

OFERTA ESPECIAL

# CHAFLANADOR

CON PLAQUITA INTERCAMBIABLE

# GRANDE

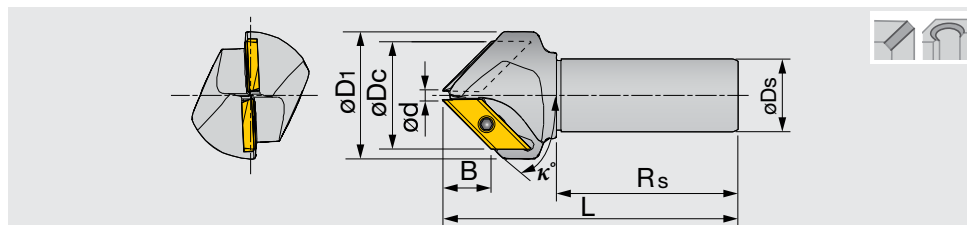


| Referencia    | Capacidad | Precio KLK neto |
|---------------|-----------|-----------------|
| ECC31005R- 30 | Ø5- 34    | 170,00€         |
| ECC31005R- 45 | Ø5- 46    | 190,00 €        |
| ECC31005R- 60 | Ø5- 55    | 200,00 €        |

### Plaquita\*

|              |       |         |
|--------------|-------|---------|
| XCET310404ER | SJ330 | 42,16 € |
|--------------|-------|---------|

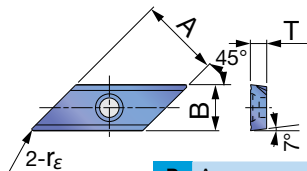
ECC31



| Referencia   | ØDc | z | κ° | ØD1 | ød  | B    | ØDs | ℓs | L     | Plaquita    |
|--------------|-----|---|----|-----|-----|------|-----|----|-------|-------------|
| ECC31005R-30 | 34  | 1 | 30 | 40  | 5.0 | 25.5 | 32  | 80 | 130.2 | XCET3104... |
| ECC31005R-45 | 46  | 2 | 45 | 56  | 5.0 | 20.5 | 32  | 80 | 130.1 | XCET3104... |
| ECC31005R-60 | 55  | 2 | 60 | 72  | 5.0 | 14.5 | 32  | 80 | 130.1 | XCET3104... |

### Plaquita

XCET31



### REPUESTOS

| Referencia | Tornillo | de | Lubrificacöte | Llave |
|------------|----------|----|---------------|-------|
| ECC31...   | CSTB-5S  |    | M-1000        | T-20D |

|   |                  |   |   |   |  |  |  |  |  |
|---|------------------|---|---|---|--|--|--|--|--|
| P | Acero            | ★ | ★ | ☆ |  |  |  |  |  |
| M | Inoxidable       | ★ |   |   |  |  |  |  |  |
| K | Fundición        | ★ |   |   |  |  |  |  |  |
| N | No ferroso       |   |   |   |  |  |  |  |  |
| S | Superalesaciones |   |   |   |  |  |  |  |  |
| H | Materiales duros |   |   |   |  |  |  |  |  |

★ : Primera opción  
☆ : Segunda opción

| Referencia   | rε  | Recubrimiento |       |      | Cermet |  |  | Sin recubrimiento |  |  | A  | B    | T   |
|--------------|-----|---------------|-------|------|--------|--|--|-------------------|--|--|----|------|-----|
|              |     | SJ330         | CT400 | HM30 |        |  |  |                   |  |  |    |      |     |
| XCET310404ER | 0.4 | ●             |       |      |        |  |  |                   |  |  | 22 | 12.7 | 4.5 |

● : Disponible

# Condiciones de corte estándar

| ISO      | Material de la pieza de trabajo  | Calidad | Nº de revoluciones: n (min <sup>-1</sup> ) | Avance por diente: fz (mm/t) |
|----------|--|---------|--|------------------------------|
| <b>P</b> | Aceros al carbono C55, etc.<br>Aleación de acero 42CrMo4, etc.<br>< 300 HB | CT400   | 1000 - 3000 - 7000                         | 0.1 - 0.25                   |
|          |  | HM30    | 700 - 2000 - 4900                          | 0.1 - 0.25                   |
|          | Aceros inyectados<br>X40CrMoV5-1, etc.<br>< 300 HB                         | SJ330   | 1000 - 3000 - 7000                         | 0.1 - 0.2                    |
| <b>M</b> | Inoxidable Aceros<br>X5CrNi18-10, etc.<br>< 250 HB                         | SJ330   | 1000 - 3000 - 7000                         | 0.1 - 0.25                   |
| <b>K</b> | Fundición (GG-GGG)<br>250, etc.  | SJ330   | 1000 - 3000 - 7000                         | 0.1 - 0.25                   |

Notas:

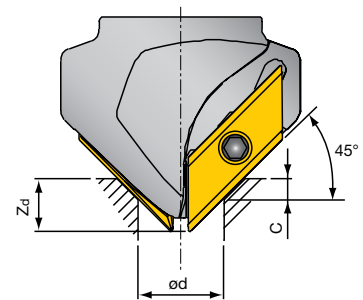
• Cuando el diámetro del agujero a chaflanar es pequeño o se usan las aristas de corte cerca del extremo frontal, aplique los valores altos del rango de revoluciones de la tabla.  
Por el contrario, si el diámetro del agujero a chaflanar es grande o la arista de corte está lejos del extremo de la herramienta, aplique los valores más pequeños del rango de revoluciones de la tabla.

• Cuando se realiza el chaflanado de un agujero de diámetro pequeño (menos de  $\phi 10$  mm) en modo axial, debe emplear avance en picoteo.  
• Si el diámetro del agujero a chaflanar es menor que  $\phi 10$  mm o las aristas de corte están cerca del extremo de la herramienta, el avance debe establecerse en menos de 0.15 mm/t.

## Directrices para la programación

Profundidad axial en eje Z: Z<sub>d</sub> (mm) chaflanado 45° del agujero

| Diá. agujero<br>ød (mm) | Tamaño del chaflán C (mm) |      |      |      |      |      |      |
|-------------------------|---------------------------|------|------|------|------|------|------|
|                         | 0.5                       | 1    | 1.5  | 2    | 3    | 4    | 5    |
| 5                       | 0.7                       | 1.2  | 1.7  | 2.2  | 3.2  | -    | -    |
| 6                       | 1.2                       | 1.7  | 2.2  | 2.7  | 3.7  | -    | -    |
| 6.8                     | 1.6                       | 2.1  | 2.6  | 3.1  | 4.1  | -    | -    |
| 8                       | 2.2                       | 2.7  | 3.2  | 3.7  | 4.7  | -    | -    |
| 8.5                     | 2.4                       | 2.9  | 3.4  | 3.9  | 4.9  | -    | -    |
| 10                      | 3.2                       | 3.7  | 4.2  | 4.7  | 5.7  | 6.7  | 7.7  |
| 10.2                    | 3.3                       | 3.8  | 4.3  | 4.8  | 5.8  | 6.8  | 7.8  |
| 12                      | 4.2                       | 4.7  | 5.2  | 5.7  | 6.7  | 7.7  | 8.7  |
| 14                      | 5.2                       | 5.7  | 6.2  | 6.7  | 7.7  | 8.7  | 9.7  |
| 16                      | 6.2                       | 6.7  | 7.2  | 7.7  | 8.7  | 9.7  | 10.7 |
| 17.5                    | 6.9                       | 7.4  | 7.9  | 8.4  | 9.4  | 10.4 | 11.4 |
| 20                      | 8.2                       | 8.7  | 9.2  | 9.7  | 10.7 | 11.7 | 12.7 |
| 21                      | 8.7                       | 9.2  | 9.7  | 10.2 | 11.2 | 12.2 | 13.2 |
| 24                      | 10.2                      | 10.7 | 11.2 | 11.7 | 12.7 | 13.7 | 14.7 |
| 30                      | 13.2                      | 13.7 | 14.2 | 14.7 | 15.7 | 16.7 | 17.7 |
| 33                      | 14.7                      | 15.2 | 15.7 | 16.2 | 17.2 | 18.2 | 19.2 |
| 36                      | 16.2                      | 16.7 | 17.2 | 17.7 | 18.7 | 19.7 | -    |
| 42                      | 19.2                      | 19.7 | 20.2 | -    | -    | -    | -    |

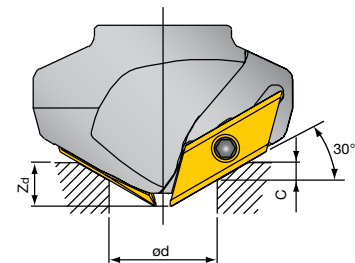


**Herramienta: ECC31005R-45**

Nota: Cuando la profundidad total del agujero es menor que la profundidad axial del eje Z, debe tener cuidado con evitar la interferencia entre el extremo frontal de la herramienta y el fondo del agujero.

Profundidad axial en eje Z: Z<sub>d</sub> (mm) chaflanado 30° del agujero

| Diá. agujero<br>ød (mm) | Tamaño del chaflán C (mm) |      |      |      |      |      |      |
|-------------------------|---------------------------|------|------|------|------|------|------|
|                         | 0.5                       | 1    | 1.5  | 2    | 2.5  | 3    | 3.5  |
| 5                       | 0.6                       | 1.1  | 1.6  | 2.1  | -    | -    | -    |
| 6                       | 0.9                       | 1.4  | 1.9  | 2.4  | -    | -    | -    |
| 6.8                     | 1.1                       | 1.6  | 2.1  | 2.6  | -    | -    | -    |
| 8                       | 1.4                       | 1.9  | 2.4  | 2.9  | -    | -    | -    |
| 8.5                     | 1.6                       | 2.1  | 2.6  | 3.1  | -    | -    | -    |
| 10                      | 2                         | 2.5  | 3    | 3.5  | 4    | 4.5  | 5    |
| 10.2                    | 2.1                       | 2.6  | 3.1  | 3.6  | 4.1  | 4.6  | 5.1  |
| 12                      | 2.6                       | 3.1  | 3.6  | 4.1  | 4.6  | 5.1  | 5.6  |
| 16                      | 3.7                       | 4.2  | 4.7  | 5.2  | 5.7  | 6.2  | 6.7  |
| 17.5                    | 4.2                       | 4.7  | 5.2  | 5.7  | 6.2  | 6.7  | 7.2  |
| 20                      | 4.9                       | 5.4  | 5.9  | 6.4  | 6.9  | 7.4  | 7.9  |
| 21                      | 5.2                       | 5.7  | 6.2  | 6.7  | 7.2  | 7.7  | 8.2  |
| 24                      | 6.1                       | 6.6  | 7.1  | 7.6  | 8.1  | 8.6  | 9.1  |
| 30                      | 7.8                       | 8.3  | 8.8  | 9.3  | 9.8  | 10.3 | 10.8 |
| 33                      | 8.7                       | 9.2  | 9.7  | 10.2 | 10.7 | 11.2 | 11.7 |
| 36                      | 9.5                       | 10   | 10.5 | 11   | 11.5 | 12   | 12.5 |
| 38                      | 10.1                      | 10.6 | 11.1 | 11.6 | 12.1 | 12.6 | 13.1 |
| 42                      | 11.2                      | 11.7 | 12.2 | 12.7 | 13.2 | 13.7 | 14.2 |
| 46                      | 12.4                      | 12.9 | 13.4 | 13.9 | 14.4 | -    | -    |
| 48                      | 13                        | 13.5 | 14   | 14.5 | -    | -    | -    |
| 52                      | 14.1                      | -    | -    | -    | -    | -    | -    |

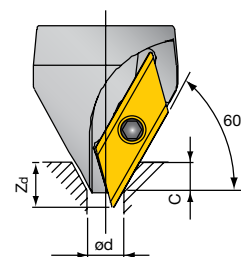


**Herramienta: ECC31005R-60**

Nota: Cuando la profundidad total del agujero es menor que la profundidad axial del eje Z, debe tener cuidado con evitar la interferencia entre el extremo frontal de la herramienta y el fondo del agujero.

Profundidad axial en eje Z: Z<sub>d</sub> (mm) chaflanado 60° del agujero

| Diá. agujero<br>ød (mm) | Tamaño del chaflán C (mm) |      |      |      |      |      |      |      |
|-------------------------|---------------------------|------|------|------|------|------|------|------|
|                         | 0.5                       | 1    | 1.5  | 2    | 2.5  | 3    | 3.5  | 4    |
| 5                       | 0.8                       | 1.3  | 1.8  | 2.3  | 2.8  | -    | -    | -    |
| 6                       | 1.7                       | 2.2  | 2.7  | 3.2  | 3.7  | -    | -    | -    |
| 6.8                     | 2.4                       | 2.9  | 3.4  | 3.9  | 4.4  | -    | -    | -    |
| 8                       | 3.4                       | 3.9  | 4.4  | 4.9  | 5.4  | -    | -    | -    |
| 8.5                     | 3.8                       | 4.3  | 4.8  | 5.3  | 5.8  | -    | -    | -    |
| 10                      | 5.1                       | 5.6  | 6.1  | 6.6  | 7.1  | 7.6  | 8.1  | 8.6  |
| 10.2                    | 5.3                       | 5.8  | 6.3  | 6.8  | 7.3  | 7.8  | 8.3  | 8.8  |
| 12                      | 6.9                       | 7.4  | 7.9  | 8.4  | 8.9  | 9.4  | 9.9  | 10.4 |
| 16                      | 10.3                      | 10.8 | 11.3 | 11.8 | 12.3 | 12.8 | 13.3 | 13.8 |
| 17.5                    | 11.6                      | 12.1 | 12.6 | 13.1 | 13.6 | 14.1 | 14.6 | 15.1 |
| 20                      | 13.7                      | 14.2 | 14.7 | 15.2 | 15.7 | 16.2 | 16.7 | 17.2 |
| 21                      | 14.6                      | 15.1 | 15.6 | 16.1 | 16.6 | 17.1 | 17.6 | 18.1 |
| 24                      | 17.2                      | 17.7 | 18.2 | 18.7 | 19.2 | 19.7 | 20.2 | 20.7 |
| 30                      | 22.4                      | 22.9 | 23.4 | 23.9 | 24.4 | 24.9 | 25.4 | -    |
| 33                      | 24.9                      | 25.4 | -    | -    | -    | -    | -    | -    |



**Herramienta:  
ECC31005R-30**

Nota: Cuando la profundidad total del agujero es menor que la profundidad axial del eje Z, debe tener cuidado con evitar la interferencia entre el extremo frontal de la herramienta y el fondo del agujero.