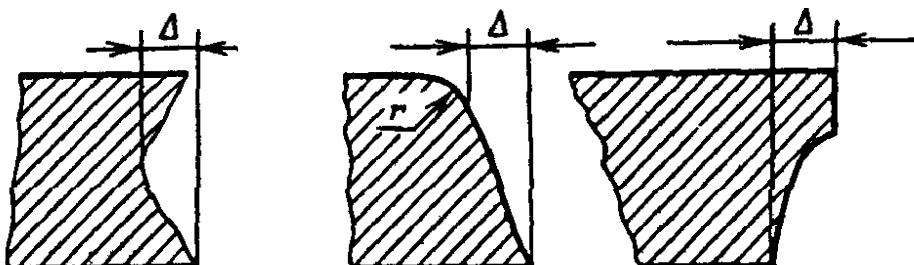
| | | | 500 | 500 1500 | 15 00 2500 | .2500 5000 |
|---|--|--------|-----------|-------------|---------------|---------------|
| 1 | | 5-30 | $\pm 1,0$ | $\pm 1,5$ | $\pm 2,0$ | $\pm 2,5$ |
| | | 31-60 | $\pm 1,0$ | $\pm 1,5$ | $\pm 2,0$ | $\pm 2,5$ |
| | | 61-100 | $\pm 1,5$ | $\pm 2,0$ | $\pm 2,5$ | $\pm 3,0$ |
| 2 | | 5-30 | $\pm 2,0$ | $\pm 2,5$ | $\pm 3,0$ | $\pm 3,5$ |
| | | 31-60 | $\pm 2,5$ | $\pm 3,0$ | $\pm 3,5$ | $\pm 4,0$ |
| | | 61-100 | $\pm 3,0$ | $\pm 3,5$ | $\pm 4,0$ | $\pm 4,5$ |
| 3 | | 5-30 | $\pm 3,5$ | $\pm 3,5$ | $\pm 4,0$ | $\pm 4,5$ |
| | | 31-60 | $\pm 4,0$ | $\pm 4,0$ | $\pm 4,5$ | $\pm 5,0$ |
| | | 61-100 | $\pm 4,5$ | $\pm 4,5$ | $\pm 5,0$ | $\pm 5,5$ |

0,5

5.

6.

(1)

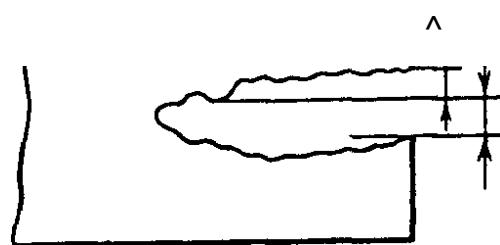


. 2.

2

| | | 5 — 12 | 13-30 | 31-60 | 61-100 |
|---|---|--------|-------|-------|--------|
| 1 | | 0,2 | 0,3 | 0,4 | 0,5 |
| | - | 0,4 | 0,5 | 0,7 | - |
| 2 | | 0,5 | 0,7 | 1,0 | 1,5 |
| | - | 1,0 | 1,2 | 1,6 | - |
| 3 | | 1,0 | 1,5 | 2,0 | 2,5 |
| | - | 2,3 | 3,0 | 4,0 | - |

2



. 2

7.

{ . 2) R_z

10

8

60 —
10 .

60

 R_z

. 3.

| | | 5-12 | 13-30 | 31-60 | 61-100 |
|---|---|----------------|----------------|----------------|--------|
| 1 | - | 0,050 0,050 | 0,060 0,060 | 0,070 0,070 | 0,085 |
| 2 | - | 0,080 0,100 | 0,160 0,200 | 0,250 0,320 | 0,500 |
| 3 | - | 0,160 0,200 | 0,250 0,320 | 0,500 0,630 | 1,000 |

8.

4.

4

| | | (|) | |
|---|-----|---|-------|-------|
| | -12 | i | 13-30 | 31-60 |
| 1 | | | 0,2 | 0,4 |
| 2 | 0,4 | f | 0,8 | 1,6 |
| 3 | 0,8 | i | i,6 | 3,2 |
| | | 1 | | |

1.

2.

3.

9.

(. . 1)

(. . 2),

(. . 3)

(. . 4).

0.

1-

, 2-

, 2-

1202

14792—80