

**ПЛАСТИНЫ СМЕННЫЕ РЕЖУЩИЕ ИЗ
БЫСТРОРЕЖУЩЕЙ СТАЛИ ДЛЯ СБОРНЫХ
ПЕРОВЫХ СВЕРЛ.**

Конструкция и основные размеры

HSS throw-away cutting inserts for spade
drills. Design and basic dimensions.

**ГОСТ
25526-82**

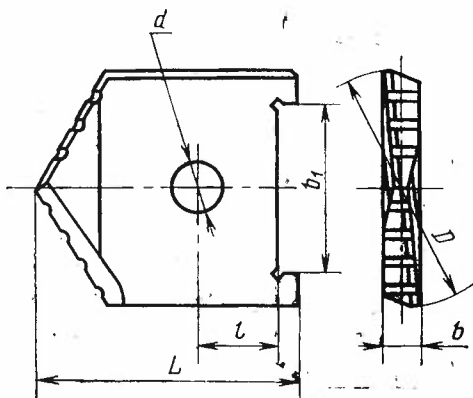
ОКП 39 1696

Постановлением Государственного комитета СССР по стандартам от 26 ноября
1982 г. № 4469 срок введения установлен

с 01.01.84

Несоблюдение стандарта преследуется по закону

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



мм

| Обозначение пластины | Приме- няемость | D (поле допуска h8) | b (поле допуска h7) | b_1 (поле допуска H7) | D | d | 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 | | | | | |
| 2000-1214 | | 32,0 | | | | | |
| 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 | | | | | |

мм

| Обозначение пластины | Приме- няемость | D (поле допуска h8) | b (поле допуска h7) | b_1 (поле допуска H7) | L | l | d |
|-------------------------|--------------------|--------------------------------|--------------------------------|----------------------------------|------|-----|-----|
| 2000-1232 | | 48,0 | 8 | 32 | 50,0 | 17 | 10 |
| 2000-1233 | | 49,0 | | | | | |
| 2000-1234 | | 50,0 | | | | | |
| 2000-1235 | | 51,0 | | | | | |
| 2000-1236 | | 52,0 | | | | | |
| 2000-1237 | | 53,0 | | | | | |
| 2000-1238 | | 54,0 | | | | | |
| 2000-1239 | | 55,0 | 10 | 44 | 58,5 | 21 | 12 |
| 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 | 11 | 52 | 68,5 | 22 | 14 |
| 2000-1248 | | 63,0 | | | | | |
| 2000-1249 | | 65,0 | | | | | |
| 2000-1251 | | 68,0 | | | | | |
| 2000-1252 | | 70,0 | | | | | |
| 2000-1253 | | 72,0 | | | | | |
| 2000-1254 | | 75,0 | | | | | |
| 2000-1255 | | 78,0 | 14 | 70 | 83,5 | 29 | 18 |
| 2000-1256 | | 80,0 | | | | | |
| 2000-1257 | | 82,0 | | | | | |
| 2000-1258 | | 85,0 | | | | | |
| 2000-1259 | | 88,0 | | | | | |
| 2000-1261 | | 90,0 | | | | | |

мм

| Обозначение пластины | Применяемость | D (поле допуска h8) | b (поле допуска h7) | δ_1 (поле допуска H7) | L | t | d |
|----------------------|---------------|--------------------------|--------------------------|---------------------------------|------|-----|-----|
| 2000-1262 | | 92,0 | 14 | 70 | 83,5 | 29 | 18 |
| 2000-1263 | | 95,0 | | | | | |
| 2000-1264 | | 98,0 | | | | | |
| 2000-1265 | | 100,0 | | | | | |
| 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:

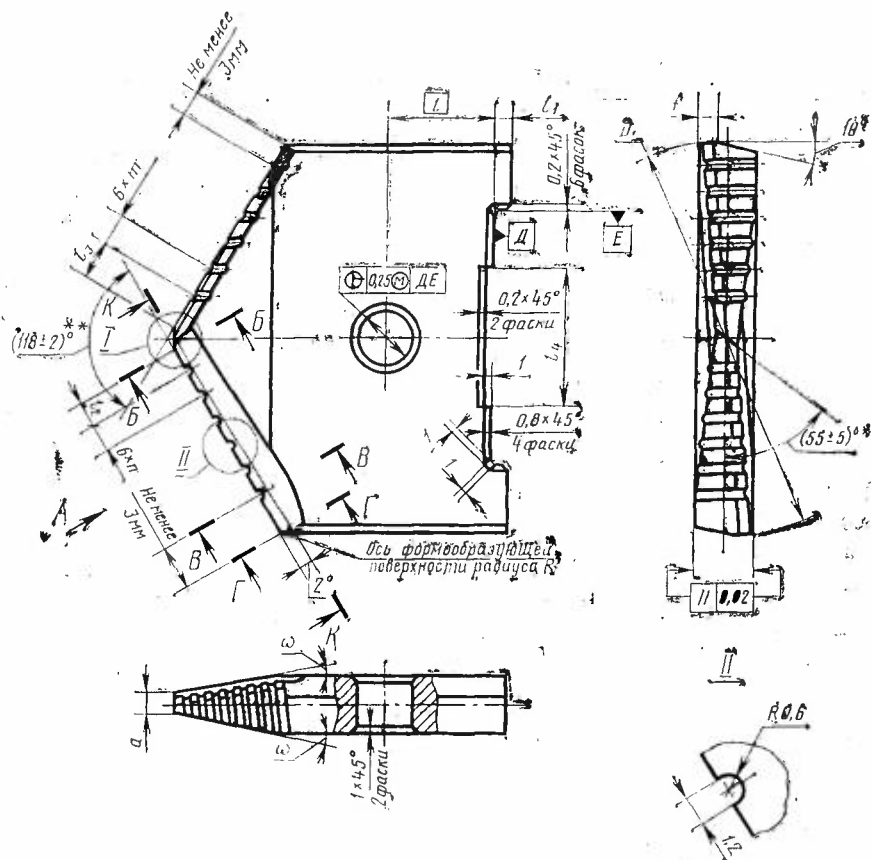
Пластина 2000-1245 ГОСТ 25526—82

2. Технические требования — по ГОСТ 25527—82.

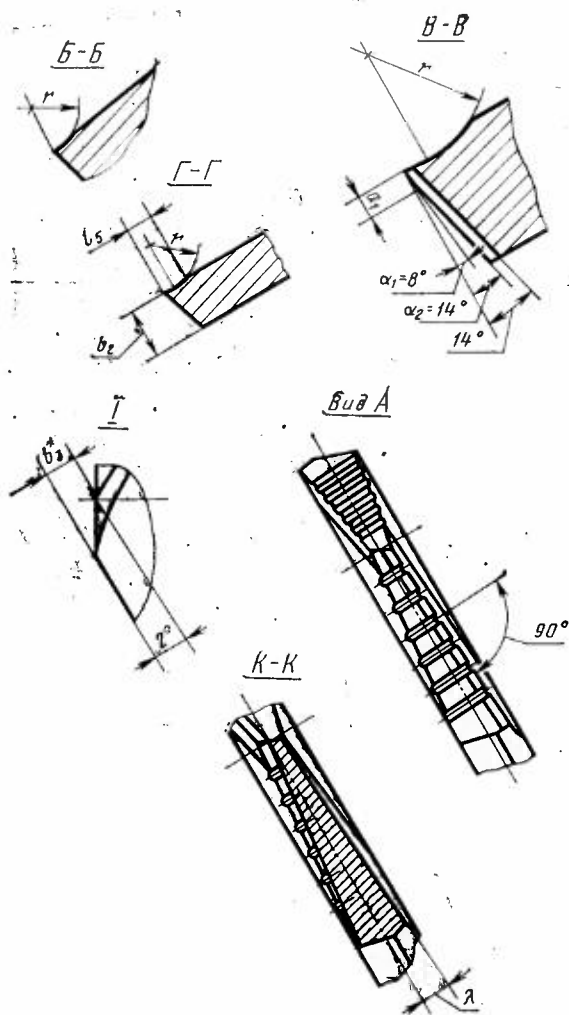
8. Конструктивные элементы пластин указаны в рекомендуемом приложении.

**КОНСТРУКТИВНЫЕ ЭЛЕМЕНТЫ
И ГЕОМЕТРИЧЕСКИЕ ПАРАМЕТРЫ ПЛАСТИН**

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



- * Размеры для справок
- ** Допускается изготавливать пластины с углами в плане 90°, 132° и 180°.



Размеры в мм

| D | l ₁ | l ₂ | l ₃ | l ₄ | l ₅ | a | a ₁ | b ₂ | b ₃ | r | n | m | f | | ω | λ | | | | | |
|------|----------------|----------------|----------------|----------------|----------------|-----|----------------|----------------|----------------|---|---|------|----------------|----------------|-------|-------|-----|--------|------|-------|-------|
| | | | | | | | | | | | | | Номинал. | 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 -0,25 | 20° | 8°56' | | | | | |
| 25,5 | | | | | | | | | | | | | | | | 8°45' | | | | | |
| 26,0 | | | | | | | | | | | | | | | | 8°33' | | | | | |
| 26,5 | | | | | | | | | | | | | | | | 8°23' | | | | | |
| 27,0 | | | | | | | | | | | | | | | | 8°13' | | | | | |
| 27,5 | | | | | 1,6 | | | | | | | | | | | 2,20 | 18° | 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 | 2,5 | 5 | 8 | 14 | 2,0 | 1,6 | 0,7 | 6,92 | 0,27 | 8 | 1 | 2,35 | +0,55 -0,25 | 21° | 7°19' | | | | | | |
| 31,0 | | | | | | | | | | | | | | | 7°04' | | | | | | |
| 32,0 | | | | | | | | | | | | | | | 2,2 | 2,45 | 21° | 10°10' | | | |
| 33,0 | | | | | | | | | | | | | | | | | | 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' | | | | | |

Размеры в мм

Продолжение

| D | l ₁ | l ₂ | l ₃ | l ₄ | l ₅ | a | a ₁ | b ₂ | b ₃ | r | n | m | f | | ω | λ |
|------|----------------|----------------|----------------|----------------|----------------|-------|----------------|----------------|----------------|----|---|---|----------|----------------|-----|-------|
| | | | | | | | | | | | | | Номинал. | Пред. откл. | | |
| 38,0 | 2,5 | | | | 2,4 | 1,6 | 0,7 | 6,92 | 0,27 | | 1 | | 2,70 | +0,55 -0,25 | 18° | 8°30' |
| 39,0 | | | | | | | | | | | | | 2,75 | | | 8°14' |
| 40,0 | 3,0 | 5 | 8 | 14 | 3,0 | | | | | 8 | 2 | | 2,85 | +0,65 -0,35 | 16° | 7°31' |
| 41,0 | | | | | | | | | | | | | 3,0 | | | 7°21' |
| 42,0 | | | | | 2,95 | 7°11' | | | | | | | | | | |
| 43,0 | | | | | 3,00 | 7°01' | | | | | | | | | | |
| 44,0 | | | | | 3,10 | 6°51' | | | | | | | | | | |
| 45,0 | | | | | 3,10 | 6°41' | | | | | | | | | | |
| 46,0 | | | | | 3,15 | 6°31' | | | | | | | | | | |
| 47,0 | | | | | 3,20 | 6°20' | | | | | | | | | | |
| 48,0 | | | | | 3,25 | 6°10' | | | | | | | | | | |
| 49,0 | | | | | 3,35 | 6°00' | | | | | | | | | | |
| 50,0 | 3,5 | | | 20 | 3,4 | 2,8 | 1,3 | 9,88 | 0,48 | 10 | 3 | | 3,40 | | 16° | 5°50' |
| 51,0 | | | | | | | | | | | | | 3,45 | | | 6°35' |
| 52,0 | | | | | | | | | | | | | 3,45 | | | 6°29' |
| 53,0 | | | | | | | | | | | | | 3,50 | | | 6°22' |
| 54,0 | | | | | | | | | | | | | 3,50 | | | 6°15' |

Размеры в мм

| D | l ₁ | l ₂ | l ₃ | l ₄ | l ₅ | a | a _г | b _а | b _б | r | n | m | f | | φ | λ | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|------|----------------|----------------|----------------|----------------|----------------|-----|----------------|----------------|----------------|----|---|---|-------|-------------|----------------|-----|-------|-----|-------|------|----|---|---|---|------|----------------|-----|-------|-----|-----|-------|------|----|---|---|---|------|----------------|-----|-------|-----|-----|-------|------|----|---|---|---|------|----------------|-----|-------|-----|-----|-------|------|----|---|---|---|------|----------------|-----|-------|-----|-----|-------|------|----|---|---|---|------|----------------|-----|-------|-----|-----|-------|------|----|---|---|---|------|----------------|-----|-------|-----|-----|-------|------|----|---|---|---|----------------|----------------|-----|-------|
| | | | | | | | | | | | | | Номи. | Пред. откл. | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 55,0 | 3,5 | 5 | 8 | 20 | 3,6 | 2,8 | 1,3 | 9,88 | 0,48 | 10 | 4 | 4 | 2 | 3,50 | +0,65 -0,35 | 15° | 6°08' | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 56,0 | | | | | | | | | | | | | 6°02' | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 57,0 | | | | | | | | | | | | | 5°55' | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 58,0 | | | | | 3,8 | | | | | | | | 28 | 4,0 | | 4,3 | 3,8 | 1,8 | 10,86 | 0,64 | 10 | 4 | 4 | 4 | 3,55 | +0,65 -0,35 | 14° | 5°49' | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 60,0 | | | | | | | | | | | | | | | | | | | | | | | | | | | | 5°35' | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 61,0 | | | | | 3 | | | | | | | | | | | | | | | | | | | | 36 | | 5,4 | 4,6 | 4,8 | 2,2 | 13,84 | 0,66 | 10 | 4 | 4 | 4 | 3,60 | +0,85 -0,40 | 13° | 5°29' | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 62,0 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 5°22' | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 63,0 | | | | | 3 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 36 | | 5,4 | 4,6 | 4,8 | 2,2 | 13,84 | 0,66 | 10 | 4 | 4 | 4 | 3,60 | +0,85 -0,40 | 12° | 5°16' | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 65,0 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 5°08' | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 68,0 | | | | | 3 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 36 | | 5,4 | 4,6 | 4,8 | 2,2 | 13,84 | 0,66 | 10 | 4 | 4 | 4 | 3,60 | +0,85 -0,40 | 11° | 4°56' | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 70,0 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 4°41' | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 72,0 | | | | | 3 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 36 | | 5,4 | 4,6 | 4,8 | 2,2 | 13,84 | 0,66 | 10 | 4 | 4 | 4 | 3,60 | +0,85 -0,40 | 11° | 4°36' | | | | | | | | | | | | | | | | | | | | | | | | |
| 75,0 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 4°21' | | | | | | | | | | | | | | | | | | | | | | | | |
| 78,0 | | | | | 3 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 36 | | 5,4 | 4,6 | 4,8 | 2,2 | 13,84 | 0,66 | 10 | 4 | 4 | 4 | 3,60 | +0,85 -0,40 | 10° | 4°16' | | | | | | | | | | | | |
| 80,0 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 4°08' | | | | | | | | | | | | |
| 82,0 | | | | | 3 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 36 | | 5,4 | 4,6 | 4,8 | 2,2 | 13,84 | 0,66 | 10 | 4 | 4 | 4 | 3,8 | +0,85 -0,40 | 13° | 5°23' |
| 85,0 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 5°13' |
| 88,0 | 6 | 36 | 5,4 | 4,6 | 4,8 | 2,2 | 13,84 | 0,66 | 10 | 4 | 4 | 4 | | | 3,8 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | +0,85 -0,40 | | 12° | 5°03' |

Размеры в мм

| D | l ₂ | l ₃ | l ₄ | l ₅ | a | a ₂ | b _a | b _b | r | n | m | f | | ω | λ | | | | | | | | | | | | | | |
|-------|----------------|----------------|----------------|----------------|-----|----------------|----------------|----------------|------|----|---|---------------------|----------------|---|-----|-------|-------|-------|-----|-------|------|----|---|---|--|----------------|-------|-------|-------|
| | | | | | | | | | | | | Номи _н . | Пред. откл. | | | | | | | | | | | | | | | | |
| 90,0 | 3,5 | | | 36 | 5,4 | 4,8 | 2,2 | 13,84 | 0,66 | 10 | 6 | 6 | 3,8 | | 12° | 4°56' | | | | | | | | | | | | | |
| 92,0 | | | | | | | | | | | | | | | | | | | | | | | | | | 4°49' | | | |
| 95,0 | | | | | | | | | | | | | | | | | | | | | | | | | | | 4°39' | | |
| 98,0 | | | | | | | | | | | | | | | | | | | | | | | | | | | | 4°29' | |
| 100,0 | | | | | | | | | | | | | | | | | | | | | | | | | | | | 4°23' | |
| 102,0 | 5,0 | | | | | | | | | | 7 | 7 | 4,0 | | 10° | 4°16' | | | | | | | | | | | | | |
| 105,0 | | | | | | | | | | | | | | | | | | | | | | | | | | | | 5°46' | |
| 108,0 | | | | | | | | | | | | | | | | | | | | | | | | | | | | 5°37' | |
| 110,0 | | | | | | | | | | | | 5 | | | 8 | | | | | | | | 8 | | | +0,85 -0,40 | | 5°32' | |
| 112,0 | | | | | | | | | | | | | | | | | | | | | | | | | | | | 13° | 5°26' |
| 115,0 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 5°17' |
| 118,0 | | | | | | | | | | | | | | | | 45 | 7,5 | 5,5 | 2,5 | 17,80 | 0,95 | 13 | | 8 | | | | | 5°09' |
| 120,0 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 5°03' |
| 122,0 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 4°57' |
| 125,0 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 4°49' |
| 128,0 | | | | | | | | | | | | | 9 | | | | 4°40' | | | | | | | | | | | | |
| 130,0 | | | | | | | | | | | | 10 | | | | | 11° | 4°35' | | | | | | | | | | | |