



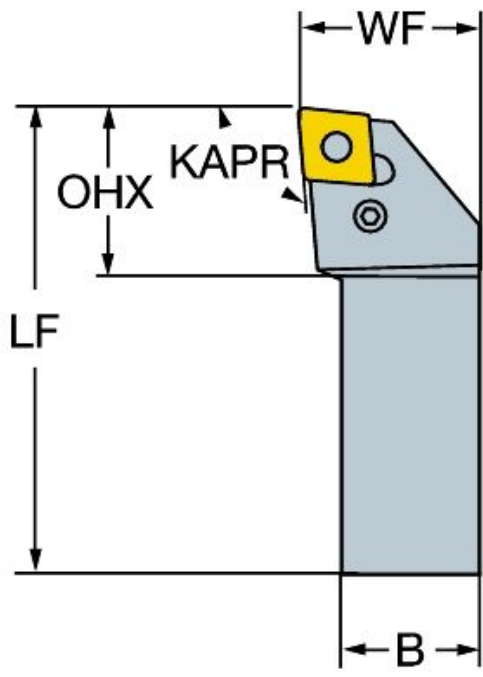
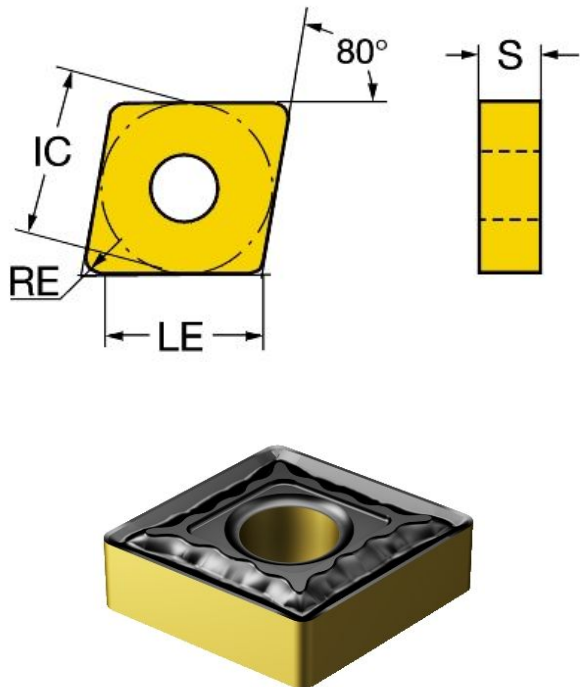
UNIVERSIDAD DE SANTIAGO DE CHILE

DEPARTAMENTO DE INGENIERÍA MECÁNICA
FACULTAD DE INGENIERÍA

TABLA DE HERRAMIENTAS: TORNO SAEIL TNL-35

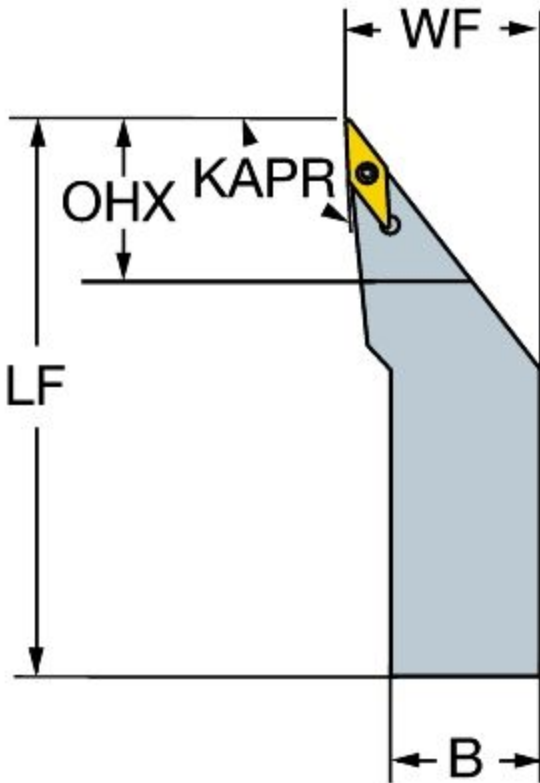
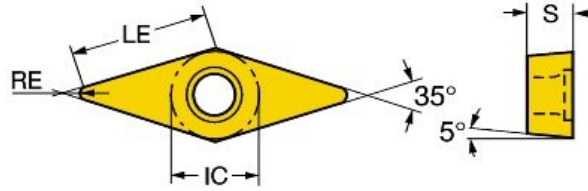
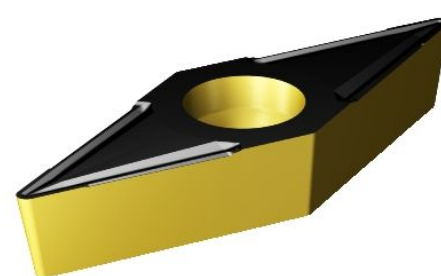


Herramienta 1 - Torneado en desbaste

Código Portaplaca		Código Placa	
PCLNR 2525M 12		CNMG 120408-QM4325	
			
KAPR	95°	IC	12.7
OHX	27.2	LE	12.096
B	25	RE	0.7938
LF	150	S	4.7625
WF	32		

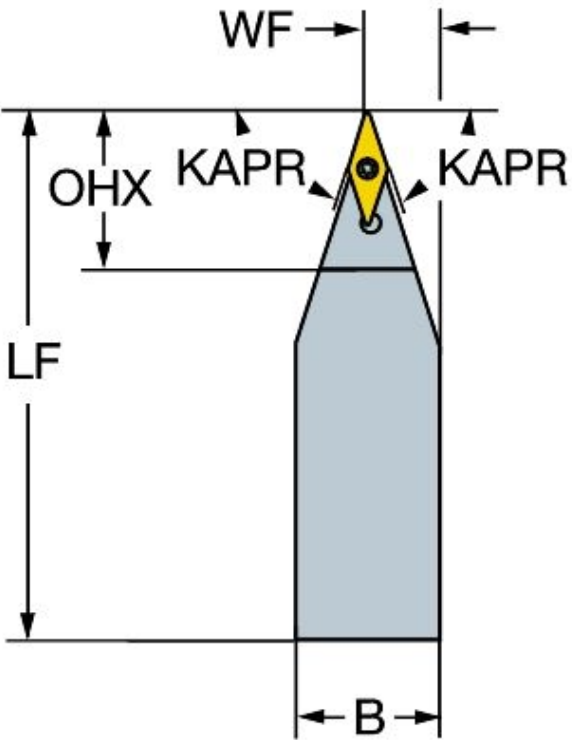
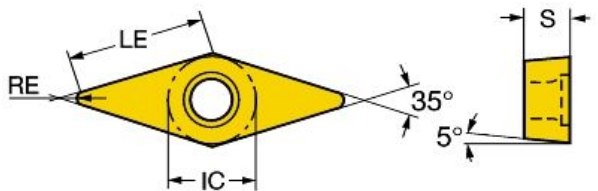
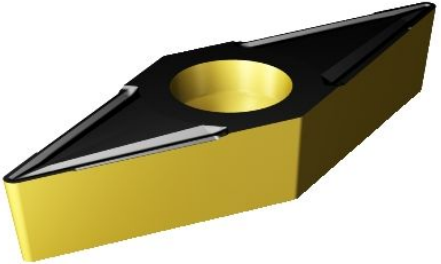
P	a_p	3mm (1 - 6)
	f_n	0.35 mm/r (0.2 - 0.5)
	v_c	325 m/min (275 - 395)
K	a_p	3mm (1 - 6)
	f_n	0.25 mm/r (0.2 - 0.45)
	v_c	190 m/min (145 - 210)

Herramienta 2 - Torneado Izquierdo

Código Portaplaca	SVJBR 2525M 16	Código Placa	VBMT 160404-UR 4325
		 	
KAPR	93°	IC	9.525
OHX	31.5	LE	16.206
B	25	RE	0.397
LF	150	S	4.7625
WF	32		

P	a_p	2mm (1 - 4)
	f_n	0.25 mm/r (0.15 - 0.3)
	V_c	365 m/min (345 - 425)
K	a_p	2mm (1 - 4)
	f_n	0.2 mm/r (0.15 - 0.3)
	V_c	210 m/min (175 - 230)

Herramienta 3 - Torneado Centrado

Código Portaplaca	SVVBN 2525M 16	Código Placa	VBMT 160404-UR 4325
		 	
KAPR	72.5°	IC	9.525
OHX	31.5	LE	16.206
B	25	RE	0.397
LF	150	S	4.7625
WF	13.1		

P	a_p	2mm (1 - 4)
	f_n	0.25 mm/r (0.15 - 0.3)
	v_c	365 m/min (345 - 425)
K	a_p	2mm (1 - 4)
	f_n	0.2 mm/r (0.15 - 0.3)
	v_c	210 m/min (175 - 230)

Herramienta 5 - Ranurado y Tronzado

Código Portaplaca		RF151.23-2525-30M1	Código Placa		N151.2-300-4E 1125
CDX		20	CW		3
OHX		41	LE		16.206
B		25	RE		0.3
LF		150	S		6.787
WF		26	AN		7°

P	f_{nx}	0.12 mm/r (0.05 - 0.24)	M	f_{nx}	0.12 mm/r (0.05 - 0.24)
	V_c	140 m/min (90 - 235)		V_c	125 m/min (80 - 215)
K	f_n	0.12 mm/r (0.05 - 0.24)	S	f_n	0.12 mm/r (0.55 - 0.24)
	V_c	95 m/min (65 - 155)		V_c	25 m/min (15 - 45)

Herramienta 6 - Torneado Derecho

Código Portaplaca	SVJBL 2525M 16	Código Placa	VBMT 160404-UR 4325
KAPR	93°	IC	9.525
OHX	31.5	LE	16.206
B	25	RE	0.397
LF	150	S	4.7625
WF	32		

P	a_p	2mm (1 - 4)
	f_n	0.25 mm/r (0.15 - 0.3)
	V_c	365 m/min (345 - 425)
K	a_p	2mm (1 - 4)
	f_n	0.2 mm/r (0.15 - 0.3)
	V_c	210 m/min (175 - 230)

Herramienta 7 - Roscado Exterior

Código Portaplaca	266RFA-2525-16	Código Placa	266RG-16VM01A001M 1125
HF	25	IC	9.525
OHX	22.2	HA	1.68
B	25	HB	0.14
LF	150	RE	0.13
WF	25.5	Tipo	Métrica (60°)

P	V_c	155 m/min (90 - 235)	M	V_c	140 m/min (80 - 215)
	K	V_c		125 m/min (65 - 155)	S