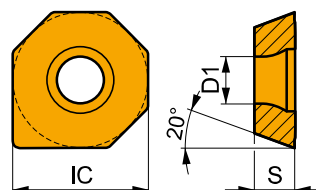


XEHT 06

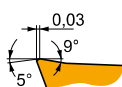


	IC	D1	S
	(mm)	(mm)	(mm)
0604	16.050	5.50	4.76



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



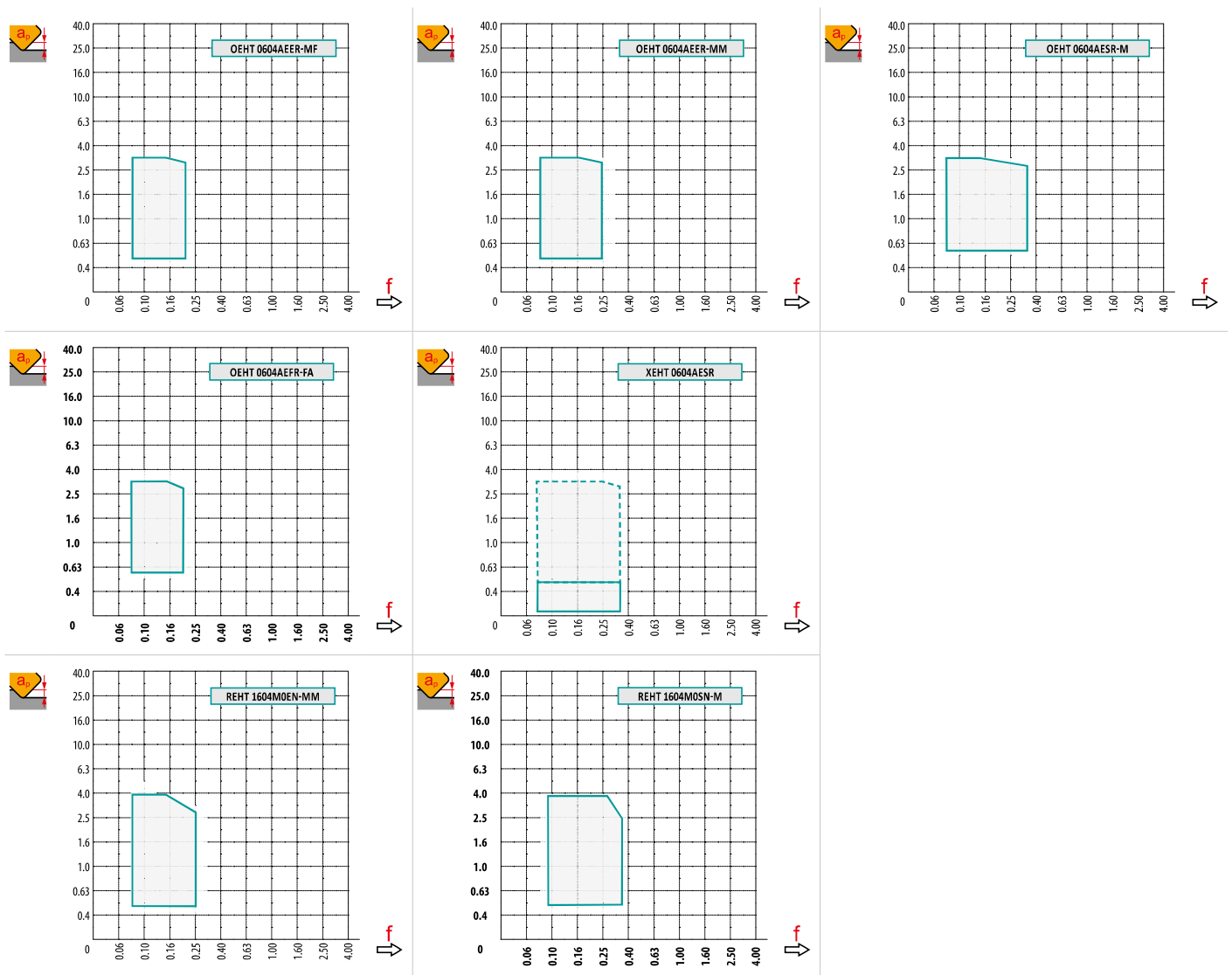
Plaquita rascadora (Wiper) con diseño ligeramente positivo para un acabado superficial mejorado.

XEHT 0604AESR	M8310	—	■	265	0.24	3.2	■	135	0.22	3.2	—	—	—	—	—	—	—	—	—
	M8330	—	■	245	0.24	3.2	■	145	0.22	3.2	—	—	—	—	—	—	—	—	—

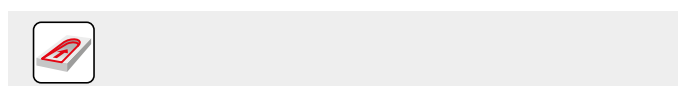
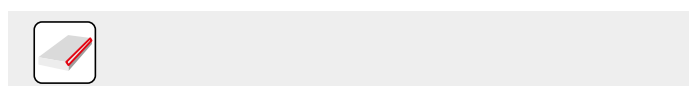


a_e DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	OEHT 06-MF	OEHT 06-MM	OEHT 06-M	OEHT 06-FA	XEHT 06	REHT 16-MM	REHT 16-M
	—	—	—	—	—	8.00	8.00
	1.36	1.36	1.36	1.36	9.91	—	—

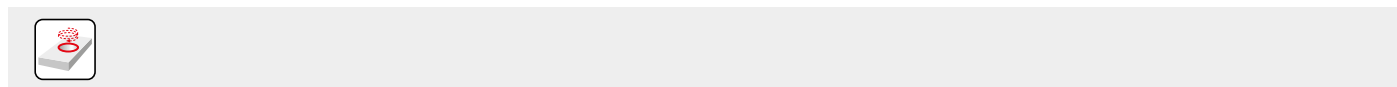


										
		0.00	0.50	0.75	1.25	1.50	2.00	2.50	3.00	4.00
50		43.90	49.47	50.66	52.49	53.23	54.48	55.52	56.39	57.76
56		49.80	55.37	56.56	58.39	59.13	60.38	61.42	62.29	63.66
63		56.90	62.47	63.66	65.49	66.23	67.48	68.52	69.39	70.76
70		63.80	69.37	70.56	72.39	73.13	74.38	75.42	76.29	77.66
80		73.90	79.47	80.66	82.49	83.23	84.48	85.52	86.39	87.76
90		83.80	89.37	90.56	92.39	93.13	94.38	95.42	96.29	97.66
100		93.90	99.47	100.66	102.49	103.23	104.48	105.52	106.39	107.76
125		118.90	124.47	125.66	127.49	128.23	129.48	130.52	131.39	132.76
160		153.90	159.47	160.66	162.49	163.23	164.48	165.52	166.39	167.76
200		193.90	199.47	200.66	202.49	203.23	204.48	205.52	206.39	207.76



		
50	1.43	0.33
56	1.45	0.35
63	1.47	0.37
70	1.49	0.39
80	1.52	0.42
90	1.55	0.44
100	1.57	0.47
125	1.62	0.52
160	1.68	0.59
200	1.73	0.66

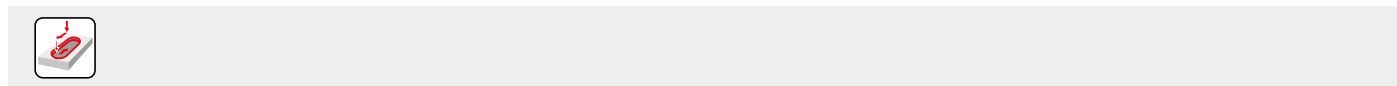
 					
					
50	59.9	4.9	8.4/100	4.6	7.9/100
56	65.8	4.2	7.2/100	4	6.8/100
63	72.9	3.6	6.1/100	3	5.1/100
70	79.8	3.1	5.3/100	2.7	4.6/100
80	89.9	2.6	4.4/100	2.2	3.7/100
90	99.8	2.3	3.9/100	2	3.3/100
100	109.9	2	3.3/100	1.8	3.0/100
125	134.9	1.5	2.5/100	1.3	2.1/100



	
	
50	59.9
56	65.8
63	72.9
70	79.8
80	89.9
90	99.8
100	109.9
125	134.9

			
DMIN	DMAX		
91.5	120.0	5.9	5.9
103.2	131.5	5.9	5.9
117.4	146.0	5.9	5.9
131.2	159.5	5.9	5.9
151.4	180.0	5.9	5.9
171.2	199.5	5.9	5.9
191.4	220.0	5.9	5.9
241.3	270.0	5.9	5.9

			
DMIN	DMAX		
91.5	119.5	5.9	5.9
103.5	131.0	5.9	5.9
118.0	145.5	5.9	5.9
131.5	159.0	5.9	5.9
151.5	179.5	5.9	5.9
171.5	199.0	5.9	5.9
191.5	219.5	5.9	5.9
241.5	269.5	5.9	5.9



	
	
3.1	3.0

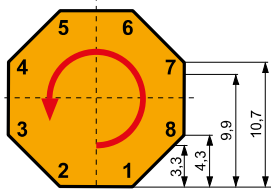


R

		3	5	10	15	20	30	40	50	60	80	100
59.9		0.848	1.095	1.548	1.896	2.189	2.681	3.096	3.461	3.792	4.378	4.895
65.8		0.889	1.147	1.622	1.987	2.294	2.810	3.245	3.628	3.974	4.589	5.130
72.9		0.935	1.207	1.708	2.091	2.415	2.958	3.415	3.818	4.183	4.830	5.400
79.8		0.979	1.263	1.787	2.188	2.527	3.095	3.573	3.995	4.376	5.053	5.650
89.9		1.039	1.341	1.896	2.322	2.682	3.285	3.793	4.240	4.645	5.364	5.997
99.8		1.094	1.413	1.998	2.447	2.826	3.461	3.996	4.468	4.894	5.651	6.318

		3	5	10	15	20	30	40	50	60	80	100
8.0		0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530

i



	
→ 3.3	8
→ 4.3	7
→ 9.9	4
→ 10.7	2

