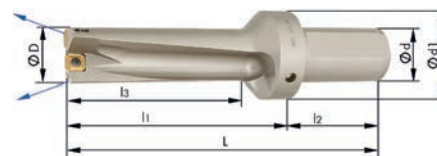


Datos de corte recomendados para plaquitas para brocas

Metal duro	Resistencia a la tracción	Velocidad de corte	Ø D mm	Ø D mm	Ø D mm	Ø D mm	Ø D mm
Clases	Rm N/mm²	Avance	15-18,5	19-22	22,5-27	28-34	35-40
P Acero	< 450	v _c m/min. f mm/rev.	250-300 0.05	250-300 0.06	250-300 0.07	250-300 0.08	250-300 0.09
	400- 700	v _c m/min. f mm/rev.	230-270 0.10	231-270 0.12	232-270 0.14	233-270 0.16	234-270 0.18
	550- 900	v _c m/min. f mm/rev.	180-230 0.11	180-230 0.15	180-230 0.18	180-230 0.20	180-230 0.22
	900-1200	v _c m/min. f mm/rev.	100-180 0.10	100-180 0.15	100-180 0.18	100-180 0.20	100-180 0.22
M Inoxidable		v _c m/min. f mm/rev.	120-200 0.07	120-200 0.09	120-200 0.11	120-200 0.12	120-200 0.13
K Fundición		v _c m/min. f mm/rev.	150-240 0.15	150-240 0.16	150-240 0.18	150-240 0.20	150-240 0.23
N Metales no férricos		v _c m/min. f mm/rev.	-	-	-	-	-
S Aleación Super		v _c m/min. f mm/rev.	80-120 0.07	80-120 0.09	80-120 0.10	80-120 0.11	80-120 0.12
H Duro		v _c m/min. f mm/rev.	-	-	-	-	-



Plaquitas de corte - Broca maciza con refrigeración interna 3 x D



Suministro sin plaquitas de corte.

Ø D mm	L mm	l ₁ mm	l ₂ mm	l ₃ mm	Ø d mm	Ø d ₁ mm	a _p max. 3 x D mm	Ajuste radial (desplazamiento de centro) - mm	Ajuste radial (desplazamiento de centro) + mm	Plaquita de corte	2999	Ref.
											€	
15	126	70	56	49	25	45	45	0.25	0.35	XPET/SCET 0502...	425,13	...5600
16	129	73	56	52.5	25	45	48	0.15	0.45	XPET/SCET 0502...	425,13	...5610
17	132	76	56	56	25	45	51	0.10	0.50	XPET/SCET 0502...	425,13	...5620
18	136.5	79	56	59	25	45	54	0.35	0.25	XPET 0602.../SCET 0502...	433,41	...5630
19	138	82	56	62.5	25	45	57	0.15	0.45	XPET 0602.../SECT 0502...	453,28	...5640
20	141	85	56	65	25	45	60	0.10	0.45	XPET/SCET 0602...	453,28	...5650
21	144	88	56	68.5	25	45	63	0.10	0.50	XPET/SCET 0602...	453,28	...5660
22	147	91	56	72	25	45	66	0.45	0.50	XPET 0703.../SCET 0602...	458,20	...5670
23	150	94	56	75.5	25	45	69	0.35	0.50	XPET/SCET 0703...	474,75	...5680
24	153	97	56	79	25	45	72	0.15	0.50	XPET/SCET 0703...	474,75	...5690
25	160	100	60	80	32	50	75	0.15	0.50	XPET/SCET 0703...	474,75	...5700
26	163	103	60	83.5	32	50	78	0.50	0.15	XPET/SCET 0703...	474,75	...5710
27	166	106	60	87	32	50	81	0.50	0.30	XPET 0903.../SCET 0703...	507,85	...5720
28	169	109	60	90.5	32	50	84	0.30	0.50	XPET 0903.../SCET 09T3...	544,21	...5725
29	172	112	60	94	32	50	87	0.20	0.50	XPET 0903.../SCET 09T3...	544,21	...5730
30	175	115	60	97.5	32	50	90	0.15	0.50	XPET 0903.../SCET 09T3...	544,21	...5735
31	178	118	60	101	32	50	93	0.15	0.50	XPET 0903.../SCET 09T3...	544,21	...5740
32	191	121	68	100.5	40	59	96	0.50	0.35	XPET 11T3.../SCET 09T3...	578,97	...5745
33	194	124	68	104	40	59	99	0.50	0.50	XPET 11T3.../SCET 09T3...	578,97	...5750
34	197	127	68	107.5	40	59	102	0.25	0.50	XPET 11T3.../SCET 09T3...	578,97	...5755
36	203	133	68	113.5	40	59	108	0.10	0.50	XPET 11T3.../SCET 1204...	600,45	...5765
37	206	136	68	117	40	59	111	0.10	0.50	XPET 11T3.../SCET 1204...	600,45	...5770
38	209	139	68	120.5	40	59	114	0.10	0.50	XPET 11T3.../SCET 1204...	600,45	...5775
39	212	142	68	124	40	59	117	0.40	0.50	XPET 12T3.../SCET 1204...	617,05	...5780

(W101)