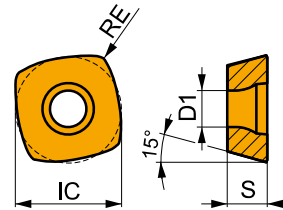


ZDCW 09

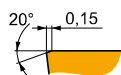


	IC	D1	S
	(mm)	(mm)	(mm)
09T3	9.525	3.40	3.97



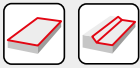
Valores de inicio adecuados para la velocidad de corte (vc), avance (f) y profundidad de corte (ap). Consulte nuestra APP Calculadora de mecanizado para obtener más cálculos.

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)



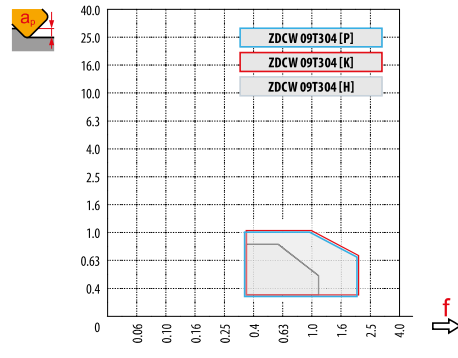
Geometría especial para fresado de alto avance.

ZDCW 09T304	M8310	0.4	320	1.00	0.6	—	—	—	300	1.00	0.6	—	—	—	—	—	60	0.15	1.0
	M8325	0.4	250	1.00	0.6	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	M8345	0.4	235	1.00	0.6	—	—	—	—	—	—	—	—	—	—	—	—	—	—

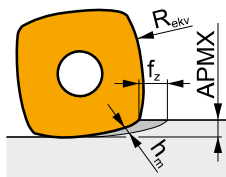


a_s DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	ZDCW 09
	0.4
	—



		0.00	0.30	0.40	0.50	0.60	0.70	0.80	0.90	1.00
25		11.6	17.4	18.2	19.0	19.7	20.3	20.9	21.5	22.0
32		18.7	24.5	25.3	26.1	26.8	27.4	28.0	28.6	29.1
35		21.7	27.3	28.1	28.8	29.5	30.1	30.7	31.2	31.7
40		27.7	33.5	34.3	35.1	35.8	36.4	37.0	37.6	38.1
42		28.7	34.3	35.1	35.8	36.5	37.1	37.7	38.2	38.7
50		36.7	42.3	43.1	43.8	44.5	45.1	45.7	46.2	46.7
52		38.7	44.3	45.1	45.8	46.5	47.1	47.7	48.2	48.7
63		49.7	55.3	56.1	56.8	57.5	58.1	58.7	59.2	59.7
66		52.7	58.3	59.1	59.8	60.5	61.1	61.7	62.2	62.7
		0.00	0.30	0.40	0.50	0.60	0.70	0.80	0.90	1.00
		—	2.00	2.00	2.00	1.75	1.50	1.25	1.13	1.00



$$f_z = h_m \times \sqrt{\frac{2R_{ekv}}{APMX}} \quad (\text{mm/diente})$$



Seguir las instrucciones para fresado de superficies planas (planeado). En caso de mecanizar cerca de una superficie vertical, reducir el avance por diente (f_z) al 50% para evitar vibraciones y daños en el filo de corte.



DCX	max	f_{max}
25	7.7	0.15
32	7.7	0.17
40	7.7	0.20



	HFC		
	0.3	0.6	1.0
	2.00	1.50	1.00



	HFC			
DCX	RPMX	APMX/l	RPMX	APMX/l
25	12.0	1.0/6	0.9	1.00/65
32	7.5	1.0/11	0.5	0.75/100
40	3.6	1.0/17	0.4	0.55/100



DCX	DMIN	DMAX		
25	35.0	50.0	0.45	1.00
32	49.0	64.0	0.45	0.85
40	65.0	80.0	0.50	0.85

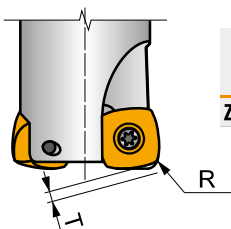


DCX		f_{max}
25	0.15	0.15
32	0.15	0.17
40	0.15	0.20



DCX		3	5	10	15	20	30	40	50	60	80	100
25		0,548	0,707	1,000	1,225	1,414	1,732	2,000	2,236	2,449	2,828	3,162
32		0,620	0,800	1,131	1,386	1,600	1,960	2,263	2,530	2,771	3,200	3,578
35		0,648	0,837	1,183	1,449	1,673	2,049	2,366	2,646	2,898	3,347	3,742
40		0,693	0,894	1,265	1,549	1,789	2,191	2,530	2,828	3,098	3,578	4,000
42		0,710	0,917	1,296	1,587	1,833	2,245	2,592	2,898	3,175	3,666	4,099
52		0,790	1,020	1,442	1,766	2,040	2,498	2,884	3,225	3,533	4,079	4,561
63		0,869	1,122	1,587	1,944	2,245	2,750	3,175	3,550	3,888	4,490	5,020
66		0,890	1,149	1,625	1,990	2,298	2,814	3,250	3,633	3,980	4,596	5,138

i



	R	T
ZDCW 09T304	2.27	0.52