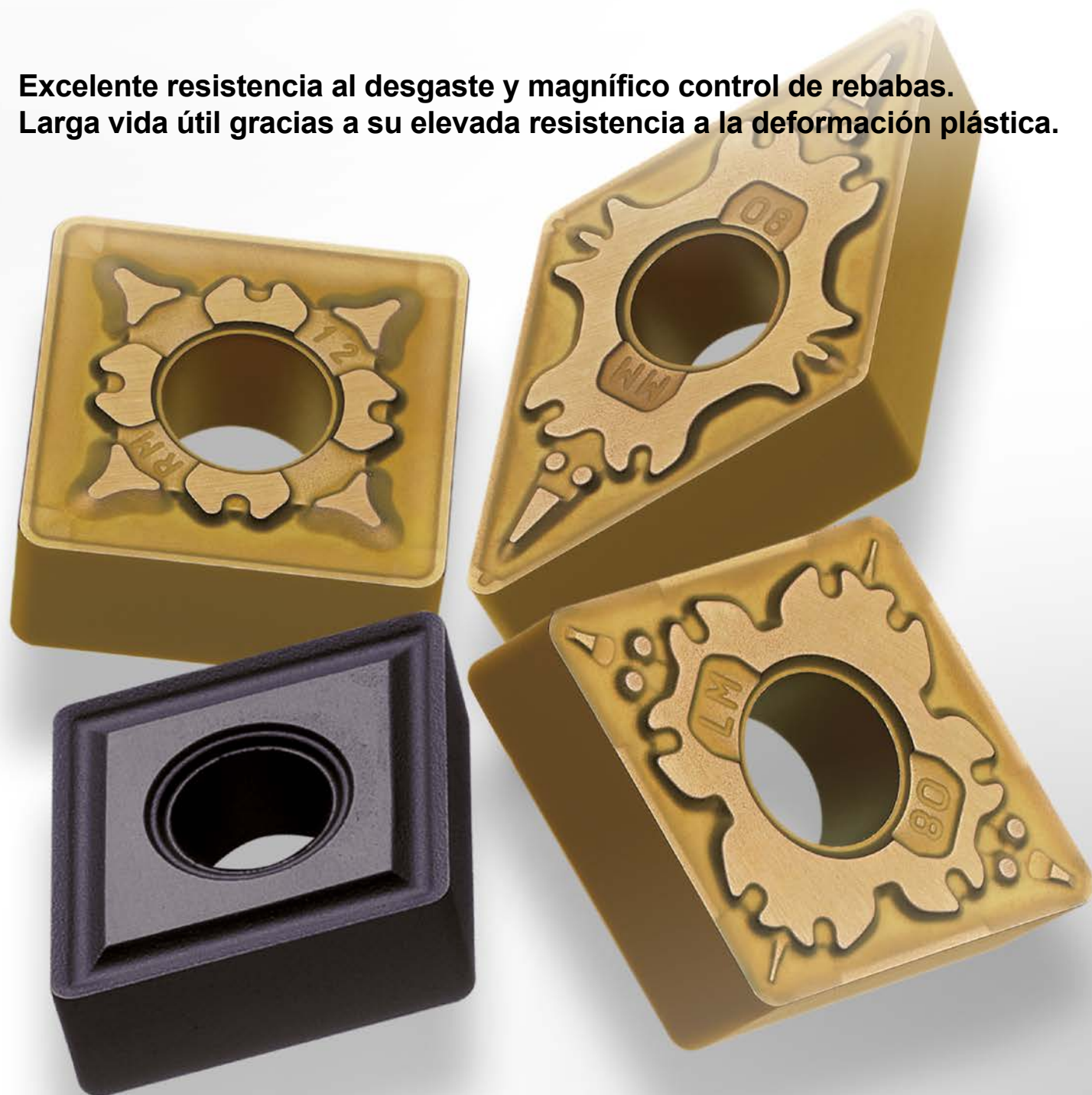


Serie de placa ISO para torneado de acero inoxidable

MIC7000

Revolución en el torneado de acero inoxidable

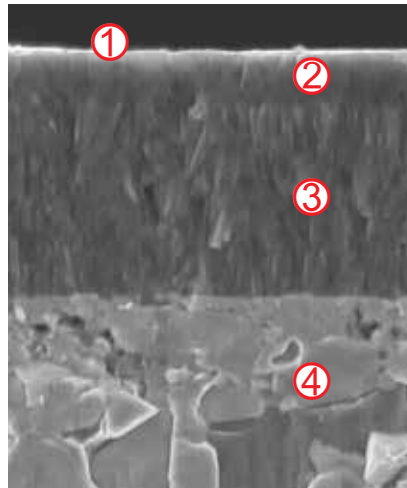
Excelente resistencia al desgaste y magnífico control de rebabas.
Larga vida útil gracias a su elevada resistencia a la deformación plástica.



Serie de placa ISO para torneado de acero inoxidable

Recubrimientos de CVD

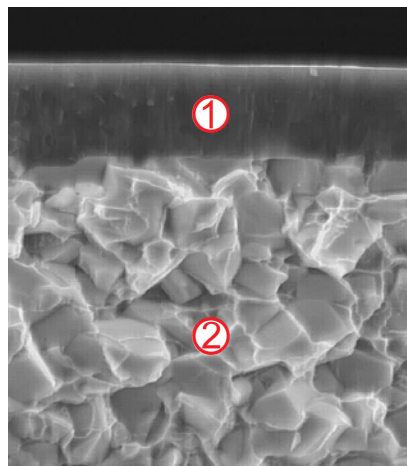
MC7015/MC7025



- ① Filo de corte liso
Previene la adhesión
- ② Rec.capa fina Al₂O₃ nanotexturizado
Controla los daños anormales
- ③ TiCN duro nanotexturizado
Elevada resistencia al desgaste
- ④ Sustrato de Metal Duro especial
Resistencia a la deformación plástica
Resistencia al astillado

Recubrimiento de PVD

MP7035

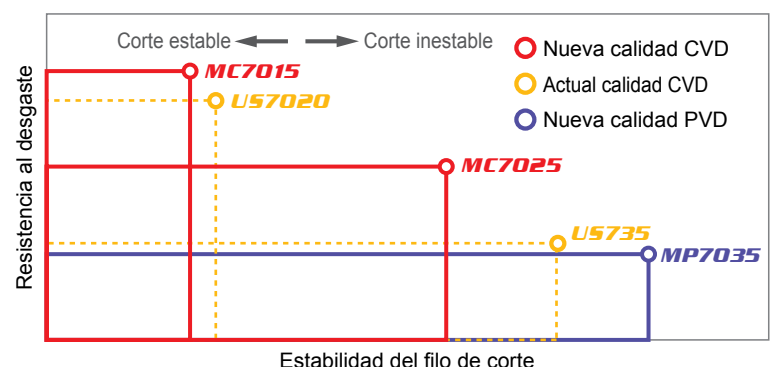


- ① Recubrimiento (Al, Ti)N
Previene la adhesión
- ② Sustrato de Metal Duro especial
Mayor resistencia a la rotura
Resistencia al choque térmico.

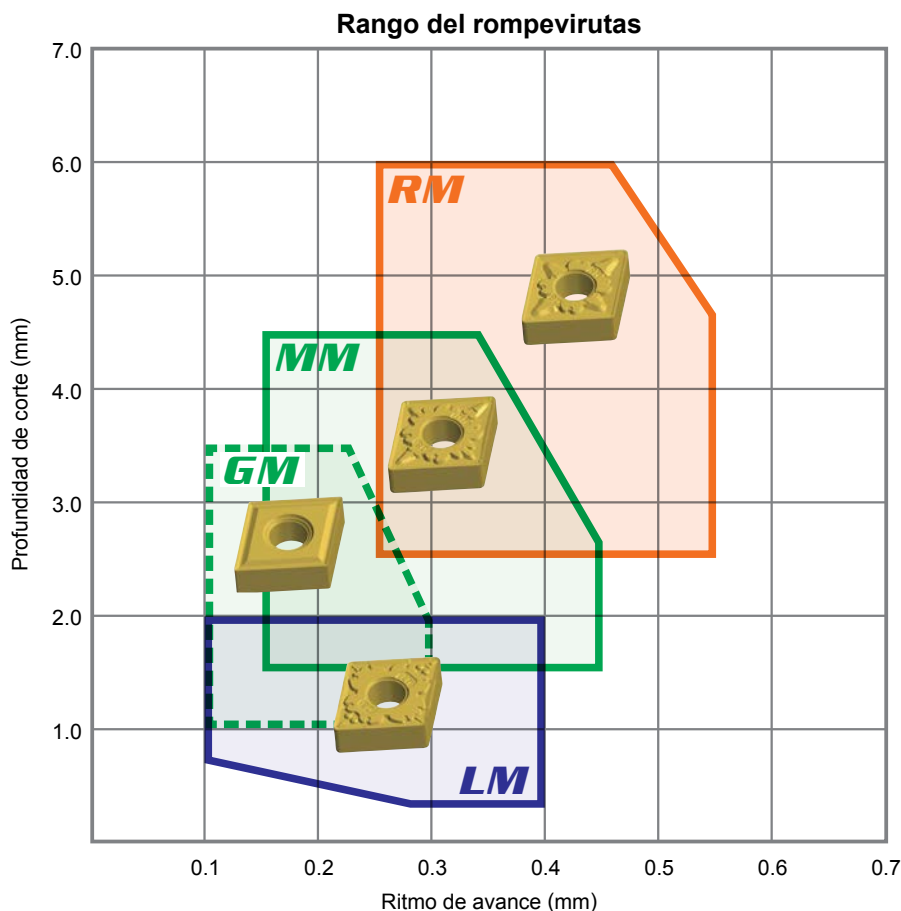
Área de aplicación

ISO	Acero inoxidable
M01	
M10	MC7015
M20	MC7015 MC7025
M30	MC7025 MP7035
M40	MP7035

Concepto de calidad



Sistema rompevirutas para torneado de acero inoxidable

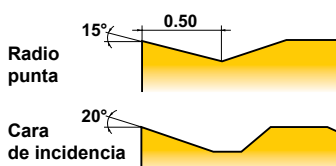


Rompevirutas principales

LM para corte ligero

Excelente control de rebabas

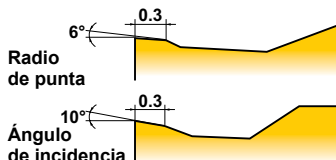
Reduce drásticamente la incidencia de rebabas gracias a la optimización de las propiedades y la fuerza del filo de corte con distintos ángulos de desprendimiento.



MM para corte medio

Excelente resistencia a la deformación plástica

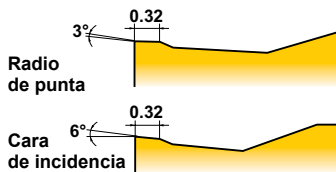
Gracias a la optimización de la geometría mediante la tecnología de análisis de simulación se logró el control de la deformación plástica de la placa y la prolongación de la vida útil de la herramienta.



RM para corte pesado

Excelente resistencia a la rotura

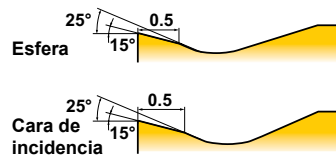
Gracias a la optimización del ángulo de incidencia y la geometría de honing se consigue una alta estabilidad del filo de corte durante el mecanizado interrumpido.



Rompevirutas alternativo

GM

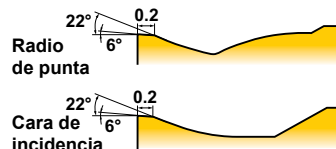
Rompevirutas alternativo, a los rompevirutas principales LM y MM. Excelente resistencia al desgaste para aplicaciones de corte de ligero a medio.



Rompevirutas General

MA


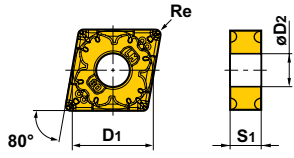

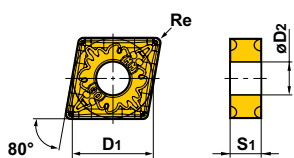

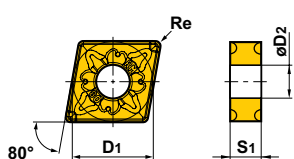

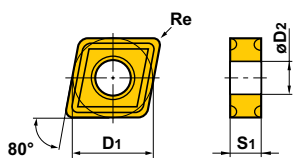

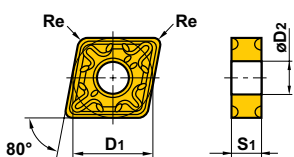

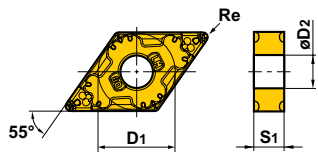

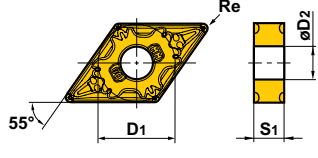
Ideal para aplicaciones de corte medio.




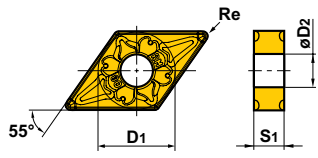
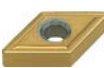
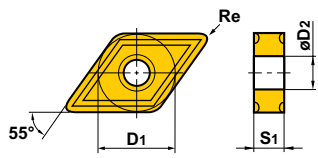

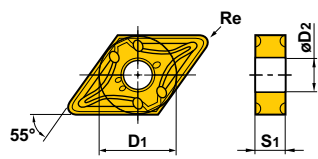

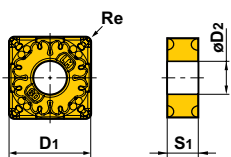

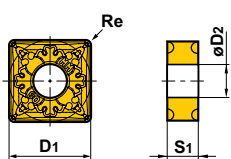

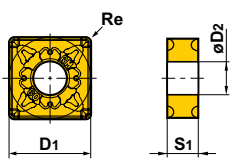

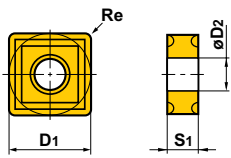
Serie de placa ISO para torneado de acero inoxidable

PLACAS

● Placas negativas (con agujero)


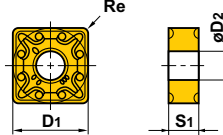

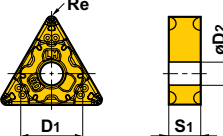

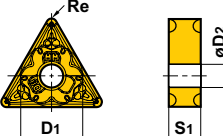

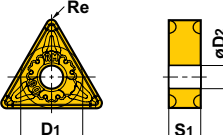

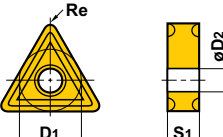

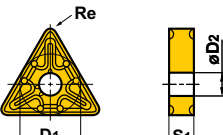

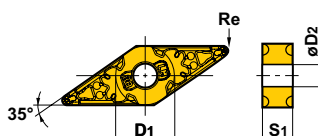

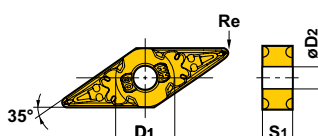
Forma	Referencia	Stock			Dimensiones (mm)				Geometría
		MC7015	MC7025	MP7035	D1	S1	Re	D2	
	CNMG120404-LM	●	●	●	12.7	4.76	0.4	5.16	
	120408-LM	●	●	●	12.7	4.76	0.8	5.16	
	120412-LM	●	●	●	12.7	4.76	1.2	5.16	
Corte ligero									
	CNMG120408-MM	●	●	●	12.7	4.76	0.8	5.16	
	120412-MM	●	●	●	12.7	4.76	1.2	5.16	
	120416-MM	●	●	●	12.7	4.76	1.6	5.16	
	160608-MM	●	●	●	15.875	6.35	0.8	6.35	
	160612-MM	●	●	●	15.875	6.35	1.2	6.35	
	160616-MM	●	●	●	15.875	6.35	1.6	6.35	
	190608-MM	●	●	●	19.05	6.35	0.8	7.93	
	190612-MM	●	●	●	19.05	6.35	1.2	7.93	
190616-MM	●	●	●	19.05	6.35	1.6	7.93		
Corte medio									
	CNMG120408-RM	●	●	●	12.7	4.76	0.8	5.16	
	120412-RM	●	●	●	12.7	4.76	1.2	5.16	
	120416-RM	●	●	●	12.7	4.76	1.6	5.16	
	160612-RM	●	●	●	15.875	6.35	1.2	6.35	
	160616-RM	●	●	●	15.875	6.35	1.6	6.35	
	190612-RM	●	●	●	19.05	6.35	1.2	7.93	
190616-RM	●	●	●	19.05	6.35	1.6	7.93		
Corte pesado									
	CNMG120404-GM	●	●	●	12.7	4.76	0.4	5.16	
	120408-GM	●	●	●	12.7	4.76	0.8	5.16	
	120412-GM	●	●	●	12.7	4.76	1.2	5.16	
Corte medio									
	CNMG120404-MA		●	●	12.7	4.76	0.4	5.16	
	120408-MA		●	●	12.7	4.76	0.8	5.16	
	120412-MA		●	●	12.7	4.76	1.2	5.16	
Corte medio									
	DNMG110404-LM	●	●	●	9.525	4.76	0.4	3.81	
	110408-LM	●	●	●	9.525	4.76	0.8	3.81	
	150404-LM	●	●	●	12.7	4.76	0.4	5.16	
	150408-LM	●	●	●	12.7	4.76	0.8	5.16	
	150412-LM	●	●	●	12.7	4.76	1.2	5.16	
	150604-LM	●	●	●	12.7	6.35	0.4	5.16	
	150608-LM	●	●	●	12.7	6.35	0.8	5.16	
150612-LM	●	●	●	12.7	6.35	1.2	5.16		
Corte ligero									
	DNMG150408-MM	●	●	●	12.7	4.76	0.8	5.16	
	150412-MM	●	●	●	12.7	4.76	1.2	5.16	
	150608-MM	●	●	●	12.7	6.35	0.8	5.16	
	150612-MM	●	●	●	12.7	6.35	1.2	5.16	
Corte medio									

● : Existencia en Europa.


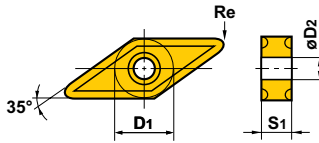

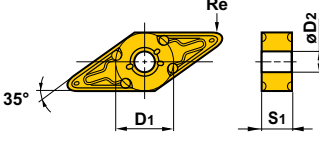

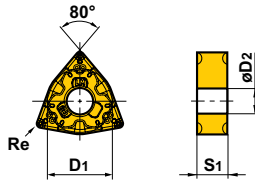

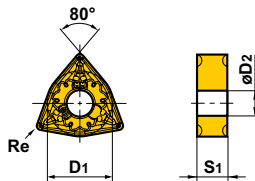

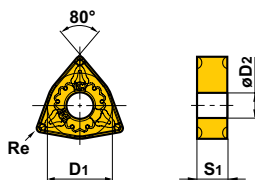

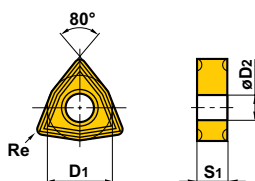

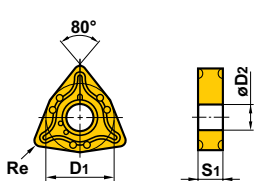
Forma	Referencia	Stock			Dimensiones (mm)				Geometría
		MC7015	MC7025	MP7035	D1	S1	Re	D2	
RM  Corte pesado	DNMG150408-RM	●	●	●	12.7	4.76	0.8	5.16	
	150412-RM	●	●	●	12.7	4.76	1.2	5.16	
	150416-RM	●	●	●	12.7	4.76	1.6	5.16	
	150608-RM	●	●	●	12.7	6.35	0.8	5.16	
	150612-RM	●	●	●	12.7	6.35	1.2	5.16	
	150616-RM	●	●	●	12.7	6.35	1.6	5.16	
GM  Corte medio	DNMG150404-GM	●	●	●	12.7	4.76	0.4	5.16	
	150408-GM	●	●	●	12.7	4.76	0.8	5.16	
	150412-GM	●	●	●	12.7	4.76	1.2	5.16	
	150604-GM	●	●	●	12.7	6.35	0.4	5.16	
	150608-GM	●	●	●	12.7	6.35	0.8	5.16	
	150612-GM	●	●	●	12.7	6.35	1.2	5.16	
MA  Corte medio	DNMG150404-MA		●	●	12.7	4.76	0.4	5.16	
	150408-MA		●	●	12.7	4.76	0.8	5.16	
	150412-MA		●	●	12.7	4.76	1.2	5.16	
	150604-MA		●	●	12.7	6.35	0.4	5.16	
	150608-MA		●	●	12.7	6.35	0.8	5.16	
	150612-MA		●	●	12.7	6.35	1.2	5.16	
LM  Corte ligero	SNMG120404-LM	●	●	●	12.7	4.76	0.4	5.16	
	120408-LM	●	●	●	12.7	4.76	0.8	5.16	
MM  Corte medio	SNMG120408-MM	●	●	●	12.7	4.76	0.8	5.16	
	120412-MM	●	●	●	12.7	4.76	1.2	5.16	
	120416-MM	●	●	●	12.7	4.76	1.6	5.16	
	150608-MM	●	●	●	15.875	6.35	0.8	6.35	
	150612-MM	●	●	●	15.875	6.35	1.2	6.35	
	150616-MM	●	●	●	15.875	6.35	1.6	6.35	
	190612-MM	●	●	●	19.05	6.35	1.2	7.93	
	190616-MM	●	●	●	19.05	6.35	1.6	7.93	
RM  Corte pesado	SNMG120408-RM	●	●	●	12.7	4.76	0.8	5.16	
	120412-RM	●	●	●	12.7	4.76	1.2	5.16	
	120416-RM	●	●	●	12.7	4.76	1.6	5.16	
	150612-RM	●	●	●	15.875	6.35	1.2	6.35	
	150616-RM	●	●	●	15.875	6.35	1.6	6.35	
	190612-RM	●	●	●	19.05	6.35	1.2	7.93	
	190616-RM	●	●	●	19.05	6.35	1.6	7.93	
GM  Corte medio	SNMG120404-GM	●	●	●	12.7	4.76	0.4	5.16	
	120408-GM	●	●	●	12.7	4.76	0.8	5.16	
	120412-GM	●	●	●	12.7	4.76	1.2	5.16	

PLACAS

● Placas negativas (con agujero)

Forma	Referencia	Stock			Dimensiones (mm)				Geometría
		MC7015	MC7025	MP7035	D1	S1	Re	D2	
	SNMG120404-MA		●	●	12.7	4.76	0.4	5.16	
	120408-MA		●	●	12.7	4.76	0.8	5.16	
	120412-MA		●	●	12.7	4.76	1.2	5.16	
Corte medio									
	TNMG160404-LM	●	●	●	9.525	4.76	0.4	3.81	
	160408-LM	●	●	●	9.525	4.76	0.8	3.81	
	160412-LM	●	●	●	9.525	4.76	1.2	3.81	
Corte ligero									
	TNMG160408-MM	●	●	●	9.525	4.76	0.8	3.81	
	160412-MM	●	●	●	9.525	4.76	1.2	3.81	
	220408-MM	●	●	●	12.7	4.76	0.8	5.16	
	220412-MM	●	●	●	12.7	4.76	1.2	5.16	
	220416-MM	●	●	●	12.7	4.76	1.6	5.16	
Corte medio									
	TNMG160408-RM	●	●	●	9.525	4.76	0.8	3.81	
	160412-RM	●	●	●	9.525	4.76	1.2	3.81	
	220408-RM	●	●	●	12.7	4.76	0.8	5.16	
	220412-RM	●	●	●	12.7	4.76	1.2	5.16	
	220416-RM	●	●	●	12.7	4.76	1.6	5.16	
Corte pesado									
	TNMG160404-GM	●	●	●	9.525	4.76	0.4	3.81	
	160408-GM	●	●	●	9.525	4.76	0.8	3.81	
	160412-GM	●	●	●	9.525	4.76	1.2	3.81	
	220408-GM	●	●	●	12.7	4.76	0.8	5.16	
	220412-GM	●	●	●	12.7	4.76	1.2	5.16	
Corte medio									
	TNMG160404-MA		●	●	9.525	4.76	0.4	3.81	
	160408-MA		●	●	9.525	4.76	0.8	3.81	
	160412-MA		●	●	9.525	4.76	1.2	3.81	
	220408-MA		●	●	12.7	4.76	0.8	5.16	
	220412-MA		●	●	12.7	4.76	1.2	5.16	
Corte medio									
	VNMG160404-LM	●	●	●	9.525	4.76	0.4	3.81	
	160408-LM	●	●	●	9.525	4.76	0.8	3.81	
Corte ligero									
	VNMG160408-MM	●	●	●	9.525	4.76	0.8	3.81	
Corte medio									


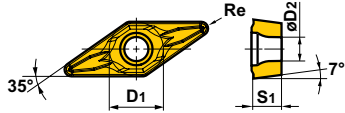

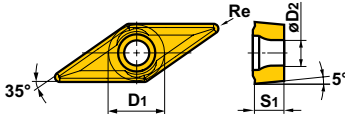
● : Existencia en Europa.

Forma	Referencia	Stock			Dimensiones (mm)				Geometría
		MC7015	MC7025	MP7035	D1	S1	Re	D2	
GM  Corte medio	VNMG160404-GM	●	●	●	9.525	4.76	0.4	3.81	
	160408-GM	●	●	●	9.525	4.76	0.8	3.81	
MA  Corte medio	VNMG160404-MA		●	●	9.525	4.76	0.4	3.81	
	160408-MA		●	●	9.525	4.76	0.8	3.81	
LM  Corte ligero	WNMG060404-LM	●	●	●	9.525	4.76	0.4	3.81	
	060408-LM	●	●	●	9.525	4.76	0.8	3.81	
	080404-LM	●	●	●	12.7	4.76	0.4	5.16	
	080408-LM	●	●	●	12.7	4.76	0.8	5.16	
MM  Corte medio	WNMG060408-MM	●	●	●	9.525	4.76	0.8	3.81	
	060412-MM	●	●	●	9.525	4.76	1.2	3.81	
	080408-MM	●	●	●	12.7	4.76	0.8	5.16	
	080412-MM	●	●	●	12.7	4.76	1.2	5.16	
RM  Corte pesado	WNMG060408-RM	●	●	●	9.525	4.76	0.8	3.81	
	060412-RM	●	●	●	9.525	4.76	1.2	3.81	
	080408-RM	●	●	●	12.7	4.76	0.8	5.16	
	080412-RM	●	●	●	12.7	4.76	1.2	5.16	
GM  Corte medio	WNMG060404-GM	●	●	●	9.525	4.76	0.4	3.81	
	060408-GM	●	●	●	9.525	4.76	0.8	3.81	
	080404-GM	●	●	●	12.7	4.76	0.4	5.16	
	080408-GM	●	●	●	12.7	4.76	0.8	5.16	
	080412-GM	●	●	●	12.7	4.76	1.2	5.16	
MA  Corte medio	WNMG060408-MA		●	●	9.525	4.76	0.8	3.81	
	060412-MA		●	●	9.525	4.76	1.2	3.81	
	080404-MA		●	●	12.7	4.76	0.4	5.16	
	080408-MA		●	●	12.7	4.76	0.8	5.16	
	080412-MA		●	●	12.7	4.76	1.2	5.16	


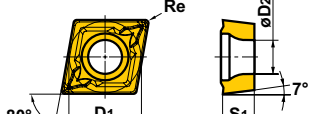

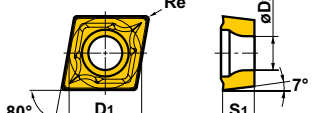

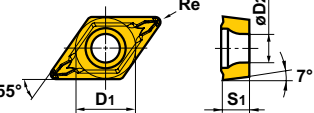

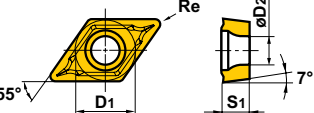

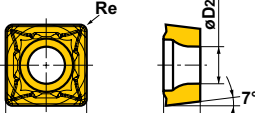
Serie de placa ISO para torneado de acero inoxidable

PLACAS


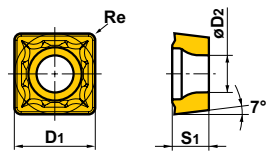

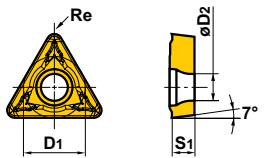

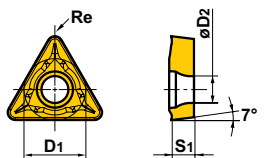

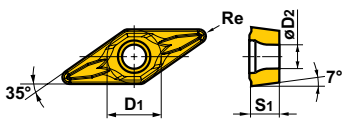

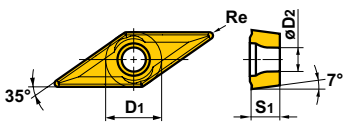
● 5° placas positivas (con agujero)

Forma	Referencia	Stock			Dimensiones (mm)				Geometría
		MC7015	MC7025	MP7035	D1	S1	Re	D2	
 Corte ligero	NEW LM VBMT110304-LM		●	●	6.35	3.18	0.4	2.9	
	110308-LM		●	●	6.35	3.18	0.8	2.9	
	160404-LM		●	●	9.525	4.76	0.4	4.4	
	160408-LM		●	●	9.525	4.76	0.8	4.4	
 Corte medio	NEW MM VBMT160404-MM		●	●	9.525	4.76	0.4	4.4	
	160408-MM		●	●	9.525	4.76	0.8	4.4	

● 7° placas positivas (con agujero)

Forma	Referencia	Stock			Dimensiones (mm)				Geometría
		MC7015	MC7025	MP7035	D1	S1	Re	D2	
 Corte ligero	NEW LM CCMT060204-LM		●	●	6.35	2.38	0.4	2.8	
	060208-LM		●	●	6.35	2.38	0.8	2.8	
	09T304-LM		●	●	9.525	3.97	0.4	4.4	
	09T308-LM		●	●	9.525	3.97	0.8	4.4	
 Corte medio	NEW MM CCMT060204-MM		●	●	6.35	2.38	0.4	2.8	
	060208-MM		●	●	6.35	2.38	0.8	2.8	
	09T304-MM		●	●	9.525	3.97	0.4	4.4	
	09T308-MM		●	●	9.525	3.97	0.8	4.4	
	120404-MM		●	●	12.7	4.76	0.4	5.5	
	120408-MM		●	●	12.7	4.76	0.8	5.5	
 Corte ligero	NEW LM DCMT070204-LM		●	●	6.35	2.38	0.4	2.8	
	070208-LM		●	●	6.35	2.38	0.8	2.8	
	11T304-LM		●	●	9.525	3.97	0.4	4.4	
	11T308-LM		●	●	9.525	3.97	0.8	4.4	
 Corte medio	NEW MM DCMT070204-MM		●	●	6.35	2.38	0.4	2.8	
	070208-MM		●	●	6.35	2.38	0.8	2.8	
	11T304-MM		●	●	9.525	3.97	0.4	4.4	
	11T308-MM		●	●	9.525	3.97	0.8	4.4	
	150404-MM		●	●	12.7	4.76	0.4	5.5	
	150408-MM		●	●	12.7	4.76	0.8	5.5	
 Corte ligero	NEW LM SCMT09T304-LM		●	●	9.525	3.97	0.4	4.4	
	09T308-LM		●	●	9.525	3.97	0.8	4.4	

● : Existencia en Europa.

Forma	Referencia	Stock			Dimensiones (mm)				Geometría
		MC7015	MC7025	MP7035	D1	S1	Re	D2	
 Corte medio	NEW MM SCMT09T304-MM		●	●	9.525	3.97	0.4	4.4	
	09T308-MM		●	●	9.525	3.97	0.8	4.4	
	120404-MM		●	●	12.7	4.76	0.4	5.5	
	120408-MM		●	●	12.7	4.76	0.8	5.5	
 Corte ligero	NEW LM TCMT090204-LM		●	●	5.56	2.38	0.4	2.5	
	090208-LM		●	●	5.56	2.38	0.8	2.5	
	110204-LM		●	●	6.35	2.38	0.4	2.8	
	110208-LM		●	●	6.35	2.38	0.8	2.8	
	16T304-LM		●	●	9.525	3.97	0.4	4.4	
	16T308-LM		●	●	9.525	3.97	0.8	4.4	
 Corte medio	NEW MM TCMT090204-MM		●	●	5.56	2.38	0.4	2.5	
	090208-MM		●	●	5.56	2.38	0.8	2.5	
	110204-MM		●	●	6.35	2.38	0.4	2.8	
	110208-MM		●	●	6.35	2.38	0.8	2.8	
	130304-MM		●	●	7.94	3.18	0.4	3.4	
	16T304-MM		●	●	9.525	3.97	0.4	4.4	
	16T308-MM		●	●	9.525	3.97	0.8	4.4	
	16T312-MM		●	●	9.525	3.97	1.2	4.4	
 Corte ligero	NEW LM VCMT110304-LM		●	●	6.35	3.18	0.4	2.8	
	110308-LM		●	●	6.35	3.18	0.8	2.8	
	160404-LM		●	●	9.525	4.76	0.4	4.4	
	160408-LM		●	●	9.525	4.76	0.8	4.4	
 Corte medio	NEW MM VCMT160404-MM		●	●	9.525	4.76	0.4	4.4	
	160408-MM		●	●	9.525	4.76	0.8	4.4	
	160412-MM		●	●	9.525	4.76	1.2	4.4	

CONDICIONES DE CORTE

Placas negativas (herramientas de torneado externo)

Material de trabajo	Dureza	Condiciones de corte	Área de corte	Rompevirutas	Calidad	Vel. de corte (m/min)	Ritmo de avance (mm/rev.)	Prof. de corte (mm)	
M Acero inoxidable austenítico (X5CrNi189, X5CrNiMo17122)	180HB	Corte estable	Corte ligero	LM	MC7015	180–285	0.10–0.30	0.30–2.00	
			Corte medio	MM	MC7015	160–255	0.15–0.45	0.70–5.00	
			Corte pesado	RM	MC7015	155–245	0.25–0.55	1.50–6.00	
		Corte general	Corte ligero	LM	MC7025	160–215	0.10–0.30	0.30–2.00	
			Corte medio	MM	MC7025	145–195	0.15–0.45	0.70–5.00	
			Corte pesado	RM	MC7025	140–185	0.25–0.55	1.50–6.00	
		Corte inestable	Corte ligero	LM	MP7035	95–155	0.10–0.30	0.30–2.00	
			Corte medio	MM	MP7035	85–140	0.15–0.45	0.70–5.00	
			Corte pesado	RM	MP7035	85–135	0.25–0.55	1.50–6.00	
	Acero inoxidable dúplex (X3CrNiCu1894)	280HB	Corte estable	Corte ligero	LM	MC7015	120–195	0.10–0.30	0.30–2.00
				Corte medio	MM	MC7015	110–175	0.15–0.45	0.70–5.00
				Corte pesado	RM	MC7015	105–165	0.25–0.55	1.50–6.00
Corte general			Corte ligero	LM	MC7025	110–150	0.10–0.30	0.30–2.00	
			Corte medio	MM	MC7025	100–135	0.15–0.45	0.70–5.00	
			Corte pesado	RM	MC7025	95–125	0.25–0.55	1.50–6.00	
Corte inestable		Corte ligero	LM	MP7035	65–105	0.10–0.30	0.30–2.00		
		Corte medio	MM	MP7035	60–95	0.15–0.45	0.70–5.00		
		Corte pesado	RM	MP7035	55–90	0.25–0.55	1.50–6.00		
Aceros inoxidables ferríticos y martensíticos (X12Cr13, X17CrNi162)	180HB	Corte estable	Corte ligero	LM	MC7015	180–285	0.10–0.30	0.30–2.00	
			Corte medio	MM	MC7015	160–255	0.15–0.45	0.70–5.00	
			Corte pesado	RM	MC7015	155–245	0.25–0.55	1.50–6.00	
		Corte general	Corte ligero	LM	MC7025	160–215	0.10–0.30	0.30–2.00	
			Corte medio	MM	MC7025	145–195	0.15–0.45	0.70–5.00	
			Corte pesado	RM	MC7025	140–185	0.25–0.55	1.50–6.00	
		Corte inestable	Corte ligero	LM	MP7035	95–155	0.10–0.30	0.30–2.00	
			Corte medio	MM	MP7035	85–140	0.15–0.45	0.70–5.00	
			Corte pesado	RM	MP7035	85–135	0.25–0.55	1.50–6.00	
Aceros inoxidables endurecidos (17-4PH, 1,4548 17-7PH, 1,4568)	350HB	Corte estable	Corte ligero	LM	MC7015	100–160	0.10–0.30	0.30–2.00	
			Corte medio	MM	MC7015	90–145	0.15–0.45	0.70–5.00	
			Corte pesado	RM	MC7015	85–135	0.25–0.55	1.50–6.00	
		Corte general	Corte ligero	LM	MC7025	90–120	0.10–0.30	0.30–2.00	
			Corte medio	MM	MC7025	80–110	0.15–0.45	0.70–5.00	
			Corte pesado	RM	MC7025	80–105	0.25–0.55	1.50–6.00	
		Corte inestable	Corte ligero	LM	MP7035	55–85	0.10–0.30	0.30–2.00	
			Corte medio	MM	MP7035	50–80	0.15–0.45	0.70–5.00	
			Corte pesado	RM	MP7035	45–75	0.25–0.55	1.50–6.00	

VIDA DE LA HERRAMIENTA

La velocidad de corte afecta a la vida de la herramienta.

En el **TOOL NAVI** de Mitsubishi se aconseja una velocidad de corte de 15-90 minutos que está basada en la ecuación de Taylor. (La relación de la calidad de la herramienta, condiciones de corte y la vida de la herramienta). Cuando el cliente requiera un tipo de herramienta diferente, los valores se obtienen de las calidades detalladas en la tabla de abajo. Multiplicar el coeficiente de las velocidades de corte para calcular una nueva velocidad de corte.

CONDICIONES DE CORTE

Placas negativas (herramientas de torneado externo)

Material de trabajo	Dureza	Condiciones de corte	Área de corte	Rompevirutas	Calidad	Vel. de corte (m/min)	Ritmo de avance (mm/rev.)	Prof. de corte (mm)
Acero inoxidable austenítico (X5CrNi189, X5CrNiMo17122)	180HB	Corte estable	Corte ligero	LM	MC7015	180—285	0.10—0.30	0.30—2.00
			Corte medio	MM	MC7015	160—255	0.15—0.45	0.70—5.00
			Corte pesado	RM	MC7015	155—245	0.25—0.55	1.50—6.00
		Corte general	Corte ligero	LM	MC7025	160—215	0.10—0.30	0.30—2.00
			Corte medio	MM	MC7025	145—195	0.15—0.45	0.70—5.00
			Corte pesado	RM	MC7025	140—185	0.25—0.55	1.50—6.00
		Corte inestable	Corte ligero	LM	MP7035	95—155	0.10—0.30	0.30—2.00
			Corte medio	MM	MP7035	85—140	0.15—0.45	0.70—5.00
			Corte pesado	RM	MP7035	85—135	0.25—0.55	1.50—6.00

M Calidad (Acero Inoxidable) Coeficiente de la velocidad de corte.

Calidades \ Vida	15min	30min	45min	60min	90min
MC7015	1.00	0.83	0.75	0.70	0.63
MC7025	1.00	0.90	0.84	0.80	0.75
MP7035	1.00	0.84	0.76	0.71	0.62

(ej.) Corte medio de acero inoxidable austenítico (200HB)
 Primera recomendación : MC7025
 Placas intercambiables : CNMG120408-MM
 Velocidad de corte recomendada : $v_c=195\text{m/min}$ (Vida = 15min)
 (Vida de la herramienta : $v_c145\text{m/min} = 90\text{min.}$)



Vida de la herramienta requerida por el cliente: 30 minutos.

$$V_c=195 \times 0.90 \approx 175\text{m/min}$$

DUREZA DEL MATERIAL

La dureza del material también afecta a la vida de la herramienta. El **TOOL NAVI** de Mitsubishi aconseja una velocidad de corte según la dureza del material a trabajar. Se obtiene el coeficiente según cada tipo de material en la tabla de abajo. Multiplicar el coeficiente según la calidad por la velocidad de corte recomendada y entonces obtendremos una nueva velocidad de corte.

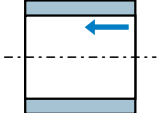
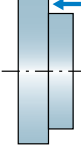
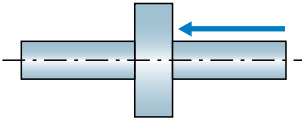






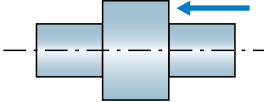
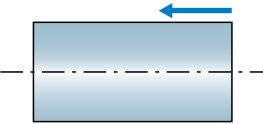
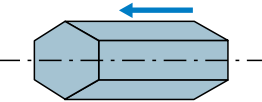






Material	Dureza	Dureza del materia HB									
		Suave ←	-60	-40	-20	0	+20	+40	+60	+80	+100
Acero inoxidable austenítico	180HB	1.41	1.23	1.10	1.0	0.91	0.85	0.72	0.68	0.64	0.61
Acero inoxidable dúplex	280HB	1.25	1.15	1.06	1.0	0.94	0.90	0.85	-	-	-
Aceros inoxidables ferríticos y martensíticos	180HB	1.41	1.23	1.10	1.0	0.91	0.85	0.78	0.72	0.68	0.64
Aceros inoxidables endurecidos	350HB	1.18	1.13	1.07	1.0	0.95	-	-	-	-	-

(ej.) Acero inoxidable austenítico (200HB)



$$V_c=175 \times 0.91 \approx 159\text{m/min}$$

EJEMPLOS DE APLICACIÓN

Placa		WNMG080408-MM	CNMG160612-RM	CNMG120408-MM
Material		1,4308 (G-X6CrNi189) 	Dúplex 1,4460 (X3CrNiMo27-5-2) 	1,4541 (X10CrNiTi189) 
Condiciones	Velocidad de corte (m/min.)	145	100	220
	Ritmo de avance (mm/rev.)	0.13	0.45	0.28
	Profundidad de corte (mm)	2.0	4.0	1.6
Refrigerante		Corte húmedo	Corte húmedo	Corte húmedo
Resultados		Placa convencional MC7025  5 piezas mecanizadas	Placa convencional MC7025  8 piezas mecanizadas	Placa convencional MC7015  4 piezas mecanizadas
Resultados		 10 piezas mecanizadas	 8 piezas mecanizadas	 8 piezas mecanizadas
Placa		CNMG120408-LM	WNMG080408-MM	CNMG120408-LM
Material		1,4529 (X1NiCrMoCuN25-20-6) 	1,4401 (X5CrNiMo1810) 	1,4350 (X5CrNi189) 
Condiciones	Velocidad de corte (m/min.)	140	122	80
	Ritmo de avance (mm/rev.)	0.2	0.3	0.1
	Profundidad de corte (mm)	1.1	2.2	2
Refrigerante		Corte húmedo	Corte húmedo	Corte húmedo
Resultados		Placa convencional MC7025  12 piezas mecanizadas	Placa convencional MC7015  60 piezas mecanizadas	Placa convencional MP7035  5 piezas mecanizadas
Resultados		 15 piezas mecanizadas	 60 piezas mecanizadas	 5 piezas mecanizadas



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