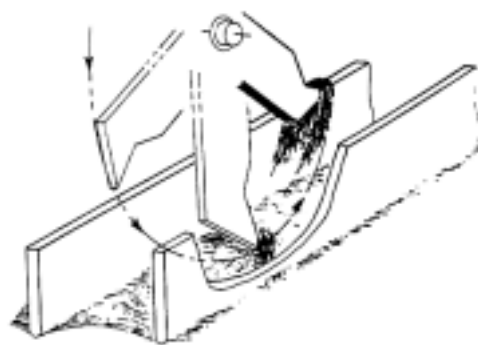


1.

가

가

가



< 1> 2

. , < 1> , 1)

2 , 2)

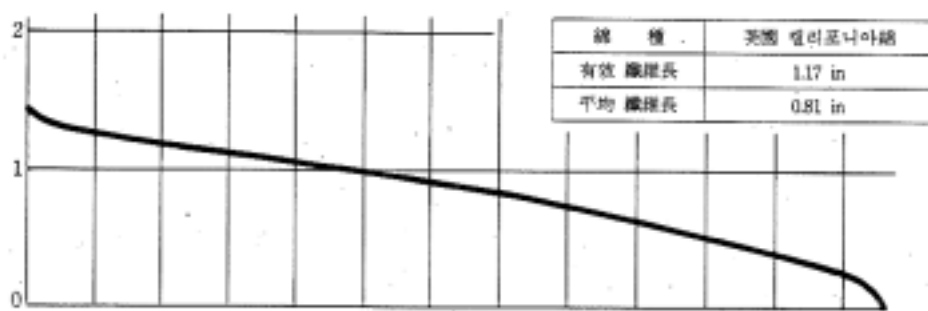
2.

가.

가

< 1>

< 1>



< 2> (a) , < 2> (b) .

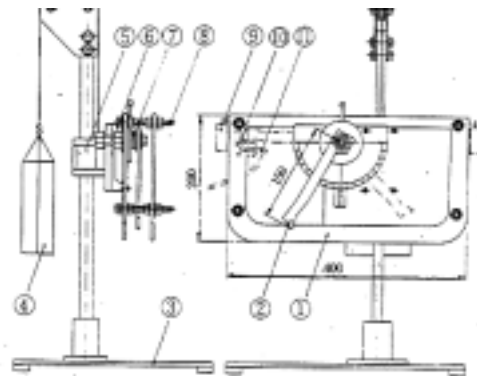
(a) ,

() ,

2

(balance)

가



< 2> (a)

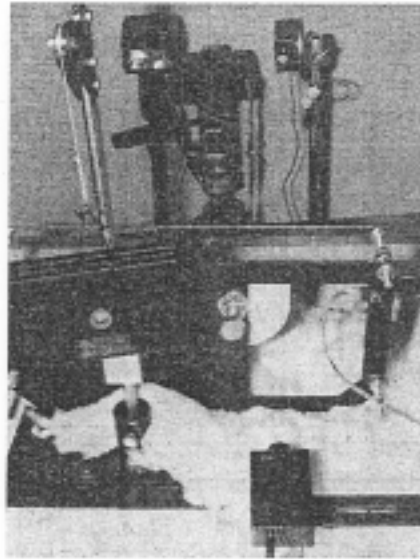
(,)

(1)

(torque)

(release)

가



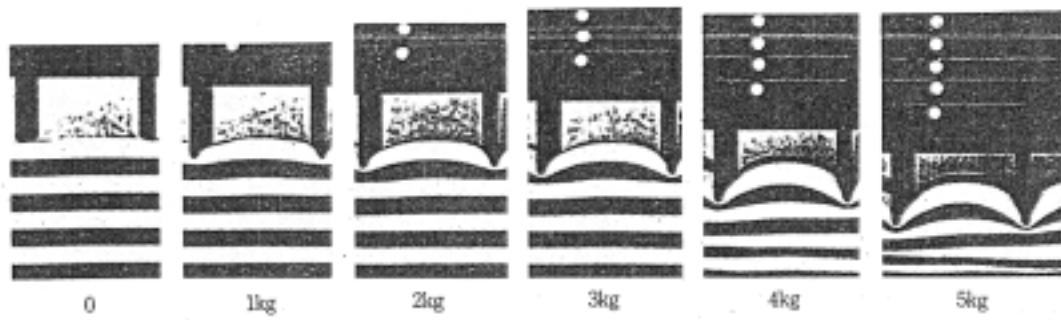
< 2> (b)

1)

,

가?

< 3>



< 3>

(○ 1kg)

(S) = 70mm, (W) = 1, 2, 3, 4,

5kg

1 kg 가 , (4kg)

가

(h) 가

가

(W) (h)

(S) 가

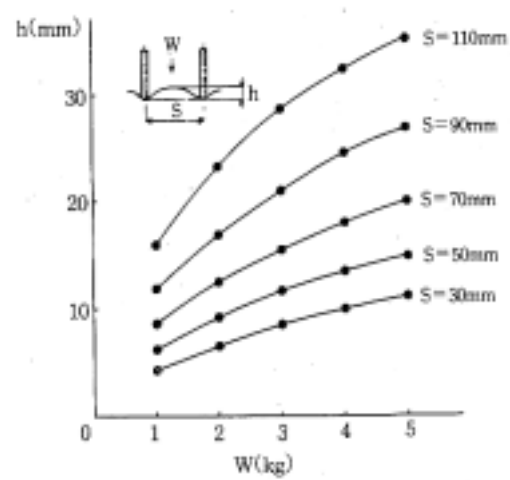
(h) 가가

(S)

2)

(7卜)

30, 50, 70 %, 110mm



< 4>

()

(F kg)

()

1.2kgf7卜

0~1.2kgf

4

0.3, 0.6, 0.9, 1.2kgf

()

(Wkg)

1.2kgf

1kg

1kg

0~1kg

, 0.25, 0.5, 0.75, 1kg

()

(dmm)

가

(F)

가

.

F=1.2kgf

W=0.25kg

d +6~-6mm

0

+6, +3, 0, -3, -6mm

.

()

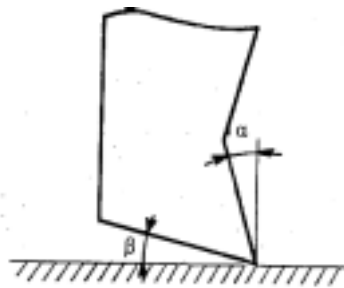
< 5>

(face angle, rake angle ; α) 15° ,

(clearance angle, relief angle ; β) 15°

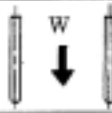
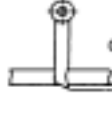
60°

.



< 5>

< 2>

No	剝取條件	設定値
1	프레스 바 간의 間隔 (mm) 	30 50 70 90 110
2	프레스 바의 壓入(kg) 	0.25 0.50 0.75 1.00
3	開鐵 棒의 剝取力(kgf) 	0.30 0.60 0.90 1.20
4	開鐵 棒의 박취 깊이 (mm) 	-6 -3 0 +3 +6

< 2> .

100

3.

가.

1) (S)

2 ,

가 .

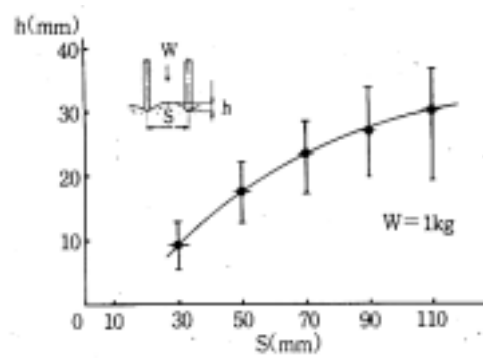
가

10 .

< 6> . I , ●

가 가

,



< 6> (S) (h)

2)

(W)

가

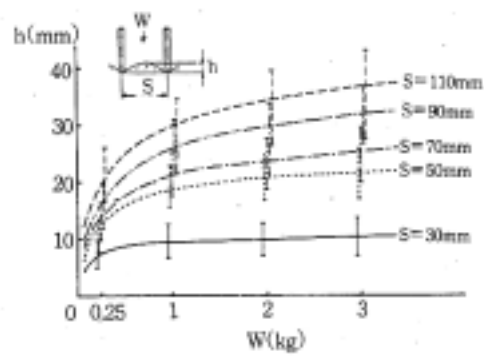
1kg

0~3kg

가

<

7>



< 7>

(W)

(h)

가

0.25~0.5kg

가 ,

가

< 8> (a), (b)

가

가

가

가

가 < 8> (c), (d)

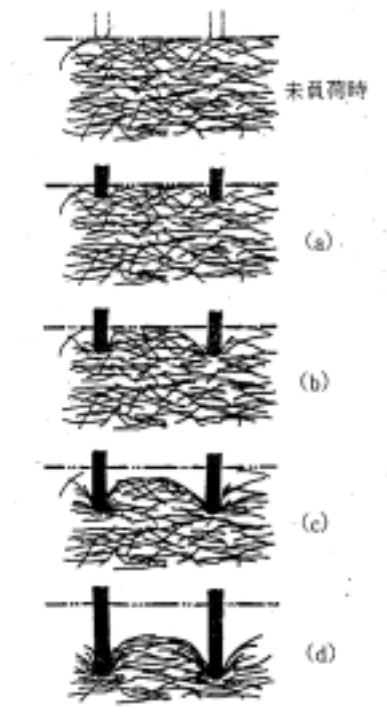
0.25~0.5kgf

가 ,

가가

< 7> (S)

0.25~1kg 가



< 8>

가

가

< 9> (a) 가

, < 9> (b)

가

.



(a)



(b)



(c)



(d)

< 9>

가

가

가

가

가

,

< 9> (c)

가 < 9 (d)>.

가

2

n=100

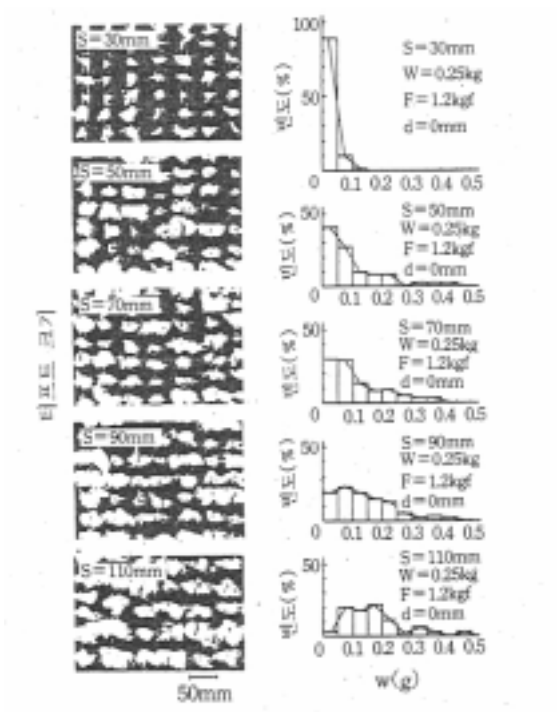
(S)

가

가

S=30~110mm

< 10>

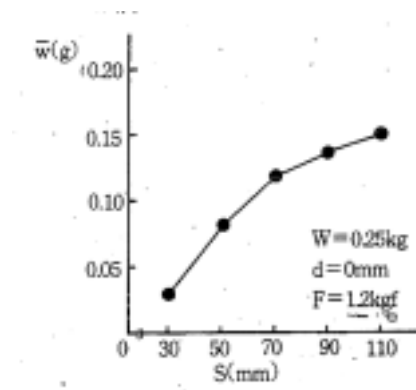


< 10>

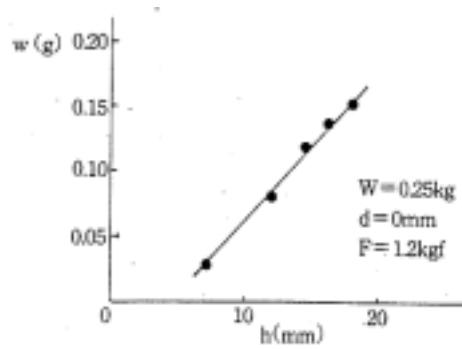
(S)

0.05g

11> (S) ($\bar{w}$)



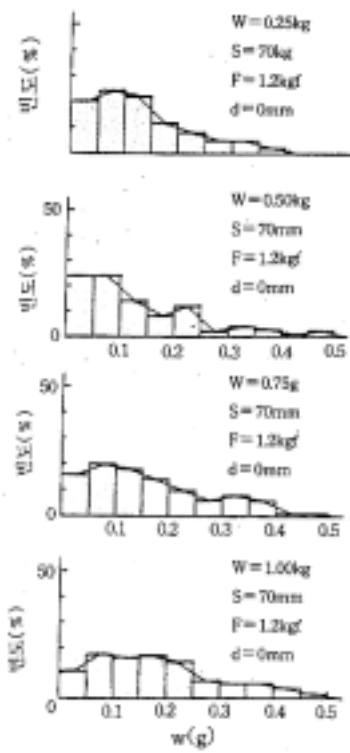
11> (S) ($\bar{w}$)



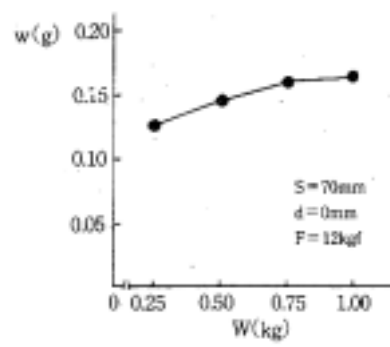
12> (h) ($\bar{w}$)

10> 11> 가
가 가 < 6>

,
 < 12>
 .
 .
 , < 10>
 ,
 (S=30mm) 가 0.1g
 50mm 0.5g 가
 가
 . ,
 .
 1) (W)
 < 8> 가 ,
 가 가
 .
 ,
 1kgf
 가
 가 가
 1kgf 가
 , S=70mm
 < 13>
 < 14> 가
 가 가



< 13> (W)



< 14> (W) ($\bar{w}$)

가

가

가

가

< 14>

2)

(F)

$F=1.2\text{kgf}$

가

가

1.2kgf

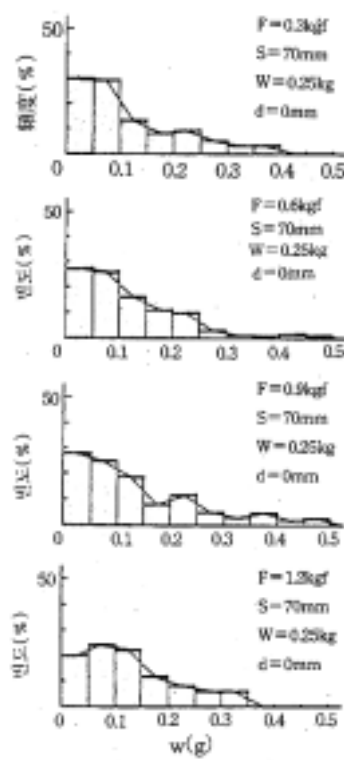
가

가

($W=0.5\text{kg}$)

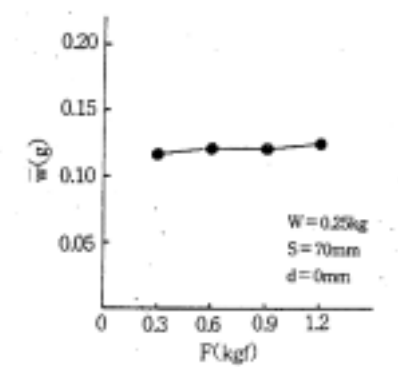
< 15>

< 16>



< 15>

(F)



< 16> (F) (w)

3) (d)가

가

가

< 17> < 18>

(

가) d<0, () d>0

. 가 가 d=-6 ,

가

85% 0.05g 가 가

d=6mm >

가 가 ,

가

, < 18>

$d=+6\text{mm}$

$d=-6\sim+6\text{mm}$

$d<0$

가

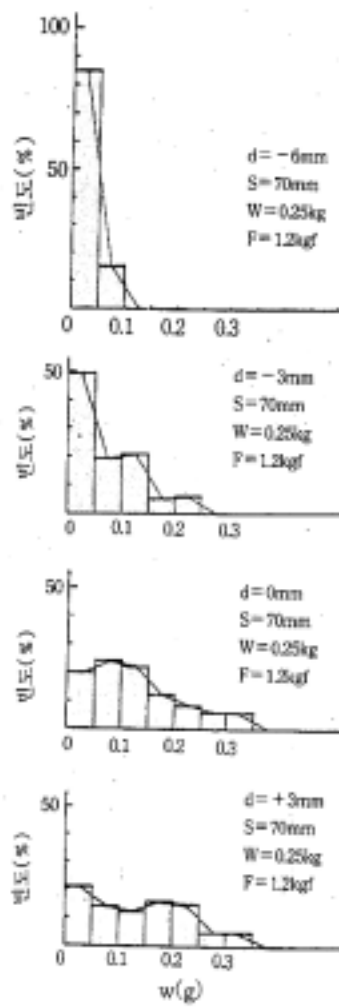
가 가

$d=0$

$d>0$

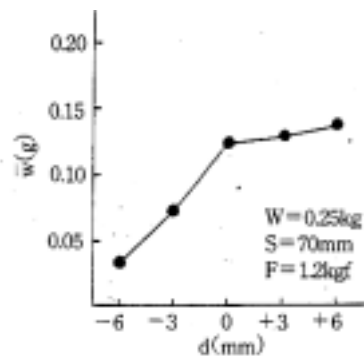
가

< 18>



< 17>

(d)



< 18> (d) ($\bar{w}$)

4.

가

1) 가

가

2) 가 , 1)

가

3)

4) 가 - 가

가 가 + 가