

## МЕЖГОСУДАРСТВЕННЫЙ СТАНДАРТ

ПЛАСТИНЫ СМЕННЫЕ РЕЖУЩИЕ ИЗ БЫСТРОРЕЖУЩЕЙ  
СТАЛИ ДЛЯ СБОРНЫХ ПЕРОВЫХ СВЕРЛ

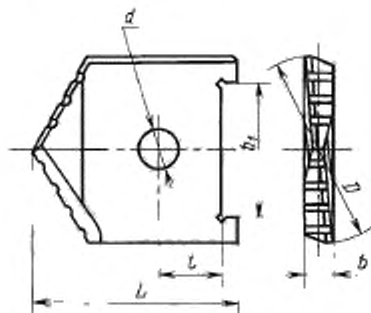
## Конструкция и основные размеры

ГОСТ  
25526—82HSS throw-away cutting inserts for spade drills,  
Design and basic dimensions,МКС 25.100.30  
ОКП 39 1696

Постановлением Государственного комитета СССР по стандартам от 26 ноября 1982 г. № 4469 дата введения установлена

01.01.84

1. Конструкция и основные размеры пластин должны соответствовать указанным на чертеже и в таблице.



мм

| Обозначение<br>пластины | Приме-<br>няемость | $D$<br>h8 | $\delta$<br>h7 | $\delta_1$<br>H7 | $L$ | $l$ | $d$ |
|-------------------------|--------------------|-----------|----------------|------------------|-----|-----|-----|
| 2000-1201               |                    | 25,0      | 6              | 20               | 35  | 10  | 7   |
| 2000-1202               |                    | 25,5      |                |                  |     |     |     |
| 2000-1203               |                    | 26,0      |                |                  |     |     |     |
| 2000-1204               |                    | 26,5      |                |                  |     |     |     |
| 2000-1205               |                    | 27,0      |                |                  |     |     |     |
| 2000-1206               |                    | 27,5      |                |                  |     |     |     |
| 2000-1207               |                    | 28,0      |                |                  |     |     |     |
| 2000-1208               |                    | 28,5      |                |                  |     |     |     |
| 2000-1209               |                    | 29,0      |                |                  |     |     |     |
| 2000-1211               |                    | 29,5      |                |                  |     |     |     |
| 2000-1212               |                    | 30,0      |                |                  |     |     |     |
| 2000-1213               |                    | 31,0      |                |                  |     |     |     |

Издание официальное



Перепечатка воспрещена

Переиздание.

мм

| Обозначение<br>пластины | Приме-<br>няемость | $D$<br>h8 | $\delta$<br>h7 | $\delta_t$<br>H7 | $L$  | $l$ | $d$ |
|-------------------------|--------------------|-----------|----------------|------------------|------|-----|-----|
| 2000-1214               |                    | 32,0      | 7              | 27               | 40,5 | 12  | 8   |
| 2000-1215               |                    | 33,0      |                |                  |      |     |     |
| 2000-1216               |                    | 34,0      |                |                  |      |     |     |
| 2000-1217               |                    | 35,0      |                |                  |      |     |     |
| 2000-1218               |                    | 36,0      |                |                  |      |     |     |
| 2000-1219               |                    | 37,0      |                |                  |      |     |     |
| 2000-1221               |                    | 38,0      |                |                  |      |     |     |
| 2000-1222               |                    | 39,0      |                |                  |      |     |     |
| 2000-1223               |                    | 40,0      | 8              | 32               | 50,0 | 17  | 10  |
| 2000-1224               |                    | 41,0      |                |                  |      |     |     |
| 2000-1225               |                    | 42,0      |                |                  |      |     |     |
| 2000-1226               |                    | 43,0      |                |                  |      |     |     |
| 2000-1227               |                    | 44,0      |                |                  |      |     |     |
| 2000-1228               |                    | 45,0      |                |                  |      |     |     |
| 2000-1229               |                    | 46,0      |                |                  |      |     |     |
| 2000-1231               |                    | 47,0      |                |                  |      |     |     |
| 2000-1232               |                    | 48,0      |                |                  |      |     |     |
| 2000-1233               |                    | 49,0      |                |                  |      |     |     |
| 2000-1234               |                    | 50,0      |                |                  |      |     |     |
| 2000-1235               |                    | 51,0      | 10             | 44               | 58,5 | 21  | 12  |
| 2000-1236               |                    | 52,0      |                |                  |      |     |     |
| 2000-1237               |                    | 53,0      |                |                  |      |     |     |
| 2000-1238               |                    | 54,0      |                |                  |      |     |     |
| 2000-1239               |                    | 55,0      |                |                  |      |     |     |
| 2000-1241               |                    | 56,0      |                |                  |      |     |     |
| 2000-1242               |                    | 57,0      |                |                  |      |     |     |
| 2000-1243               |                    | 58,0      |                |                  |      |     |     |
| 2000-1244               |                    | 59,0      |                |                  |      |     |     |
| 2000-1245               |                    | 60,0      |                |                  |      |     |     |
| 2000-1246               |                    | 61,0      |                |                  |      |     |     |
| 2000-1247               |                    | 62,0      |                |                  |      |     |     |
| 2000-1248               |                    | 63,0      |                |                  |      |     |     |
| 2000-1249               |                    | 65,0      | 11             | 52               | 68,5 | 22  | 14  |
| 2000-1251               |                    | 68,0      |                |                  |      |     |     |
| 2000-1252               |                    | 70,0      |                |                  |      |     |     |
| 2000-1253               |                    | 72,0      |                |                  |      |     |     |
| 2000-1254               |                    | 75,0      |                |                  |      |     |     |
| 2000-1255               |                    | 78,0      |                |                  |      |     |     |
| 2000-1256               |                    | 80,0      |                |                  |      |     |     |
| 2000-1257               |                    | 82,0      | 14             | 70               | 83,5 | 29  | 18  |
| 2000-1258               |                    | 85,0      |                |                  |      |     |     |
| 2000-1259               |                    | 88,0      |                |                  |      |     |     |
| 2000-1261               |                    | 90,0      |                |                  |      |     |     |
| 2000-1262               |                    | 92,0      |                |                  |      |     |     |
| 2000-1263               |                    | 95,0      |                |                  |      |     |     |
| 2000-1264               |                    | 98,0      |                |                  |      |     |     |

мм

| Обозначение<br>пластины | Приме-<br>няемость | $D$<br>h8 | $\delta$<br>h7 | $\delta$<br>H7 | $L$  | $l$ | $d$ |
|-------------------------|--------------------|-----------|----------------|----------------|------|-----|-----|
| 2000-1265               |                    | 100,0     | 14             | 70             | 83,5 | 29  | 18  |
| 2000-1266               |                    | 102,0     |                |                |      |     |     |
| 2000-1267               |                    | 105,0     | 18             | 90             | 99,0 | 32  | 22  |
| 2000-1268               |                    | 108,0     |                |                |      |     |     |
| 2000-1269               |                    | 110,0     |                |                |      |     |     |
| 2000-1271               |                    | 112,0     |                |                |      |     |     |
| 2000-1272               |                    | 115,0     |                |                |      |     |     |
| 2000-1273               |                    | 118,0     |                |                |      |     |     |
| 2000-1274               |                    | 120,0     |                |                |      |     |     |
| 2000-1275               |                    | 122,0     |                |                |      |     |     |
| 2000-1276               |                    | 125,0     |                |                |      |     |     |
| 2000-1277               |                    | 128,0     |                |                |      |     |     |
| 2000-1278               |                    | 130,0     |                |                |      |     |     |

Пример условного обозначения пластины диаметром  $D = 60$  мм:

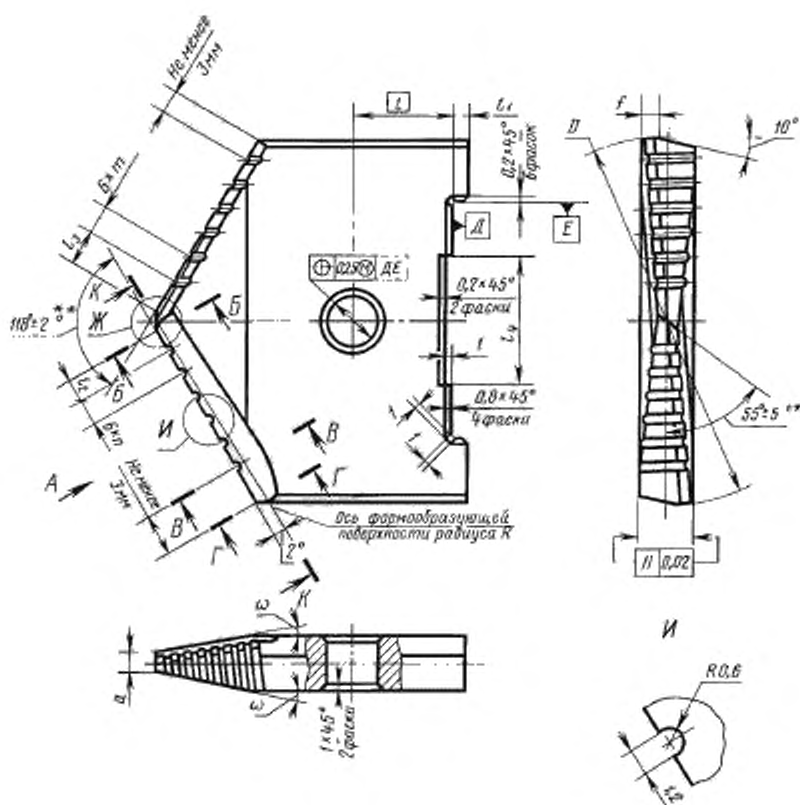
*Пластина 2000-1245 ГОСТ 25526—82*

2. Технические требования — по НТД.

3. Конструктивные элементы пластин указаны в приложении.

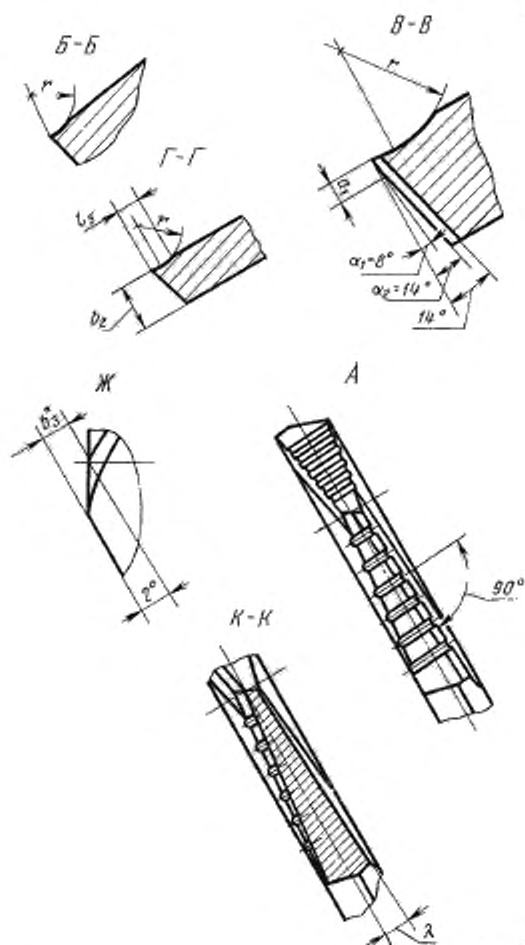
## КОНСТРУКТИВНЫЕ ЭЛЕМЕНТЫ И ГЕОМЕТРИЧЕСКИЕ ПАРАМЕТРЫ ПЛАСТИН

Конструктивные элементы и геометрические параметры пластин приведены на чертеже и в таблице



\* Размеры для справок.

\*\* Допускается изготавливать пластины с углами в плане  $90^\circ$ ,  $132^\circ$  и  $180^\circ$ .



\*Размеры для справок

Размеры, мм

| D    | l <sub>1</sub> | l <sub>2</sub> | l <sub>3</sub> | l <sub>4</sub> | l <sub>5</sub> | a   | a <sub>1</sub> | b <sub>2</sub> | b <sub>3</sub> | r | n | m | f      |                | α     | λ     |       |
|------|----------------|----------------|----------------|----------------|----------------|-----|----------------|----------------|----------------|---|---|---|--------|----------------|-------|-------|-------|
|      |                |                |                |                |                |     |                |                |                |   |   |   | Номин. | Пред. откл.    |       |       |       |
| 25,0 | 2,0            | 3              | 6              | 12             | 1,5            | 1,6 | 0,7            | 5,94           | 0,25           | 6 | 1 | 0 | 2,1    | +0,55<br>—0,25 | 20°   | 8°56′ |       |
| 25,5 |                |                |                |                | 8°45′          |     |                |                |                |   |   |   |        |                |       |       |       |
| 26,0 |                |                |                |                | 8°33′          |     |                |                |                |   |   |   |        |                |       |       |       |
| 26,5 |                |                |                |                | 8°23′          |     |                |                |                |   |   |   |        |                |       |       |       |
| 27,0 |                |                |                |                | 1,6            |     |                |                |                |   |   |   | 2,20   |                | 18°   | 8°13′ |       |
| 27,5 |                |                |                |                |                |     |                |                |                |   |   |   | 8°03′  |                |       |       |       |
| 28,0 |                |                |                |                |                |     |                |                |                |   |   |   | 7°54′  |                |       |       |       |
| 28,5 |                |                |                |                |                |     |                |                |                |   |   |   | 7°45′  |                |       |       |       |
| 29,0 |                |                |                |                |                |     |                |                |                |   |   |   | 1,7    |                | 2,30  | 16°   | 7°37′ |
| 29,5 |                |                |                |                |                |     |                |                |                |   |   |   |        |                | 7°27′ |       |       |
| 30,0 |                |                |                |                |                |     |                |                |                |   |   |   |        |                | 7°19′ |       |       |
| 31,0 |                |                |                |                |                |     |                |                |                |   |   |   |        |                | 7°04′ |       |       |

| D    | l <sub>1</sub> | l <sub>2</sub> | l <sub>3</sub> | l <sub>4</sub> | l <sub>5</sub> | a     | a <sub>1</sub> | b <sub>2</sub> | b <sub>1</sub> | r | n    | m              | f      |                | α     | λ      |       |
|------|----------------|----------------|----------------|----------------|----------------|-------|----------------|----------------|----------------|---|------|----------------|--------|----------------|-------|--------|-------|
|      |                |                |                |                |                |       |                |                |                |   |      |                | Номин. | Пред. откл.    |       |        |       |
| 32,0 | 2,5            | 5              | 8              | 14             | 2,0            | 1,6   | 0,7            | 6,92           | 0,27           | 8 | 1    | 1              | 2,45   | +0,55<br>-0,25 | 21°   | 10°10' |       |
| 33,0 |                |                |                |                |                |       |                |                |                |   |      |                | 2,50   |                |       | 9°53'  |       |
| 34,0 |                |                |                |                |                |       |                |                |                |   |      |                | 2,60   |                |       | 20°    | 9°37' |
| 35,0 |                |                |                |                |                |       |                |                |                |   |      |                |        |                |       |        | 9°20' |
| 36,0 |                |                |                |                | 2,65           |       |                |                |                |   |      |                | 19°    |                | 9°04' |        |       |
| 37,0 |                |                |                |                |                |       |                |                |                |   |      |                |        |                | 2,70  | 8°47'  |       |
| 38,0 |                |                |                |                |                |       |                |                |                |   |      |                |        |                |       | 2,75   | 8°30' |
| 39,0 |                |                |                |                |                |       |                |                |                |   |      |                |        |                | 8°14' |        |       |
| 40,0 | 3,0            |                |                |                | 3,0            | 2,0   | 0,9            | 7,90           | 0,33           |   | 2,85 | +0,65<br>-0,35 | 18°    | 7°31'          |       |        |       |
| 41,0 |                |                |                |                |                |       |                |                |                |   |      |                |        | 7°21'          |       |        |       |
| 42,0 |                |                |                |                |                |       |                |                |                |   |      |                |        | 7°11'          |       |        |       |
| 43,0 |                |                |                |                |                |       |                |                |                |   |      |                |        | 7°01'          |       |        |       |
| 44,0 |                |                |                |                | 3,3            |       |                |                |                |   | 16°  |                | 6°51'  |                |       |        |       |
| 45,0 |                |                |                |                |                |       |                |                |                |   |      |                | 6°41'  |                |       |        |       |
| 46,0 |                |                |                |                |                |       |                |                |                |   |      |                | 6°31'  |                |       |        |       |
| 47,0 |                |                |                |                |                |       |                |                |                |   |      |                | 14°    | 6°20'          |       |        |       |
| 48,0 |                |                |                |                | 6°10'          |       |                |                |                |   |      |                |        |                |       |        |       |
| 49,0 |                |                |                |                | 6°00'          |       |                |                |                |   |      |                |        |                |       |        |       |
| 50,0 |                |                |                |                | 5°50'          |       |                |                |                |   |      |                |        |                |       |        |       |
| 51,0 |                |                |                |                | 3,5            |       |                |                |                |   | 20   |                | 3,4    | 2,8            | 1,3   | 9,88   | 0,48  |
| 52,0 | 6°29'          |                |                |                |                |       |                |                |                |   |      |                |        |                |       |        |       |
| 53,0 | 3,50           |                |                | 6°22'          |                |       |                |                |                |   |      |                |        |                |       |        |       |
| 54,0 |                |                |                | 6°15'          |                |       |                |                |                |   |      |                |        |                |       |        |       |
| 55,0 | 3,6            |                |                | 15°            |                | 6°08' |                |                |                |   |      |                |        |                |       |        |       |
| 56,0 |                |                |                |                |                | 6°02' |                |                |                |   |      |                |        |                |       |        |       |
| 57,0 |                |                |                |                |                | 5°55' |                |                |                |   |      |                |        |                |       |        |       |
| 58,0 |                |                |                |                |                | 14°   | 5°49'          |                |                |   |      |                |        |                |       |        |       |
| 60,0 | 5°35'          |                |                |                |                |       |                |                |                |   |      |                |        |                |       |        |       |
| 61,0 | 3              |                |                | 5°29'          |                |       |                |                |                |   |      |                |        |                |       |        |       |
| 62,0 |                |                |                | 5°22'          |                |       |                |                |                |   |      |                |        |                |       |        |       |
| 63,0 |                |                |                | 4              |                | 5°16' |                |                |                |   |      |                |        |                |       |        |       |
| 65,0 |                |                |                |                |                | 5°08' |                |                |                |   |      |                |        |                |       |        |       |
| 68,0 | 12°            |                |                |                |                | 4°56' |                |                |                |   |      |                |        |                |       |        |       |
| 70,0 |                |                |                |                |                | 4°41' |                |                |                |   |      |                |        |                |       |        |       |
| 72,0 |                |                |                | 4              |                | 4°36' |                |                |                |   |      |                |        |                |       |        |       |
| 75,0 |                |                |                |                |                | 4°21' |                |                |                |   |      |                |        |                |       |        |       |
| 78,0 | 3,6            |                |                |                |                | 4°16' |                |                |                |   |      |                |        |                |       |        |       |
| 80,0 |                |                |                |                |                | 4°08' |                |                |                |   |      |                |        |                |       |        |       |
| 82,0 |                |                |                | 5              |                | 5°23' |                |                |                |   |      |                |        |                |       |        |       |
| 85,0 |                |                |                |                |                | 5     | 5°13'          |                |                |   |      |                |        |                |       |        |       |
| 88,0 | 5°03'          |                |                |                |                |       |                |                |                |   |      |                |        |                |       |        |       |
| 90,0 | 6              |                |                |                |                |       | 4°56'          |                |                |   |      |                |        |                |       |        |       |
| 92,0 |                |                |                | 4°49'          |                |       |                |                |                |   |      |                |        |                |       |        |       |
| 95,0 |                |                |                | 7              |                | 4°39' |                |                |                |   |      |                |        |                |       |        |       |
| 98,0 |                |                |                |                | 4°29'          |       |                |                |                |   |      |                |        |                |       |        |       |

Продолжение

Размеры, мм

| D     | l <sub>1</sub> | l <sub>2</sub> | l <sub>3</sub> | l <sub>4</sub> | l <sub>5</sub> | a   | a <sub>1</sub> | b <sub>2</sub> | b <sub>3</sub> | r  | n   | m     | f      |                | α     | λ     |
|-------|----------------|----------------|----------------|----------------|----------------|-----|----------------|----------------|----------------|----|-----|-------|--------|----------------|-------|-------|
|       |                |                |                |                |                |     |                |                |                |    |     |       | Номин. | Пред-откл.     |       |       |
| 100,0 | 3,5            | 5              | 8              | 36             | 5,4            | 4,8 | 2,2            | 13,84          | 0,66           | 10 | 7   | 7     | 3,8    | +0,85<br>-0,40 | 10°   | 4°23' |
| 102,0 |                |                |                |                |                |     |                |                |                |    |     |       |        |                |       | 4°16' |
| 105,0 | 5,0            |                |                | 45             | 7,5            | 5,5 | 2,5            | 17,80          | 0,95           | 13 | 8   | 8     | 4,0    |                | 13°   | 5°46' |
| 108,0 |                |                |                |                |                |     |                |                |                |    |     |       |        |                |       | 5°37' |
| 110,0 |                |                |                |                |                |     |                |                |                |    | 9   | 8     | 12°    |                | 5°32' |       |
| 112,0 |                |                |                |                |                |     |                |                |                |    |     |       |        |                | 5°26' |       |
| 115,0 |                |                |                |                |                |     |                |                |                |    | 10  | 9     | 11°    |                | 5°17' |       |
| 118,0 |                |                |                |                |                |     |                |                |                |    |     |       |        |                | 5°09' |       |
| 120,0 |                |                |                |                |                |     |                |                |                |    |     |       |        |                | 5°03' |       |
| 122,0 |                |                |                |                |                |     |                |                |                |    |     |       |        |                | 4°57' |       |
| 125,0 |                |                |                |                |                |     |                |                |                |    |     |       |        |                | 4°49' |       |
| 128,0 |                |                |                |                |                |     |                |                |                |    | 11° | 4°40' |        |                |       |       |
| 130,0 |                |                |                |                |                |     |                |                |                |    |     | 4°35' |        |                |       |       |