

*Mathematical dependence of a continuity of a composite covering on the basis of copper with non-metallic components from basic technological parameters of the flexible instrument plating process is received. It is showed that the rational technological parameters of the plating for formation of coverings from the composite materials-donors must be next:  $n = 8-12$ ,  $N = 0,8-1,3$  mm,  $V_d/V_w = 0,23-0,27$ . In this case the reception of a continuous covering is provided.*

( ) [1, 2],

( , , , . . )

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( , , , , .),

[3].

:  ${}_1 - 5-15$ ;  ${}_2 - 0,5-1,5$  ;  ${}_3 - 0,15-0,35$ .

$S$

$S$  :

$$\lambda = \frac{S}{S} \cdot 100\% .$$

$200^\times$

"Mira" "Tescan".

( ) , 5 20 0,5 0,5,

54-56). 20 (HRC  
( 65 ) 0,2 ( ) 250 , 80 47

1.

1.

	0	1	2	3	1 2	1 3	2 3	${}_1^2$	${}_2^2$	${}_3^2$	, %
1	+	+	+	0	+	0	0	+	+	0	100
2	+	+	-	0	-	0	0	+	+	0	90
3	+	-	+	0	-	0	0	+	+	0	65
4	+	-	-	0	+	0	0	+	+	0	40
5	+	0	0	0	0	0	0	0	0	0	99
6	+	+	0	+	0	+	0	+	0	+	100
7	+	+	0	-	0	-	0	+	0	+	99
8	+	-	0	+	0	-	0	+	0	+	62
9	+	-	0	-	0	+	0	+	0	+	60
10	+	0	0	0	0	0	0	0	0	0	100
11	+	0	+	+	0	0	+	0	+	+	100
12	+	0	+	-	0	0	-	0	+	+	99
13	+	0	-	+	0	0	-	0	+	+	80
14	+	0	-	-	0	0	+	0	+	+	76
15	+	0	0	0	0	0	0	0	0	0	100

( . 1)

, . 1,

20-25

[3]

$$\lambda = 99,67 + 20,25 \cdot 1 + 9,75 \cdot 2 + \dots - 3,75 \cdot 1 \cdot 2 - 17,21 \cdot 1^2 - 8,71 \cdot 2^2 - 2,21 \cdot 3^2. \quad (1)$$

5 %-

(1)

,

1,

$$(1) \quad (n, N, V/V). \quad (1, 2, \dots)$$

$$x_1 = \frac{n-n_0}{\Delta n}; \quad x_2 = \frac{N-N_0}{\Delta N}; \quad x_3 = \frac{(V/V) - (V/V)_0}{\Delta(V/V)},$$

$$n_0, N_0, (V/V)_0, \dots; \quad n, N, \dots$$

$$(V/V) -$$

$$x_1 = \frac{n-10}{5}; \quad x_2 = \frac{N-1}{0,5}; \quad x_3 = \frac{(V/V) - 0,25}{0,1}.$$

(1)

$$\lambda = -95,32 + 19,32n + 104,18N + 120,5(V/V) - 1,5nN - 0,69n^2 - 34,84N^2 - 221(V/V)^2.$$

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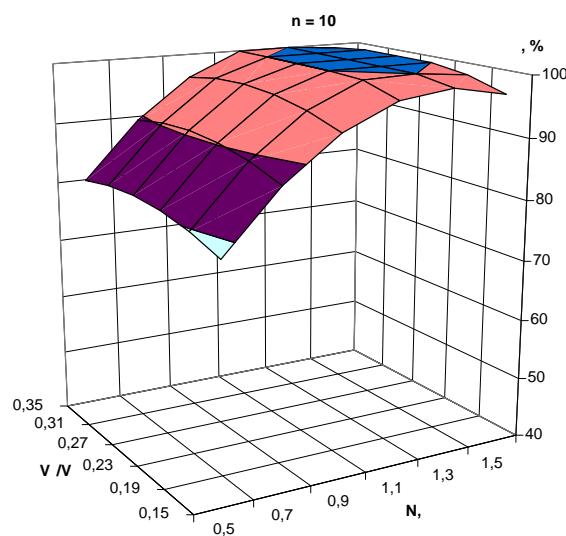
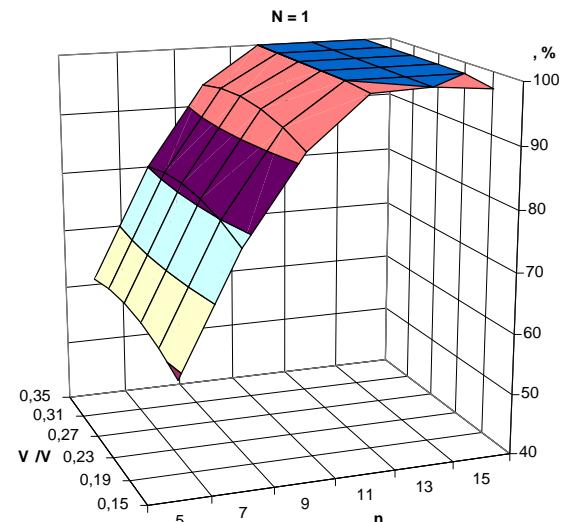
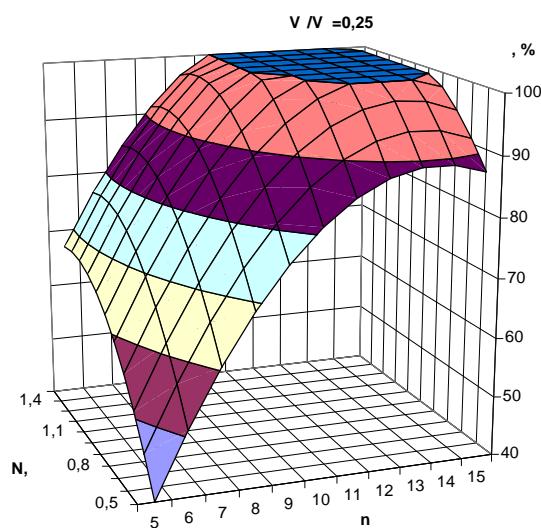
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100 %-

$$n = 8-12, \quad N = 0,8-1,3, \quad V/V = 0,23-0,27.$$

$$5 \quad 20 \quad 0,5 \quad 0,5,$$

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N,

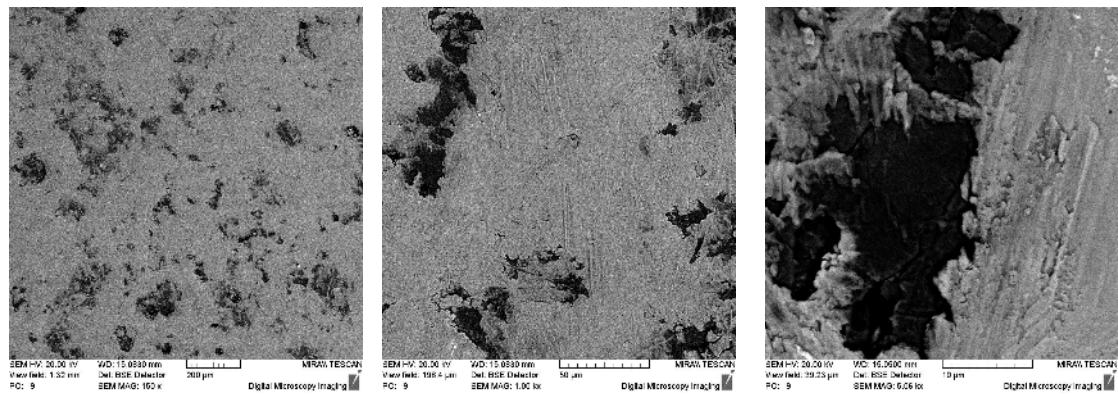
n,

V/V

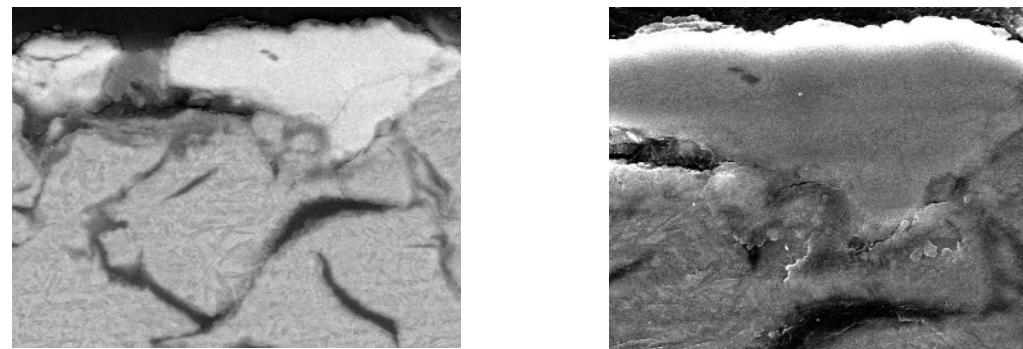
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( . 2).



2.  
 5 20 0,5 0,5  
 ( ) , 20, 150 ( ), 1000 ( ), 5060



3. , 5 20 0,5 0,5  
 20, 5000 ( ), 10000 ( )

, 10,3:1; 5:1; 0,8:1.

, 5 20 0,5 0,5

, 46–100 % . - , 50–91 % , 79–100 % -

6 %

47 %

( )

, 79–100 %

$$= 8-12, N = 0,8-1,3 \quad , V/V = 0,23-0,27.$$

47 %

6 %

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12.05.2010 .

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