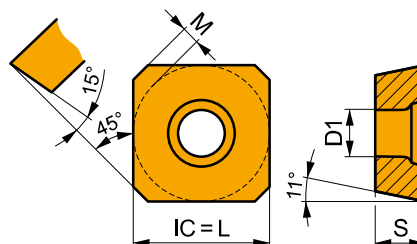


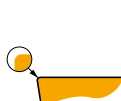
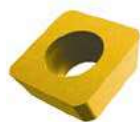
SPEW 12 AD

	IC	D1	L	M	S
	(mm)	(mm)	(mm)	(mm)	(mm)
1204	12.700	5.50	12.70	2	4.76



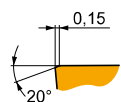
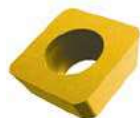
Valores de inicio adecuados para la velocidad de corte (vc), avance (f) y profundidad de corte (ap). Consulte nuestra APP Calculadora de mecanizado para obtener más cálculos.

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)



Preparación del filo ADEN con ángulo de desprendimiento de 0° para mecanizado ligero a medio.

SPEW 1204ADEN	M8330	—	220	0.20	12.0	—	—	—	205	0.20	12.0	—	—	—	—	—	40	0.15	1.0
	M8340	—	200	0.20	12.0	—	—	—	190	0.20	12.0	—	—	—	—	—	—	—	—



Preparación del filo ADSN con ángulo de desprendimiento de 0° para mecanizado medio.

SPEW 1204ADSN	M8330	—	220	0.20	12.0	—	—	—	205	0.20	12.0	—	—	—	—	—	40	0.15	1.0
	M8340	—	200	0.20	12.0	—	—	—	190	0.20	12.0	—	—	—	—	—	—	—	—



a_e DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	0.89	0.81	0.76	0.73	0.71	0.70	0.67	0.65	0.63	0.62	0.60	0.60	0.60	0.45



	1		2.5		5		7.5		10		15		20	
	$f_{\min}$ 	$f_{\max}$ 	$f_{\min}$ 	$f_{\max}$ 	$f_{\min}$ 	$f_{\max}$ 	$f_{\min}$ 	$f_{\max}$ 	$f_{\min}$ 	$f_{\max}$ 	$f_{\min}$ 	$f_{\max}$ 	$f_{\min}$ 	$f_{\max}$ 
50	0.50	0.71	0.32	0.45	0.23	0.32	0.19	0.27	0.16	0.23	0.14	0.19	0.12	0.17
63	0.56	0.80	0.35	0.51	0.25	0.36	0.21	0.30	0.18	0.26	0.15	0.21	0.13	0.19
80	0.63	0.90	0.40	0.57	0.28	0.40	0.23	0.33	0.20	0.29	0.17	0.24	0.15	0.21

	25	32	40	50	63	80
	f_{min} 	f_{max} 	f_{min} 	f_{max} 	f_{min} 	f_{max}
50	0.11	0.16	0.10	0.14	0.10	0.14
63	0.12	0.17	0.11	0.16	0.10	0.15
80	0.13	0.19	0.12	0.17	0.11	0.16

	APET 15	APEW 15	SPET 12	SPET 12AD	SPEW 12AD
RE	1.2	1.2	0.8	—	—
BS	—	—	—	—	—



ISO				
50J4R110H50-SSAP37+21	50	2+2	58	55.6
50J4R128H50-SSAP55+21	50	2+2	76	73.6
63J4R150H50-SSAP74+21	63	2+2	95	92.6
50J4R106X50-SSAP37+21	50	2+2	58	55.6
50J4R124X50-SSAP55+21	50	2+2	76	73.6
63J4R146X50-SSAP74+21	63	2+2	95	92.6
50J4R110H50-SSAP58-A	50	2+2	58	55.6
50J4R128H50-SSAP76-A	50	2+2	76	73.6
63J4R150H50-SSAP95-A	63	2+2	95	92.6
80J6R155H50-SSAP95-A	80	3+3	95	92.6
50J4R106X50-SSAP58-A	50	2+2	58	55.6
50J4R124X50-SSAP76-A	50	2+2	76	73.6
63J4R146X50-SSAP95-A	63	2+2	95	92.6
80J6R151X50-SSAP95-A	80	3+3	95	92.6