

Julio 2007

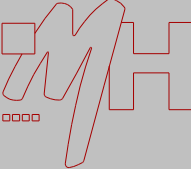


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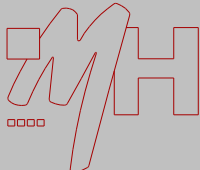
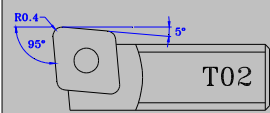
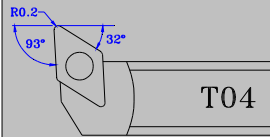
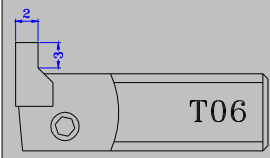
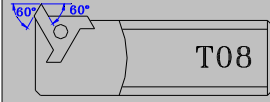
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1. HERRAMIENTAS TRABAJO EXTERIOR

		T01	T03	T05	T07	T09	T00
Numero Hta		T1	T3	T5	T7	T9	T0
Operación		Desbaste	Acabado	Ranurado	Roscado	Perfilado	Perfilado
Latón	Vc [m/mín]	280	380	180	750	260	260
	F [mm/rev]	0.25	0.15	0.15	paso	0.15	0.15
	Ap [mm]	2	0.5	1.5	0.3 (1ª)	0.5	0.5
Delrin	Vc [m/mín]	330	410	210	850 rpm	380	380
	F [mm/rev]	0.3	0.2	0.2	paso	0.2	0.2
	Ap [mm]	2.5	1.0	1.5	0.4 (1ª)	0.6	0.6
Aluminio	Vc [m/mín]	200	350	120	850 rpm	220	220
	F [mm/rev]	0.2	0.1	0.1	paso	0.15	0.15
	Ap [mm]	1.5	0.4	1	0.3 (1ª)	0.4	0.4

2. HERRAMIENTAS DE TRABAJO INTERIOR

	Hta	Operación	Latón			Delrin			Aluminio		
			Vc	F	Ap	Vc	F	Ap	Vc	F	Ap
	T2	Desbaste	300	0,20	2,00	350	0,30	3	250	0,10	1,50
	T4	Acabado	400	0,10	1,00	400	0,20	1	350	0,08	0,80
	T6	Ranurado	190	0,15	1,50	250	0,15	1,50	150	0,05	1,50
	T8	Roscado	800 rpm	S/ paso	0,30 (1ª)	800 rpm	S/ paso	0,30 (1ª)	S/ paso	700 rpm	0,30 (1ª)