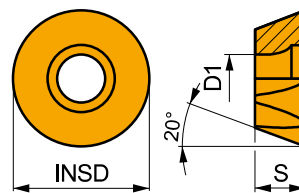


REHT 24

	INSD	D1	S
	(mm)	(mm)	(mm)
2406	24.0	8.60	7.15



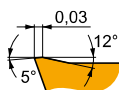
Valores de inicio adecuados para la velocidad de corte (vc), avance (f) y profundidad de corte (ap). Consulte nuestra APP Calculadora de mecanizado para obtener más cálculos.

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)



Geometría MM para copiado y perfilado, con diseño ligeramente positivo para mecanizado ligero a medio y potencialmente desbaste.

REHT 2406M0EN-MM	M8330	—	280	0.25	2.0	165	0.23	2.0	—	—	—	840	0.30	2.0	70	0.18	1.6	—	—	—
	M8340	—	255	0.25	2.0	150	0.23	2.0	—	—	—	—	—	—	60	0.18	1.6	—	—	—



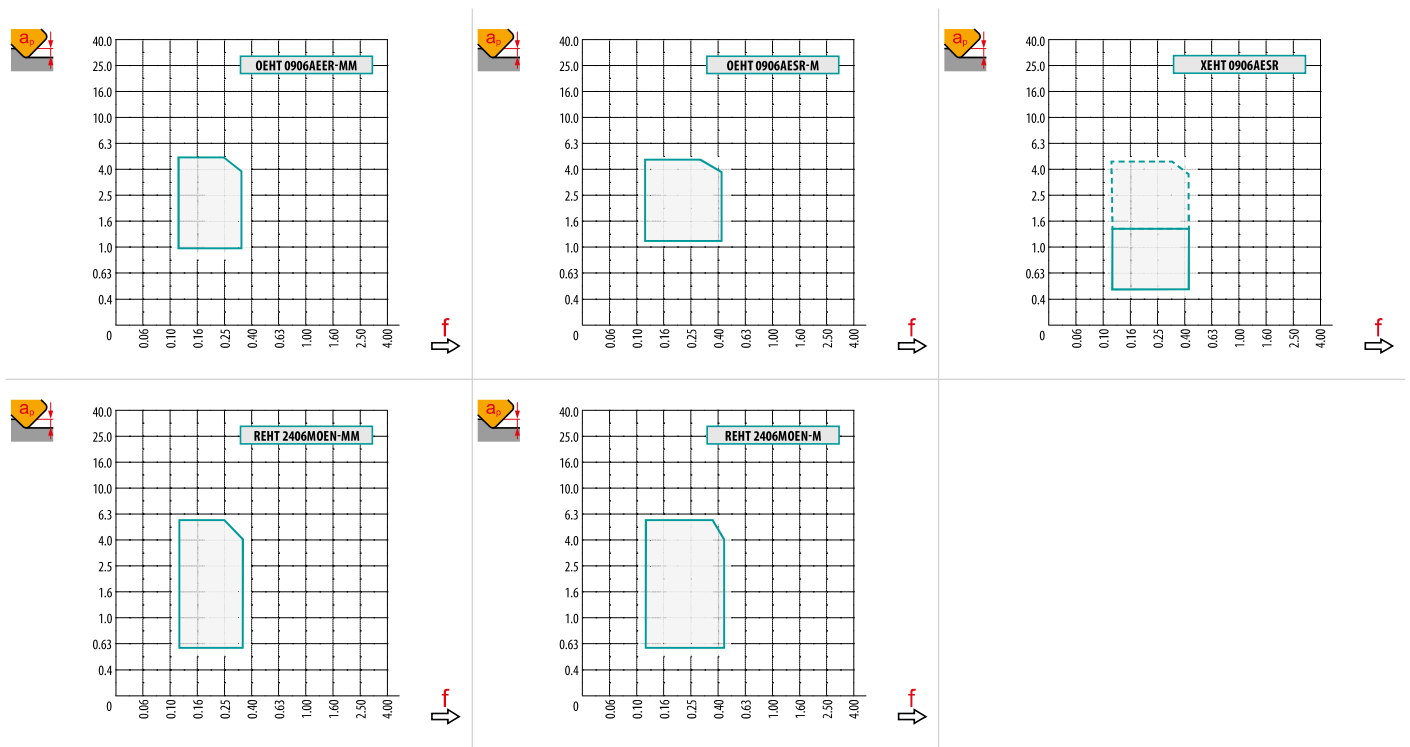
Plaquita para copiado y perfilado con geometría M, diseño ligeramente positivo para mecanizado ligero a medio

REHT 2406M0SN-M	M8330	—	260	0.35	2.0	155	0.32	2.0	—	—	—	—	—	—	65	0.25	1.6	—	—	—
	M8340	—	240	0.35	2.0	140	0.32	2.0	—	—	—	—	—	—	60	0.25	1.6	—	—	—



$\frac{a_e}{DC}$	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	—	—



		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

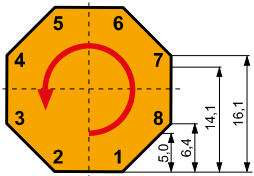


R

		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

