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$$v_i = \prod_{k=1}^p v_{ik}, \tag{1}$$

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$$\eta_i = \frac{t_o}{t_o + t} \quad (6)$$

η_i -

$$= \frac{\prod_{k=1}^p v_{ik}}{t_o} \quad (7)$$

(7) (6),

$$\eta_i = \frac{t_o}{t_o + t} = \frac{1}{\varepsilon_i} \quad (8)$$

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$$= \frac{\prod_{k=1}^p v_{ik}}{t_o} \eta_i = \frac{\prod_{k=1}^p v_{ik}}{t_o \varepsilon_i}.$$

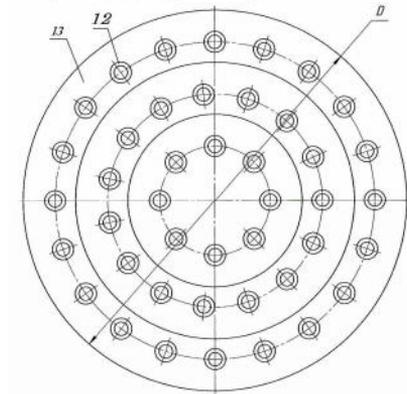
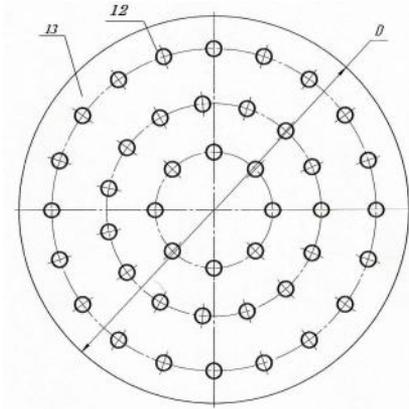
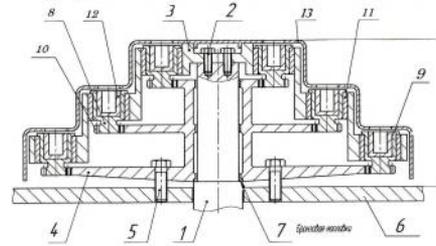
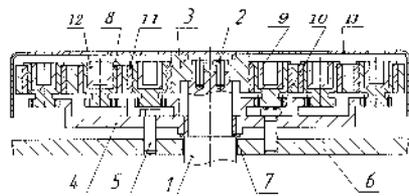
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18.05.2010 .

**INCREASE PRODUCTIVITY APPLICATION PROCESSES OF VACUUM ION
 PLASMA COATINGS ON SPIRAL DRILLS OF HIGH-SPEED STEELS
 MAJEED A. H., MIKHAYLOV A.N., FENIK L.N., MIKHAYLOVA E. A.
 (DonNTU, Donetsk, Ukraine, iraqi295@mail.ru)**

Abstract. The basic principles for improving performance application Covered based on the principle concentration of working positions in a vacuum chamber and parallelism in the implementation of technological impacts on items processing, would enable to design a snap technological system of the coating on the spiral drills.

Keywords: spiral drills, surface, roughness, finishing processing.