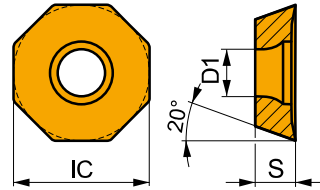


OEHT 09

	IC	D1	S
	(mm)	(mm)	(mm)
0906	24.100	8.60	7.15



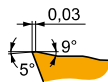
Valores de inicio adecuados para la velocidad de corte (vc), avance (f) y profundidad de corte (ap). Consulte nuestra APP Calculadora de mecanizado para obtener más cálculos.

Producto	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



Plaquita de planeado a 45° con geometría MM, diseño positivo y afilado para mecanizado ligero a medio y potencialmente desbaste.

OEHT 0906AEER-MM	M8330	—	255	0.25	3.5	150	0.23	3.5	—	—	—	765	0.30	3.5	60	0.18	2.8	—	—	—
	M8340	—	230	0.25	3.5	135	0.23	3.5	—	—	—	—	—	—	55	0.18	2.8	—	—	—



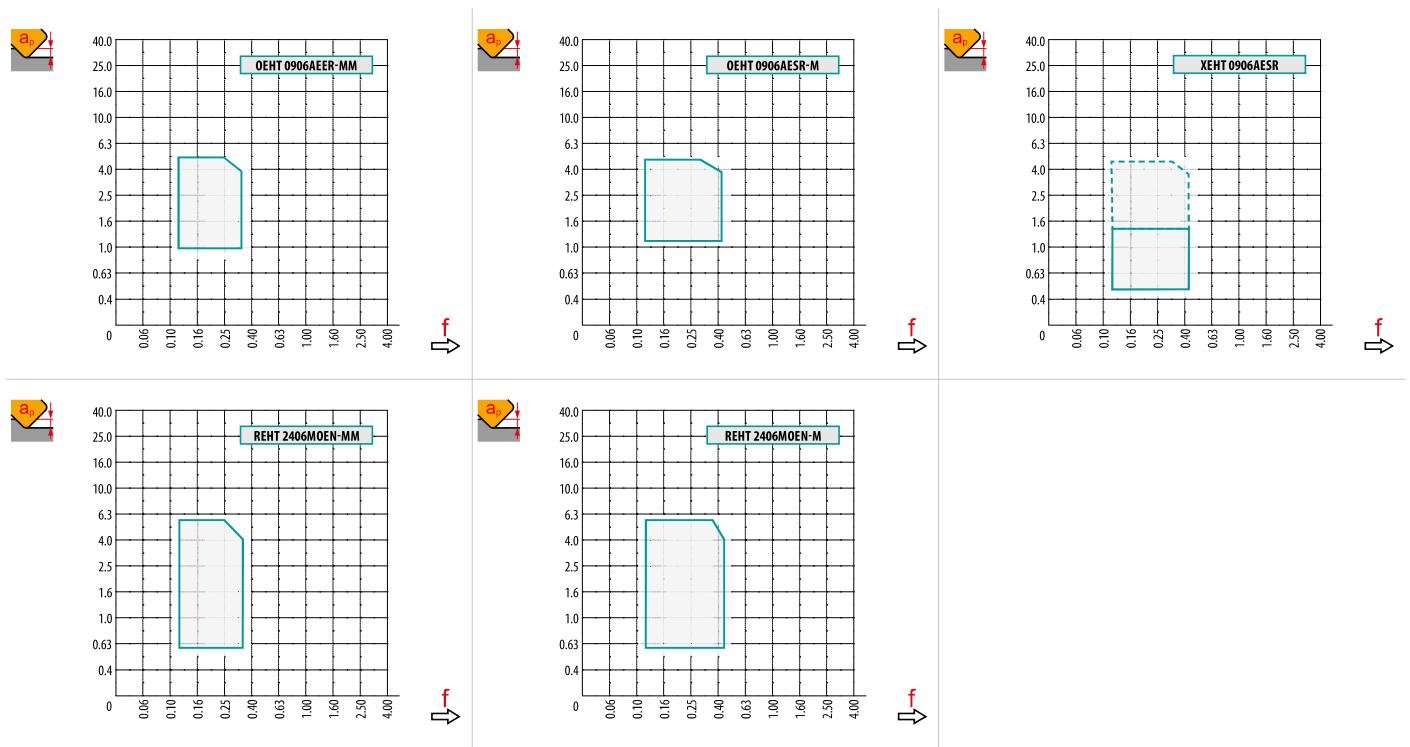
Plaquita de planeado a 45° con geometría M, diseño positivo para mecanizado ligero a medio y potencialmente desbaste.

OEHT 0906AESR-M	M8310	—	250	0.35	3.5	125	0.32	3.5	—	—	—	—	—	—	—	—	—	—	—	—
	M8330	—	235	0.35	3.5	140	0.32	3.5	—	—	—	—	—	—	55	0.25	2.8	—	—	—
	M8340	—	215	0.35	3.5	125	0.32	3.5	—	—	—	—	—	—	50	0.25	2.8	—	—	—
	M9325	—	275	0.35	3.5	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—



a_e DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	OEHT 09-MM	OEHT 09-M	XEHT 09	REHT 24-MM	REHT 24-M
	—	—	—	12.00	12.00
	2.00	2.00	14.80	—	—



		R										
		0.00	0.50	0.75	1.25	1.50	2.00	2.50	3.00	4.00	5.00	6.00
80		70.90	77.76	79.25	81.57	82.52	84.17	85.56	86.77	88.79	90.39	91.68
100		90.90	97.76	99.25	101.57	102.52	104.17	105.56	106.77	108.79	110.39	111.68
125		115.90	122.76	124.25	126.57	127.52	129.17	130.56	131.77	133.79	135.39	136.68
160		150.90	157.76	159.25	161.57	162.52	164.17	165.56	166.77	168.79	170.39	171.68
200		190.90	197.76	199.25	201.57	202.52	204.17	205.56	206.77	208.79	210.39	211.68
250		240.60	247.46	248.95	251.27	252.22	253.87	255.26	256.47	258.49	260.09	261.38
315		305.60	312.46	313.95	316.27	317.22	318.87	320.26	321.47	323.49	325.09	326.38



		$f_{\max}$ 
80	1.44	0.51
100	1.48	0.57
125	1.53	0.64
160	1.58	0.72
200	1.63	0.80
250	1.68	0.90
315	1.74	1.01



					
					
80	94.9	4.9	8.4/100	5.0	8.6/100
100	114.9	3.7	6.3/100	3.7	6.3/100
125	139.9	2.8	4.7/100	2.8	4.7/100
160	174.9	2.1	3.5/100	2.1	3.5/100
200	214.9	1.6	2.6/100	1.6	2.6/100



									
		DMIN	DMAX			DMIN	DMAX		
80	94.9	146.0	190.0	8.8	8.8	146.0	189.0	11.5	11.5
100	114.9	186.0	230.0	8.8	8.8	186.0	229.0	11.5	11.5
125	139.9	236.0	280.0	8.8	8.8	236.0	279.0	11.5	11.5
160	174.9	306.0	350.0	8.8	8.8	306.0	349.0	11.5	11.5
200	214.9	386.0	430.0	8.8	8.8	386.0	429.0	11.5	11.5



	
	5.5
	5.4

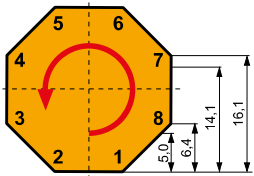


R

		3	5	10	15	20	30	40	50	60	80	100
94.9		1.067	1.378	1.948	2.386	2.755	3.375	3.897	4.357	4.772	5.511	6.161

		3	5	10	15	20	30	40	50	60	80	100
12.0		0.537	0.693	0.980	1.200	1.386	1.697	1.960	2.191	2.400	2.771	3.098

i



	
-> 5.0	8
-> 6.4	7
-> 14.1	4
-> 16.1	2

