



Recomendaciones de datos de corte para CoroTurn® XS

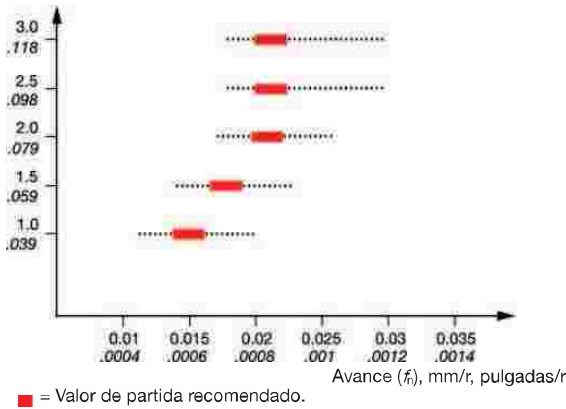
Plaquetas para tornear

Tamaño de plaqueta dm _m	Dimensiones, mm, pulgadas				Área de aplicación				Avance recomendado			
	b ₂₁ mm	b ₂₁ pulgadas	r mm	r pulga	Torneado general/Mandrinado a tracción		Profundidad recomendada		f _i mm/r		f _i pulgadas/	
					a _p mm	Min. - Máx.	a _p pulgada	Min. - Máx.	f _i mm/r	Min. - Máx.	f _i pulgadas/	Min. - Máx.
04	0.18	.007	-	-	0.05	(0.01 - 0.08)	.0020	(.0004 - .0031)	0.007	(0.050 - 0.015)	.00028	(.00020 - .00059)
04	0.28	.011	-	-	0.06	(0.01 - 0.10)	.0024	(.0004 - .0041)	0.010	(0.050 - 0.014)	.00039	(.00020 - .00059)
04	0.38	.015	-	-	0.08	(0.01 - 0.15)	.0031	(.0004 - .0059)	0.012	(0.008 - 0.017)	.00047	(.00032 - .00067)
04	0.46	.018	-	-	0.09	(0.01 - 0.20)	.0035	(.0004 - .0071)	0.015	(0.010 - 0.020)	.00059	(.00039 - .00079)
04	0.56	.022	-	-	0.12	(0.01 - 0.22)	.0047	(.0004 - .0087)	0.018	(0.010 - 0.025)	.00071	(.00039 - .00098)
04	0.63	.025	-	-	0.15	(0.01 - 0.25)	.0059	(.0004 - .0098)	0.020	(0.012 - 0.025)	.00079	(.00047 - .00098)
04	0.66	.026	0.05	.002	0.15	(0.05 - 0.30)	.0059	(.0020 - .0118)	0.020	(0.012 - 0.030)	.00079	(.00047 - .00118)
04	0.66	.026	0.10	.004	0.15	(0.09 - 0.30)	.0059	(.0039 - .0118)	0.020	(0.015 - 0.080)	.00079	(.00059 - .00315)
04	0.74	.029	-	-	0.15	(0.01 - 0.25)	.0059	(.0004 - .0098)	0.020	(0.012 - 0.025)	.00079	(.00047 - .00098)
04	1.04	.041	0.05	.002	0.18	(0.05 - 0.30)	.0071	(.0020 - .0118)	0.020	(0.012 - 0.030)	.00079	(.00047 - .00118)
04	1.04	.041	0.10	.004	0.18	(0.01 - 0.30)	.0071	(.0004 - .0118)	0.020	(0.015 - 0.080)	.00079	(.00059 - .00315)
04	1.55	.061	0.05	.002	0.20	(0.05 - 0.40)	.0079	(.0020 - .0158)	0.020	(0.012 - 0.030)	.00079	(.00047 - .00118)
04	1.55	.061	0.10	.004	0.20	(0.09 - 0.40)	.0079	(.0039 - .0158)	0.020	(0.015 - 0.080)	.00079	(.00059 - .00315)
04	2.06	.081	0.05	.002	0.25	(0.05 - 0.51)	.0098	(.0020 - .0200)	0.020	(0.012 - 0.030)	.00079	(.00047 - .00118)
04	2.06	.081	0.15	.006	0.25	(0.15 - 0.51)	.0098	(.0059 - .0200)	0.025	(0.015 - 0.050)	.00098	(.00059 - .00197)
04	2.54	.100	0.05	.002	0.30	(0.05 - 0.51)	.0118	(.0020 - .0200)	0.020	(0.015 - 0.030)	.00079	(.00059 - .00118)
04	2.06/2.59	.100/.102	0.15	.006	0.30	(0.15 - 0.51)	.0118	(.0059 - .0200)	0.025	(0.015 - 0.050)	.00098	(.00059 - .00197)
04	2.95	.116	0.15	.006	0.30	(0.15 - 0.51)	.0118	(.0059 - .0200)	0.025	(0.015 - 0.050)	.00098	(.00059 - .00197)
04	3.45	.136	0.05	.002	0.30	(0.05 - 0.51)	.0118	(.0020 - .0200)	0.020	(0.015 - 0.030)	.00079	(.00059 - .00118)
04	3.45	.136	0.15	.006	0.30	(0.15 - 0.51)	.0118	(.0059 - .0200)	0.025	(0.015 - 0.050)	.00098	(.00059 - .00197)
05	3.76	.148	0.15	.006	0.35	(0.15 - 0.60)	.0138	(.0059 - .0236)	0.040	(0.020 - 0.060)	.00157	(.00079 - .00236)
05	3.75/3.81	.148/.150	0.20	.008	0.35	(0.20 - 0.60)	.0138	(.0079 - .0236)	0.040	(0.020 - 0.060)	.00157	(.00079 - .00236)
05	4.19	.165	0.20	.008	0.35	(0.20 - 0.60)	.0138	(.0079 - .0236)	0.040	(0.020 - 0.070)	.00157	(.00079 - .00276)
05	4.24	.167	0.05	.002	0.25	(0.05 - 0.60)	.0098	(.0020 - .0236)	0.030	(0.020 - 0.040)	.00118	(.00079 - .00157)
05	4.24	.167	0.20	.008	0.35	(0.20 - 0.60)	.0138	(.0079 - .0236)	0.040	(0.020 - 0.070)	.00157	(.00079 - .00276)
06	3.96/3.99	.156/.157	0.15	.006	0.35	(0.15 - 0.60)	.0138	(.0059 - .0236)	0.045	(0.020 - 0.070)	.00177	(.00079 - .00276)
06	3.96	.156	0.20	.008	0.35	(0.20 - 0.60)	.0138	(.0079 - .0236)	0.045	(0.020 - 0.070)	.00177	(.00079 - .00276)
06	5.26	.207	0.20	.008	0.40	(0.20 - 0.70)	.0157	(.0079 - .0276)	0.045	(0.020 - 0.080)	.00177	(.00079 - .00315)
07	4.29	.169	0.20	.008	0.35	(0.20 - 0.60)	.0138	(.0079 - .0236)	0.040	(0.020 - 0.070)	.00157	(.00079 - .00276)
07	6.25	.246	0.20	.008	0.50	(0.20 - 0.80)	.0197	(.0079 - .0315)	0.050	(0.030 - 0.080)	.00197	(.00118 - .00315)

Cuando se utiliza la calidad CB7015 de CBN debe reducirse el avance y la profundidad de corte un 50%, respecto a las calidades de metal duro.

Ranurado y ranurado frontal

Anchura de plaqueta (A), mm, pulgadas



Recomendaciones de velocidad de corte

Velocidad de corte (v_c), m/min (p/min)

Calidad 1025	P	M	N	S
	60-200 (185-655)	60-180 (195-590)	90-400 (295-1310)	20-50 (65-165)

Calidad CB7015	H
	60-200 (200-600)

Roscado, (profundidades de pasada recomendadas)

Rosca	Paso mm	H.P.P.	a _p mm	a _p pulgada	nap
Métrica 60° (MM)	0.50		0.26	.0106	7
	0.70		0.38	.0150	8
	0.75		0.40	.0161	8
	0.80		0.43	.0169	8
	1.00		0.55	.0217	11
	1.25		0.68	.0268	11
	1.50		0.81	.0319	13
	1.75		0.95	.0374	14
UN 60°	2.00		1.08	.0425	18
		48	0.29	.0114	7
		36	0.38	.0150	8
		32	0.43	.0169	8
		28	0.49	.0193	9
		24	0.56	.0224	11
		20	0.69	.0272	11
		18	0.76	.0299	12
Whitworth 55° (WH)		16	0.86	.0339	13
		28	0.60	.0236	10
		26	0.65	.0256	11
		24	0.68	.0268	11
		22	0.74	.0291	12
NPT 60° (NT)		20	0.82	.0323	14
		19	0.87	.0343	14
		27	0.71	.0280	12
ISO Trapezoidal 30°		18	1.06	.0417	18
	1.50		0.86	.0340	6
	2.00		1.17	.0460	8
	3.00		1.70	.0670	12

a_p = profundidad total de la rosca
nap = número de pasadas





A

TORNEADO GENERAL Datos de corte

Profundidad de corte y avance recomendadas, métrica

Plaquitas negativas T-MAX P

TURN - SPA

B

Plaquita	Profundidad recomendada $a_p = \text{mm}$			Avance recomendado $f_r = \text{mm/r}$		
	Min	Máx.		Min	Máx.	
CNMG090304-WF	0.5	0.3	1.5	0.15	0.05	0.25
CNMG090308-WF	1	0.3	2	0.3	0.1	0.5
CNMG120404-WF	0.4	0.25	3	0.15	0.05	0.25
CNMG120408-WF	1	0.25	4	0.3	0.1	0.5
CNMG120412-WF	1.5	0.4	4	0.5	0.2	0.6
DNMX110404-WF	1	0.2	1.5	0.2	0.08	0.3
DNMX110408-WF	1	0.2	3	0.3	0.1	0.4
DNMX150404-WF	0.8	0.2	3	0.2	0.08	0.3
DNMX150408-WF	1.5	0.2	3	0.3	0.1	0.4
DNMX150412-WF	1.5	0.4	3.5	0.4	0.15	0.55
DNMX150604-WF	0.8	0.2	3	0.2	0.08	0.3
DNMX150608-WF	1.5	0.2	3	0.3	0.1	0.4
DNMX150612-WF	1.5	0.4	3.5	0.4	0.15	0.55
TNMX160404-WF	1	0.2	3	0.2	0.08	0.3
TNMX160408-WF	1.5	0.2	3	0.3	0.1	0.4
WNMG060404-WF	0.4	0.25	2	0.15	0.05	0.25
WNMG060408-WF	1	0.25	3	0.3	0.1	0.5
WNMG080404-WF	0.4	0.25	3	0.15	0.05	0.25
WNMG080408-WF	1	0.25	4	0.3	0.1	0.5
WNMG080412-WF	1.5	0.4	4	0.5	0.2	0.6
CNMG090304-PF	0.4	0.25	1.5	0.15	0.07	0.3
CNMG090308-PF	0.4	0.3	1.5	0.15	0.1	0.3
CNMG120404-PF	0.4	0.25	1.5	0.15	0.07	0.3
CNMG120408-PF	0.4	0.3	1.5	0.2	0.1	0.4
CNMG120412-PF	0.8	0.35	1.5	0.25	0.15	0.5
DNMG110404-PF	0.4	0.25	1.5	0.15	0.07	0.3
DNMG110408-PF	0.4	0.3	1.5	0.2	0.1	0.4
DNMG110412-PF	0.8	0.35	1.5	0.25	0.15	0.5
DNMG150404-PF	0.4	0.25	1.5	0.15	0.07	0.3
DNMG150408-PF	0.4	0.3	1.5	0.2	0.1	0.4
DNMG150412-PF	0.8	0.35	1.5	0.25	0.15	0.5
DNMG150604-PF	0.4	0.25	1.5	0.15	0.07	0.3
DNMG150608-PF	0.4	0.3	1.5	0.2	0.1	0.4
DNMG150612-PF	0.8	0.35	1.5	0.25	0.15	0.5
SNMG120408-PF	0.4	0.3	1.5	0.2	0.1	0.4
SNMG120412-PF	0.8	0.35	1.5	0.25	0.15	0.5
TNMG160404-PF	0.4	0.25	1.5	0.15	0.07	0.3
TNMG160408-PF	0.4	0.3	1.5	0.2	0.1	0.4
TNMG160412-PF	0.8	0.35	1.5	0.25	0.15	0.5

C

Plaquita	Profundidad recomendada $a_p = \text{mm}$			Avance recomendado $f_r = \text{mm/r}$		
	Min	Máx.		Min	Máx.	
CNMG120412-KF	1	0.2	2.5	0.25	0.1	0.35
DNMG110404-KF	0.5	0.15	2	0.15	0.08	0.25
DNMG110408-KF	0.5	0.15	2	0.2	0.1	0.3
DNMG150404-KF	0.5	0.15	2	0.15	0.08	0.25
DNMG150408-KF	0.5	0.15	2	0.2	0.1	0.3
DNMG150604-KF	0.5	0.15	2	0.15	0.08	0.25
DNMG150608-KF	0.5	0.15	2	0.2	0.1	0.3
DNMG150612-KF	1	0.2	2.5	0.25	0.1	0.35
TNMG160404-KF	0.5	0.15	2	0.15	0.08	0.25
TNMG160408-KF	0.5	0.15	2	0.2	0.1	0.3
WNMG060404-KF	0.5	0.15	2	0.15	0.08	0.25
WNMG060408-KF	0.5	0.15	2	0.2	0.1	0.3
WNMG080404-KF	0.5	0.15	2	0.15	0.08	0.25
WNMG080408-KF	0.5	0.15	2	0.2	0.1	0.3
WNMG080412-KF	1	0.2	2.5	0.25	0.1	0.35
CNMG120408-WMX	3	0.5	5	0.45	0.15	0.7
CNMG120412-WMX	3.5	0.8	6	0.5	0.2	0.75
CNMG160608-WMX	3	0.5	5	0.45	0.15	0.7
CNMG160612-WMX	3.5	0.8	6	0.5	0.2	0.75
DNMX150408-WMX	3	0.5	5	0.45	0.15	0.7
DNMX150412-WMX	3.5	0.8	6	0.5	0.2	0.75
DNMX150416-WMX	3.5	0.5	6	0.5	0.2	0.8
DNMX150608-WMX	3	0.5	5	0.45	0.15	0.7
DNMX150612-WMX	3.5	0.8	6	0.5	0.2	0.75
DNMX150616-WMX	3.5	0.5	6	0.5	0.2	0.8
TNMX160408-WMX	3	0.5	5	0.45	0.15	0.7
TNMX160412-WMX	3.5	0.8	6	0.5	0.2	0.75
WNMG060408-WMX	3	0.5	5	0.45	0.15	0.7
WNMG060412-WMX	3.5	0.8	6	0.5	0.2	0.75
WNMG080408-WMX	3	0.5	5	0.45	0.15	0.7
WNMG080412-WMX	3.5	0.8	6	0.5	0.2	0.75
CNMG120408-WM	3	0.5	5	0.3	0.15	0.6
CNMG120412-WM	3.5	0.8	6	0.5	0.2	0.9
CNMG160608-WM	3.5	0.7	6.5	0.4	0.2	0.7
CNMG160612-WM	3.5	0.7	6.5	0.4	0.2	0.7
DNMX110408-WM	1.5	0.5	3.5	0.35	0.15	0.5
DNMX110412-WM	2	0.5	4	0.45	0.15	0.6
DNMX150408-WM	2	0.5	4.5	0.35	0.15	0.5
DNMX150412-WM	2.5	0.5	5	0.45	0.15	0.6
DNMX150416-WM	3.5	0.5	6	0.6	0.2	0.8
DNMX150608-WM	2	0.5	4.5	0.35	0.15	0.5
DNMX150612-WM	2.5	0.5	5	0.45	0.15	0.6
DNMX150616-WM	3.5	0.5	6	0.6	0.2	0.8
TNMX160408-WM	2	0.5	4.5	0.35	0.15	0.5
TNMX160412-WM	2.5	0.5	5	0.4	0.15	0.6
WNMG060408-WM	1.5	0.5	3.5	0.3	0.15	0.6
WNMG060412-WM	1.5	0.8	3.5	0.5	0.2	0.9
WNMG080408-WM	3	0.5	5	0.3	0.15	0.6
WNMG080412-WM	3.5	0.8	6	0.5	0.2	0.9
CNMG090304-PM	2	0.4	4	0.2	0.1	0.3
CNMG090308-PM	2	0.5	4	0.3	0.15	0.5
CNMG120404-PM	3	0.4	5.5	0.2	0.1	0.3
CNMG120408-PM	3	0.5	5.5	0.3	0.15	0.5
CNMG120412-PM	3	0.8	5.5	0.35	0.18	0.6
CNMG120416-PM	3	1	5.5	0.4	0.23	0.65
CNMG160608-PM	4	0.5	7.2	0.3	0.15	0.5
CNMG160612-PM	4	0.8	7.2	0.35	0.18	0.6
CNMG160616-PM	4	1	7.2	0.4	0.23	0.65
CNMG190608-PM	4	0.5	8.6	0.3	0.15	0.5
CNMG190612-PM	4	0.8	8.6	0.35	0.18	0.6
CNMG190616-PM	4	1	8.6	0.4	0.23	0.65
DNMG110404-PM	2	0.4	5	0.2	0.1	0.3
DNMG110408-PM	2	0.5	5	0.3	0.15	0.5
DNMG110412-PM	2	0.8	5	0.35	0.18	0.5
DNMG150404-PM	3	0.4	6	0.2	0.1	0.3
DNMG150408-PM	3	0.5	6	0.3	0.15	0.5
DNMG150412-PM	3	0.8	6	0.35	0.18	0.6
DNMG150604-PM	3	0.4	6	0.2	0.1	0.3
DNMG150608-PM	3	0.5	6	0.3	0.15	0.5
DNMG150612-PM	3	0.8	6	0.35	0.18	0.6
DNMG150616-PM	3	1	6	0.4	0.23	0.65
SNMG090304-PM	2	0.4	4.5	0.2	0.1	0.3
SNMG090308-PM	2	0.5	4.5	0.3	0.15	0.5

G

H

I

J

A 500





TURN - SPA

Datos de corte TORNEADO GENERAL

Profundidad de corte y avance recomendadas, métrica

Plaquitas negativas T-MAX P

Plaquita	Profundidad recomendada $a_p = \text{mm}$		Avance recomendado $f_s = \text{mm/r}$			
	Min	Máx.	Min	Máx.		
SNMG120404-PM	3	0.4	6	0.2	0.1	0.3
SNMG120408-PM	3	0.5	6	0.3	0.15	0.5
SNMG120412-PM	3	0.8	6	0.35	0.18	0.6
SNMG120416-PM	3	1	6	0.4	0.23	0.65
SNMG150612-PM	4	0.8	7.5	0.35	0.18	0.6
SNMG150616-PM	4	1	7.5	0.4	0.23	0.65
TNMG160404-PM	3	0.4	5	0.2	0.1	0.3
TNMG160408-PM	3	0.5	5	0.3	0.15	0.5
TNMG160412-PM	3	0.8	5	0.35	0.18	0.6
TNMG220404-PM	4	0.4	6.6	0.2	0.1	0.3
TNMG220408-PM	4	0.5	6.6	0.3	0.15	0.5
TNMG220412-PM	4	0.8	6.6	0.35	0.18	0.6
TNMG220416-PM	4	1	6.6	0.4	0.23	0.65
VNMG160408-PM	2	0.5	4	0.3	0.15	0.5
VNMG160412-PM	2	0.8	4	0.35	0.18	0.6
WNMG060408-PM	2	0.5	3	0.3	0.15	0.5
WNMG060412-PM	2	0.8	3	0.35	0.18	0.6
WNMG080408-PM	2.5	0.5	4	0.3	0.15	0.5
WNMG080412-PM	2.5	0.8	4	0.35	0.18	0.6
WNMG080416-PM	3	1	4	0.4	0.23	0.65
CNMG120408-MM	3	0.5	5.7	0.25	0.1	0.45
CNMG120412-MM	3	0.5	5.7	0.3	0.1	0.6
CNMG120416-MM	3	0.5	5.7	0.37	0.1	0.65
CNMG160608-MM	4	0.5	7.2	0.25	0.1	0.45
CNMG160612-MM	4	0.5	7.2	0.3	0.1	0.6
CNMG160616-MM	4	0.5	7.2	0.37	0.1	0.65
CNMG190608-MM	4	0.5	8.5	0.25	0.1	0.45
CNMG190612-MM	4	0.5	8.5	0.3	0.1	0.6
CNMG190616-MM	4	0.5	8.5	0.37	0.1	0.65
DNMG110408-MM	2	0.5	4.4	0.25	0.1	0.45
DNMG110412-MM	2	0.5	4.4	0.3	0.1	0.6
DNMG150408-MM	3	0.5	6.4	0.25	0.1	0.45
DNMG150412-MM	3	0.5	6.4	0.3	0.1	0.6
DNMG150608-MM	3	0.5	6.4	0.25	0.1	0.45
DNMG150612-MM	3	0.5	6.4	0.3	0.1	0.6
SNMG120408-MM	3	0.5	6.35	0.25	0.1	0.45
SNMG120412-MM	3	0.5	6.35	0.3	0.1	0.6
SNMG120416-MM	3	0.5	6.35	0.37	0.1	0.65
SNMG150612-MM	4	0.5	8	0.3	0.1	0.6
SNMG150616-MM	4	0.5	8	0.37	0.1	0.65
SNMG190612-MM	4	0.5	9.5	0.3	0.1	0.6
SNMG190616-MM	4	0.5	9.5	0.37	0.1	0.65
TNMG160408-MM	3	0.5	4.8	0.25	0.1	0.45
TNMG160412-MM	3	0.5	4.8	0.3	0.1	0.6
TNMG220408-MM	4	0.5	6.6	0.25	0.1	0.45
TNMG220412-MM	4	0.5	6.6	0.3	0.1	0.6
TNMG220416-MM	4	0.5	6.6	0.37	0.1	0.65
VNMG160408-MM	2	0.5	4	0.25	0.1	0.45
VNMG060408-MM	2	0.5	3	0.25	0.1	0.45
WNMG060412-MM	2	0.5	3	0.3	0.1	0.6
WNMG080408-MM	2.5	0.5	4	0.25	0.1	0.45
WNMG080412-MM	2.5	0.5	4	0.3	0.1	0.6
CNMG120408-KM	3	0.2	6	0.35	0.15	0.5
CNMG120412-KM	3	0.3	6	0.4	0.15	0.6
CNMG120416-KM	3	0.3	6	0.45	0.2	0.7
CNMG160608-KM	4	0.2	8	0.35	0.15	0.5
CNMG160612-KM	4	0.3	8	0.4	0.15	0.6
CNMG160616-KM	4	0.3	8	0.45	0.2	0.7
CNMG190612-KM	4.5	0.3	9	0.4	0.15	0.6
CNMG190616-KM	4.5	0.3	9	0.45	0.2	0.7
DNMG110408-KM	2	0.2	3.5	0.35	0.15	0.5
DNMG110412-KM	2	0.3	3.5	0.4	0.15	0.6
DNMG150408-KM	2.5	0.2	5	0.35	0.15	0.5
DNMG150412-KM	2.5	0.3	5	0.4	0.15	0.6
DNMG150608-KM	2.5	0.2	5	0.35	0.15	0.5
DNMG150612-KM	2.5	0.3	5	0.4	0.15	0.6
SNMG090308-KM	2.5	0.2	4.5	0.35	0.15	0.5
SNMG120408-KM	3	0.2	6	0.35	0.15	0.5
SNMG120412-KM	3	0.3	6	0.4	0.15	0.6
SNMG120416-KM	3	0.3	6	0.45	0.2	0.7
SNMG150612-KM	4	0.3	8	0.4	0.15	0.6
SNMG150616-KM	4	0.3	8	0.45	0.2	0.7
SNMG190612-KM	4.5	0.3	9	0.4	0.15	0.6

Plaquita	Profundidad recomendada $a_p = \text{mm}$		Avance recomendado $f_s = \text{mm/r}$			
	Min	Máx.	Min	Máx.		
SNMG190616-KM	4.5	0.3	9	0.45	0.2	0.7
TNMG160408-KM	3	0.2	5.5	0.35	0.15	0.5
TNMG160412-KM	3	0.3	5.5	0.4	0.15	0.6
TNMG220408-KM	4	0.2	8	0.35	0.15	0.5
TNMG220412-KM	4	0.3	8	0.4	0.15	0.6
TNMG220416-KM	4	0.3	8	0.45	0.2	0.7
VNMG160408-KM	2	0.2	3.5	0.3	0.15	0.4
VNMG160412-KM	2	0.3	3.5	0.35	0.15	0.5
WNMG060408-KM	2	0.2	4	0.35	0.15	0.5
WNMG060412-KM	2	0.3	4	0.4	0.15	0.6
WNMG080408-KM	2.5	0.2	5	0.35	0.15	0.5
WNMG080412-KM	2.5	0.3	5	0.4	0.15	0.6
WNMG160612-HM	4	1	8	0.5	0.25	0.8
CNMG160616-HM	4	1.5	8	0.6	0.3	0.9
CNMG190612-HM	4	1	10	0.5	0.25	0.8
CNMG190616-HM	4	1.5	10	0.6	0.3	0.9
CNMG190624-HM	5	2	10	0.6	0.3	1.2
SNMG150612-HM	4	1	8	0.5	0.25	0.8
SNMG150616-HM	4	1.5	8	0.6	0.3	0.9
SNMG190612-HM	4	1	10	0.5	0.25	0.8
SNMG190616-HM	4	1.5	10	0.6	0.3	0.9
SNMG190624-HM	5	2	10	0.6	0.3	1.2
SNMG250924-HM	6	2	15	0.8	0.4	1.2
TNMG270612-HM	6	2	12	0.6	0.35	0.75
TNMG270616-HM	6	2	12	0.6	0.35	0.75
TNMG330924-HM	7	3	15	0.6	0.45	0.9
CNMM120408-WR	2.5	0.8	5	0.6	0.3	0.8
CNMM120412-WR	2.5	1	5	0.8	0.4	1.1
CNMM120416-WR	2.5	1.2	5	0.8	0.44	1.2
CNMM160612-WR	3	1.2	6	0.8	0.42	1.2
CNMM160616-WR	3	1.4	6	0.9	0.46	1.3
CNMM190616-WR	3.3	1.6	6.7	1	0.48	1.3
TNMM220412-WR	2.5	1	5	0.8	0.4	1.1
TNMM220416-WR	2.5	1.2	5	0.9	0.44	1.2
CNMM120408-PR	5	0.7	7.5	0.4	0.2	0.55
CNMM120412-PR	5	1	7.5	0.5	0.25	0.7
CNMM120416-PR	5	1.5	7.5	0.55	0.32	0.9
CNMM160608-PR	6	0.7	9.5	0.4	0.2	0.55
CNMM160612-PR	6	1	9.5	0.5	0.25	0.7
CNMM160616-PR	6	1.5	9.5	0.55	0.32	0.9
CNMM190612-PR	6	1	12	0.5	0.25	0.7
CNMM190616-PR	6	1.5	12	0.55	0.32	0.9
CNMM190624-PR	6	2	12	0.55	0.35	1.2
DNMM150608-PR	5	0.7	6	0.4	0.2	0.55
DNMM150612-PR	5	1	6	0.5	0.25	0.7
DNMM150616-PR	5	1.5	6	0.55	0.32	0.9
SNMM120408-PR	5	0.7	7.5	0.4	0.2	0.55
SNMM120412-PR	5	1	7.5	0.5	0.25	0.7
SNMM150612-PR	6	1	9	0.5	0.25	0.7
SNMM150616-PR	6	1.5	9	0.55	0.32	0.9
SNMM190612-PR	6	1	12	0.5	0.25	0.7
SNMM190616-PR	6	1.5	12	0.55	0.32	0.9
SNMM190624-PR	6	2	12	0.55	0.35	1.2
TNMM160408-PR	4	0.7	6	0.4	0.2	0.55
TNMM160412-PR	4	1	6	0.5	0.25	0.7
TNMM220408-PR	5	0.7	8	0.4	0.2	0.55
TNMM220412-PR	5	1	8	0.5	0.25	0.7
TNMM220416-PR	5	1.5	8	0.55	0.32	0.9
CNMG120408-PR	4	0.7	7	0.35	0.2	0.5
CNMG120412-PR	4	1	7	0.4	0.25	0.7
CNMG120416-PR	4	1.5	7	0.5	0.32	0.75
CNMG160608-PR	5	0.7	8	0.35	0.2	0.5
CNMG160612-PR	5	1	8	0.4	0.25	0.7
CNMG160616-PR	5	1.5	8	0.5	0.3	0.8
CNMG160624-PR	5	2	8	0.5	0.32	0.9
CNMG190608-PR	5	0.7	10	0.35	0.2	0.5
CNMG190612-PR	5	1	10	0.4	0.25	0.7
CNMG190616-PR	5	1.5	10	0.5	0.3	0.8
CNMG190624-PR	5	2	10	0.5	0.32	0.9
CNMG250924-PR	6	2	15	0.6	0.4	1
DNMG150408-PR	4	0.7	6	0.35	0.2	0.5
DNMG150412-PR	4	1	6	0.4	0.25	0.7
DNMG150416-PR	4	1.5	6	0.5	0.3	0.75





A

TORNEADO GENERAL Datos de corte

Profundidad de corte y avance recomendadas, métrica

Plaquetas negativas T-MAX P

TURB - SPA

B

Plaqueta	Profundidad recomendada $a_p = \text{mm}$		Avance recomendado $f_c = \text{mm/r}$			
	Min	Máx.	Min	Máx.		
DNMG150608-PR	4	0.7	6	0.35	0.2	0.5
DNMG150612-PR	4	1	6	0.4	0.25	0.7
DNMG150616-PR	4	1.5	6	0.5	0.32	0.75
SNMG120408-PR	4	0.7	7	0.35	0.2	0.5
SNMG120412-PR	4	1	7	0.4	0.25	0.7
SNMG120416-PR	4	1.5	7	0.5	0.32	0.75
SNMG150608-PR	5	1.5	8	0.35	0.2	0.5
SNMG150612-PR	5	1	8	0.4	0.25	0.7
SNMG150616-PR	5	1.5	8	0.5	0.3	0.8
SNMG150624-PR	5	2	8	0.5	0.32	0.9
SNMG190608-PR	5	0.7	10	0.35	0.2	0.5
SNMG190612-PR	5	1	10	0.4	0.25	0.7
SNMG190616-PR	5	1.5	10	0.5	0.3	0.8
SNMG190624-PR	5	2	10	0.5	0.32	0.9
SNMG250716-PR	6	2	15	0.8	0.4	1
SNMG250724-PR	6	2	15	1	0.4	1.2
SNMG250924-PR	6	2	15	1	0.4	1.2
TNMG160408-PR	3	0.7	6	0.35	0.2	0.55
TNMG160412-PR	3	1	6	0.4	0.25	0.65
TNMG220408-PR	4	0.7	7	0.35	0.2	0.55
TNMG220412-PR	4	1	7	0.4	0.25	0.65
TNMG220416-PR	4	1.5	7	0.5	0.32	0.75
TNMG270608-PR	6	1.5	12	0.5	0.35	0.55
TNMG270612-PR	6	2	12	0.6	0.35	0.75
TNMG270616-PR	6	2	12	0.6	0.35	0.7
TNMG330716-PR	3	1.5	8	0.6	0.4	0.75
TNMG330924-PR	7	3	15	0.6	0.45	0.9
WNMG060408-PR	3	0.7	3.5	0.3	0.2	0.45
WNMG060412-PR	3	0.8	3.5	0.35	0.25	0.55
WNMG080408-PR	4	0.7	5	0.35	0.2	0.55
WNMG080412-PR	4	1	5	0.4	0.25	0.7
WNMG080416-PR	4	1.5	5	0.5	0.32	0.75
CNMG120408-MR	3	2	7.6	0.3	0.15	0.55
CNMG120412-MR	3	2	7.6	0.35	0.15	0.6
CNMG120416-MR	3	2	7.6	0.4	0.15	0.7
CNMG160612-MR	4	2	10	0.35	0.15	0.6
CNMG160616-MR	4	2	10	0.4	0.15	0.7
CNMG190612-MR	4	2	11.4	0.35	0.15	0.6
CNMG190616-MR	4	2	11.4	0.4	0.15	0.7
CNMG190624-MR	4	2	11.4	0.5	0.15	1
DNMG150408-MR	3	2	6	0.3	0.15	0.55
DNMG150412-MR	3	2	6	0.35	0.15	0.6
DNMG150416-MR	3	2	6	0.4	0.15	0.7
DNMG150608-MR	3	2	6	0.3	0.15	0.55
DNMG150612-MR	3	2	6	0.35	0.15	0.6
DNMG150616-MR	3	2	6	0.4	0.15	0.7
SNMG120408-MR	3	2	7.6	0.3	0.15	0.55
SNMG120412-MR	3	2	7.6	0.35	0.15	0.6
SNMG150612-MR	4	2	9.6	0.35	0.15	0.6
SNMG150616-MR	4	2	9.6	0.4	0.15	0.7
SNMG190612-MR	4	2	11.4	0.35	0.15	0.6
SNMG190616-MR	4	2	11.4	0.4	0.15	0.7
SNMG190624-MR	4	2	11.4	0.5	0.15	1
TNMG160408-MR	3	2	5.6	0.3	0.15	0.55
TNMG160412-MR	3	2	5.6	0.35	0.15	0.6
TNMG220408-MR	4	2	7.7	0.3	0.15	0.55
TNMG220412-MR	4	2	7.7	0.35	0.15	0.6
TNMG220416-MR	4	2	7.7	0.4	0.15	0.7
WNMG060408-MR	2	1.5	3	0.3	0.15	0.55
WNMG060412-MR	2	1.5	3	0.35	0.15	0.6
WNMG080408-MR	2.5	2	4	0.3	0.15	0.55
WNMG080412-MR	2.5	2	4	0.35	0.15	0.6
CNMM120408-MR	3	0.7	7.5	0.35	0.2	0.55
CNMM120412-MR	3	1	7.5	0.4	0.25	0.7
CNMM120416-MR	3	1.5	7.5	0.5	0.32	0.9
CNMM160612-MR	6	1.2	9.5	0.45	0.32	0.65
CNMM160616-MR	6	1.5	9.5	0.5	0.35	0.8
CNMM190612-MR	7	1.5	12	0.5	0.32	0.7
CNMM190616-MR	7	1.8	12	0.55	0.35	0.9
CNMM190624-MR	7	2.5	12	0.6	0.4	1.2
CNMM250924-MR	9	2.5	15	0.65	0.45	1.4
CNMM250932-MR	9	3.5	15	0.65	0.45	1.4
DNMM150608-MR	3	0.7	6	0.35	0.2	0.55

Plaqueta	Profundidad recomendada $a_p = \text{mm}$		Avance recomendado $f_c = \text{mm/r}$			
	Min	Máx.	Min	Máx.		
DNMM150612-MR	3	1	6	0.4	0.25	0.7
SNMM120408-MR	3	0.7	7.5	0.35	0.2	0.55
SNMM120412-MR	3	1	7.5	0.4	0.25	0.7
SNMM120416-MR	3	1.5	7.5	0.5	0.32	0.9
SNMM150612-MR	4	1	9	0.4	0.25	0.7
SNMM150616-MR	4	1.5	9	0.5	0.32	0.9
SNMM190612-MR	7	1.5	12	0.5	0.32	0.7
SNMM190616-MR	7	1.8	12	0.55	0.35	0.9
SNMM190624-MR	7	2.5	12	0.6	0.4	1.2
SNMM190632-MR	4	3.5	12	0.5	0.4	1.2
SNMM250724-MR	9	2.8	18	0.7	0.45	1.4
SNMM250732-MR	6	2	15	0.5	0.32	1.4
SNMM250924-MR	9	2.8	18	0.7	0.45	1.4
TNMM160408-MR	3	0.7	7.5	0.35	0.2	0.55
TNMM220408-MR	3	0.7	8	0.35	0.2	0.55
TNMM220412-MR	3	1	8	0.4	0.25	0.7
TNMM220416-MR	3	1.5	8	0.5	0.32	0.9
TNMM270616-MR	4	1.5	9	0.5	0.32	0.9
TNMM270624-MR	4	2	9	0.5	0.35	1
CNMA120404-KR	2.5	0.2	5	0.2	0.1	0.3
CNMA120408-KR	4	0.2	8	0.35	0.15	0.6
CNMA120412-KR	4	0.3	8	0.45	0.2	0.8
CNMA120416-KR	4	0.3	8	0.55	0.2	1
CNMA160612-KR	5	0.3	10	0.45	0.2	0.8
CNMA160616-KR	5	0.3	10	0.55	0.2	1
CNMA190608-KR	6	0.2	12	0.35	0.15	0.6
CNMA190612-KR	6	0.3	12	0.45	0.2	0.8
CNMA190616-KR	6	0.3	12	0.55	0.2	1
CNMA190624-KR	6	0.4	12	0.6	0.2	1.4
DNMA150408-KR	3	0.2	6	0.35	0.15	0.6
DNMA150412-KR	3	0.3	6	0.45	0.2	0.8
DNMA150608-KR	3	0.2	6	0.35	0.15	0.6
DNMA150612-KR	3	0.3	6	0.45	0.2	0.8
DNMA150616-KR	3	0.3	6	0.55	0.2	1
SNMA120408-KR	4	0.2	8	0.35	0.15	0.6
SNMA120412-KR	4	0.3	8	0.45	0.2	0.8
SNMA120416-KR	4	0.3	8	0.55	0.2	1
SNMA150612-KR	5	0.3	10	0.45	0.2	0.8
SNMA150616-KR	5	0.3	10	0.55	0.2	1
SNMA190608-KR	6	0.2	12	0.35	0.15	0.6
SNMA190612-KR	6	0.3	12	0.45	0.2	0.8
SNMA190616-KR	6	0.3	12	0.55	0.2	1
SNMA250724-KR	6	0.4	12	0.6	0.2	1.4
TNMA160404-KR	2.5	0.2	5	0.2	0.1	0.3
TNMA160408-KR	3.5	0.2	7	0.35	0.15	0.6
TNMA160412-KR	3.5	0.3	7	0.45	0.2	0.8
TNMA160416-KR	3.5	0.3	7	0.55	0.2	1
TNMA220404-KR	2.5	0.2	10	0.2	0.1	0.3
TNMA220408-KR	5	0.2	10	0.35	0.15	0.6
TNMA220412-KR	5	0.3	10	0.45	0.2	0.8
TNMA220416-KR	5	0.3	10	0.55	0.2	1
TNMA220432-KR	5	0.5	10	0.6	0.5	1.2
TNMA270616-KR	5	0.3	12	0.5	0.2	1
WNMA060408-KR	2.5	0.2	4	0.35	0.15	0.6
WNMA060412-KR	2.5	0.3	4	0.45	0.2	0.8
WNMA080408-KR	3	0.2	5	0.35	0.15	0.6
WNMA080412-KR	3	0.3	5	0.45	0.2	0.8
WNMA080416-KR	3	0.3	5	0.55	0.2	1
CNMG120408-KR	3.5	0.38	7	0.38	0.19	0.53
CNMG120412-KR	3.5	0.5	7	0.5	0.25	0.7
CNMG120416-KR	3.5	0.75	7	0.61	0.28	0.85
CNMG160612-KR	4.7	0.8	9.3	0.55	0.28	0.77
CNMG160616-KR	4.7	1	9.3	0.61	0.3	0.85
CNMG190612-KR	7	1	14	0.55	0.28	0.77
CNMG190616-KR	7	1.5	14	0.61	0.3	0.85
CNMG120408-KRR	4	0.2	8	0.35	0.15	0.6
CNMG120412-KRR	4	0.3	8	0.45	0.2	0.8
CNMG120416-KRR	4	0.3	8	0.55	0.2	1
CNMG160612-KRR	5	0.3	10	0.45	0.2	0.8
CNMG160616-KRR	5	0.3	10	0.55	0.2	1
DNMG150408-KR	3.5	0.38	7	0.34	0.17	0.47
DNMG150412-KR	3.5	0.5	7	0.45	0.23	0.63
DNMG150608-KR	3.5	0.38	7	0.34	0.17	0.47

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A

TORNEADO GENERAL Datos de corte

Profundidad de corte y avance recomendadas, métrica

CoroTurn® 107, plaquitas de forma básica positiva

TURB - SPA

B

Plaquita	Profundidad recomendada a_p = mm			Avance recomendado f_r = mm/r			Plaquita	Profundidad recomendada a_p = mm			Avance recomendado f_r = mm/r		
	Min	Máx.		Min	Máx.			Min	Máx.		Min	Máx.	
CCMT060202-WF	0.3	0.1	1.5	0.1	0.03	0.15	VBMT110304-MF	0.3	0.1	1.7	0.1	0.05	0.19
CCMT060204-WF	0.8	0.3	2	0.12	0.05	0.3	VBMT110308-MF	0.3	0.13	1.7	0.13	0.07	0.26
CCMT060208-WF	0.8	0.3	2	0.15	0.09	0.35	VBMT160402-MF	0.32	0.07	1.8	0.07	0.04	0.14
CCMT09T302-WF	0.3	0.1	1.5	0.1	0.03	0.15	VBMT160404-MF	0.32	0.1	1.8	0.1	0.05	0.2
CCMT09T304-WF	1	0.3	3	0.2	0.07	0.3	VBMT160408-MF	0.32	0.14	1.8	0.14	0.07	0.27
CCMT09T308-WF	1	0.3	3	0.25	0.12	0.5	VBMT160412-MF	0.32	0.14	1.8	0.16	0.09	0.32
DCMX070202-WF	0.3	0.1	1.5	0.1	0.03	0.15	CCMT060202-KF	0.3	0.06	1.7	0.06	0.03	0.11
DCMX070204-WF	0.7	0.3	2	0.12	0.05	0.25	CCMT060204-KF	0.3	0.1	1.7	0.08	0.05	0.17
DCMX070208-WF	0.7	0.3	2	0.15	0.09	0.35	CCMT09T302-KF	0.35	0.08	2	0.08	0.04	0.15
DCMX11T302-WF	0.3	0.1	1.5	0.1	0.03	0.15	CCMT09T304-KF	0.35	0.11	2	0.11	0.06	0.23
DCMX11T304-WF	1	0.3	3	0.2	0.07	0.3	CCMT120404-KF	0.42	0.14	2.4	0.14	0.07	0.27
DCMX11T308-WF	1	0.3	3	0.25	0.12	0.4	DCMT070202-KF	0.26	0.06	1.5	0.06	0.03	0.11
TCMX090202-WF	0.3	0.1	1.5	0.1	0.03	0.15	DCMT070204-KF	0.26	0.08	1.5	0.08	0.05	0.17
TCMX090204-WF	0.7	0.3	2	0.12	0.05	0.3	DCMT11T302-KF	0.35	0.08	2	0.08	0.04	0.15
TCMX090208-WF	0.7	0.3	2	0.25	0.1	0.35	DCMT11T304-KF	0.35	0.11	2	0.11	0.06	0.23
TCMX110302-WF	0.3	0.1	1.5	0.1	0.03	0.15	SCMT09T304-KF	0.35	0.11	2	0.11	0.06	0.23
TCMX110304-WF	1	0.3	3	0.25	0.12	0.4	SCMT09T308-KF	0.35	0.15	2	0.15	0.08	0.3
TCMX110308-WF	1	0.3	3	0.25	0.12	0.4	TCMT06T102-KF	0.26	0.06	1.5	0.06	0.03	0.11
TCMX16T304-WF	1.2	0.3	3.5	0.2	0.07	0.35	TCMT06T104-KF	0.26	0.08	1.5	0.08	0.05	0.17
TCMX16T308-WF	1.2	0.3	3.5	0.25	0.12	0.5	TCMT06T108-KF	0.26	0.11	1.5	0.11	0.06	0.23
CCMT060202-PF	0.3	0.06	1.7	0.06	0.03	0.11	TCMT090202-KF	0.3	0.06	1.7	0.06	0.03	0.13
CCMT060204-PF	0.3	0.1	1.7	0.08	0.05	0.17	TCMT090204-KF	0.3	0.1	1.7	0.1	0.05	0.19
CCMT09T302-PF	0.35	0.08	2	0.08	0.04	0.15	TCMT110302-KF	0.3	0.06	1.7	0.06	0.03	0.13
CCMT09T304-PF	0.35	0.11	2	0.11	0.06	0.23	TCMT110304-KF	0.3	0.1	1.7	0.1	0.05	0.19
CCMT09T308-PF	0.35	0.15	2	0.15	0.08	0.3	VBMT16T304-KF	0.35	0.11	2	0.11	0.06	0.23
CCMT120404-PF	0.42	0.14	2.4	0.14	0.07	0.27	VBMT110302-KF	0.3	0.06	1.7	0.06	0.03	0.13
DCMT070202-PF	0.26	0.06	1.5	0.06	0.03	0.11	VBMT110304-KF	0.3	0.1	1.7	0.1	0.05	0.19
DCMT070204-PF	0.26	0.08	1.5	0.08	0.05	0.17	VBMT110308-KF	0.3	0.13	1.7	0.13	0.07	0.26
DCMT11T302-PF	0.35	0.08	2	0.08	0.04	0.15	VBMT160402-KF	0.32	0.07	1.8	0.07	0.04	0.14
DCMT11T304-PF	0.35	0.11	2	0.11	0.06	0.23	VBMT160404-KF	0.32	0.1	1.8	0.1	0.05	0.2
DCMT11T308-PF	0.35	0.15	2	0.15	0.08	0.3	VBMT160408-KF	0.32	0.14	1.8	0.14	0.07	0.27
SCMT09T304-PF	0.35	0.11	2	0.11	0.06	0.23	TCMX050100L-F	0.15	0.05	0.8	0.06	0.02	0.1
SCMT09T308-PF	0.35	0.15	2	0.15	0.08	0.3	TCMX050100R-F	0.15	0.05	0.8	0.06	0.02	0.1
TCMT06T102-PF	0.26	0.06	1.5	0.06	0.03	0.11	TCMX050101L-F	0.15	0.05	0.8	0.06	0.02	0.1
TCMT06T104-PF	0.26	0.08	1.5	0.08	0.05	0.17	TCMX050101R-F	0.15	0.05	0.8	0.06	0.02	0.1
TCMT06T108-PF	0.26	0.11	1.5	0.11	0.06	0.23	TCMX06T100L-F	0.2	0.05	1.5	0.08	0.02	0.12
TCMT090202-PF	0.3	0.06	1.7	0.06	0.03	0.13	TCMX06T100R-F	0.2	0.05	1.5	0.08	0.02	0.12
TCMT090204-PF	0.3	0.1	1.7	0.1	0.05	0.19	TCMX06T101L-F	0.2	0.05	1.5	0.08	0.02	0.12
TCMT110302-PF	0.3	0.06	1.7	0.06	0.03	0.13	TCMX06T101R-F	0.2	0.05	1.5	0.08	0.02	0.12
TCMT110304-PF	0.3	0.1	1.7	0.1	0.05	0.19	TCMX06T102L-F	0.2	0.05	0.5	0.08	0.02	0.12
TCMT110308-PF	0.3	0.13	1.7	0.13	0.07	0.26	TCMX090200L-F	0.3	0.05	3	0.1	0.02	0.15
TCMT16T304-PF	0.35	0.11	2	0.11	0.06	0.23	TCMX090200R-F	0.3	0.05	3	0.1	0.02	0.15
VBMT110302-PF	0.3	0.06	1.7	0.06	0.03	0.13	TCMX090201L-F	0.3	0.05	3	0.1	0.02	0.15
VBMT110304-PF	0.3	0.1	1.7	0.1	0.05	0.19	TCMX090201R-F	0.3	0.05	3	0.1	0.02	0.15
VBMT110308-PF	0.3	0.13	1.7	0.13	0.07	0.26	TCMX090202L-F	0.2	0.05	0.5	0.1	0.02	0.15
VBMT110312-PF	0.3	0.13	1.7	0.15	0.08	0.31	TCX110300L-F	0.4	0.05	4	0.1	0.02	0.15
VBMT160402-PF	0.32	0.07	1.8	0.07	0.04	0.14	TCX110300R-F	0.4	0.05	4	0.1	0.02	0.15
VBMT160404-PF	0.32	0.1	1.8	0.1	0.05	0.2	TCX110301L-F	0.4	0.05	4	0.1	0.02	0.15
VBMT160408-PF	0.32	0.14	1.8	0.14	0.07	0.27	TCX110301R-F	0.4	0.05	4	0.1	0.02	0.15
VBMT160412-PF	0.32	0.14	1.8	0.16	0.09	0.32	TCX110302L-F	0.2	0.05	0.5	0.1	0.02	0.2
CCMT060202-MF	0.3	0.06	1.7	0.06	0.03	0.11	VCEX110300L-F	1	0.03	4	0.05	0.01	0.2
CCMT060204-MF	0.3	0.1	1.7	0.08	0.05	0.17	VCEX110300R-F	1	0.03	4	0.05	0.01	0.2
CCMT09T302-MF	0.35	0.08	2	0.08	0.04	0.15	VCEX110301L-F	1	0.05	4	0.1	0.01	0.3
CCMT09T304-MF	0.35	0.11	2	0.11	0.06	0.23	VCEX110301R-F	1	0.05	4	0.1	0.01	0.3
CCMT09T308-MF	0.35	0.15	2	0.15	0.08	0.3	TCGX06T104L-WK	0.5	0.15	1	0.15	0.03	0.25
CCMT120404-MF	0.42	0.14	2.4	0.14	0.07	0.27	TCGX06T104R-WK	0.5	0.15	1	0.15	0.03	0.25
DCMT070202-MF	0.26	0.06	1.5	0.06	0.03	0.11	TCGX090204L-WK	0.5	0.15	1.2	0.2	0.04	0.28
DCMT070204-MF	0.26	0.08	1.5	0.08	0.05	0.17	TCGX090204R-WK	0.5	0.15	1.2	0.2	0.04	0.28
DCMT11T302-MF	0.35	0.08	2	0.08	0.04	0.15	TCGX110204L-WK	0.5	0.15	1.5	0.2	0.05	0.3
DCMT11T304-MF	0.35	0.11	2	0.11	0.06	0.23	TCGX110204R-WK	0.5	0.15	1.5	0.2	0.05	0.3
DCMT11T308-MF	0.35	0.15	2	0.15	0.08	0.3	TCGX110304L-WK	0.5	0.15	1.5	0.2	0.05	0.3
SCMT09T308-MF	0.35	0.15	2	0.15	0.08	0.3	TCGX110304R-WK	0.5	0.15	1.5	0.2	0.05	0.3
TCMT06T102-MF	0.26	0.06	1.5	0.06	0.03	0.11	CCMT060208-WM	1.2	0.5	2.5	0.2	0.1	0.4
TCMT06T104-MF	0.26	0.08	1.5	0.08	0.05	0.17	CCMT09T304-WM	1.5	0.5	4	0.25	0.12	0.4
TCMT06T108-MF	0.26	0.11	1.5	0.11	0.06	0.23	CCMT09T308-WM	1.5	0.7	4	0.3	0.15	0.5
TCMT090202-MF	0.3	0.06	1.7	0.06	0.03	0.13	CCMT120404-WM	2	0.5	4	0.25	0.15	0.4
TCMT090204-MF	0.3	0.1	1.7	0.1	0.05	0.19	CCMT120408-WM	2	0.7	4	0.3	0.15	0.5
TCMT110302-MF	0.3	0.06	1.7	0.06	0.03	0.13	DCMX11T304-WM	1.5	0.5	4	0.25	0.12	0.4
TCMT110304-MF	0.3	0.1	1.7	0.1	0.05	0.19	DCMX11T308-WM	1.5	0.5	4	0.3	0.15	0.5
TCMT110308-MF	0.3	0.13	1.7	0.13	0.07	0.26	TCMX110304-WM	1.2	0.5	3	0.25	0.12	0.35
TCMT16T304-MF	0.35	0.11	2	0.11	0.06	0.23	TCMX110308-WM	1.2	0.5	3	0.3	0.15	0.5
VBMT110302-MF	0.3	0.06	1.7	0.06	0.03	0.13	TCMX16T308-WM	1.5	0.5	4	0.3	0.15	0.5
							CCMT060204-PM	0.64	0.2	2.4	0.11	0.06	0.17

A 504





TURN - SPA

Datos de corte TORNEADO GENERAL

Profundidad de corte y avance recomendadas, métrica

CoroTurn® 107, plaquitas de forma básica positiva

Plaquita	Profundidad recomendada $a_p = \text{mm}$			Avance recomendado $f_s = \text{mm/r}$		
	Min	Máx.		Min	Máx.	
CCMT060208-PM	0.64	0.4	2.4	0.15	0.08	0.23
CCMT09T304-PM	0.64	0.25	3	0.15	0.08	0.23
CCMT09T308-PM	0.8	0.5	3	0.2	0.1	0.3
CCMT120404-PM	0.96	0.3	3.6	0.18	0.09	0.27
CGMT120408-PM	0.96	0.6	3.6	0.24	0.12	0.36
CCMT120412-PM	0.96	0.72	3.6	0.29	0.14	0.43
DCMT070204-PM	0.6	0.19	2.25	0.11	0.06	0.17
DCMT070208-PM	0.6	0.38	2.25	0.15	0.08	0.23
DCMT11T304-PM	0.8	0.25	3	0.15	0.08	0.23
DCMT11T308-PM	0.8	0.5	3	0.2	0.1	0.3
DCMT11T312-PM	0.8	0.6	3	0.24	0.12	0.36
SCMT09T304-PM	0.8	0.25	3	0.15	0.08	0.23
SCMT09T308-PM	0.8	0.5	3	0.2	0.1	0.3
SCMT120404-PM	0.96	0.3	3.6	0.18	0.09	0.27
SCMT120408-PM	0.96	0.6	3.6	0.24	0.12	0.36
SCMT120412-PM	0.96	0.72	3.6	0.29	0.14	0.43
TCMT090204-PM	0.6	0.19	2.25	0.11	0.06	0.17
TCMT090208-PM	0.6	0.38	2.25	0.15	0.08	0.23
TCMT110304-PM	0.67	0.21	2.5	0.13	0.06	0.19
TCMT110308-PM	0.67	0.42	2.5	0.17	0.09	0.26
TCMT110312-PM	0.67	0.5	2.5	0.2	0.1	0.31
TCMT16T304-PM	0.8	0.25	3	0.15	0.08	0.23
TCMT16T308-PM	0.8	0.5	3	0.2	0.1	0.3
TCMT16T312-PM	0.8	0.6	3	0.24	0.12	0.36
TCMT220408-PM	0.96	0.6	3.6	0.24	0.12	0.36
VBMT160404-PM	0.72	0.23	2.7	0.14	0.07	0.2
VBMT160408-PM	0.72	0.45	2.7	0.18	0.09	0.27
VBMT160412-PM	0.72	0.54	2.7	0.22	0.11	0.32
CCMT060204-MM	0.64	0.2	2.4	0.11	0.06	0.17
CCMT060208-MM	0.64	0.4	2.4	0.15	0.08	0.23
CCMT09T304-MM	0.64	0.25	3	0.15	0.08	0.23
CCMT09T308-MM	0.8	0.5	3	0.2	0.1	0.3
CCMT120404-MM	0.96	0.3	3.6	0.18	0.09	0.27
CCMT120408-MM	0.96	0.6	3.6	0.24	0.12	0.36
CCMT120412-MM	0.96	0.72	3.6	0.29	0.14	0.43
DCMT070204-MM	0.6	0.19	2.25	0.11	0.06	0.17
DCMT070208-MM	0.6	0.38	2.25	0.15	0.08	0.23
DCMT11T304-MM	0.8	0.25	3	0.15	0.08	0.23
DCMT11T308-MM	0.8	0.5	3	0.2	0.1	0.3
DCMT11T312-MM	0.8	0.6	3	0.24	0.12	0.36
SCMT09T304-MM	0.8	0.25	3	0.15	0.08	0.23
SCMT09T308-MM	0.8	0.5	3	0.2	0.1	0.3
SCMT120404-MM	0.96	0.3	3.6	0.18	0.09	0.27
SCMT120408-MM	0.96	0.6	3.6	0.24	0.12	0.36
SCMT120412-MM	0.96	0.72	3.6	0.29	0.14	0.43
TCMT090204-MM	0.6	0.19	2.25	0.11	0.06	0.17
TCMT090208-MM	0.6	0.38	2.25	0.15	0.08	0.23
TCMT110304-MM	0.67	0.21	2.5	0.13	0.06	0.19
TCMT110308-MM	0.67	0.42	2.5	0.17	0.09	0.26
TCMT16T304-MM	0.8	0.25	3	0.15	0.08	0.23
TCMT16T308-MM	0.8	0.5	3	0.2	0.1	0.3
TCMT16T312-MM	0.8	0.6	3	0.24	0.12	0.36
TCMT220408-MM	0.96	0.6	3.6	0.24	0.12	0.36
VBMT160404-MM	0.72	0.23	2.7	0.14	0.07	0.2
VBMT160408-MM	0.72	0.45	2.7	0.18	0.09	0.27
VBMT160412-MM	0.72	0.54	2.7	0.22	0.11	0.32
CCMT060204-KM	0.64	0.2	2.4	0.11	0.06	0.17
CCMT060208-KM	0.64	0.4	2.4	0.15	0.08	0.23
CCMT09T304-KM	0.64	0.25	3	0.15	0.08	0.23
CCMT09T308-KM	0.8	0.5	3	0.2	0.1	0.3
CCMT120404-KM	0.96	0.3	3.6	0.18	0.09	0.27
CCMT120408-KM	0.96	0.6	3.6	0.24	0.12	0.36
DCMT070204-KM	0.6	0.19	2.25	0.11	0.06	0.17
DCMT070208-KM	0.6	0.38	2.25	0.15	0.08	0.23
DCMT11T304-KM	0.8	0.25	3	0.15	0.08	0.23
DCMT11T308-KM	0.8	0.5	3	0.2	0.1	0.3
SCMT09T304-KM	0.8	0.25	3	0.15	0.08	0.23
SCMT09T308-KM	0.8	0.5	3	0.2	0.1	0.3
SCMT120408-KM	0.96	0.6	3.6	0.24	0.12	0.36
TCMT090204-KM	0.6	0.19	2.25	0.11	0.06	0.17
TCMT090208-KM	0.6	0.38	2.25	0.15	0.08	0.23
TCMT110304-KM	0.67	0.21	2.5	0.13	0.06	0.19
TCMT110308-KM	0.67	0.42	2.5	0.17	0.09	0.26

Plaquita	Profundidad recomendada $a_p = \text{mm}$			Avance recomendado $f_s = \text{mm/r}$		
	Min	Máx.		Min	Máx.	
TCMT16T304-KM	0.8	0.25	3	0.15	0.08	0.23
TCMT16T308-KM	0.8	0.5	3	0.2	0.1	0.3
TCMT16T312-KM	0.8	0.6	3	0.24	0.12	0.36
TCMT220408-KM	0.96	0.6	3.6	0.24	0.12	0.36
VBMT160404-KM	0.72	0.23	2.7	0.14	0.07	0.2
VBMT160408-KM	0.72	0.45	2.7	0.18	0.09	0.27
VBMT160412-KM	0.72	0.54	2.7	0.22	0.11	0.32
CCET060201-UM	0.3	0.1	4	0.03	0.01	0.06
CCET060202-UM	0.3	0.1	4	0.03	0.01	0.06
CCET060204-UM	1	0.5	4	0.03	0.01	0.08
CCET060204-UM	1	0.5	4	0.03	0.01	0.06
DCET070200-UM	0.3	0.1	4	0.03	0.01	0.06
DCET070201-UM	0.3	0.1	4	0.03	0.01	0.06
DCET070201-UM	0.5	0.1	4	0.03	0.01	0.06
DCET11T301-UM	0.3	0.1	4	0.03	0.01	0.06
DCET11T302-UM	0.3	0.2	4	0.03	0.01	0.06
DCET11T304-UM	1.25	0.5	4	0.05	0.02	0.1
VCET110301-UM	0.3	0.1	4	0.03	0.01	0.06
VCET110302-UM	0.5	0.2	4	0.03	0.02	0.08
RCMT0502M0	1	0.5	2	0.112	0.032	0.158
RCMT0602M0	1.5	0.5	2.4	0.15	0.038	0.173
RCMT0803M0	2	0.8	3.2	0.2	0.051	0.253
RCMT10T3M0	2.5	1	4	0.25	0.063	0.316
RCMT1204M0	3	1.2	4.8	0.3	0.076	0.379
RCMT1606M0	3.5	1.6	6.4	0.374	0.101	0.506
RCMT2006M0	4	2	8	0.447	0.126	0.632
RCMT2507M0	5	2.5	10	0.559	0.158	0.791
RCMT3209M0	6	3.2	12.8	0.693	0.202	1.012
CGGX060202-AL	1	0.3	3	0.12	0.05	0.15
CGGX060204-AL	1.5	0.5	3	0.2	0.1	0.3
CGGX09T304-AL	1.5	0.5	5	0.2	0.1	0.3
CGGX09T308-AL	1.5	0.5	5	0.3	0.15	0.6
CGGX120404-AL	1.5	0.5	7	0.2	0.1	0.3
CGGX120408-AL	1.5	0.5	7	0.3	0.15	0.6
DCGX070202-AL	1	0.3	4	0.12	0.05	0.15
DCGX070204-AL	1.5	0.5	4	0.2	0.1	0.3
DCGX11T302-AL	1	0.3	5.5	0.12	0.05	0.15
DCGX11T304-AL	1.5	0.5	5.5	0.2	0.1	0.3
DCGX11T308-AL	1.5	0.5	5.5	0.3	0.15	0.6
RCGX0602M0-AL	1	0.6	2.4	0.245	0.126	0.379
RCGX0803M0-AL	1.5	0.8	3.2	0.346	0.158	0.538
RCGX10T3M0-AL	2	1	4	0.358	0.158	0.632
RCGX1204M0-AL	2.5	1.2	4.8	0.455	0.19	0.79
SCGX09T308-AL	1.5	0.5	5	0.3	0.15	0.6
TCGX06T104-AL	1	0.5	2	0.2	0.1	0.3
TCGX090202-AL	1	0.3	4	0.12	0.05	0.15
TCGX090204-AL	1.5	0.5	4	0.2	0.1	0.3
TCGX110202-AL	1	0.3	5	0.12	0.05	0.15
TCGX110204-AL	1.5	0.5	5	0.2	0.1	0.3
TCGX110208-AL	1.5	0.5	5	0.3	0.15	0.6
TCGX110302-AL	1	0.3	5	0.12	0.05	0.15
TCGX110304-AL	1.5	0.5	5	0.2	0.1	0.3
TCGX110308-AL	1.5	0.5	5	0.3	0.15	0.6
TCGX16T304-AL	1.5	0.5	7	0.2	0.1	0.3
TCGX16T308-AL	1.5	0.5	7	0.3	0.15	0.6
VCGX110202-AL	1	0.3	3	0.12	0.05	0.15
VCGX110204-AL	1.5	0.5	3	0.2	0.1	0.3
VCGX110302-AL	1	0.3	3	0.12	0.05	0.15
VCGX110304-AL	1.5	0.5	3	0.2	0.1	0.3
VCGX160404-AL	1.5	0.5	5	0.2	0.1	0.3
VCGX160408-AL	1.5	0.5	5	0.3	0.15	0.6
VCGX160412-AL	1.5	0.5	5	0.4	0.15	0.8
VCGX220502-AL	1.5	0.5	7	0.6	0.25	1
VCGX220530-AL	1.5	0.5	7	0.6	0.25	1
CCMT060208-PR	1.6	0.8	3.2	0.19	0.09	0.26
CCMT09T308-PR	2	1	4	0.25	0.12	0.35
CCMT09T312-PR	2	1.2	4	0.3	0.14	0.42
CCMT120408-PR	2.4	1.2	4.8	0.3	0.14	0.42
CCMT120412-PR	2.4	1.44	4.8	0.36	0.17	0.5
DCMT11T308-PR	2	1	4	0.25	0.12	0.35
DCMT11T312-PR	2	1.2	4	0.3	0.14	0.42





A

TORNEADO GENERAL Datos de corte

Profundidad de corte y avance recomendadas, pulg

T-Max® P, plaquitas de forma básica negativa

B

Plaquita	Profundidad recomendada a _p = pulgadas		Avance recomendado f _n = pulgadas/r			
	Min	Máx.	Min	Máx.		
CNMG321-WF	.02	.012	.059	.006	.002	.01
CNMG322-WF	.039	.012	.079	.012	.004	.02
CNMG431-WF	.016	.01	.118	.006	.002	.01
CNMG432-WF	.039	.01	.157	.012	.004	.02
CNMG433-WF	.059	.016	.157	.02	.008	.024
DNMX331-WF	.039	.008	.059	.008	.003	.012
DNMX332-WF	.039	.008	.118	.012	.004	.016
DNMX431-WF	.031	.008	.118	.008	.003	.012
DNMX432-WF	.059	.008	.118	.012	.004	.016
DNMX433-WF	.059	.016	.138	.016	.006	.022
DNMX441-WF	.031	.008	.118	.008	.003	.012
DNMX442-WF	.059	.008	.118	.012	.004	.016
DNMX443-WF	.059	.016	.138	.016	.006	.022
TNMX331-WF	.039	.008	.118	.008	.003	.012
TNMX332-WF	.059	.008	.118	.012	.004	.016
WNMG331-WF	.016	.01	.079	.006	.002	.01
WNMG332-WF	.039	.01	.118	.012	.004	.02
WNMG431-WF	.016	.01	.118	.006	.002	.01
WNMG432-WF	.039	.01	.157	.012	.004	.02
WNMG433-WF	.059	.016	.157	.02	.008	.024
CNMG321-PF	.016	.01	.059	.006	.003	.012
CNMG322-PF	.016	.012	.059	.006	.004	.012
CNMG431-PF	.016	.01	.059	.006	.003	.012
CNMG432-PF	.016	.012	.059	.008	.004	.016
CNMG433-PF	.031	.014	.059	.01	.006	.02
DNMG331-PF	.016	.01	.059	.006	.003	.012
DNMG332-PF	.016	.012	.059	.008	.004	.016
DNMG333-PF	.031	.014	.059	.01	.006	.02
DNMG441-PF	.016	.01	.059	.006	.003	.012
DNMG442-PF	.016	.012	.059	.008	.004	.016
DNMG443-PF	.031	.014	.059	.01	.006	.02
SNMG432-PF	.016	.012	.059	.008	.004	.016
SNMG433-PF	.031	.014	.059	.01	.006	.02
TNMG331-PF	.016	.01	.059	.006	.003	.012
TNMG332-PF	.016	.012	.059	.008	.004	.016
TNMG333-PF	.031	.014	.059	.01	.006	.02
TNMG432-PF	.016	.012	.059	.008	.004	.016
TNMG433-PF	.031	.014	.059	.01	.006	.02
TNMG442-PF	.016	.012	.059	.008	.004	.016
TNMG443-PF	.031	.014	.059	.01	.006	.02
WNMG331-PF	.016	.01	.059	.006	.003	.012
WNMG332-PF	.016	.012	.059	.008	.004	.016
WNMG333-PF	.031	.014	.059	.01	.006	.02
WNMG431-PF	.016	.01	.059	.006	.003	.012
WNMG432-PF	.016	.012	.059	.008	.004	.016
WNMG433-PF	.031	.014	.059	.01	.006	.02
CNMG431-MF	.016	.004	.059	.006	.002	.012
CNMG432-MF	.016	.004	.059	.008	.004	.016
CNMG433-MF	.031	.008	.098	.01	.006	.02
DNMG331-MF	.016	.004	.059	.006	.002	.012
DNMG332-MF	.016	.004	.059	.008	.004	.016
DNMG431-MF	.016	.004	.059	.006	.002	.012
DNMG432-MF	.016	.004	.059	.008	.004	.016
DNMG441-MF	.016	.004	.059	.006	.002	.012
DNMG442-MF	.016	.004	.059	.008	.004	.016
DNMG443-MF	.031	.008	.098	.01	.006	.02
SNMG431-MF	.016	.004	.059	.006	.002	.012
SNMG432-MF	.016	.004	.059	.008	.004	.016
TNMG331-MF	.016	.004	.059	.006	.002	.012
TNMG332-MF	.016	.004	.059	.008	.004	.016
TNMG333-MF	.031	.008	.098	.01	.006	.02
VNMG331-MF	.016	.004	.059	.006	.002	.012
VNMG332-MF	.031	.008	.098	.006	.003	.012
WNMG331-MF	.016	.004	.059	.006	.002	.012
WNMG332-MF	.016	.004	.059	.008	.004	.016
WNMG431-MF	.016	.004	.059	.006	.002	.012
WNMG432-MF	.016	.004	.059	.008	.004	.016
CNMG431-KF	.02	.006	.079	.006	.003	.01
CNMG432-KF	.02	.006	.079	.008	.004	.012

C

G

H

I

J

Plaquita	Profundidad recomendada a _p = pulgadas		Avance recomendado f _n = pulgadas/r			
	Min	Máx.	Min	Máx.		
CNMG433-KF	.039	.008	.098	.01	.004	.014
DNMG331-KF	.02	.006	.079	.006	.003	.01
DNMG332-KF	.02	.006	.079	.008	.004	.012
DNMG431-KF	.02	.006	.079	.006	.003	.01
DNMG432-KF	.02	.006	.079	.008	.004	.012
DNMG441-KF	.02	.006	.079	.006	.003	.01
DNMG442-KF	.02	.006	.079	.008	.004	.012
DNMG443-KF	.039	.008	.098	.01	.004	.014
TNMG331-KF	.02	.006	.079	.006	.003	.01
TNMG332-KF	.02	.006	.079	.008	.004	.012
WNMG431-KF	.02	.006	.079	.006	.003	.01
WNMG432-KF	.02	.006	.079	.008	.004	.012
WNMG433-KF	.02	.006	.079	.006	.003	.01
WNMG332-KF	.02	.006	.079	.008	.004	.012
WNMG431-KF	.02	.006	.079	.006	.003	.01
WNMG432-KF	.02	.006	.079	.008	.004	.012
WNMG433-KF	.039	.008	.098	.01	.004	.014
CNMG432-WMX	.118	.02	.197	.018	.006	.028
CNMG433-WMX	.138	.031	.236	.02	.008	.03
CNMG542-WMX	.118	.02	.197	.018	.006	.028
CNMG543-WMX	.138	.031	.236	.02	.008	.03
DNMX432-WMX	.118	.02	.197	.018	.006	.028
DNMX433-WMX	.138	.031	.236	.02	.008	.03
DNMX434-WMX	.138	.02	.236	.02	.008	.031
DNMX442-WMX	.118	.02	.197	.018	.006	.028
DNMX443-WMX	.138	.031	.236	.02	.008	.03
DNMX444-WMX	.138	.02	.236	.02	.008	.031
TNMX332-WMX	.118	.02	.197	.018	.006	.028
TNMX333-WMX	.138	.031	.236	.02	.008	.03
WNMG332-WMX	.118	.02	.197	.018	.006	.028
WNMG333-WMX	.138	.031	.236	.02	.008	.03
WNMG432-WMX	.118	.02	.197	.018	.006	.028
WNMG433-WMX	.138	.031	.236	.02	.008	.03
CNMG432-WM	.118	.02	.197	.012	.006	.024
CNMG433-WM	.138	.031	.236	.02	.008	.035
CNMG542-WM	.138	.028	.256	.016	.008	.028
CNMG543-WM	.138	.028	.256	.016	.008	.028
DNMX332-WM	.059	.02	.138	.014	.006	.02
DNMX333-WM	.079	.02	.157	.018	.006	.024
DNMX432-WM	.079	.02	.177	.014	.006	.02
DNMX433-WM	.098	.02	.197	.018	.006	.024
DNMX434-WM	.138	.02	.236	.024	.008	.031
DNMX442-WM	.079	.02	.177	.014	.006	.02
DNMX443-WM	.098	.02	.197	.018	.006	.024
DNMX444-WM	.138	.02	.236	.024	.008	.031
TNMX332-WM	.079	.02	.177	.014	.006	.02
TNMX333-WM	.098	.02	.197	.016	.006	.024
WNMG332-WM	.059	.02	.138	.012	.006	.024
WNMG333-WM	.059	.031	.138	.02	.008	.035
WNMG432-WM	.118	.02	.197	.012	.006	.024
WNMG433-WM	.138	.031	.236	.02	.008	.035
CNMG321-PM	.079	.016	.157	.008	.004	.012
CNMG322-PM	.079	.02	.157	.012	.006	.02
CNMG431-PM	.118	.016	.217	.008	.004	.012
CNMG432-PM	.118	.02	.217	.012	.006	.02
CNMG433-PM	.118	.031	.217	.014	.007	.024
CNMG434-PM	.118	.039	.217	.016	.009	.026
CNMG542-PM	.157	.02	.283	.012	.006	.02
CNMG543-PM	.157	.031	.283	.014	.007	.024
CNMG544-PM	.157	.039	.283	.016	.009	.026
CNMG642-PM	.157	.02	.339	.012	.006	.02
CNMG643-PM	.157	.031	.339	.014	.007	.024
CNMG644-PM	.157	.039	.339	.016	.009	.026
DNMG331-PM	.079	.016	.197	.008	.004	.012
DNMG332-PM	.079	.02	.197	.012	.006	.02
DNMG333-PM	.079	.031	.197	.014	.007	.02
DNMG431-PM	.118	.016	.236	.008	.004	.012
DNMG432-PM	.118	.02	.236	.012	.006	.02
DNMG433-PM	.118	.031	.236	.014	.007	.024
DNMG441-PM	.118	.016	.236	.008	.004	.012
DNMG442-PM	.118	.02	.236	.012	.006	.02
DNMG443-PM	.118	.031	.236	.014	.007	.024
DNMG444-PM	.118	.039	.236	.016	.009	.026
SNMG321-PM	.079	.016	.177	.008	.004	.012
SNMG322-PM	.079	.02	.177	.012	.006	.02





TURN - SPA

Datos de corte TORNEADO GENERAL

Profundidad de corte y avance recomendadas, pulg

T-Max® P, plaquitas de forma básica negativa

Plaquita	Profundidad recomendada a _p = pulgadas		Avance recomendado f _n = pulgadas/r			
	Min	Máx.	Min	Máx.		
SNMG431-PM	.118	.016	.236	.008	.004	.012
SNMG432-PM	.118	.02	.236	.012	.006	.02
SNMG433-PM	.118	.031	.236	.014	.007	.024
SNMG434-PM	.118	.039	.236	.016	.009	.026
SNMG543-PM	.157	.031	.295	.014	.007	.024
SNMG544-PM	.157	.039	.295	.016	.009	.026
TNMG331-PM	.118	.016	.197	.008	.004	.012
TNMG332-PM	.118	.02	.197	.012	.006	.02
TNMG333-PM	.118	.031	.197	.014	.007	.024
TNMG431-PM	.157	.016	.26	.008	.004	.012
TNMG432-PM	.157	.02	.26	.012	.006	.02
TNMG433-PM	.157	.031	.26	.014	.007	.024
TNMG434-PM	.157	.039	.26	.016	.009	.026
VNMG332-PM	.079	.02	.157	.012	.006	.02
VNMG333-PM	.079	.031	.157	.014	.007	.024
VNMG332-PM	.079	.02	.118	.012	.006	.02
VNMG333-PM	.079	.031	.118	.014	.007	.024
WNMG432-PM	.098	.02	.157	.012	.006	.02
WNMG433-PM	.098	.031	.157	.014	.007	.024
WNMG434-PM	.118	.039	.157	.016	.009	.026
CNMG432-MM	.118	.02	.224	.01	.004	.018
CNMG433-MM	.118	.02	.224	.012	.004	.024
CNMG434-MM	.118	.02	.224	.015	.004	.026
CNMG542-MM	.157	.02	.283	.01	.004	.018
CNMG543-MM	.157	.02	.283	.012	.004	.024
CNMG544-MM	.157	.02	.283	.015	.004	.026
CNMG642-MM	.157	.02	.335	.01	.004	.018
CNMG643-MM	.157	.02	.335	.012	.004	.024
CNMG644-MM	.157	.02	.335	.015	.004	.026
DNMG332-MM	.079	.02	.173	.01	.004	.018
DNMG333-MM	.079	.02	.173	.012	.004	.024
DNMG432-MM	.118	.02	.252	.01	.004	.018
DNMG433-MM	.118	.02	.252	.012	.004	.024
DNMG442-MM	.118	.02	.252	.01	.004	.018
DNMG443-MM	.118	.02	.252	.012	.004	.024
SNMG432-MM	.118	.02	.25	.01	.004	.018
SNMG433-MM	.118	.02	.25	.012	.004	.024
SNMG434-MM	.118	.02	.25	.015	.004	.026
SNMG543-MM	.157	.02	.315	.012	.004	.024
SNMG544-MM	.157	.02	.315	.015	.004	.026
SNMG643-MM	.157	.02	.374	.012	.004	.024
SNMG644-MM	.157	.02	.374	.015	.004	.026
TNMG332-MM	.118	.02	.189	.01	.004	.018
TNMG333-MM	.118	.02	.189	.012	.004	.024
TNMG432-MM	.157	.02	.26	.01	.004	.018
TNMG433-MM	.157	.02	.26	.012	.004	.024
TNMG434-MM	.157	.02	.26	.015	.004	.026
VNMG332-MM	.079	.02	.157	.01	.004	.018
VNMG333-MM	.079	.02	.118	.01	.004	.018
VNMG333-MM	.079	.02	.118	.012	.004	.024
WNMG432-MM	.098	.02	.157	.01	.004	.018
WNMG433-MM	.098	.02	.157	.012	.004	.024
CNMG432-KM	.118	.008	.236	.014	.006	.02
CNMG433-KM	.118	.012	.236	.016	.006	.024
CNMG434-KM	.118	.012	.236	.018	.008	.028
CNMG542-KM	.157	.008	.315	.014	.006	.02
CNMG543-KM	.157	.012	.315	.016	.006	.024
CNMG544-KM	.157	.012	.315	.018	.008	.028
CNMG643-KM	.177	.012	.354	.016	.006	.024
CNMG644-KM	.177	.012	.354	.018	.008	.028
DNMG332-KM	.079	.008	.138	.014	.006	.02
DNMG333-KM	.079	.012	.138	.016	.006	.024
DNMG432-KM	.098	.008	.197	.014	.006	.02
DNMG433-KM	.098	.012	.197	.016	.006	.024
DNMG442-KM	.098	.008	.197	.014	.006	.02
DNMG443-KM	.098	.012	.197	.016	.006	.024
SNMG322-KM	.098	.008	.177	.014	.006	.02
SNMG432-KM	.118	.008	.236	.014	.006	.02
SNMG433-KM	.118	.012	.236	.016	.006	.024
SNMG434-KM	.118	.012	.236	.018	.008	.028
SNMG543-KM	.157	.012	.315	.016	.006	.024
SNMG544-KM	.157	.012	.315	.018	.008	.028
SNMG643-KM	.177	.012	.354	.016	.006	.024

Plaquita	Profundidad recomendada a _p = pulgadas		Avance recomendado f _n = pulgadas/r			
	Min	Máx.	Min	Máx.		
SNMG644-KM	.177	.012	.354	.018	.008	.028
TNMG332-KM	.118	.008	.217	.014	.006	.02
TNMG333-KM	.118	.012	.217	.016	.006	.024
TNMG432-KM	.157	.008	.315	.014	.006	.02
TNMG433-KM	.157	.012	.315	.016	.006	.024
TNMG434-KM	.157	.012	.315	.018	.008	.028
VNMG332-KM	.079	.008	.138	.012	.006	.016
VNMG333-KM	.079	.012	.138	.014	.006	.02
WNMG332-KM	.079	.008	.157	.014	.006	.02
WNMG333-KM	.079	.012	.157	.016	.006	.024
WNMG432-KM	.098	.008	.197	.014	.006	.02
WNMG433-KM	.098	.012	.197	.016	.006	.024
CNMG543-HM	.157	.039	.315	.02	.01	.031
CNMG544-HM	.157	.059	.315	.024	.012	.035
CNMG643-HM	.157	.039	.394	.02	.01	.031
CNMG644-HM	.157	.059	.394	.024	.012	.035
CNMG646-HM	.197	.079	.394	.024	.012	.047
SNMG543-HM	.157	.039	.315	.02	.01	.031
SNMG544-HM	.157	.059	.315	.024	.012	.035
SNMG643-HM	.157	.039	.394	.02	.01	.031
SNMG644-HM	.157	.059	.394	.024	.012	.035
SNMG646-HM	.197	.079	.394	.024	.012	.047
SNMG866-HM	.236	.079	.591	.031	.016	.047
TNMG543-HM	.236	.079	.472	.024	.014	.03
TNMG544-HM	.236	.079	.472	.024	.014	.03
TNMG666-HM	.276	.118	.591	.024	.018	.035
CNMM432-WR	.098	.031	.197	.024	.012	.031
CNMM433-WR	.098	.039	.197	.031	.016	.043
CNMM434-WR	.098	.047	.197	.031	.017	.047
CNMM543-WR	.118	.047	.236	.031	.017	.047
CNMM544-WR	.118	.055	.236	.035	.018	.051
CNMM644-WR	.13	.063	.264	.039	.019	.051
TNMX433-WR	.098	.039	.197	.031	.016	.043
TNMX434-WR	.098	.047	.197	.035	.017	.047
CNMM432-PR	.197	.028	.295	.016	.008	.022
CNMM433-PR	.197	.039	.295	.02	.01	.028
CNMM434-PR	.197	.059	.295	.022	.013	.035
CNMM542-PR	.236	.028	.374	.016	.008	.022
CNMM543-PR	.236	.039	.374	.02	.01	.028
CNMM544-PR	.236	.059	.374	.022	.013	.035
CNMM643-PR	.236	.039	.472	.02	.01	.028
CNMM644-PR	.236	.059	.472	.022	.013	.035
CNMM646-PR	.236	.079	.472	.022	.014	.047
DNMM442-PR	.197	.028	.236	.016	.008	.022
DNMM443-PR	.197	.039	.236	.02	.01	.028
DNMM444-PR	.197	.059	.236	.022	.013	.035
SNMM432-PR	.197	.028	.295	.016	.008	.022
SNMM433-PR	.197	.039	.295	.02	.01	.028
SNMM543-PR	.236	.039	.354	.02	.01	.028
SNMM544-PR	.236	.059	.354	.022	.013	.035
SNMM643-PR	.236	.039	.472	.02	.01	.028
SNMM644-PR	.236	.059	.472	.022	.013	.035
SNMM646-PR	.236	.079	.472	.022	.014	.047
TNMM332-PR	.157	.028	.236	.016	.008	.022
TNMM333-PR	.157	.039	.236	.02	.01	.028
TNMM432-PR	.197	.028	.315	.016	.008	.022
TNMM433-PR	.197	.039	.315	.02	.01	.028
TNMM434-PR	.197	.059	.315	.022	.013	.035
CNMG432-PR	.157	.028	.276	.014	.008	.02
CNMG433-PR	.157	.039	.276	.016	.01	.028
CNMG434-PR	.157	.059	.276	.02	.013	.03
CNMG542-PR	.197	.028	.315	.014	.008	.02
CNMG543-PR	.197	.039	.315	.016	.01	.028
CNMG544-PR	.197	.059	.315	.02	.012	.031
CNMG546-PR	.197	.079	.315	.02	.013	.035
CNMG642-PR	.197	.028	.394	.014	.008	.02
CNMG643-PR	.197	.039	.394	.016	.01	.028
CNMG644-PR	.197	.059	.394	.02	.012	.031
CNMG646-PR	.197	.079	.394	.02	.013	.035
CNMG866-PR	.236	.079	.591	.024	.016	.039
DNMG432-PR	.157	.028	.236	.014	.008	.02
DNMG433-PR	.157	.039	.236	.016	.01	.028
DNMG434-PR	.157	.059	.236	.02	.012	.03





A

TORNEADO GENERAL Datos de corte

Profundidad de corte y avance recomendadas, pulg

T-Max® P, plaquitas de forma básica negativa

B

Plaquita	Profundidad recomendada a _p = pulgadas		Avance recomendado f _n = pulgadas/r			
	Min	Máx.	Min	Máx.		
DNMG442-PR	.157	.028	.236	.014	.008	.02
DNMG443-PR	.157	.039	.236	.016	.01	.028
DNMG444-PR	.157	.059	.236	.02	.013	.03
SNMG432-PR	.157	.028	.276	.014	.008	.02
SNMG433-PR	.157	.039	.276	.016	.01	.028
SNMG434-PR	.157	.059	.276	.02	.013	.03
SNMG542-PR	.197	.059	.315	.014	.008	.02
SNMG543-PR	.197	.039	.315	.016	.01	.028
SNMG544-PR	.197	.059	.315	.02	.012	.031
SNMG546-PR	.197	.079	.315	.02	.013	.035
SNMG642-PR	.197	.028	.394	.014	.008	.02
SNMG643-PR	.197	.039	.394	.016	.01	.028
SNMG644-PR	.197	.059	.394	.02	.012	.031
SNMG646-PR	.197	.079	.394	.02	.013	.035
SNMG854-PR	.236	.079	.591	.031	.016	.039
SNMG856-PR	.236	.079	.591	.039	.016	.047
SNMG866-PR	.236	.079	.591	.039	.016	.047
TNMG332-PR	.118	.028	.236	.014	.008	.022
TNMG333-PR	.118	.039	.236	.016	.01	.026
TNMG432-PR	.157	.028	.276	.014	.008	.022
TNMG433-PR	.157	.039	.276	.016	.01	.026
TNMG434-PR	.157	.059	.276	.02	.013	.03
TNMG542-PR	.236	.059	.472	.02	.014	.022
TNMG543-PR	.236	.079	.472	.024	.014	.03
TNMG544-PR	.236	.079	.472	.024	.014	.028
TNMG654-PR	.118	.059	.315	.024	.016	.03
TNMG666-PR	.276	.118	.591	.024	.018	.035
WNMG332-PR	.118	.028	.138	.012	.008	.018
WNMG333-PR	.118	.031	.138	.014	.01	.022
WNMG432-PR	.157	.028	.197	.014	.008	.022
WNMG433-PR	.157	.039	.197	.016	.01	.028
WNMG434-PR	.157	.059	.197	.02	.013	.03
CNMG432-MR	.118	.079	.299	.012	.006	.022
CNMG433-MR	.118	.079	.299	.014	.006	.024
CNMG434-MR	.118	.079	.299	.016	.006	.028
CNMG543-MR	.157	.079	.394	.014	.006	.024
CNMG544-MR	.157	.079	.394	.016	.006	.028
CNMG643-MR	.157	.079	.449	.014	.006	.024
CNMG644-MR	.157	.079	.449	.016	.006	.028
CNMG646-MR	.157	.079	.449	.02	.006	.039
DNMG432-MR	.118	.079	.236	.012	.006	.022
DNMG433-MR	.118	.079	.236	.014	.006	.024
DNMG434-MR	.118	.079	.236	.016	.006	.028
DNMG442-MR	.118	.079	.236	.012	.006	.022
DNMG443-MR	.118	.079	.236	.014	.006	.024
DNMG444-MR	.118	.079	.236	.016	.006	.028
SNMG432-MR	.118	.079	.299	.012	.006	.022
SNMG433-MR	.118	.079	.299	.014	.006	.024
SNMG434-MR	.118	.079	.299	.016	.006	.028
SNMG543-MR	.157	.079	.378	.014	.006	.024
SNMG544-MR	.157	.079	.378	.016	.006	.028
SNMG643-MR	.157	.079	.449	.014	.006	.024
SNMG644-MR	.157	.079	.449	.016	.006	.028
SNMG646-MR	.157	.079	.449	.02	.006	.039
TNMG332-MR	.118	.079	.22	.012	.006	.022
TNMG333-MR	.118	.079	.22	.014	.006	.024
TNMG432-MR	.157	.079	.303	.012	.006	.022
TNMG433-MR	.157	.079	.303	.014	.006	.024
TNMG434-MR	.157	.079	.303	.016	.006	.028
WNMG332-MR	.079	.059	.118	.012	.006	.022
WNMG333-MR	.079	.059	.118	.014	.006	.024
WNMG432-MR	.098	.079	.157	.012	.006	.022
WNMG433-MR	.098	.079	.157	.014	.006	.024
CNMM432-MR	.118	.028	.295	.014	.008	.022
CNMM433-MR	.118	.039	.295	.016	.01	.028
CNMM434-MR	.118	.059	.295	.02	.013	.035
CNMM543-MR	.236	.047	.374	.018	.013	.026
CNMM544-MR	.236	.059	.374	.02	.014	.031
CNMM643-MR	.276	.059	.472	.02	.013	.028
CNMM644-MR	.276	.071	.472	.022	.014	.035
CNMM646-MR	.276	.098	.472	.024	.016	.047
CNMM866-MR	.354	.098	.591	.026	.018	.055
CNMM868-MR	.354	.138	.591	.026	.018	.055
DNMM442-MR	.118	.028	.236	.014	.008	.022

H

J

Plaquita	Profundidad recomendada a _p = pulgadas		Avance recomendado f _n = pulgadas/r			
	Min	Máx.	Min	Máx.		
DNMM443-MR	.118	.039	.236	.016	.01	.028
SNMM432-MR	.118	.028	.295	.014	.008	.022
SNMM433-MR	.118	.039	.295	.016	.01	.028
SNMM434-MR	.118	.059	.295	.02	.013	.035
SNMM543-MR	.157	.039	.354	.016	.01	.028
SNMM544-MR	.157	.059	.354	.02	.013	.035
SNMM643-MR	.276	.059	.472	.02	.013	.028
SNMM644-MR	.276	.071	.472	.022	.014	.035
SNMM646-MR	.276	.098	.472	.024	.016	.047
SNMM648-MR	.157	.138	.472	.02	.016	.047
SNMM856-MR	.354	.11	.709	.028	.018	.055
SNMM858-MR	.236	.079	.591	.02	.013	.055
SNMM866-MR	.354	.11	.709	.028	.018	.055
TNMM332-MR	.118	.028	.295	.014	.008	.022
TNMM432-MR	.118	.028	.315	.014	.008	.022
TNMM433-MR	.118	.039	.315	.016	.01	.028
TNMM434-MR	.118	.059	.315	.02	.013	.035
TNMM544-MR	.157	.059	.354	.02	.013	.035
TNMM546-MR	.157	.079	.354	.02	.014	.039
CNMA431-KR	.098	.008	.197	.008	.004	.012
CNMA432-KR	.157	.008	.315	.014	.006	.024
CNMA433-KR	.157	.012	.315	.018	.008	.031
CNMA434-KR	.157	.012	.315	.022	.008	.039
CNMA543-KR	.197	.012	.394	.018	.008	.031
CNMA544-KR	.197	.012	.394	.022	.008	.039
CNMA642-KR	.236	.008	.472	.014	.006	.024
CNMA643-KR	.236	.012	.472	.018	.008	.031
CNMA644-KR	.236	.012	.472	.022	.008	.039
CNMA646-KR	.236	.016	.472	.024	.008	.055
DNMA432-KR	.118	.008	.236	.014	.006	.024
DNMA433-KR	.118	.012	.236	.018	.008	.031
DNMA442-KR	.118	.008	.236	.014	.006	.024
DNMA443-KR	.118	.012	.236	.018	.008	.031
DNMA444-KR	.118	.012	.236	.022	.008	.039
SNMA432-KR	.157	.008	.315	.014	.006	.024
SNMA433-KR	.157	.012	.315	.018	.008	.031
SNMA434-KR	.157	.012	.315	.022	.008	.039
SNMA543-KR	.197	.012	.394	.018	.008	.031
SNMA544-KR	.197	.012	.394	.022	.008	.039
SNMA642-KR	.236	.008	.472	.014	.006	.024
SNMA643-KR	.236	.012	.472	.018	.008	.031
SNMA644-KR	.236	.012	.472	.022	.008	.039
SNMA856-KR	.236	.016	.472	.024	.008	.055
TNMA331-KR	.098	.008	.197	.008	.004	.012
TNMA332-KR	.138	.008	.276	.014	.006	.024
TNMA333-KR	.138	.012	.276	.018	.008	.031
TNMA334-KR	.138	.012	.276	.022	.008	.039
TNMA431-KR	.098	.008	.394	.008	.004	.012
TNMA432-KR	.197	.008	.394	.014	.006	.024
TNMA433-KR	.197	.012	.394	.018	.008	.031
TNMA434-KR	.197	.012	.394	.022	.008	.039
TNMA438-KR	.197	.02	.394	.024	.02	.047
TNMA544-KR	.197	.012	.472	.02	.008	.039
WNMA332-KR	.098	.008	.157	.014	.006	.024
WNMA333-KR	.098	.012	.157	.018	.008	.031
WNMA432-KR	.118	.008	.197	.014	.006	.024
WNMA433-KR	.118	.012	.197	.018	.008	.031
WNMA434-KR	.118	.012	.197	.022	.008	.039
CNMG432-KR	.138	.015	.276	.015	.007	.021
CNMG433-KR	.138	.02	.276	.02	.01	.028
CNMG434-KR	.138	.03	.276	.024	.011	.033
CNMG543-KR	.185	.031	.366	.022	.011	.03
CNMG544-KR	.185	.039	.366	.024	.012	.033
CNMG643-KR	.276	.039	.551	.022	.011	.03
CNMG644-KR	.276	.059	.551	.024	.012	.033
CNMG432-KRR	.157	.008	.315	.014	.006	.024
CNMG433-KRR	.157	.012	.315	.018	.008	.031
CNMG434-KRR	.157	.012	.315	.022	.008	.039
CNMG543-KRR	.197	.012	.394	.018	.008	.031
CNMG544-KRR	.197	.012	.394	.022	.008	.039
DNMG432-KR	.138	.015	.276	.013	.007	.019
DNMG433-KR	.138	.02	.276	.018	.009	.025
DNMG442-KR	.138	.015	.276	.013	.007	.019





A

TORNEADO GENERAL Datos de corte

Profundidad de corte y avance recomendadas, pulg

CoroTurn® 107, plaquitas de forma básica positiva

B

Plaquita	Profundidad recomendada a _p = pulgadas		Avance recomendado f _n = pulgadas/r			Plaquita	Profundidad recomendada a _p = pulgadas		Avance recomendado f _n = pulgadas/r				
	Min	Máx.	Min	Máx.	Min		Máx.	Min	Máx.	Min	Máx.		
CCMT2(1.5)0-WF	.012	.004	.059	.004	.001	.006	VBMT221-MF	.012	.004	.067	.004	.002	.007
CCMT2(1.5)1-WF	.031	.012	.079	.005	.002	.012	VBMT222-MF	.012	.005	.067	.005	.003	.01
CCMT2(1.5)2-WF	.031	.012	.079	.006	.004	.014	VBMT330-MF	.013	.003	.071	.003	.002	.006
CCMT3(2.5)0-WF	.012	.004	.059	.004	.001	.006	VBMT331-MF	.013	.004	.071	.004	.002	.008
CCMT3(2.5)1-WF	.039	.012	.118	.008	.003	.012	VBMT332-MF	.013	.006	.071	.006	.003	.011
CCMT3(2.5)2-WF	.039	.012	.118	.01	.005	.02	VBMT333-MF	.013	.006	.071	.006	.004	.013
DCMX2(1.5)0-WF	.012	.004	.059	.004	.001	.006	CCMT2(1.5)0-KF	.012	.002	.067	.002	.001	.004
DCMX2(1.5)1-WF	.028	.012	.079	.005	.002	.01	CCMT2(1.5)1-KF	.012	.004	.067	.003	.002	.007
DCMX2(1.5)2-WF	.028	.012	.079	.006	.004	.014	CCMT3(2.5)0-KF	.014	.003	.079	.003	.002	.006
DCMX3(2.5)0-WF	.012	.004	.059	.004	.001	.006	CCMT3(2.5)1-KF	.014	.004	.079	.004	.002	.009
DCMX3(2.5)1-WF	.039	.012	.118	.008	.003	.012	CCMT3(2.5)2-KF	.014	.006	.079	.006	.003	.012
DCMX3(2.5)2-WF	.039	.012	.118	.01	.005	.016	DCMT2(1.5)0-KF	.01	.002	.059	.002	.001	.004
TCMX1.8(1.5)0-WF	.012	.004	.059	.004	.001	.006	DCMT2(1.5)1-KF	.01	.003	.059	.003	.002	.007
TCMX1.8(1.5)1-WF	.028	.012	.079	.005	.002	.012	DCMT3(2.5)0-KF	.014	.003	.079	.003	.002	.006
TCMX1.8(1.5)2-WF	.028	.012	.079	.01	.004	.014	DCMT3(2.5)1-KF	.014	.004	.079	.004	.002	.009
TCMX220-WF	.012	.004	.059	.004	.001	.006	SCMT3(2.5)1-KF	.014	.004	.079	.004	.002	.009
TCMX221-WF	.039	.012	.098	.008	.003	.012	SCMT3(2.5)2-KF	.014	.006	.079	.006	.003	.012
TCMX222-WF	.039	.012	.098	.01	.005	.016	TCMT1.2(1.2)0-KF	.01	.002	.059	.002	.001	.004
TCMX3(2.5)1-WF	.047	.012	.138	.008	.003	.014	TCMT1.2(1.2)1-KF	.01	.003	.059	.003	.002	.007
TCMX3(2.5)2-WF	.047	.012	.138	.01	.005	.02	TCMT1.2(1.2)2-KF	.01	.004	.059	.004	.002	.009
CCMT2(1.5)0-PF	.012	.002	.067	.002	.001	.004	TCMT1.8(1.5)0-KF	.012	.002	.067	.002	.001	.005
CCMT2(1.5)1-PF	.012	.004	.067	.003	.002	.007	TCMT1.8(1.5)1-KF	.012	.004	.067	.004	.002	.007
CCMT3(2.5)0-PF	.014	.003	.079	.003	.002	.006	TCMT220-KF	.012	.002	.067	.002	.001	.005
CCMT3(2.5)1-PF	.014	.004	.079	.004	.002	.009	TCMT221-KF	.012	.004	.067	.004	.002	.007
CCMT3(2.5)2-PF	.014	.006	.079	.006	.003	.012	TCMT3(2.5)1-KF	.014	.004	.079	.004	.002	.009
CCMT431-PF	.017	.006	.094	.006	.003	.011	VBMT220-KF	.012	.002	.067	.002	.001	.005
DCMT2(1.5)0-PF	.01	.002	.059	.002	.001	.004	VBMT221-KF	.012	.004	.067	.004	.002	.007
DCMT2(1.5)1-PF	.01	.003	.059	.003	.002	.007	VBMT222-KF	.012	.005	.067	.005	.003	.01
DCMT3(2.5)0-PF	.014	.003	.079	.003	.002	.006	VBMT330-KF	.013	.003	.071	.003	.002	.006
DCMT3(2.5)1-PF	.014	.004	.079	.004	.002	.009	VBMT331-KF	.013	.004	.071	.004	.002	.008
DCMT3(2.5)2-PF	.014	.006	.079	.006	.003	.012	VBMT332-KF	.013	.006	.071	.006	.003	.011
SCMT3(2.5)1-PF	.014	.004	.079	.004	.002	.009	TCMX1(1)00L-F	.006	.002	.031	.002	.001	.004
SCMT3(2.5)2-PF	.014	.006	.079	.006	.003	.012	TCMX1(1)00R-F	.006	.002	.031	.002	.001	.004
TCMT1.2(1.2)0-PF	.01	.002	.059	.002	.001	.004	TCMX1(1)03L-F	.006	.002	.031	.002	.001	.004
TCMT1.2(1.2)1-PF	.01	.003	.059	.003	.002	.007	TCMX1(1)03R-F	.006	.002	.031	.002	.001	.004
TCMT1.2(1.2)2-PF	.01	.004	.059	.004	.002	.009	TCMX1.2(1.2)00L-F	.008	.002	.059	.003	.001	.005
TCMT1.8(1.5)0-PF	.012	.002	.067	.002	.001	.005	TCMX1.2(1.2)00R-F	.008	.002	.059	.003	.001	.005
TCMT1.8(1.5)1-PF	.012	.004	.067	.004	.002	.007	TCMX1.2(1.2)03L-F	.008	.002	.059	.003	.001	.005
TCMT220-PF	.012	.002	.067	.002	.001	.005	TCMX1.2(1.2)03R-F	.008	.002	.059	.003	.001	.005
TCMT221-PF	.012	.004	.067	.004	.002	.007	TCMX1.2(1.2)0L-F	.008	.002	.02	.003	.001	.005
TCMT222-PF	.012	.005	.067	.005	.003	.01	TCMX1.8(1.5)00L-F	.012	.002	.118	.004	.001	.006
TCMT3(2.5)1-PF	.014	.004	.079	.004	.002	.009	TCMX1.8(1.5)00R-F	.012	.002	.118	.004	.001	.006
VBMT220-PF	.012	.002	.067	.002	.001	.005	TCMX1.8(1.5)03L-F	.012	.002	.118	.004	.001	.006
VBMT221-PF	.012	.004	.067	.004	.002	.007	TCMX1.8(1.5)03R-F	.012	.002	.118	.004	.001	.006
VBMT222-PF	.012	.005	.067	.005	.003	.01	TCMX1.8(1.5)0L-F	.008	.002	.02	.004	.001	.006
VBMT223-PF	.012	.005	.067	.006	.003	.012	TCMX220(L)-F	.016	.002	.157	.004	.001	.006
VBMT330-PF	.013	.003	.071	.003	.002	.006	TCMX220(R)-F	.016	.002	.157	.004	.001	.006
VBMT331-PF	.013	.004	.071	.004	.002	.008	TCMX2203(L)-F	.016	.002	.157	.004	.001	.006
VBMT332-PF	.013	.006	.071	.006	.003	.011	TCMX2203(R)-F	.016	.002	.157	.004	.001	.006
VBMT333-PF	.013	.006	.071	.006	.004	.013	TCMX220L-F	.008	.002	.02	.004	.001	.008
CCMT2(1.5)0-MF	.012	.002	.067	.002	.001	.004	VCEX220(L)-F	.039	.001	.157	.002	0	.008
CCMT2(1.5)1-MF	.012	.004	.067	.003	.002	.007	VCEX220(R)-F	.039	.001	.157	.002	0	.008
CCMT3(2.5)0-MF	.014	.003	.079	.003	.002	.006	VCEX2203(L)-F	.039	.002	.157	.004	0	.012
CCMT3(2.5)1-MF	.014	.004	.079	.004	.002	.009	VCEX2203(R)-F	.039	.002	.157	.004	0	.012
CCMT3(2.5)2-MF	.014	.006	.079	.006	.003	.012	TCGX1.2(1.2)1L-WK	.02	.006	.039	.006	.001	.01
CCMT431-MF	.017	.006	.094	.006	.003	.011	TCGX1.2(1.2)1R-WK	.02	.006	.039	.006	.001	.01
DCMT2(1.5)0-MF	.01	.002	.059	.002	.001	.004	TCGX1.8(1.5)1L-WK	.02	.006	.047	.008	.002	.011
DCMT2(1.5)1-MF	.01	.003	.059	.003	.002	.007	TCGX1.8(1.5)1R-WK	.02	.006	.047	.008	.002	.011
DCMT3(2.5)0-MF	.014	.003	.079	.003	.002	.006	TCGX2(1.5)1L-WK	.02	.006	.059	.008	.002	.012
DCMT3(2.5)1-MF	.014	.004	.079	.004	.002	.009	TCGX2(1.5)1R-WK	.02	.006	.059	.008	.002	.012
DCMT3(2.5)2-MF	.014	.006	.079	.006	.003	.012	TCGX221L-WK	.02	.006	.059	.008	.002	.012
SCMT3(2.5)1-MF	.014	.004	.079	.004	.002	.009	TCGX221R-WK	.02	.006	.059	.008	.002	.012
SCMT3(2.5)2-MF	.014	.006	.079	.006	.003	.012	CCMT2(1.5)2-WM	.047	.02	.098	.008	.004	.016
TCMT1.2(1.2)0-MF	.01	.002	.059	.002	.001	.004	CCMT3(2.5)1-WM	.059	.02	.157	.01	.005	.016
TCMT1.2(1.2)1-MF	.01	.003	.059	.003	.002	.007	CCMT3(2.5)2-WM	.059	.028	.157	.012	.006	.02
TCMT1.2(1.2)2-MF	.01	.004	.059	.004	.002	.009	CCMT431-WM	.079	.02	.157	.01	.006	.016
TCMT1.8(1.5)0-MF	.012	.002	.067	.002	.001	.005	CCMT432-WM	.079	.028	.157	.012	.006	.02
TCMT1.8(1.5)1-MF	.012	.004	.067	.004	.002	.007	DCMX3(2.5)1-WM	.059	.02	.157	.01	.005	.016
TCMT220-MF	.012	.002	.067	.002	.001	.005	DCMX3(2.5)2-WM	.059	.02	.157	.012	.006	.02
TCMT221-MF	.012	.004	.067	.004	.002	.007	TCMX221-WM	.047	.02	.118	.01	.005	.014
TCMT222-MF	.012	.005	.067	.005	.003	.01	TCMX222-WM	.047	.02	.118	.012	.006	.02
TCMT3(2.5)1-MF	.014	.004	.079	.004	.002	.009	TCMX3(2.5)2-WM	.059	.02	.157	.012	.006	.02
VBMT220-MF	.012	.002	.067	.002	.001	.005	CCMT2(1.5)1-PM	.025	.008	.094	.004	.002	.007

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TURN - SPA

Datos de corte TORNEADO GENERAL

Profundidad de corte y avance recomendadas, pulg

CoroTurn® 107, plaquitas de forma básica positiva

Plaquita	Profundidad recomendada a _p = pulgadas		Avance recomendado f _n = pulgadas/r			
	Min	Máx.	Min	Máx.	Min	Máx.
CCMT2(1.5)2-PM	.025	.016	.094	.006	.003	.009
CCMT3(2.5)1-PM	.025	.01	.118	.006	.003	.009
CCMT3(2.5)2-PM	.031	.02	.118	.008	.004	.012
CCMT431-PM	.038	.012	.142	.007	.004	.011
CGMT432-PM	.038	.024	.142	.009	.005	.014
CCMT433-PM	.038	.028	.142	.011	.006	.017
DCMT2(1.5)1-PM	.024	.007	.089	.004	.002	.007
DCMT2(1.5)2-PM	.024	.015	.089	.006	.003	.009
DCMT3(2.5)1-PM	.031	.01	.118	.006	.003	.009
DCMT3(2.5)2-PM	.031	.02	.118	.008	.004	.012
DCMT3(2.5)3-PM	.031	.024	.118	.009	.005	.014
SCMT3(2.5)1-PM	.031	.01	.118	.006	.003	.009
SCMT3(2.5)2-PM	.031	.02	.118	.008	.004	.012
SCMT431-PM	.038	.012	.142	.007	.004	.011
SCMT432-PM	.038	.024	.142	.009	.005	.014
SCMT433-PM	.038	.028	.142	.011	.006	.017
TCMT1.8(1.5)1-PM	.024	.007	.089	.004	.002	.007
TCMT1.8(1.5)2-PM	.024	.015	.089	.006	.003	.009
TCMT221-PM	.026	.008	.098	.005	.002	.007
TCMT222-PM	.026	.017	.098	.007	.004	.01
TCMT223-PM	.026	.02	.098	.008	.004	.012
TCMT3(2.5)1-PM	.031	.01	.118	.006	.003	.009
TCMT3(2.5)2-PM	.031	.02	.118	.008	.004	.012
TCMT3(2.5)3-PM	.031	.024	.118	.009	.005	.014
TCMT432-PM	.038	.024	.142	.009	.005	.014
VBMT331-PM	.028	.009	.106	.006	.003	.008
VBMT332-PM	.028	.018	.106	.007	.004	.011
VBMT333-PM	.028	.021	.106	.009	.004	.013
CCMT2(1.5)1-MM	.025	.008	.094	.004	.002	.007
CCMT2(1.5)2-MM	.025	.016	.094	.006	.003	.009
CCMT3(2.5)1-MM	.025	.01	.118	.006	.003	.009
CCMT3(2.5)2-MM	.031	.02	.118	.008	.004	.012
CCMT431-MM	.038	.012	.142	.007	.004	.011
CCMT432-MM	.038	.024	.142	.009	.005	.014
CCMT433-MM	.038	.028	.142	.011	.006	.017
DCMT2(1.5)1-MM	.024	.007	.089	.004	.002	.007
DCMT2(1.5)2-MM	.024	.015	.089	.006	.003	.009
DCMT3(2.5)1-MM	.031	.01	.118	.006	.003	.009
DCMT3(2.5)2-MM	.031	.02	.118	.008	.004	.012
DCMT3(2.5)3-MM	.031	.024	.118	.009	.005	.014
DCMT432-MM	.038	.024	.142	.009	.005	.014
VBMT331-MM	.028	.009	.106	.006	.003	.008
VBMT332-MM	.028	.018	.106	.007	.004	.011
VBMT333-MM	.028	.021	.106	.009	.004	.013
CCMT2(1.5)1-KM	.025	.008	.094	.004	.002	.007
CCMT2(1.5)2-KM	.025	.016	.094	.006	.003	.009
CCMT3(2.5)1-KM	.025	.01	.118	.006	.003	.009
CCMT3(2.5)2-KM	.031	.02	.118	.008	.004	.012
CCMT431-KM	.038	.012	.142	.007	.004	.011
CCMT432-KM	.038	.024	.142	.009	.005	.014
DCMT2(1.5)1-KM	.024	.007	.089	.004	.002	.007
DCMT2(1.5)2-KM	.024	.015	.089	.006	.003	.009
DCMT3(2.5)1-KM	.031	.01	.118	.006	.003	.009
DCMT3(2.5)2-KM	.031	.02	.118	.008	.004	.012
DCMT3(2.5)3-KM	.031	.024	.118	.009	.005	.014
SCMT1.8(1.5)1-KM	.024	.007	.089	.004	.002	.007
SCMT1.8(1.5)2-KM	.024	.015	.089	.006	.003	.009
TCMT221-KM	.026	.008	.098	.005	.002	.007
TCMT222-KM	.026	.017	.098	.007	.004	.01

Plaquita	Profundidad recomendada a _p = pulgadas		Avance recomendado f _n = pulgadas/r			
	Min	Máx.	Min	Máx.	Min	Máx.
TCMT3(2.5)1-KM	.031	.01	.118	.006	.003	.009
TCMT3(2.5)2-KM	.031	.02	.118	.008	.004	.012
TCMT3(2.5)3-KM	.031	.024	.118	.009	.005	.014
TCMT432-KM	.038	.024	.142	.009	.005	.014
VBMT331-KM	.028	.009	.106	.006	.003	.008
VBMT332-KM	.028	.018	.106	.007	.004	.011
VBMT333-KM	.028	.021	.106	.009	.004	.013
CCET2(1.5)03-UM	.012	.004	.157	.001	0	.002
CCET2(1.5)03-UM	.012	.004	.157	.001	0	.003
CCET2(1.5)0-UM	.02	.008	.157	.001	0	.002
CCET2(1.5)0-UM	.02	.008	.157	.001	0	.003
CCET2(1.5)1-UM	.039	.02	.157	.001	0	.002
CCET2(1.5)1-UM	.039	.02	.157	.001	0	.003
DCET2(1.5)00-UM	.012	.004	.157	.001	0	.002
DCET2(1.5)03-UM	.012	.004	.157	.001	0	.002
DCET2(1.5)03-UM	.02	.004	.157	.001	0	.002
DCET3(2.5)03-UM	.012	.004	.157	.001	0	.002
DCET3(2.5)0-UM	.012	.008	.157	.001	0	.002
DCET3(2.5)1-UM	.049	.02	.157	.002	.001	.004
VCET22(03)-UM	.012	.004	.157	.001	0	.002
VCET220-UM	.02	.008	.157	.001	.001	.003
CGX2(1.5)0-AL	.039	.012	.118	.005	.002	.006
CGX2(1.5)1-AL	.059	.02	.118	.008	.004	.012
CGX3(2.5)1-AL	.059	.02	.197	.008	.004	.012
CGX3(2.5)2-AL	.059	.02	.197	.012	.006	.024
CGX431-AL	.059	.02	.276	.008	.004	.012
CGX432-AL	.059	.02	.276	.012	.006	.024
DCGX2(1.5)0-AL	.039	.012	.157	.005	.002	.006
DCGX2(1.5)1-AL	.059	.02	.157	.008	.004	.012
DCGX3(2.5)0-AL	.039	.012	.217	.005	.002	.006
DCGX3(2.5)1-AL	.059	.02	.217	.008	.004	.012
DCGX3(2.5)2-AL	.059	.02	.217	.012	.006	.024
SCGX3(2.5)2-AL	.059	.02	.197	.012	.006	.024
TCGX1.2(1.2)1-AL	.039	.02	.079	.008	.004	.012
TCGX1.8(1.5)0-AL	.039	.012	.157	.005	.002	.006
TCGX1.8(1.5)1-AL	.059	.02	.157	.008	.004	.012
TCGX2(1.5)0-AL	.039	.012	.197	.005	.002	.006
TCGX2(1.5)1-AL	.059	.02	.197	.008	.004	.012
TCGX2(1.5)2-AL	.059	.02	.197	.012	.006	.024
TCGX220-AL	.039	.012	.197	.005	.002	.006
TCGX221-AL	.059	.02	.197	.008	.004	.012
TCGX222-AL	.059	.02	.197	.012	.006	.024
TCGX3(2.5)1-AL	.059	.02	.276	.008	.004	.012
TCGX3(2.5)2-AL	.059	.02	.276	.012	.006	.024
VCGX2(1.5)0-AL	.039	.012	.118	.005	.002	.006
VCGX2(1.5)1-AL	.059	.02	.118	.008	.004	.012
VCGX220-AL	.039	.012	.118	.005	.002	.006
VCGX221-AL	.059	.02	.118	.008	.004	.012
VCGX331-AL	.059	.02	.197	.008	.004	.012
VCGX332-AL	.059	.02	.197	.012	.006	.024
VCGX333-AL	.059	.02	.197	.016	.006	.031
CCMT2(1.5)2-PR	.063	.031	.126	.007	.004	.01
CCMT3(2.5)2-PR	.079	.039	.157	.01	.005	.014
CCMT3(2.5)3-PR	.079	.047	.157	.012	.006	.017
CCMT432-PR	.094	.047	.189	.012	.006	.017
CCMT433-PR	.094	.057	.189	.014	.007	.02
DCMT3(2.5)2-PR	.079	.039	.157	.01	.005	.014
DCMT3(2.5)3-PR	.079	.047	.157	.012	.006	.017
SCMT3(2.5)2-PR	.079	.039	.157	.01	.005	.014
SCMT3(2.5)3-PR	.079	.047	.157	.012	.006	.017
SCMT432-PR	.094	.047	.189	.012	.006	.017
SCMT433-PR	.094	.057	.189	.014	.007	.02
TCMT222-PR	.059	.03	.118	.008	.004	.012
TCMT223-PR	.059	.035	.118	.01	.005	.014
TCMT3(2.5)2-PR	.079	.039	.157	.01	.005	.014
TCMT3(2.5)3-PR	.079	.047	.157	.012	.006	.017
TCMT432-PR	.094	.047	.189	.012	.006	.017
TCMT433-PR	.094	.057	.189	.014	.007	.02
VBMT332-PR	.071	.035	.142	.009	.004	.013
VBMT333-PR	.071	.043	.142	.011	.005	.015
CCMT2(1.5)2-MR	.063	.031	.126	.007	.004	.01
CCMT3(2.5)2-MR	.079	.039	.157	.01	.005	.014
CCMT3(2.5)3-MR	.079	.047	.157	.012	.006	.017





A

TORNEADO GENERAL Datos de corte

Recomendaciones de velocidad de corte, valores métricos

Las recomendaciones son válidas si se utiliza refrigerante.

B

ISO P	N.º CMC	Acero	Fuerza de corte específica k_{c1}	Dureza Brinell	<<<< RESISTENCIA AL DESGASTE				
					CT5005		CT5015	GC1525	GC15
					h_{ex} mm	feed f_n mm/r	Velocidad de corte (V_c), m/min		
Núm. MC	N.º CMC	Material	N/mm²	HB	0.05-0.1-0.2	0.05-0.1-0.2	0.05-0.1-0.2	0.1-0.2-0.3	
P1.1.Z.AN P1.2.Z.AN P1.3.Z.AN	01.1 01.2 01.3	Acero no aleado (elementos de aleación ≤5%) C = 0,1-0,25% C = 0,25-0,55% C = 0,55-0,80%	1500 1600 1700	125 150 170	730-590-485 650-530-420 -	650-540-440 570-480-385 510-425-340	560-465-380 495-415-335 430-365-295	300-250-215 275-225-195 260-215-185	
P2.1.Z.AN P2.1.Z.AN P2.5.Z.HT P2.5.Z.HT	02.1 02.12 02.2 02.2	Acero de baja aleación (elementos de aleación ≤5%) No templado Acero para rodamientos de bola Endurecido y templado Endurecido y templado	1700 1800 1850 2050	180 210 275 350	530-450-360 - 395-325-250 320-260-200	480-400-320 - 285-235-190 230-190-150	375-320-255 - 200-165-135 160-135-110	220-175-150 190-155-135 140-115-100 110-95-80	
P3.0.Z.AN P3.0.Z.HT	03.11 03.21	Acero de alta aleación (elementos de aleación >5%) Recocido Acero de herram. templado	1950 3000	200 325	- -	395-330-250 195-165-130	260-215-175 145-115-90	- -	
P1.5.C.UT P2.6.C.UT P3.0.C.UT	06.1 06.2 06.3	Acero fundido No aleado De baja aleación (elementos de aleación ≤5%) Alta aleación (elementos de aleación >5%)	1550 1600 2050	180 200 225	- - -	260-215-175 270-225-170 200-165-125	225-185-145 175-145-105 140-115-85	- - -	

C

ISO M	N.º CMC	Acero inoxidable	Fuerza de corte específica k_{c1}	Dureza Brinell	<<<< RESISTENCIA AL DESGASTE			
					GC1525	GC1105	GC1115	GC15
					h_{ex} mm	feed f_n mm/r	Velocidad de corte (V_c), m/min	
Núm. MC	N.º CMC	Material	N/mm²	HB	0.1-0.2	0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.2-0.3
P5.0.Z.AN P5.0.Z.PH P5.0.Z.HT	05.11 05.12 05.13	Ferrítico/martensítico Barras/forjadas No templado Templado PH Templado	1800 2850 2350	200 330 330	290-240 170-150 170-150	380-305-245 350-280-225 245-195-160	335-255-200 185-150-120 200-160-140	250-190-150 145-115-95 145-120-105
M1.0.Z.AQ M1.0.Z.PH M2.0.Z.AQ	05.21 05.22 05.23	Austenítico Barras/forjadas Austenítico Templado PH Super austenítico	1800 2850 2250	180 330 200	220-195 195-170 145-130	410-330-265 220-175-145 245-200-160	265-215-165 185-150-120 220-190-155	205-165-130 145-115-90 170-145-120
M3.1.Z.AQ M3.2.Z.AQ	05.51 05.52	Austenítico-ferrítico (Dúplex) Barras/forjadas No soldable ≥ 0,05% C Soldable < 0,05% C	2000 2450	230 260	- -	315-255-205 280-225-185	250-205-155 230-170-130	195-160-120 175-130-100
P5.0.C.UT P5.0.C.HT	15.11 15.12 15.13	Ferrítico/martensítico Fundición No templado Templado PH Templado	1700 2450 2150	200 330 330	- - -	320-265-205 160-130-95 175-145-110	320-265-205 160-130-95 175-145-110	240-200-155 135-110-80 140-115-85
M1.0.C.UT M2.0.C.AQ	15.21 15.22 15.23	Austenítico Fundición Austenítico Templado PH Super austenítico	1700 2450 2150	180 330 200	- - -	280-225-170 160-130-95 210-180-150	280-225-170 160-130-95 210-180-150	215-175-135 135-110-80 160-135-115
M3.1.C.AQ M3.2.C.AQ	15.51 15.52	Austenítico-ferrítico (Dúplex) Fundición No soldable ≥ 0,05% C Soldable < 0,05% C	1800 2250	230 260	- -	230-170-120 205-155-110	230-170-120 205-155-110	185-135-95 170-130-90

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I

ISO K	N.º CMC	Fundición maleable	Fuerza de corte específica k_{c1}	Dureza Brinell	<<<< RESISTENCIA AL DESGASTE			
					CB50	CB7525	CB7925	CC620
					h_{ex} mm	feed f_n mm/r	Velocidad de corte (V_c), m/min	
Núm. MC	N.º CMC	Material	N/mm²	HB	0.1-0.25-0.4	0.1-0.25-0.4	0.1-0.25-0.4	0.1-0.25-0.4
K1.1.C.NS	07.1 07.2	Ferrítica (viruta corta) Perfítica (viruta larga)	790 900	130 230	- -	- -	- -	800-700-600 700-590-500
K2.1.C.UT K2.2.C.UT	08.1 08.2	Fundición gris Baja resistencia a la tracción Alta resistencia a la tracción	890 970	180 220	1700-1450-1200 1450-1250-1050	1700-1450-1200 1450-1250-1050	1450-1200-1050 1250-1050-890	800-700-600 760-650-540
K3.1.C.UT K3.3.C.UT K3.4.C.UT	09.1 09.2 09.3	Hierro SG nodular Ferrítica Perfítica Martensítica	900 1350 2100	160 250 380	- - -	- - -	- - -	- - -

J





TURN - SPA

Datos de corte TORNEADO GENERAL

Recomendaciones de velocidad de corte, valores métricos

TENACIDAD >>>>										
GC1515	GC1125	GC3005	GC4205	GC4215	GC4225	GC2015	GC4235	GC30	GC2025	
0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.3-0.5	0.1-0.4-0.8	0.1-0.4-0.8	0.1-0.4-0.8	0.1-0.4-0.8	0.1-0.4-0.8	0.15-0.25-0.4	0.1-0.4-0.8	
310-290-255 280-255-245 285-260-230	310-290-255 280-255-225 260-235-210	520-415-340 470-370-305 445-355-290	620-450-330 560-405-295 530-385-275	570-405-300 510-365-265 460-330-240	510-345-245 455-305-215 425-290-205	440-300-210 400-270-190 370-250-175	425-275-200 380-245-180 365-235-170	305-260-215 275-235-195 260-220-185	295-200-145 265-180-130 250-170-120	
295-200-125 - 195-100-40 160-80-34	- - - -	500-375-300 - 275-215-175 225-170-140	610-410-285 530-350-250 330-230-175 265-185-140	560-370-260 460-305-215 300-210-155 240-170-125	460-305-215 395-265-190 255-180-140 205-145-110	395-265-190 350-230-160 260-180-140 210-145-115	300-185-135 250-155-110 185-120-85 150-95-70	215-180-150 190-160-130 135-115-95 110-95-80	220-145-100 195-125-85 145-95-65 115-75-50	
	- -	370-275-225 180-130-105	445-295-215 220-140-105	405-270-200 200-130-95	300-205-150 135-95-75	260-180-130 115-85-65	240-155-105 110-70-50		185-125-85 85-55-38	
	- - -	275-220-185 270-200-170 205-155-130	335-235-185 290-205-155 225-150-115	300-215-170 260-185-140 205-135-105	240-180-130 210-140-100 185-125-90	210-155-110 180-120-85 160-110-75	185-140-100 165-100-70 145-95-65		140-105-80 125-80-55 110-75-50	
TENACIDAD >>>>										
GC1515	GC1125	GC2015	GC30	GC2025	GC2035	GC235				
0.1-0.2-0.3	0.1-0.2-0.3	0.2-0.4-0.6	0.15-0.25-0.4	0.2-0.4-0.6	0.2-0.4-0.6	0.2-0.4-0.6				
305-235-185 170-135-110 180-150-130	280-215-170 155-125-100 165-135-120	260-220-200 125-100-80 145-120-85	220-200-175 85-75-60 95-90-70	230-175-135 110-70-50 120-80-55	180-160-130 85-65-45 95-70-50	130-110-90 70-55-45 75-60-50				
245-195-150 170-135-110 205-175-145	220-180-135 155-125-100 185-160-130	290-240-190 130-100-80 160-135-100	190-175-145 100-85-70 130-120-95	240-175-130 100-70-55 130-100-75	170-145-115 85-65-45 100-90-70	115-100-85 70-55-45 85-70-60				
230-185-145 210-155-120	210-170-130 190-140-110	220-185-145 190-150-120	175-160-130 125-115-105	190-150-110 150-120-90	160-135-105 130-110-85	105-95-80 95-80-70				
290-240-185 150-120-90 160-130-100	265-220-170 135-110-80 145-120-90	250-210-170 100-70-55 110-90-60	200-170-150 80-65-50 90-75-60	220-160-120 85-55-40 120-80-55	170-145-115 70-50-40 75-60-50	115-100-85 60-45-35 65-50-40				
255-205-160 150-120-90 195-165-135	230-185-145 135-110-80 175-150-125	220-180-140 105-80-60 145-115-95	155-135-115 80-65-50 120-100-85	200-155-115 85-55-40 130-90-65	150-120-95 70-50-40 100-80-60	100-90-75 65-45-33 80-65-55				
210-155-110 185-145-100	190-140-100 170-130-90	185-150-135 160-140-105	165-145-115 115-100-95	150-120-90 125-105-80	130-110-85 105-95-75	95-80-70 90-75-65				
TENACIDAD >>>>										
CC650	CC6190	CC1690	CT5015	GC3205	GC3210	GC3215	GC3005	GC4215	GC30	H13A
0.1-0.25-0.4	0.2-0.4-0.6	0.2-0.4-0.6	0.1-0.2-0.3	0.2-0.4-0.6	0.2-0.4-0.6	0.2-0.4-0.6	0.2-0.4-0.6	0.2-0.4-0.6	0.2-0.4-0.6	0.1-0.3-0.5
800-700-600 700-600-500	810-660-550 700-550-440	740-600-500 640-500-400	200-165-135 140-115-95	460-380-325 375-310-265	385-315-265 315-255-215	260-215-185 210-175-150	250-210-185 235-190-150	325-265-225 265-220-185	165-165-150 120-110-90	140-125-110 125-110-90
800-700-600 760-650-540	890-720-600 790-620-500	740-600-500 690-540-435	320-260-220 280-235-205	530-435-375 425-350-300	445-360-305 355-290-245	300-250-210 240-200-170	275-245-225 260-225-200	370-305-260 285-245-220	230-200-160 175-150-120	180-145-110 140-115-95
610-550-450 510-450-350 350-305-260	- - -	580-450-345 480-350-250 325-260-220	255-200-160 230-195-170 115-95-85	390-330-275 350-300-250 265-225-190	360-305-250 325-275-225 245-210-170	240-195-165 215-175-150 165-135-115	265-215-180 240-195-160 185-140-110	280-230-195 260-210-175 205-160-125	170-145-120 120-105-90 65-50-37	135-125-95 125-115-90 100-85-65



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A

TORNEADO GENERAL Datos de corte

Recomendaciones de velocidad de corte, valores métricos

Las recomendaciones son válidas si se utiliza refrigerante.

B

ISO N	Núm. MC	N.º CMC	Metales no-ferreos Material	Fuerza de corte específica k_{c1} N/mm ²	Dureza Brinell HB	<<<< RESISTENCIA AL DESGASTE		
						CD10	CD1810	H10
						h_{max} , mm	feed f_n , mm/r	
						Velocidad de corte (V_c), m/min		
						0.05-0.4	0.15-0.8	0.15-0.8
N1.2.Z.UT	30.11		Aleaciones de aluminio Forjadas o forjadas y trabajadas en frío, sin envejecimiento	400	60	2 000 (2500-250) ¹⁾	2 000 (2500-250) ¹⁾	2 000 (2500-250) ¹⁾
N1.2.Z.AG	30.12		Forjadas o forjadas y envejecidas	650	100	2 000 (2500-250) ¹⁾	2 000 (2500-250) ¹⁾	2 000 (2500-250) ¹⁾
N1.3.C.UT	30.21		Aleaciones de aluminio Fundida, no envejecida	600	75	2 000 (2500-250) ¹⁾	2 000 (2500-250) ¹⁾	2 000 (2500-250) ¹⁾
N1.3.C.AG	30.22		Fundición, o fundición y envejecidas	700	90	2 000 (2500-250) ¹⁾	2 000 (2500-250) ¹⁾	2 000 (2500-250) ¹⁾
N1.4.C.NS	30.41		Aleaciones de aluminio Fundidas, 13-15% Si	700	130	1 550 (1950-195) ¹⁾	770 (960-95) ¹⁾	450 (560-55) ¹⁾
	30.42		Fundidas, 16-22% Si	700	130	770 (960-95) ¹⁾	510 (640-65) ¹⁾	300 (375-38) ¹⁾
N3.3.U.UT	33.1		Cobre y aleaciones de cobre Aleaciones de fácil mecanización, ≥1% Pb	550	110	500 (630-65) ¹⁾	500 (630-65) ¹⁾	500 (630-65) ¹⁾
N3.2.C.UT	33.2		Latón, bronce con plomo, ≤1% Pb	550	90	500 (630-65) ¹⁾	500 (630-65) ¹⁾	500 (630-65) ¹⁾
N3.1.U.UT	33.3		Bronce y cobre sin plomo, incl. cobre electrolítico	1350	100	300 (375-38) ¹⁾	300 (375-38) ¹⁾	300 (375-38) ¹⁾

C

ISO S	Núm. MC	N.º CMC	Material termo-resistente Material	Fuerza de corte específica k_{c1} N/mm ²	Dureza Brinell HB	<<<< RESISTENCIA AL DESGASTE		
						CC650	CC6060	CC6065
						h_{max} , mm	feed f_n , mm/r	
						Velocidad de corte (V_c), m/min		
						0.1 - 0.2	0.1-0.2-0.3	0.1-0.2-0.3
S1.0.U.AN	20.11		Superaleaciones termorresistentes Base de hierro Recocidas o tratadas en solución	2400	200	-	-	-
S1.0.U.AG	20.12		Envejecidas o tratadas en solución y envejecidas	2500	280	-	-	-
S2.0.Z.AN	20.21		Base de níquel Recocidas o tratadas en solución	2650	250	400-320	400-325-270	330-255-200
S2.0.Z.AG	20.22		Envejecidas o tratadas en solución y envejecidas	2900	350	340-265	300-235-190	240-175-130
S2.0.C.NS	20.24		Fundición, o fundición y envejecido	3000	320	220-160	240-205-175	215-180-150
S3.0.Z.AN	20.31		Base de cobalto Recocidas o tratadas en solución	2700	200	345-260	-	-
S3.0.Z.AG	20.32		Tratadas en solución y envejecidas	3000	300	300-225	-	-
S3.0.C.NS	20.33		Fundición, o fundición y envejecido	3100	320	285-225	-	-
S4.1.Z.UT	23.1		Aleaciones de titanio²⁾ Comercial puro (99.5% Ti)	1300	Rm ³⁾ 400	0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.3-0.5
S4.2.Z.AN	23.21		Aleaciones α , cerca de α y $\alpha + \beta$, aleaciones	1400	950	205-170-145	205-170-145	195-160-135
S4.3.Z.AG	23.22		$\alpha + \beta$ envejecidas, aleaciones β recocidas o envejecidas	1400	1050	85-70-55	85-70-55	80-65-55
						80-60-50	80-60-50	80-60-50

H

ISO H	Núm. MC	N.º CMC	Material templado Material	Fuerza de corte específica k_{c1} N/mm ²	Dureza Brinell HB	<<<< RESISTENCIA AL DESGASTE		
						CB7015	CB7025	CB20
						h_{max} , mm	feed f_n , mm/r	
						Velocidad de corte (V_c), m/min		
						0.05-0.15-0.25	0.05-0.15-0.25	0.05-0.15-0.25
H1.1.Z.HA	04.1		Acero duro Endurecido y templado	2500	45HRC	-	-	-
H1.1.Z.HA	04.1			3050	50HRC	350-265-225	250-210-185	260-230-205
H1.2.Z.HA	04.1			3650	55HRC	295-225-185	210-175-155	215-195-170
H1.3.Z.HA	04.1		Acero extraduro Endurecido y templado	4300	60HRC	250-190-160	180-150-135	185-165-145
H1.4.Z.HA	04.1			5000	65HRC	215-165-135	155-130-115	160-140-125

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H2.0.C.UT	10.1		Fundición en coquilla Fundidas o fundidas y envejecidas	2250	400	-	-	-
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1) Las velocidades de corte indicadas en la tabla son válidas para todos los avances comprendidos en la gama de avances.

2) Se debe utilizar un ángulo de posición de 45-60°, geometría de corte positiva y refrigerante.

3) Rm = resistencia a la tracción última, medida en MPa.

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TURN - SPA

Datos de corte TORNEADO GENERAL

Recomendaciones de velocidad de corte, valores métricos

TENACIDAD >>>>					
H13A	GC1115	GC15	GC1025	GC1125	
0.15-0.8	0.15-0.8	0.15-0.8	0.15-0.8	0.15-0.8	
1 900 (2400-240) ¹⁾	810 (1000-100) ¹⁾	810 (1000-100) ¹⁾	770 (960-95) ¹⁾	770 (960-95) ¹⁾	
1 900 (2400-240) ¹⁾	315 (395-39) ¹⁾	315 (395-39) ¹⁾	300 (375-38) ¹⁾	300 (375-38) ¹⁾	
1 900 (2400-240) ¹⁾	810 (1000-100) ¹⁾	810 (1000-100) ¹⁾	770 (960-95) ¹⁾	770 (960-95) ¹⁾	
1 900 (2400-240) ¹⁾	540 (680-70) ¹⁾	540 (680-70) ¹⁾	510 (640-65) ¹⁾	510 (640-65) ¹⁾	
400 (500-50) ¹⁾	315 (395-39) ¹⁾	315 (395-39) ¹⁾	300 (375-38) ¹⁾	300 (375-38) ¹⁾	
250 (315-31) ¹⁾	220 (275-28) ¹⁾	220 (275-28) ¹⁾	210 (265-26) ¹⁾	210 (265-26) ¹⁾	
450 (560-55) ¹⁾	210 (265-26) ¹⁾	210 (265-26) ¹⁾	200 (250-25) ¹⁾	200 (250-25) ¹⁾	
450 (560-55) ¹⁾	125 (155-16) ¹⁾	125 (155-16) ¹⁾	120 (150-15) ¹⁾	120 (150-15) ¹⁾	
270 (340-34) ¹⁾	90 (115-11) ¹⁾	90 (115-11) ¹⁾	85 (105-11) ¹⁾	85 (105-11) ¹⁾	

TENACIDAD >>>>									
CC670	S05F	GC1105	GC1115	GC15	GC1005	H10A	H13A	GC1125	H10F
0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.3-0.5	0.1-0.3-0.5	0.1-0.3-0.5	0.1-0.3-0.5	0.1-0.3-0.5	0.1-0.3-0.5	0.1-0.2-0.5	0.1-0.3-0.5
-	160-135-110	150-100-70	120-80-55	120-80-55	150-100-70	85-70-55	80-65-50	75-60-45	70-55-40
-	125-105-85	120-80-60	95-65-50	95-65-50	120-80-60	65-55-40	60-50-40	55-45-35	50-40-30
385-315-270	100-85-70	90-55-30	70-45-24	70-45-24	90-55-30	55-40-32	50-40-30	45-35-25	40-30-20
325-270-230	90-75-60	80-50-27	65-40-22	65-40-22	80-50-27	40-32-21	40-30-20	35-25-15	30-20-10
295-245-210	80-65-55	70-45-24	60-37-19	60-37-19	70-45-24	26-21-16	25-20-15	23-17-12	20-15-10
345-255-205	100-85-70	90-60-30	70-45-24	70-45-24	90-60-30	55-40-32	50-40-30	45-35-25	40-30-20
300-225-175	90-75-60	80-50-27	65-40-21	65-40-21	80-50-27	40-32-21	40-30-20	35-25-15	30-20-10
285-225-170	80-65-55	70-45-24	60-37-19	60-37-19	70-45-24	26-21-16	25-20-15	23-17-12	20-15-10
H13A	H10F	GC1115	GC15						
0.1-0.3-0.5	0.1-0.3-0.5	0.1-0.3-0.5	0.1-0.3-0.5						
180-150-125	160-135-115	185-155-130	185-155-130						
75-60-50	65-55-45	80-65-50	80-65-50						
70-55-45	65-50-40	75-55-45	75-55-45						

TENACIDAD >>>>						
CB7525	CB7925	CC6050	CC670	GC4205	GC4215	H13A
0.1-0.25-0.4	0.1-0.25-0.4	0.05-0.15-0.25	0.1-0.25-0.4	0.1-0.3-0.6	0.1-0.3-0.6	0.1-0.3-0.6
-	-	290-235-175	205-170-135	70-45-29	65-40-26	45-25-16
205-165-135	-	240-195-145	165-140-110	-	-	-
175-140-110	-	200-165-120	140-115-95	-	-	-
145-120-95	-	170-140-105	120-100-80	-	-	-
125-100-80	-	145-120-90	105-85-70	-	-	-
180-150-120	180-150-120	-	120-90-60	50-29-17	45-26-15	35-20-11





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TORNEADO GENERAL Datos de corte

Recomendaciones de velocidad de corte, valores en pulgadas

Las recomendaciones son válidas si se utiliza refrigerante.

B

ISO P	N.º CMC	Acero	Fuerza de corte específica k_{c1}	Dureza Brinell	<<<< RESISTENCIA AL DESGASTE						
					CT5005		CT5015		GC1525	GC15	GC1515
					h_{max} , pulgadas avance, f_r , pulgadas/rev. a 0° a -5° avance						
Núm. MC	Material	lbs/pulg.²	HB	Velocidad de corte v_c , p/min							
P1.1.Z.AN	01.1	Acero no aleado C = 0,1-0,25% C = 0,25-0,55% C = 0,55-0,80%	216,500	125	2400-1950-1600	2150-1800-1450	1850-1500-1250	990-820-710	1000-950-830		
P1.2.Z.AN	01.2		233,000	150	2150-1750-1350	1900-1550-1250	1600-1350-1100	890-740-640	1000-910-810		
P1.3.Z.AN	01.3		247,000	170	-	1650-1400-1100	1400-1200-960	850-700-610	940-850-750		
P2.1.Z.AN	02.1	Acero de baja aleación (elementos de aleación ≤5%) No templado Acero para rodamientos de bola Endurecido y templado Endurecido y templado	249,500	180	1750-1450-1150	1550-1300-1050	1250-1050-830	710-570-490	960-650-405		
P2.1.Z.AN	02.12		259,500	210	-	-	-	630-510-440	-		
P2.5.Z.HT	02.2		268,000	275	1300-1050-810	920-770-610	650-540-435	455-375-325	640-320-130		
P2.5.Z.HT	02.2		298,000	350	1050-850-650	740-620-495	520-435-350	365-305-265	520-255-105		
P3.0.Z.AN	03.11	Acero de alta aleación (elementos de aleación >5%) Recocido Acero de herra. templado	282,000	200	-	1300-1050-820	840-710-570	-	-		
P3.0.Z.HT	03.21		435,500	325	-	640-530-420	465-370-290	-	-		
P1.5.C.UT	06.1	Acero fundido No aleado De baja aleación (elementos de aleación ≤5%) Alta aleación (elementos de aleación >5%)	225,000	180	-	850-700-570	740-600-470	-	-		
P2.6.C.UT	06.2		230,500	200	-	880-730-550	580-470-345	-	-		
P3.0.C.UT	06.3		300,500	225	-	660-550-410	460-365-280	-	-		

C

ISO M	N.º CMC	Acero inoxidable	Fuerza de corte específica k_{c1}	Dureza Brinell	<<<< RESISTENCIA AL DESGASTE						
					GC1525		GC1105		GC1115	GC15	GC1515
					h_{max} , pulgadas avance, f_r , pulgadas/rev. a 0° a -5° avance						
Núm. MC	Material	lbs/pulg.²	HB	Velocidad de corte v_c , p/min							
P5.0.Z.AN	05.11	Ferrítico/martensítico Barras/forjadas No templado Templado PH Templado	262,000	200	950-790	1250-990-800	1100-840-650	820-620-485	1000-770-600		
P5.0.Z.PH	05.12		411,500	330	560-490	1150-910-740	610-490-390	470-380-300	560-445-355		
P5.0.Z.HT	05.13		340,000	330	560-490	790-630-510	650-530-460	475-385-340	590-485-425		
M1.0.Z.AQ	05.21	Austenítico Barras/forjadas Austenítico Templado PH Super austenítico	259,000	180	720-640	1350-1050-870	870-700-530	680-540-415	800-640-490		
M1.0.Z.PH	05.22		414,000	330	630-560	720-580-470	610-490-390	470-375-385	560-445-355		
M2.0.Z.AQ	05.23		328,000	200	485-430	810-640-520	730-630-510	550-475-385	670-570-465		
M3.1.Z.AQ	05.51	Austenítico-ferrítico (Dúplex) Barras/forjadas No soldable ≥ 0,05% C Soldable < 0,05% C	286,500	230	-	1050-820-670	830-660-510	640-510-390	760-610-465		
M3.2.Z.AQ	05.52		356,500	260	-	920-740-600	740-550-430	570-415-325	680-500-390		
P5.0.C.UT	15.11	Ferrítico/martensítico Fundición No templado Templado PH Templado	246,500	200	-	-	1050-860-660	790-650-500	960-790-610		
P5.0.C.UT	15.12		354,500	330	-	-	530-430-310	440-355-255	490-395-285		
P5.0.C.HT	15.13		311,000	330	-	-	570-470-350	460-380-280	520-430-320		
M1.0.C.UT	15.21	Austenítico Fundición Austenítico Templado PH Super austenítico	248,000	180	-	-	910-730-560	710-570-435	830-670-510		
M1.0.C.UT	15.22		356,000	330	-	-	530-430-310	440-355-255	485-395-285		
M2.0.C.AQ	15.23		310,500	200	-	-	690-590-490	520-440-365	630-540-445		
M3.1.C.AQ	15.51	Austenítico-ferrítico (Dúplex) Fundición No soldable ≥ 0,05% C Soldable < 0,05% C	258,000	230	-	-	750-550-390	600-440-315	680-500-355		
M3.2.C.AQ	15.52		326,000	260	-	-	670-510-350	550-420-290	610-465-320		

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ISO K	N.º CMC	Fundición	Fuerza de corte específica k_{c1}	Dureza Brinell	<<<< RESISTENCIA AL DESGASTE						
					CB50		CB7525		CB7925	CC620	CC650
					h_{max} , pulgadas avance, f_r , pulgadas/rev. a 0° a -5° avance						
Núm. MC	Material	lbs/pulg.²	HB	Velocidad de corte v_c , p/min							
K1.1.C.NS	07.1	Fundición maleable Ferrítica (viruta corta) Perlitica (viruta larga)	115,000	130	-	-	-	2600-2300-1950	2600-2300-1950		
K1.1.C.NS	07.2		131,000	230	-	-	-	2300-1950-1650	2300-1950-1600		
K2.1.C.UT	08.1	Fundición gris Baja resistencia a la tracción Alta resistencia a la tracción	130,000	180	5600-4650-3950	5600-4650-3950	4750-3950-3400	2650-2300-1950	2650-2300-1950		
K2.2.C.UT	08.2		140,500	220	4800-4000-3450	4800-4000-3450	4100-3400-2900	2500-2100-1750	2500-2100-1750		
K3.1.C.UT	09.1	Hierro SG nodular Ferrítica Perlitica Martensítica	130,000	160	-	-	-	-	2000-1800-1450		
K3.3.C.UT	09.2		194,500	250	-	-	-	-	1650-1450-1150		
K3.4.C.UT	09.3		307,000	380	-	-	-	-	1150-1000-860		

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TURN - SPA

Datos de corte TORNEADO GENERAL

Recomendaciones de velocidad de corte, valores en pulgadas

TENACIDAD >>>>									
GC1125	GC3005	GC4205	GC4215	GC4225	GC2015	GC4235	GC30	GC2025	
.004-.008-.012	.004-.012-.020	.004-.016-.031	.004-.016-.031	.004-.016-.031	.004-.016-.031	.004-.016-.031	.006-.010-.016	.004-.016-.031	
1000-950-830 920-830-730 850-770-690	1700-1350-1100 1550-1200-1000 1450-1150-950	2050-1450-1100 1850-1300-970 1750-1250-920	1850-1350-990 1650-1200-880 1500-1100-790	1650-1150-810 1500-990-710 1400-940-680	1450-980-700 1300-880-630 1200-810-580	1400-890-660 1250-800-590 1200-760-560	990-840-710 890-760-640 850-720-610	970-650-480 870-590-430 820-550-395	
-	1650-1250-980	2000-1350-940	1800-1200-860	1500-1000-710	1300-860-630	980-600-445	700-580-485	720-470-330	
-	-	1750-1150-820	1500-990-710	1300-870-620	1150-750-530	820-500-365	620-520-430	640-405-280	
-	910-700-580	1050-750-570	980-680-510	830-590-455	850-590-460	600-385-280	450-380-315	475-310-215	
-	730-560-465	870-610-460	790-550-415	670-475-365	690-475-375	485-310-225	360-310-255	380-250-175	
-	1200-900-740	1450-970-720	1350-880-650	980-670-500	850-590-430	780-500-345	-	610-405-280	
-	590-425-350	710-460-345	650-415-315	445-310-240	375-275-215	360-225-165	-	280-180-125	
-	910-710-610	1100-770-610	990-700-550	790-580-430	690-510-365	600-450-335	-	460-345-265	
-	880-660-560	950-670-510	860-610-470	690-460-330	590-390-280	540-320-235	-	410-260-180	
-	670-500-420	730-490-380	660-450-345	600-410-295	520-360-250	470-305-220	-	360-245-165	
TENACIDAD >>>>									
GC1125	GC2015	GC30	GC2025	GC2035	GC235				
.004-.008-.012	.008-.016-.024	.006-.010-.016	.008-.016-.024	.008-.016-.024	.008-.016-.024				
910-700-550 510-405-325 540-440-385	850-720-650 410-325-260 475-390-275	720-650-570 285-245-195 315-295-220	750-570-440 360-225-160 390-260-175	590-520-420 280-210-145 310-225-160	425-360-295 230-180-145 245-195-165				
730-580-445 510-405-325 610-520-420	950-780-620 425-325-260 520-440-325	620-570-465 320-275-220 420-385-315	790-570-425 330-235-175 425-325-245	560-470-375 280-210-145 330-295-225	375-325-275 230-180-145 280-230-195				
690-550-420 620-455-355	720-600-470 620-490-390	570-520-425 405-375-350	620-485-355 490-380-290	520-440-340 425-360-275	345-310-260 310-260-230				
870-720-550 445-360-260 475-390-290	820-680-550 325-225-180 360-290-195	660-560-490 255-205-165 300-245-190	720-520-390 275-180-130 390-260-175	560-470-375 230-165-130 240-190-160	375-325-275 195-145-115 215-165-130				
760-610-465 445-360-260 570-490-405	720-590-455 345-260-195 475-375-310	500-445-365 255-205-165 385-330-270	660-500-370 275-180-130 425-290-210	490-390-310 230-165-130 330-260-195	330-295-245 205-145-110 260-210-180				
620-455-325 560-420-290	600-490-440 530-455-340	540-465-280 385-335-205	490-390-290 410-340-260	425-360-275 345-310-245	310-260-230 295-245-210				
TENACIDAD >>>>									
CC6190	CC1690	CT5015	GC3205	GC3210	GC3215	GC3005	GC4215	GC30	H13A
.008-.016-.024	.008-.016-.024	.004-.010-.012	.008-.016-.024	.008-.016-.024	.008-.016-.024	.008-.016-.024	.008-.016-.024	.006-.010-.016	.004-.010-.016
2650-2150-1800 2300-1800-1450	2400-1950-1650 2100-1600-1300	650-530-445 455-370-310	1500-1250-1050 1250-1000-860	1250-1050-860 1050-830-700	850-700-600 690-570-490	820-690-600 770-620-485	1050-870-740 870-720-600	540-540-485 390-355-295	460-410-360 410-360-295
2900-2350-1950 2600-2000-1650	2400-1950-1650 2250-1750-1400	1050-850-710 910-770-670	1750-1400-1200 1400-1150-980	1450-1150-990 1150-950-800	980-820-680 790-650-550	900-810-740 850-730-650	1200-1000-860 930-800-720	750-650-530 580-495-390	590-470-355 460-375-310
-	1900-1450-1100	840-650-530	1300-1100-890	1200-990-810	780-640-540	860-690-590	920-750-630	560-470-385	445-470-310
-	1600-1150-820	740-630-560	1150-980-810	1050-900-730	700-570-490	780-630-520	840-680-560	390-350-295	410-375-290
-	1050-860-710	370-315-275	870-730-620	800-680-550	540-440-375	600-455-355	660-510-410	205-160-120	330-275-210



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TORNEADO GENERAL Datos de corte

Recomendaciones de velocidad de corte, valores en pulgadas

Las recomendaciones son válidas si se utiliza refrigerante.

ISO N	N.º CMC	Metales no-férreos	Fuerza de corte específica k_{c1}	Dureza Brinell	<<<< RESISTENCIA AL DESGASTE		
					CD10	CD1810	H10
Núm. MC	N.º CMC	Material	lbs/pulg. ²	HB	h_{ext} , pulgadas	avance, f_n pulgadas/rev.	a 0° a -5° avance
					.002-.016	.006-.031	.006-.031
					Velocidad de corte v_c , p/min		
Aleaciones de aluminio							
N1.2.Z.UT	30.11	Forjadas o forjadas y trabajadas en frío, sin envejecimiento	58,000	60	6550 (8200-820) ¹⁾	6550 (8200-820) ¹⁾	6550 (8200-820) ¹⁾
N1.2.Z.AG	30.12	Forjadas o forjadas y envejecidas	94,500	100	6550 (8200-820) ¹⁾	6550 (8200-820) ¹⁾	6550 (8200-820) ¹⁾
Aleaciones de aluminio							
N1.3.C.UT	30.21	Fundida, no envejecida	87,000	75	6550 (8200-820) ¹⁾	6550 (8200-820) ¹⁾	6550 (8200-820) ¹⁾
N1.3.C.AG	30.22	Fundición, o fundición y envejecido	101,500	90	6550 (8200-820) ¹⁾	6550 (8200-820) ¹⁾	6550 (8200-820) ¹⁾
Aleaciones de aluminio							
N1.4.C.NS	30.41	Fundidas, 13-15% Si	101,500	130	5000 (6250-630) ¹⁾	2500 (3150-315) ¹⁾	1500 (1900-190) ¹⁾
	30.42	Fundidas, 16-22% Si	101,500	130	2500 (3150-315) ¹⁾	1650 (2050-205) ¹⁾	980 (1250-125) ¹⁾
Cobre y aleaciones de cobre							
N3.3.U.UT	33.1	Aleaciones de fácil mecanización, ≥1% Pb	79,500	110	1650 (2050-205) ¹⁾	1650 (2050-205) ¹⁾	1650 (2050-205) ¹⁾
N3.2.C.UT	33.2	Latón, bronzes con plomo, ≤1% Pb	80,000	90	1650 (2050-205) ¹⁾	1650 (2050-205) ¹⁾	1650 (2050-205) ¹⁾
N3.1.U.UT	33.3	Bronce y cobre sin plomo, incl. cobre electrolítico	196,000	100	980 (1250-125) ¹⁾	980 (1250-125) ¹⁾	980 (1250-125) ¹⁾
ISO S		Material termo-resistente	Fuerza de corte específica k_{c1}	Dureza Brinell	<<<< RESISTENCIA AL DESGASTE		
Núm. MC	N.º CMC				CC650	CC6060	CC6065
Núm. MC	N.º CMC	Material	lbs/pulg. ²	HB	h_{ext} , pulgadas	avance, f_n pulgadas/rev.	a 0° a -5° avance
					.004-.008	.004-.008-.012	.004-.008-.012
					Velocidad de corte v_c , p/min		
Superalaciones termorresistentes							
Base de hierro							
S1.0.U.AN	20.11	Recocidas o tratadas en solución	348,000	200	-	-	-
S1.0.U.AG	20.12	Envejecidas o tratadas en solución y envejecidas	359,000	280	-	-	-
Base de níquel							
S2.0.Z.AN	20.21	Recocidas o tratadas en solución	383,000	250	1300-1050	1300-1050-880	1100-830-650
S2.0.Z.AG	20.22	Envejecidas o tratadas en solución y envejecidas	420,500	350	1100-860	980-770-620	790-570-420
S2.0.C.NS	20.24	Fundición, o fundición y envejecido	436,500	320	720-520	790-660-570	700-580-485
Base de cobalto							
S3.0.Z.AN	20.31	Recocidas o tratadas en solución	391,500	200	1150-840	-	-
S3.0.Z.AG	20.32	Tratadas en solución y envejecidas	432,000	300	980-720	-	-
S3.0.C.NS	20.33	Fundición, o fundición y envejecido	450,500	320	930-730	-	-
Aleaciones de titanio²⁾							
S4.1.Z.UT	23.1	Comercial puro (99.5% Ti)	188,500	Rm ³⁾ 400	.004-.008-.012	.004-.008-.012	.004-.012-.020
S4.2.Z.AN	23.21	Aleaciones α , cerca de α y $\alpha + \beta$, aleaciones	203,000	950	670-550-470	670-550-470	640-530-445
S4.3.Z.AG	23.22	$\alpha + \beta$ envejecidas, aleaciones β recocidas o envejecidas	203,000	1050	280-230-180	280-230-180	265-215-175
					260-195-165	260-195-165	255-190-160
ISO H		Material templado	Fuerza de corte específica k_{c1}	Dureza	<<<< RESISTENCIA AL DESGASTE		
Núm. MC	N.º CMC				CB7015	CB7025	CB20
Núm. MC	N.º CMC	Material	lbs/pulg. ²		h_{ext} , pulgadas	avance, f_n pulgadas/rev.	a 0° a -5° avance
					.002-.006-.010	.002-.006-.010	.002-.006-.010
					Velocidad de corte v_c , p/min		
Acero duro							
H1.1.Z.HA	04.1	Endurecido y templado	366,000	45HRC	-	-	-
H1.1.Z.HA	04.1		445,500	50HRC	1150-870-730	820-690-610	850-760-670
H1.2.Z.HA	04.1		532,000	55HRC	960-730-610	690-580-510	710-630-560
Acero extraduro							
H1.3.Z.HA	04.1	Endurecido y templado	625,500	60HRC	820-620-520	590-490-435	610-540-480
H1.4.Z.HA	04.1		726,500	65HRC	710-530-450	510-425-375	520-465-410
Fundición en coquilla							
H2.0.C.UT	10.1	Fundición, o fundición y envejecido	326,500	400 HB	-	-	-

1) Las velocidades de corte indicadas en la tabla son válidas para todos los avances comprendidos en la gama de avances.

2) Se debe utilizar un ángulo de posición de 45-60°, geometría de corte positiva y refrigerante.

3) Rm = resistencia a la tracción última, medida en MPa.

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TURN - SPA

Datos de corte TORNEADO GENERAL

Recomendaciones de velocidad de corte, valores en pulgadas

TENACIDAD >>>>						
GC1115	GC15	GC1025	GC1125	H13A		
.006-.031	.006-.031	.006-.031	.006-.031	.006-.031		
2650 (3300-330) ¹⁾	2650 (3300-330) ¹⁾	2500 (3150-315) ¹⁾	2500 (3150-315) ¹⁾	6250 (7800-780) ¹⁾		
1050 (1300-130) ¹⁾	1050 (1300-130) ¹⁾	980 (1250-125) ¹⁾	980 (1250-125) ¹⁾	6250 (7800-780) ¹⁾		
2650 (3300-330) ¹⁾ 1750 (2200-220) ¹⁾	2650 (3300-330) ¹⁾ 1750 (2200-220) ¹⁾	2500 (3150-315) ¹⁾ 1650 (2050-205) ¹⁾	2500 (3150-315) ¹⁾ 1650 (2050-205) ¹⁾	6250 (7800-780) ¹⁾ 6250 (7800-780) ¹⁾		
1050 (1300-130) ¹⁾ 720 (900-90) ¹⁾	1050 (1300-130) ¹⁾ 720 (900-90) ¹⁾	980 (1250-125) ¹⁾ 690 (860-85) ¹⁾	980 (1250-125) ¹⁾ 690 (860-85) ¹⁾	1300 (1650-165) ¹⁾ 820 (1050-105) ¹⁾		
690 (860-85) ¹⁾ 410 (510-50) ¹⁾ 290 (365-36) ¹⁾	690 (860-85) ¹⁾ 410 (510-50) ¹⁾ 290 (365-36) ¹⁾	650 (810-80) ¹⁾ 390 (490-50) ¹⁾ 275 (345-34) ¹⁾	650 (810-80) ¹⁾ 390 (490-50) ¹⁾ 275 (345-34) ¹⁾	1500 (1900-190) ¹⁾ 1500 (1900-190) ¹⁾ 890 (1100-110) ¹⁾		

TENACIDAD >>>>									
CC670	S05F	GC1105	GC1115	GC15	GC1005	H10A	H13A	GC1125	H10F
.004-.008-.012	.004-.008-.012	.004-.012-.020	.004-.012-.020	.004-.012-.020	.004-.012-.020	.004-.012-.020	.004-.012-.020	.004-.012-.020	.004-.012-.020
-	520-435-355 410-345-280	490-325-225 390-260-195	395-260-180 315-210-155	395-260-180 315-210-155	490-325-225 390-260-195	280-230-180 215-180-130	260-210-160 195-165-130	245-195-145 180-145-115	230-180-130 165-130-95
1250-1050-880 1050-870-740 970-800-680	325-275-225 295-245-200 260-220-180	295-185-95 265-165-85 235-150-75	235-150-75 215-135-70 190-120-60	235-150-75 215-135-70 190-120-60	295-185-95 265-165-85 235-150-75	180-130-105 130-105-70 85-70-50	165-130-95 130-95-65 80-65-50	150-115-80 115-80-50 75-55-39	130-95-65 100-65-32 65-50-32
1150-830-660 980-720-570 930-730-550	325-275-225 290-245-200 260-220-180	295-185-95 265-165-85 235-150-75	240-150-75 210-135-70 190-120-60	240-150-75 210-135-70 190-120-60	295-185-95 265-165-85 235-150-75	180-130-105 130-105-70 85-70-50	165-130-95 130-95-65 80-65-50	150-115-80 115-80-50 75-55-39	130-95-65 100-65-32 65-50-32
H13A	H10F	GC1115	GC15						
.004-.012-.020	.004-.012-.020	.004-.012-.020	.004-.012-.020						
590-485-410 245-200-165 235-175-150	530-440-370 220-180-145 210-155-135	610-500-425 255-205-170 245-180-155	610-500-425 255-205-170 245-180-155						

TENACIDAD >>>>						
CB7525	CB7925	CC6050	CC670	GC4205	GC4215	H13A
.004-.010-.016	.004-.010-.016	.002-.006-.010	.004-.010-.016	.004-.012-.024	.004-.012-.024	.004-.012-.024
-	-	950-770-570 780-630-470 660-530-395	670-550-440 550-450-365 460-375-305	225-155-95 -	205-135-85 -	145-80-50 - -
680-540-435 570-455-365	-	560-450-335 480-390-290	390-320-260 335-275-225	- -	- -	- -
480-385-310 415-330-270	-					
590-480-390	590-480-390	-	390-290-190	170-95-55	155-85-50	115-65-35

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