621.941

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                              [1, 2, 3, 4, 5]:
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          [1, 2, 4].
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V → Операция 1 → Операция 2 → ••• → Операция n → W

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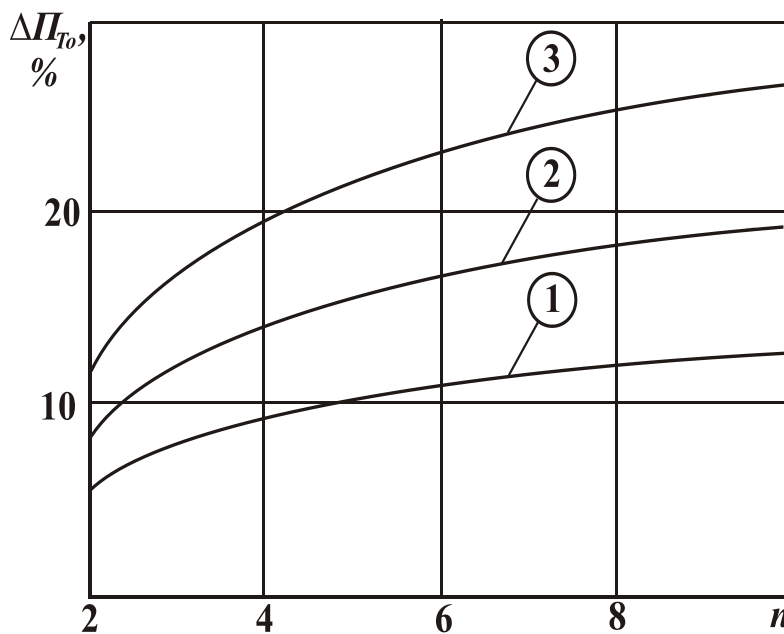1.   -
                                                                                                                             -

[1]

/		IT,	R_a,
1		10-8	6,3-0,8
2	: - ,	9-7	6,3-0,4
	-	6-5	3,2-0,1
3	: - ,	10-8	6,3-0,4
	-	7-5	3,2-0,2
4		9-6	6,3-0,2
5	: - ,	7-6	3,2-0,2
	-	6-5	1,6-0,1
6		5-4	1,6-0,1
7		6-5	1,6-0,1
8		5-4	0,06-0,04
9		5-4	0,1-0,012
10		5-4	0,05-0,01
11		10-8	6,3-0,4
12		8-6	6,3-0,1
13		6-5	0,4-0,1
14		6-5	0,22-0,18

:

$$a = \frac{1}{t_{o1} + t_{o2} + t_{o3}}, \qquad (1)$$

Ta -
;
t_{o1}, t_{o2}, t_{o3} -   1- , 2-   3-   -
.
(1)   -
$$t_{o1} = t_{o2} = t_{o3} = t_o,$$ -

$$a = \frac{1}{3t_o}. \qquad (2)$$

(-
)   ,

:

$$b = \frac{1}{(1+0,1)\, t_{o1} + (1+0,1)\, t_{o2}(1-0,3) + t_{o3}(1-0,3)} , \qquad (3)$$

Tb -

.

(3) : 0,1
10%

, 0,3 −
30%. , $t_{o1} = t_{o2} = t_{o3} = t_o$ -

$$b = \frac{1}{2,57\, t_o} . \qquad (4)$$

(2) (4) -
-

16,7%,

$$\Delta\ T_o = (\frac{Tb}{Ta} - 1)\, 100\ \% = 16,7\ \% . \qquad (5)$$

(5)

:

$$\Delta\ T_o = \left[\frac{n}{(1+k_1) + (1+k_1)(1-k_2)(n-2) + (1-k_2)} - 1 \right] 100\ \% , \qquad (6)$$

$\Delta\ T_o$ -

;
n - ;
k_1 - ;
k_2 - -

.
(6) , -
$n \geq 2$ $k_1 < k_2$.
. 2

-

.

. 2.

:
-     1 – $k_1 = 0,1; k_2 = 0,2$;
-     2 – $k_1 = 0,1; k_2 = 0,25$;
-     3 – $k_1 = 0,1; k_2 = 0,3$

5-25%

3.

(   )

: **1.** - . 2- . /
. . . . - .: , .1, 1986, - 656 .;
.2, 1985, - 496 . **2.** . . . – .:
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656 . **4.** / . . . . , . . -
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IMPROVING THE EFFICIENCY OF PROCESSING MACHINE PRODUCTS BASED ON THE PRINCIPLE OF CONSEQUENT MINIMIZATION PARAMETERS PRECEDING OPERATIONS

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Abstract*. In this paper some issues related to the efficiency of processing engineering products based on the principle of sequential minimization of processing parameters on the previous operations process. The analysis of the characteristics of processing products for operations process and proposed measures to improve the efficiency of processing products in the process. And also a comparison of productivity of processing products in the application of principles developed for the specific structure of the process.*
Keywords: *product engineering, technological processing, the principle of enhancing the effectiveness of treatment.*