

RRD



Fresa idónea para una amplia gama de operaciones como por ejemplo el planeado, el mecanizado profundos y el contorneado.

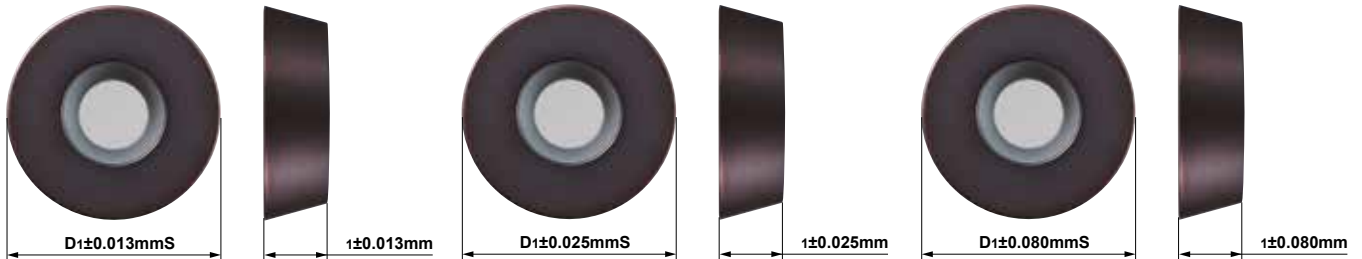


Fresas con placas redondas

RRD

Características

RRD es un concepto de fresado que incorpora plaquitas redondas que se utilizan para máquinas de elevada y baja potencia. Las placas están disponibles en tres tipos de tolerancias para cubrir todas las necesidades en el fresado.



RDHX

RDZX

RDMX

- Retificada en periferia (Tolerancia H)
- Prensado de precisión (Tolerancia E)
- Prensado de semi-precisión (Tolerancia M)
- Para fresado de alta precisión
- Para fresado universal
- Para fresado universal
- Para acabado y semi-acabado
- Placa económica con larga vida
- Para desbaste y semi-acabado


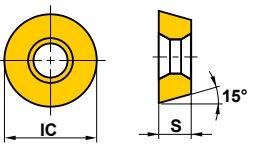

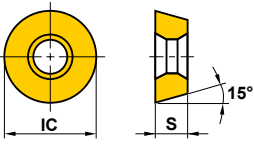

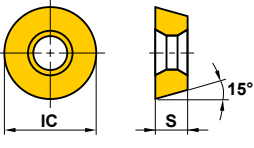
Calidades para placas RRD

ISOM	etal duro recubierto	Cermet / Cermet recubierto	Metal duro		
P Acero P01 P10 P20 P30 P40	VP05HT VP10H VP15TF VP20M E7030	VP25N NX4545	UT120T	↑ Resistencia al desgaste ↓ Tenacidad	
	M01 M10 M20 M30 M40	VP15TF VP20M E7030	VP25N NX4545		UT120T
	K01 K10 K20 K30	VP15TF	VP25N		UT120T
	H01 H10 H20 H30	VP05HT VP10H VP15TF			

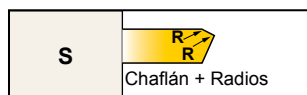
Posibilidades en fresas RRD



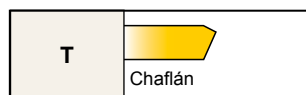
PLACAS

Material	P	Acero	Recubrimiento					Condiciones de corte (Guía):			
	M	Acero Inoxidable	F7030	VP15TF	VP20M	VP10H	VP05HT	Convencional	UTi20T		
Material	K	Fundición	Honing					Dimensiones (mm)			
	S	Aleaciones termo-resistentes, Aleaciones de titanio	Honing					IC	S		
Material	H	Materiales endurecidos	Geometría								
			Clase	Honing							
	RDHX0501M0E	H	E	●	●	●	●	●	5	1.5	
	RDHX0501M0S	H	S	●	●	●	●	●	5	1.5	
	RDHX07T1M0E	H	E	●	●	●	●	●	7	1.98	
	RDHX07T1M0S	H	S	□	●	●	●	●	7	1.98	
	RDHX0702M0E	H	E	●	●	●	●	●	7	2.38	
	RDHX0702M0S	H	S	□	●	●	●	●	7	2.38	
	RDHX1003M0E	H	E	●	●	●	●	●	10	3.18	
	RDHX1003M0S	H	S	□	●	●	●	●	10	3.18	
	RDHX12T3M0E	H	E	●	●	●	●	●	12	3.97	
	RDHX12T3M0S	H	S	□	●	●	●	●	12	3.97	
	RDHX1604M0E	H	E	●	●	●	●	●	16	4.76	
	RDHX1604M0S	H	S	□	●	●	●	●	16	4.76	
IC: ±0.013 mm S: ±0.013 mm											
	RDMX07T1M0E	M	E					●	7	1.98	
	RDMX07T1M0T	M	T	●	●	●	●	□	7	1.98	
	RDMX0702M0E	M	E					●	7	2.38	
	RDMX0702M0T	M	T	●	●	●	●	□	7	2.38	
	RDMX1003M0E	M	E					●	10	3.18	
	RDMX1003M0S	M	S	●	●	●	●	●	10	3.18	
	RDMX1003M0T	M	T	●	●	●	●	●	10	3.18	
	RDMX12T3M0E	M	E					●	12	3.97	
	RDMX12T3M0S	M	S	●	●	●	●	●	12	3.97	
	RDMX12T3M0T	M	T	●	●	●	●	●	12	3.97	
	RDMX1604M0E	M	E					●	16	4.76	
	RDMX1604M0S	M	S	●	●	●	●	●	16	4.76	
RDMX1604M0T	M	T	●	●	●	●	●	16	4.76		
IC: ±0.080 mm S: ±0.080 mm											
	RDZX0501M0E	Z	E	●					5	1.50	
	RDZX0501M0S	Z	S	●					5	1.50	
	RDZX07T1M0E	Z	E	●					7	1.98	
	RDZX07T1M0S	Z	S	●					7	1.98	
	RDZX0702M0E	Z	E	●					7	2.38	
	RDZX0702M0S	Z	S	●					7	2.38	
	RDZX1003M0E	Z	E	●					10	3.18	
	RDZX1003M0S	Z	S	●	●				10	3.18	
	RDZX12T3M0E	Z	E	●					12	3.97	
	RDZX12T3M0S	Z	S	●	●				12	3.97	
	RDZX1604M0E	Z	E	●					16	4.76	
	RDZX1604M0S	Z	S	●	●				16	4.76	
IC: ±0.025 mm S: ±0.025 mm											

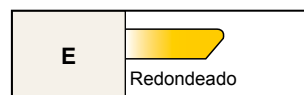
Forma del bisel



Para desbaste



Para desbaste y acabado



Para acabado

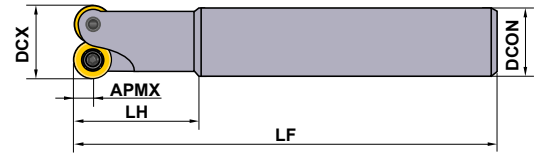
● : Stock Europa. □ : A fabricar según demanda.

FRESADO MULTIFUNCIONAL

RRD



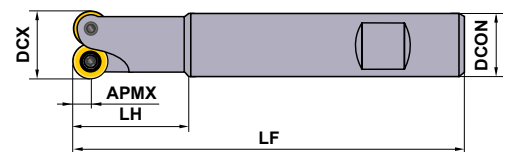
Desbaste



CON MANGO RECTO

Solo herramienta a mano derecha.

R (mm)	Referencia	Stock	Número de dientes	Dimensiones (mm)					Tornillo	Llave	Placa
				DCX	DCON	LF	LH	APMX			
2.5	RRD025R102S10Z-B20	●	2	10	10	75	23	2.5	B-TS20	TKY06F	RDH/Z 0501M0
	RRD025R123S12Z-B20	●	3	12	12	75	23	2.5	B-TS20	TKY06F	
	RRD025R154S16Z-B20	●	4	15	16	80	23	2.5	B-TS20	TKY06F	
3.5	RRD035R122S10Z	●	2	12	10	75	23	3.5	B-TS253	TKY07F	RDH/M/Z 07T1M0
	RRD035R122S12Z	●	2	12	12	75	23	3.5	B-TS253	TKY07F	
	RRD035R122S16Z	●	2	12	16	88	15	3.5	B-TS253	TKY07F	
	RRD035R122S16ZL	●	2	12	16	128	15	3.5	B-TS253	TKY07F	
	RRD035R122S16ZM	●	2	12	16	108	15	3.5	B-TS253	TKY07F	
3.5	RRD035R152S16Z	●	2	15	16	88	18	3.5	TS25	TKY08F	RDH/M/Z 0702M0
	RRD035R152S16ZM	●	2	15	16	108	18	3.5	TS25	TKY08F	
	RRD035R152S20Z	●	2	15	20	130	20	3.5	TS25	TKY08F	
	RRD035R152S20ZM	●	2	15	20	150	20	3.5	TS25	TKY08F	
	RRD035R152S25Z	●	2	15	25	176	20	3.5	TS25	TKY08F	
3.5	RRD035R153S12Z	●	3	15	12	75	17	3.5	TS253	TKY08F	RDH/M/Z 07T1M0
	RRD035R153S16Z	●	3	15	16	78	30	3.5	TS253	TKY08F	
5	RRD050R202S20Z	●	2	20	20	90	31	5.0	B-TS35	TKY15F	RDH/M/Z 1003M0
	RRD050R202S20ZM	●	2	20	20	110	51	5.0	B-TS35	TKY15F	
	RRD050R202S25Z	●	2	20	25	136	72	5.0	B-TS35	TKY15F	
	RRD050R202S25ZL	●	2	20	25	176	112	5.0	B-TS35	TKY15F	
	RRD050R202S25ZM	●	2	20	25	156	92	5.0	B-TS35	TKY15F	



MANGO TIPO WELDON

Solo herramienta a mano derecha.

R (mm)	Referencia	Stock	Número de dientes	Dimensiones (mm)					Tornillo	Llave	Placa
				DCX	DCON	LF	LH	APMX			
3.5	RRD035R122S16W	●	2	12	16	88	15	3.5	B-TS253	TKY07F	RDH/M/Z 07T1M0
	RRD035R122S16WL	●	2	12	16	128	15	3.5	B-TS253	TKY07F	
	RRD035R122S16WM	●	2	12	16	108	15	3.5	B-TS253	TKY07F	
3.5	RRD035R152S16W	●	2	15	16	88	18	3.5	TS25	TKY08F	RDH/M/Z 0702M0
	RRD035R152S16WM	●	2	15	16	108	18	3.5	TS25	TKY08F	
	RRD035R152S20W	●	2	15	20	130	20	3.5	TS25	TKY08F	
	RRD035R152S20WM	●	2	15	20	150	20	3.5	TS25	TKY08F	
	RRD035R152S25W	●	2	15	25	176	20	3.5	TS25	TKY08F	
3.5	RRD035R153S16W	●	3	15	16	78	30	3.5	TS253	TKY08F	RDH/M/Z 07T1M0
5	RRD050R202S20W	●	2	20	20	90	31	5.0	B-TS35	TKY15F	RDH/M/Z 1003M0
	RRD050R202S20WM	●	2	20	20	110	51	5.0	B-TS35	TKY15F	
	RRD050R202S25W	●	2	20	25	135	72	5.0	B-TS35	TKY15F	
	RRD050R202S25WL	●	2	20	25	176	112	5.0	B-TS35	TKY15F	
	RRD050R202S25WM	●	2	20	25	156	92	5.0	B-TS35	TKY15F	

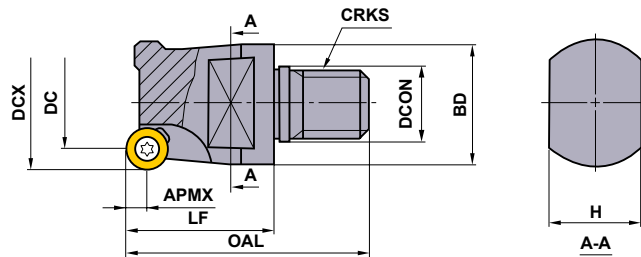
● : Existencia en Europa.

FRESADO MULTIFUNCIONAL

RRD



Desbaste



TIPO TORNILLO

Solo herramienta a mano derecha.

R (mm)	Referencia	Stock	Número de dientes	Dimensiones (mm)								Tornillo	Tornillo	Llave	Placa	
				DCX	DC	OAL	LF	DCON	BD	CRKS	APMX					H
2.5	RRD025R102M5-B20	●	2	10	5	35	20	5.5	9.9	M5	2.5	6	B-TS20	—	TKY06F	RDH/Z 0501M0
	RRD025R123M8-B20	●	3	12	7	38	20	8.5	13.5	M8	2.5	9	B-TS20	—	TKY06F	
	RRD025R154M8-B20	●	4	15	10	38	20	8.5	13.5	M8	2.5	10	B-TS20	—	TKY06F	
	RRD025R205M10-B20	●	5	20	15	44	25	10.5	18	M10	2.5	15	B-TS20	—	TKY06F	
3.5	RRD035R122M8	●	2	12	5	46	28	8.5	13.5	M8	3.5	9	B-TS253	—	TKY07F	RDH/M/Z 07T1M0
	RRD035R153M8	●	3	15	8	46	28	8.5	13.5	M8	3.5	10	TS253	—	TKY08F	
	RRD035R204M10	●	4	20	13	47	28	10.5	18	M10	3.5	15	TS253	—	TKY08F	
	RRD035R255M12	●	5	25	18	50	28	12.5	21	M12	3.5	17	TS253	—	TKY08F	
	RRD035R306M16	●	6	30	23	51	28	17	29	M16	3.5	22	TS253	—	TKY08F	
	RRD035R357M16	●	7	35	28	51	28	17	29	M16	3.5	22	TS253	—	TKY08F	
3.5	RRD035R152M8	●	2	15	8	46	28	8.5	13.5	M8	3.5	10	TS25	—	TKY08F	RDH/M/Z 0702M0
	RRD035R153M8X	●	3	15	8	43	28	8.5	13.5	M8	3.5	10	TS25	—	TKY08F	
5	RRD050R202M10	●	2	20	10	47	28	10.5	18	M10	5.0	15	B-TS35	—	TKY15F	RDH/M/Z 1003M0
	RRD050R252M12	●	2	25	15	54	32	12.5	21	M12	5.0	17	B-TS35	—	TKY15F	
	RRD050R253M12	●	3	25	15	54	32	12.5	21	M12	5.0	17	B-TS35	—	TKY15F	
	RRD050R304M12	●	4	30	20	54	32	12.5	21	M12	5.0	17	B-TS35	—	TKY15F	
	RRD050R304M16	●	4	30	20	55	32	17	29	M16	5.0	22	B-TS35	—	TKY15F	
	RRD050R355M16	●	5	35	25	65	42	17	29	M16	5.0	22	B-TS35	—	TKY15F	
	RRD050R426M16	●	6	42	32	65	42	17	29	M16	5.0	22	B-TS35	—	TKY15F	
6	RRD060R242M12	●	2	24	12	54	32	12.5	21	M12	6.0	17	B-TS35	—	TKY15F	RDH/M/Z 12T3M0
	RRD060R353M16	●	3	35	23	65	42	17	29	M16	6.0	22	B-TS35	TS1001	TKY15F	
	RRD060R354M16	●	4	35	23	65	42	17	29	M16	6.0	22	B-TS35	TS1001	TKY15F	
	RRD060R424M16	●	4	42	30	55	32	17	29	M16	6.0	24	B-TS35	TS1001	TKY15F	
	RRD060R425M16	●	5	42	30	65	42	17	29	M16	6.0	22	B-TS35	TS1001	TKY15F	
8	RRD080R322M16	●	2	32	16	65	42	17	29	M16	8.0	22	214	—	TKY20F	RDH/M/Z 1604M0

(Nota) Para husillos del tipo con tornillo, consulte la página K144–K145.

FRESADO MULTIFUNCIONAL

RRD N



Desbaste

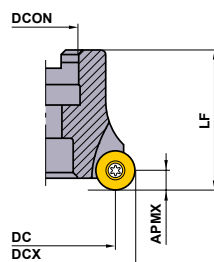








Tabla placas para herramienta RRD.

TIPO FRONTAL

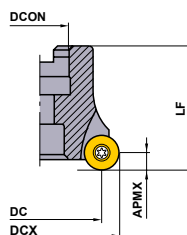
R (mm)	Referencia	Stock	Número de dientes	Dimensiones (mm)					* WT (kg)	     					
				R	DCX	DC	LF	DCON		APMX	Placa Brida	Tornillo Brida	Tornillo	Tornillo	Llave
5	RRD050N-042A06R	●	6	42	32	44	16	5	0.26	—	—	B-TS35	—	TKY15F	RDH/M/Z 1003M0
	RRD050N-052A07R	●	7	52	42	50	22	5	0.4	—	—	B-TS35	—	TKY15F	
6	RRD060N-042A05R	●	5	42	30	42	16	6	0.26	—	—	B-TS35	TS1001	TKY15F	RDH/M/Z 12T3M0
	RRD060N-050A05R	●	5	50	38	50	22	6	0.38	—	—	B-TS35	TS1001	TKY15F	
	RRD060N-052A05R	●	5	52	40	50	22	6	0.4	—	—	B-TS35	TS1001	TKY15F	
	RRD060N-063A06R	●	6	63	51	50	22	6	0.33	—	—	B-TS35	TS1001	TKY15F	
8	RRD080N-050A04R	●	4	50	34	50	22	8	0.4	KS-12	B-TS45	214	—	TKY20F	RDH/M/Z 1604M0
	RRD080N-052A04R	●	4	52	36	50	22	8	0.4	KS-12	B-TS45	214	—	TKY20F	
	RRD080N-052A05R	●	5	52	36	50	22	8	0.4	KS-12	B-TS45	214	—	TKY20F	
	RRD080N-063A05R	●	5	63	47	50	22	8	0.58	KS-12	B-TS45	214	—	TKY20F	
	RRD080N-066A05R	●	5	66	50	50	27	8	0.6	KS-12	B-TS45	214	—	TKY20F	
	RRD080N-080A06R	●	6	80	64	52	27	8	1	KS-12	B-TS45	214	—	TKY20F	
	RRD080N-100A07R	●	7	100	84	52	32	8	1.5	KS-12	B-TS45	214	—	TKY20F	
	RRD080N-125B08R	●	8	125	109	52	40	8	2.5	KS-12	B-TS45	214	—	TKY20F	
RRD080N-160C09R	●	9	160	144	52	40	8	3.5	KS-12	B-TS45	214	—	TKY20F		

* WT : Peso de la herramienta

RRD P









Desbaste



Solo herramienta a mano derecha.

TIPO FRONTAL

R (mm)	Referencia	Stock	Número de dientes	Dimensiones (mm)					* WT (kg)	     					
				R	DCX	DC	LF	DCON		APMX	Placa Brida	Tornillo Brida	Tornillo	Tornillo	Llave
6	RRD060P-050A05R	●	5	50	38	50	22	6	0.33	—	—	B-TS35	TS1001	TKY15F	RDH/M/Z 12T3M0E
	RRD060P-052A05R	●	5	52	40	50	22	6	0.35	—	—	B-TS35	TS1001	TKY15F	
	RRD060P-063A06R	●	6	63	51	50	22	6	0.58	—	—	B-TS35	TS1001	TKY15F	
	RRD060P-066A06R	●	6	66	54	52	27	6	0.6	—	—	B-TS35	TS1001	TKY15F	
	RRD060P-080A07R	●	7	80	68	50	27	6	1.0	—	—	B-TS35	TS1001	TKY15F	
8	RRD080P-050A04R	●	4	50	34	50	22	8	0.33	KS-12	B-TS45	214	—	TKY20F	RDH/M/Z 1604M0
	RRD080P-063A05R	●	5	63	47	50	22	8	0.53	KS-12	B-TS45	214	—	TKY20F	
	RRD080P-066A05R	●	5	66	50	50	27	8	0.55	KS-12	B-TS45	214	—	TKY20F	
	RRD080P-080A06R	●	6	80	64	52	27	8	1.0	KS-12	B-TS45	214	—	TKY20F	
	RRD080P-100A07R	●	7	100	84	52	32	8	1.5	KS-12	B-TS45	214	—	TKY20F	
	RRD080P-125B08R	●	8	125	109	52	40	8	2.6	KS-12	B-TS45	214	—	TKY20F	
	RRD080P-160C09R	●	9	160	144	52	40	8	3.5	KS-12	B-TS45	214	—	TKY20F	

* WT : Peso de la herramienta

● : Existencia en Europa.

CONDICIONES DE CORTE RECOMENDADAS

CONDICIONES DE CORTE PARA DESBASTE (ae=50% of Ø)

Material	Dureza	Calidad	Velocidad de corte (m/min)	Ø10-15mm		Ø20mm		Ø24-25mm		Ø30-42mm		Ø50-80mm		Ø100-160mm	
				ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)
P Acero Dulce	≤180HB	NX4545 F7030 VP15TF	(250-320)	-0.2	0.25	-0.5	0.45	-1.0	0.35	-1.0	0.40	-1.0	0.50	-1.5	0.60
			(240-300)	0.2-0.3	0.20	0.5-1.0	0.25	1.0-2.0	0.30	1.5-2.0	0.32	1.0-1.5	0.40	1.5-2.5	0.45
			(200-280)	0.3-0.5	0.12	1.0-1.5	0.15	2.0-2.5	0.20	2.0-3.0	0.25	1.5-3.0	0.35	2.5-5.0	0.35
Acero al carbono Acero aleado	180-350HB	NX4545 F7030 VP15TF	(220-300)	-0.2	0.20	-0.5	0.40	-1.0	0.30	-1.0	0.40	-1.0	0.50	-1.5	0.55
			(200-290)	0.2-0.3	0.15	0.5-1.0	0.20	1.0-1.5	0.25	1.5-2.0	0.30	1.0-1.5	0.38	1.5-2.5	0.40
			(160-250)	0.3-0.5	0.10	1.0-1.5	0.10	1.5-2.0	0.22	2.0-3.0	0.22	1.5-3.0	0.30	2.5-4.5	0.32
M Acero inoxidable	≤270HB	F7030 VP20M	(180-240)	-0.1	0.15	-0.5	0.20	-1.0	0.20	-1.0	0.25	-1.0	0.25	-1.5	0.30
			(160-200)	0.1-0.2	0.15	0.5-1.0	0.15	1.0-2.0	0.18	1.5-2.0	0.20	1.0-1.5	0.22	1.5-2.5	0.25
			(140-180)	0.2-0.25	0.10	1.0-1.5	0.12	2.0-2.5	0.14	2.0-3.0	0.15	1.5-3.0	0.18	2.5-5.0	0.20
K Fundición	Resistente a la tracción ≤450MPa	VP15TF VP20M VP10H	(200-250)	-0.1	0.15	-0.5	0.18	-1.0	0.20	-1.0	0.25	-1.0	0.30	-1.5	0.35
			(180-230)	0.1-0.2	0.10	0.5-1.0	0.10	1.0-1.5	0.15	1.5-2.0	0.18	1.0-1.5	0.25	1.5-2.5	0.22
			(160-200)	0.2-0.25	0.10	1.0-1.5	0.10	1.5-2.0	0.12	2.0-3.0	0.15	1.5-3.0	0.18	2.5-4.5	0.20
H Acero endurecido	-52HRC -58HRC -60HRC	VP15TF VP10H VP05HT	(140-200)	-0.1	0.12	-0.1	0.14	-0.1	0.15	-0.1	0.18	-0.1	0.18	-0.1	0.20
			(110-180)	0.1-0.15	0.10	0.1-0.20	0.12	0.1-0.30	0.12	0.1-0.30	0.14	0.1-0.30	0.14	0.1-0.30	0.15
			(100-170)	0.1-0.15	0.10	0.1-0.20	0.10	0.1-0.30	0.10	0.1-0.30	0.12	0.1-0.30	0.12	0.1-0.30	0.12

(Nota 1) Cuando utilizamos el ancho completo de corte hay que reducir las condiciones de corte en un 20%.

(Nota 2) Cuando utilizamos un voladizo muy largo por favor reducir las condiciones de corte un 20%.

CONDICIONES DE CORTE PARA ACABADO (ae=20% of Ø)

Material	Dureza	Calidad	Velocidad de corte (m/min)	Ø10-15mm		Ø20mm		Ø24-25mm		Ø30-42mm		Ø50-80mm		Ø100-160mm	
				ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)
P Acero Dulce	≤180HB	NX4545 F7030 VP15TF	(260-360)	-0.1	0.15	-0.15	0.20	-0.15	0.25	-0.15	0.30	-0.15	0.32	-0.3	0.35
			(240-320)	0.1-0.2	0.15	0.1-0.2	0.15	0.1-0.2	0.18	0.1-0.3	0.20	0.1-0.3	0.22	0.2-0.3	0.25
			(220-280)	0.2-0.24	0.10	0.1-0.30	0.15	0.1-0.30	0.18	0.1-0.30	0.20	0.2-0.30	0.20	0.3-0.40	0.20
Acero al carbono Acero aleado	180-350HB	NX4545 F7030 VP15TF	(250-350)	-0.1	0.12	-0.1	0.15	-0.1	0.18	-0.1	0.25	-0.1	0.28	-0.15	0.30
			(230-310)	0.1-0.15	0.12	0.1-0.30	0.15	0.1-0.30	0.15	0.1-0.30	0.20	0.1-0.3	0.22	0.15-0.3	0.25
			(210-270)	0.15-0.2	0.10	0.15-0.30	0.12	0.15-0.30	0.15	0.15-0.30	0.15	0.2-0.3	0.18	0.2-0.3	0.18
M Acero inoxidable	≤270HB	F7030 VP20M	(180-240)	-0.1	0.12	-0.1	0.18	-0.1	0.20	-0.1	0.22	-0.1	0.25	-0.15	0.30
			(160-200)	0.1-0.2	0.10	0.1-0.30	0.12	0.1-0.3	0.15	0.1-0.3	0.18	0.1-0.3	0.20	0.15-0.3	0.22
			(140-180)	0.2-0.25	0.10	0.2-0.30	0.10	0.2-0.3	0.12	0.2-0.3	0.12	0.2-0.3	0.15	0.2-0.3	0.18
K Fundición	Resistente a la tracción ≤450MPa	VP15TF VP20M VP10H	(200-300)	-0.1	0.15	-0.1	0.18	-0.1	0.20	-0.1	0.22	-0.1	0.25	-0.15	0.30
			(200-280)	0.1-0.2	0.10	0.1-0.30	0.10	0.1-0.3	0.15	0.1-0.3	0.15	0.1-0.3	0.20	0.15-0.3	0.22
			(180-240)	0.2-0.25	0.10	0.2-0.40	0.10	0.2-0.4	0.12	0.2-0.4	0.12	0.2-0.4	0.15	0.2-0.4	0.18
H Acero endurecido	-52HRC -58HRC -60HRC	VP15TF VP10H VP05HT	(150-200)	-0.1	0.15	-0.1	0.14	-0.1	0.15	-0.1	0.18	-0.1	0.18	-0.1	0.20
			(120-180)	0.1-0.15	0.10	0.1-0.20	0.12	0.1-0.30	0.12	0.1-0.30	0.14	0.1-0.30	0.14	0.1-0.30	0.15
			(100-180)	0.1-0.15	0.10	0.1-0.20	0.10	0.1-0.30	0.10	0.1-0.30	0.12	0.1-0.30	0.12	0.1-0.30	0.12

(Nota 1) Cuando utilizamos el ancho completo de corte hay que reducir las condiciones de corte en un 20%.

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