

Prática de usinagem

Torneamento



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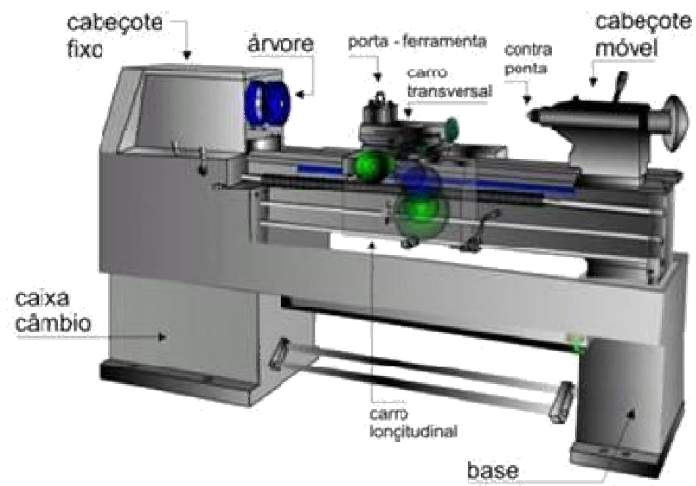
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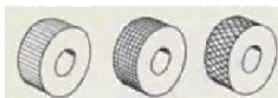
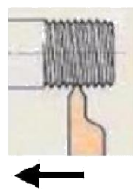
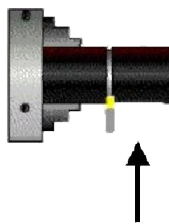
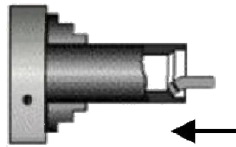
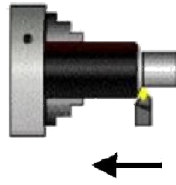
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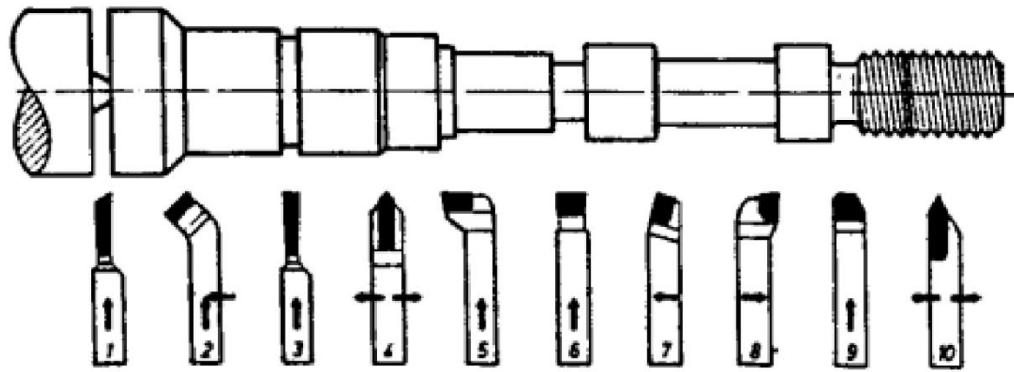
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1.2 - Operações básicas de torneamento.



1.3 – As ferramentas de corte e suas respectivas operações.



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|------------------------|----------------------------------|
| 1. Cortar | 6. Sangrar com grande dimensão |
| 2. Cilindrar à direita | 7. Desbastar à direita |
| 3. Sangrar | 8. Cilindrar e facear à esquerda |
| 4. Alisar | 9. Formar |
| 5. Facear à direita | 10. Roscar |

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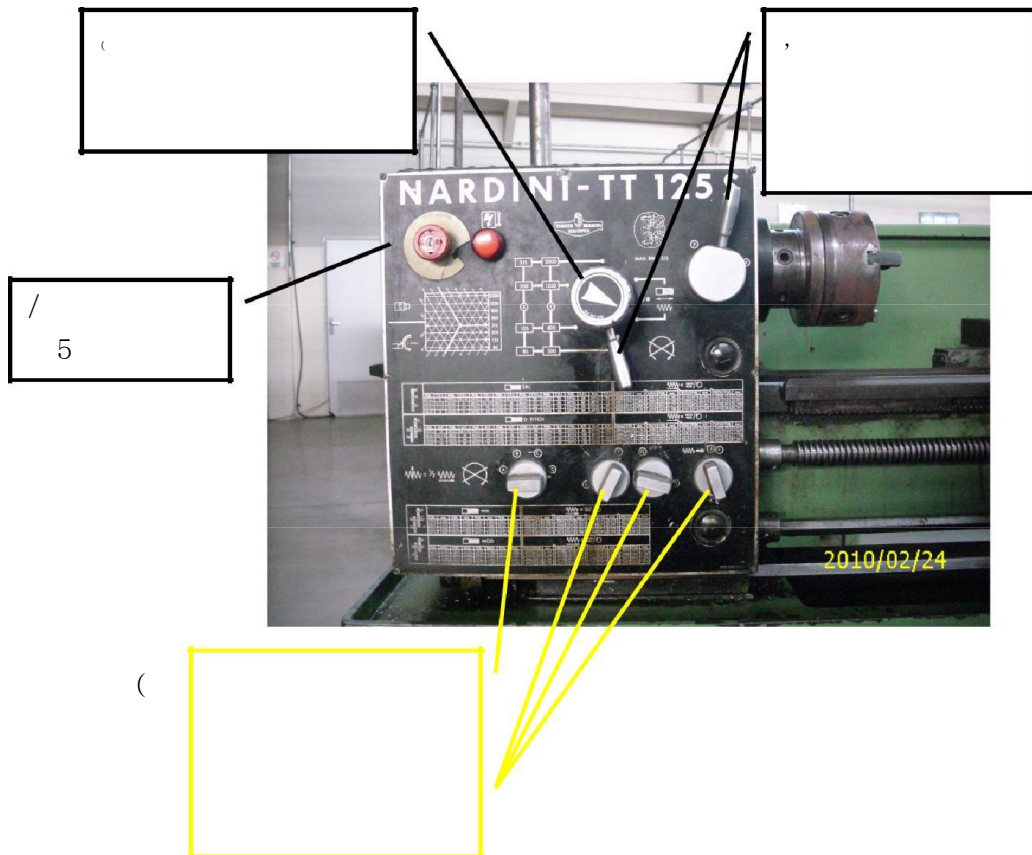
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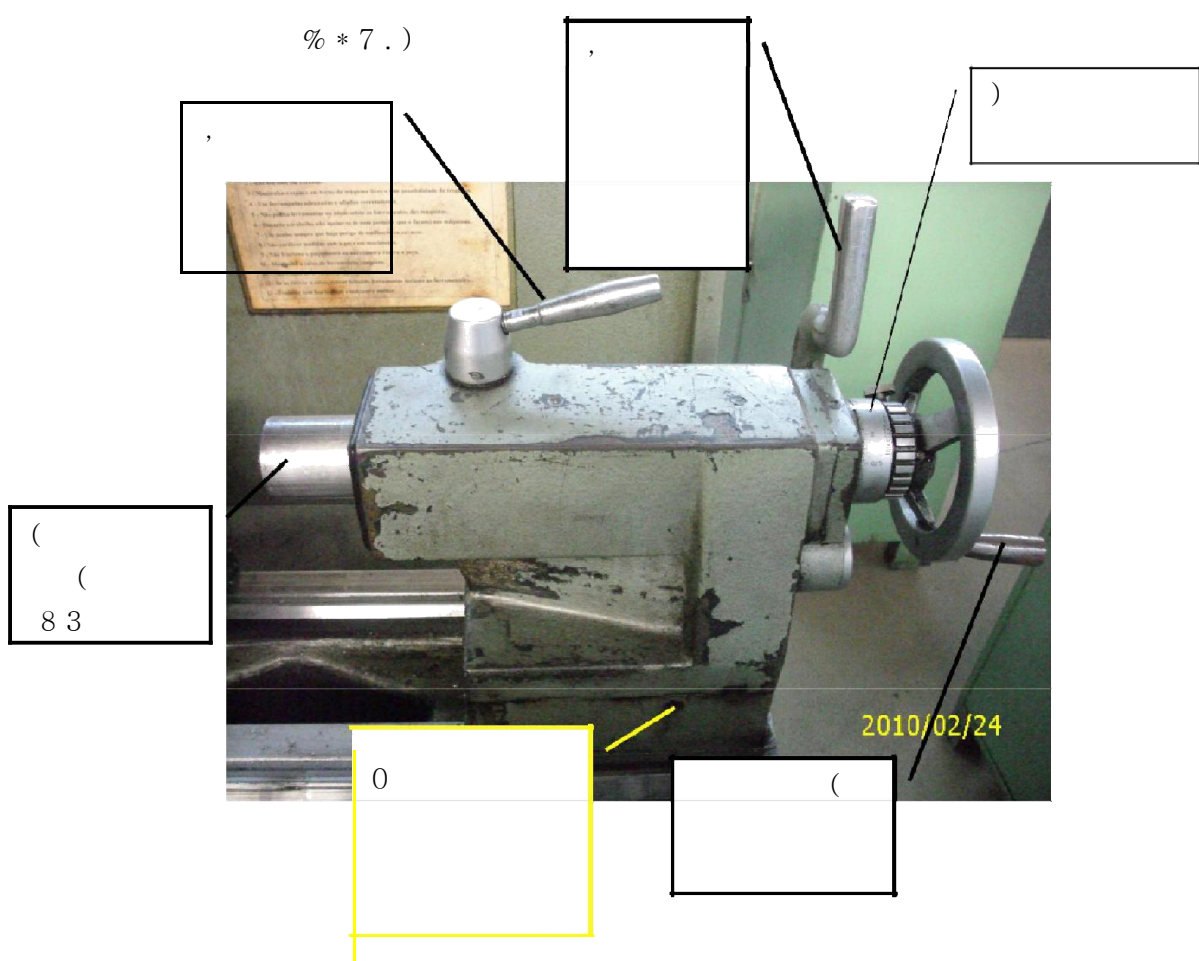
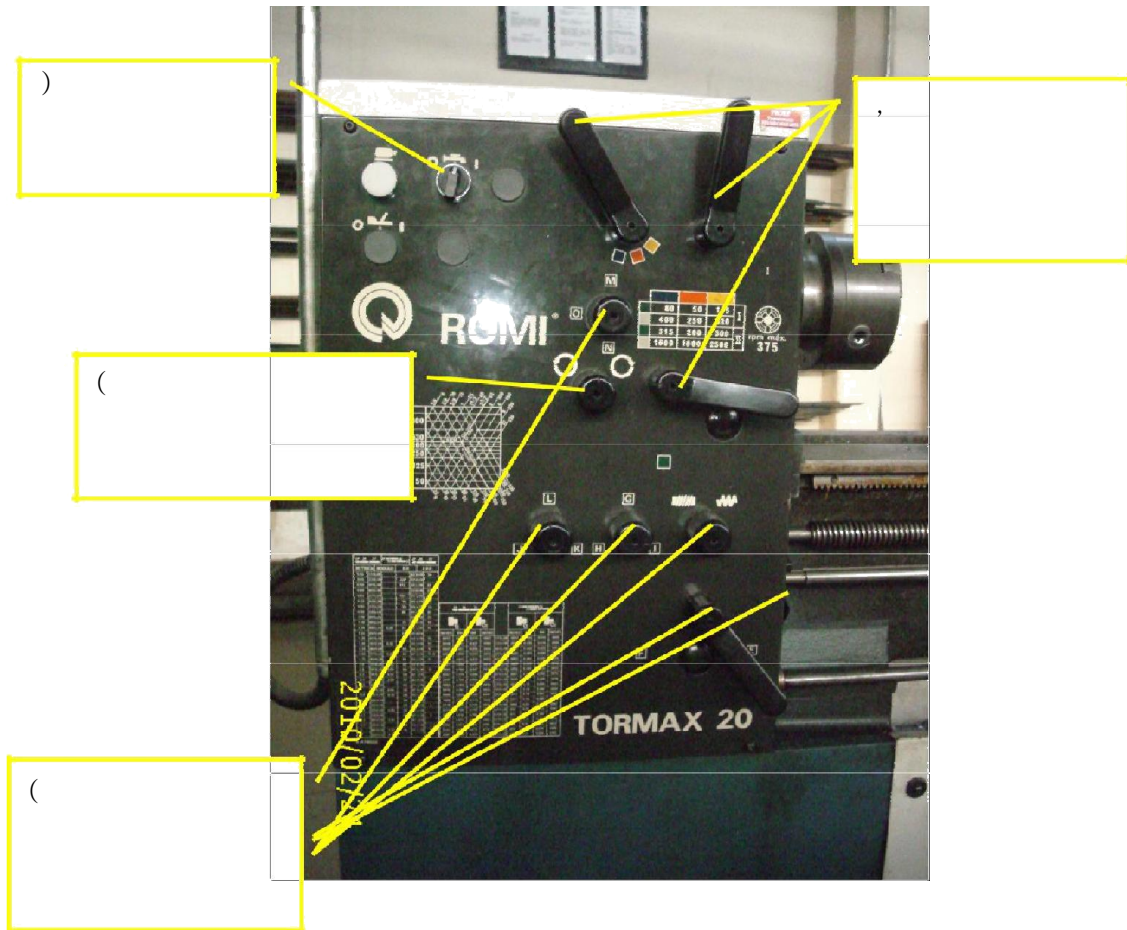
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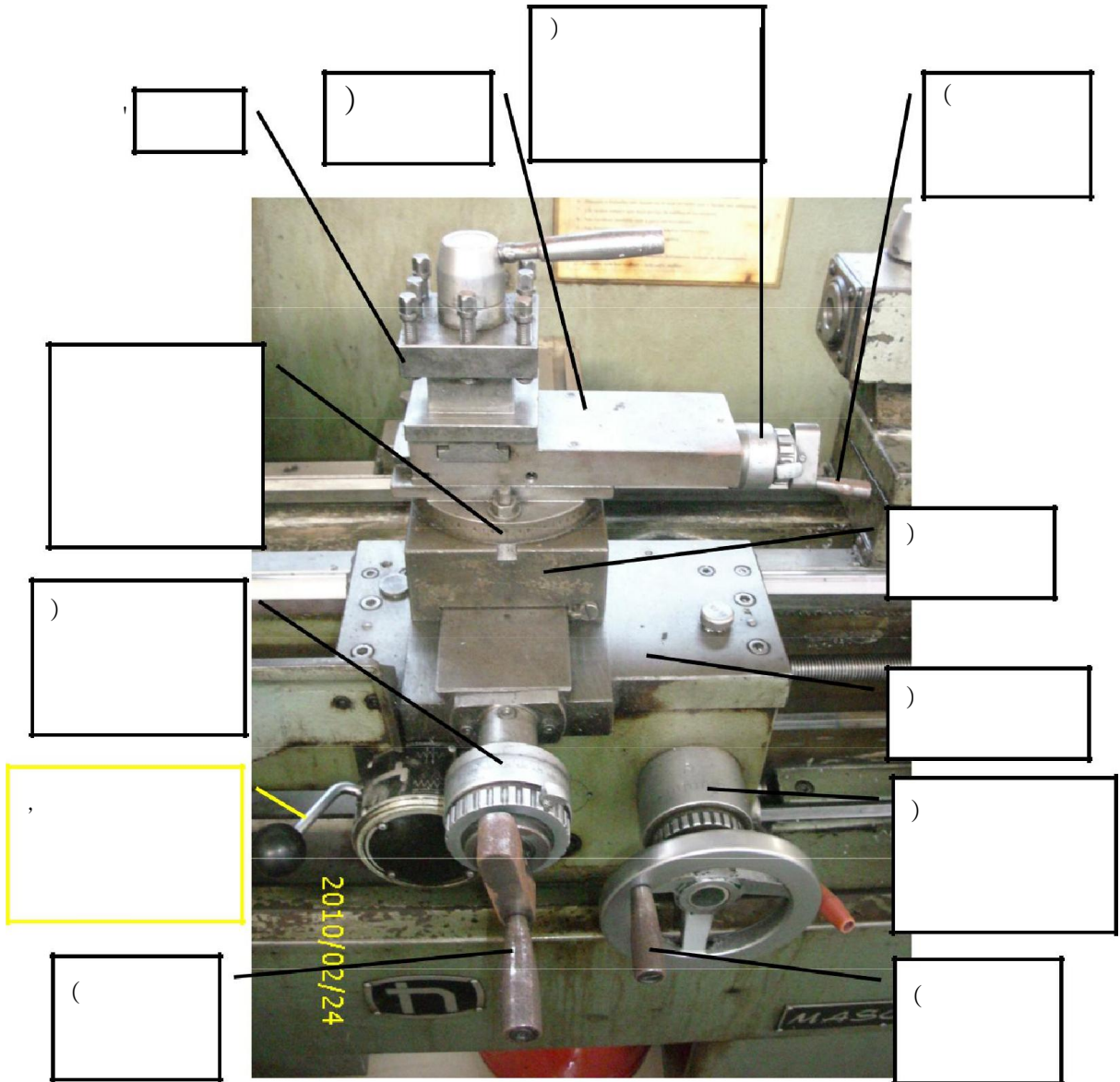
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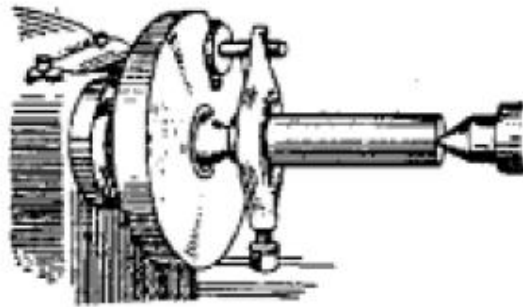
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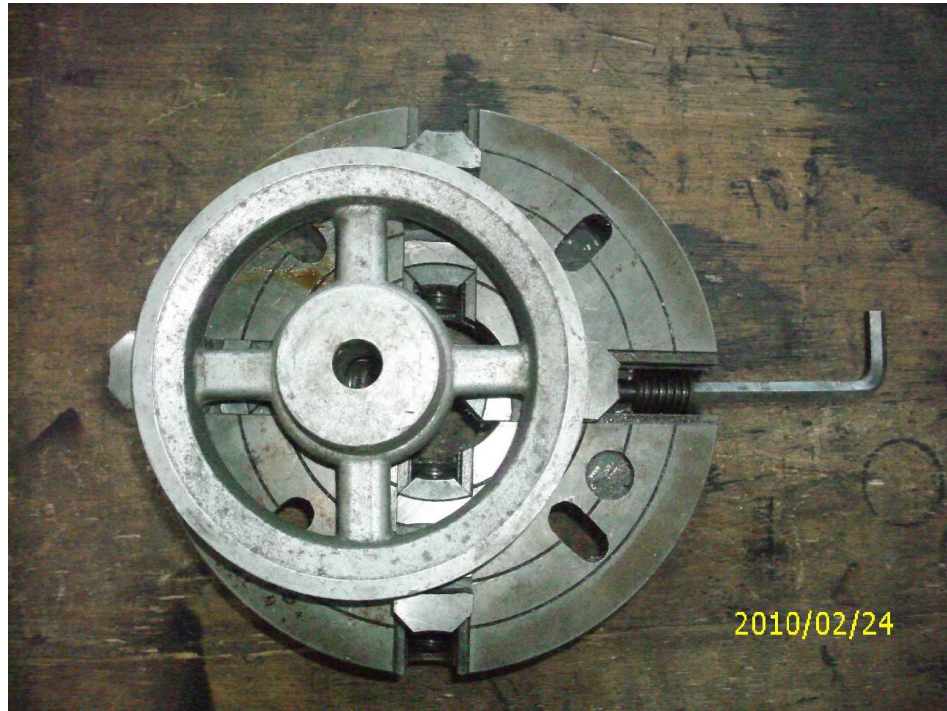


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TABELA DE VELOCIDADE DE CORTE (V) PARA O TORNO (EM METROS POR MINUTO)					
MATERIAIS	FERRAMENTAS DE AÇO RÁPIDO			FERRAMENTAS DE CARBONETO-METÁLICO	
	DESBASTE	ACABAMENTO	ROSCAR RECARTILHAR	DESBASTE	ACABAMENTO
AÇO 1020	25	30	10	200	300
AÇO 1045	20	25	8	120	160
AÇO EXTRADURO 1060	15	20	6	40	60
FERRO FUNDIDO MALEÁVEL	20	25	8	70	85
FERRO FUNDIDO GRIS	15	20	8	65	95
FERRO FUNDIDO DURO	10	15	6	30	50
BRONZE	30	40	10-25	300	380
LATÃO E COBRE	40	50	10-25	350	400
ALUMÍNIO	60	90	15-35	500	700
FIBRA E EBNITE	25	40	10-20	120	150

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$$V_c = \frac{\pi \cdot d \cdot n}{1000} \text{ (m / min)}$$

$d = \text{diâmetro} \qquad \text{em mm}$

$n = \text{rotação} \qquad \text{em rpm}$

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$$\frac{V_c}{1000} \cdot n$$

$$n = \frac{1000 \cdot V_c}{\pi \cdot d} \text{ (rpm)}$$

$V_c = \text{Velocidade de Corte (m / min)}$

$d = \text{diâmetro em mm}$

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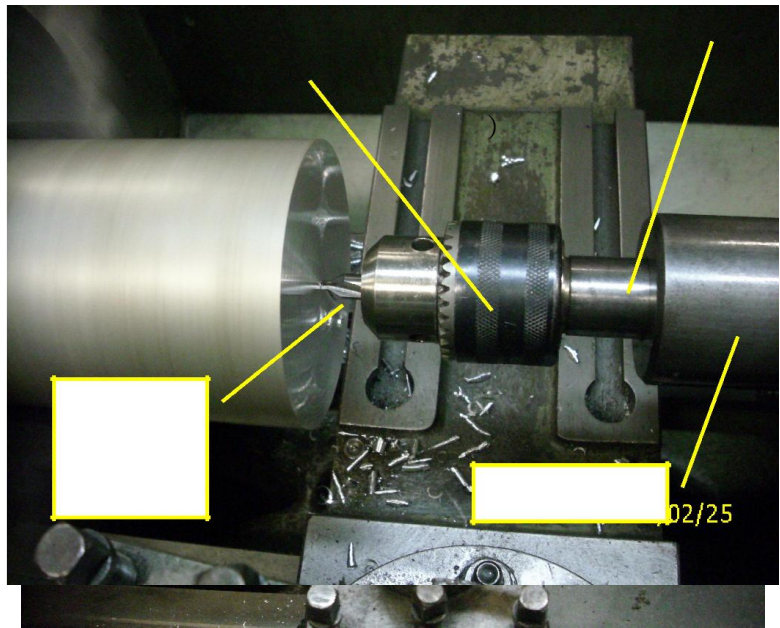
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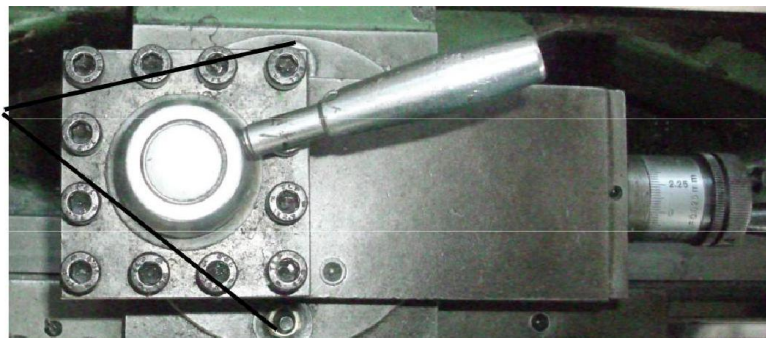
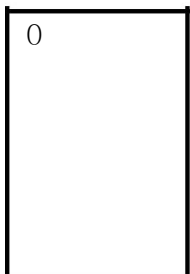


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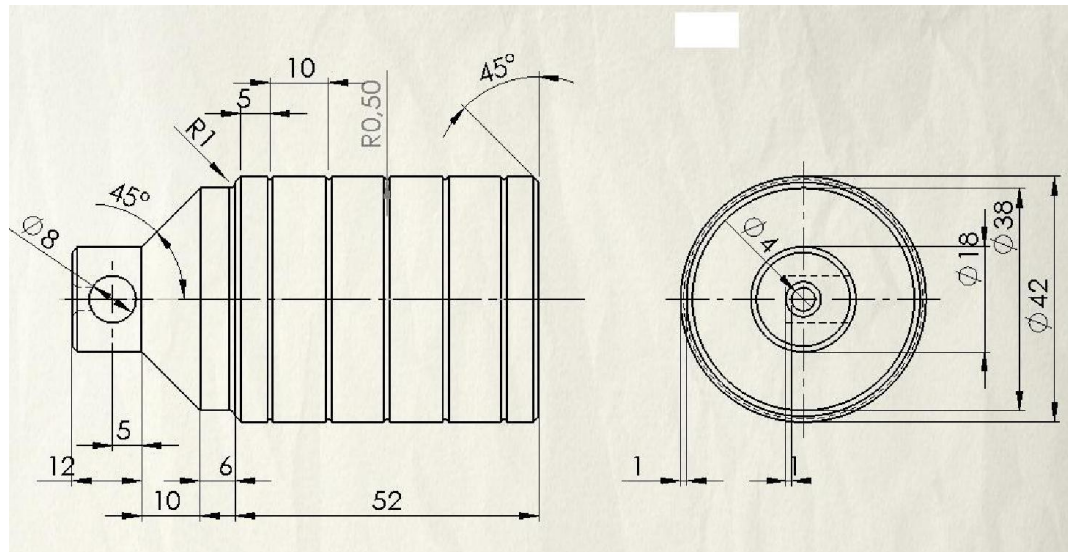
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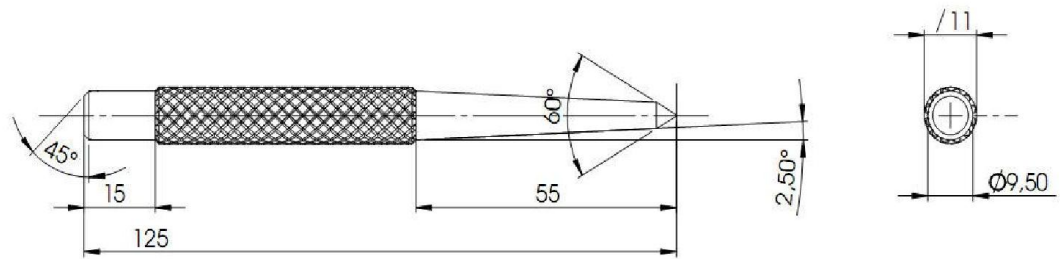
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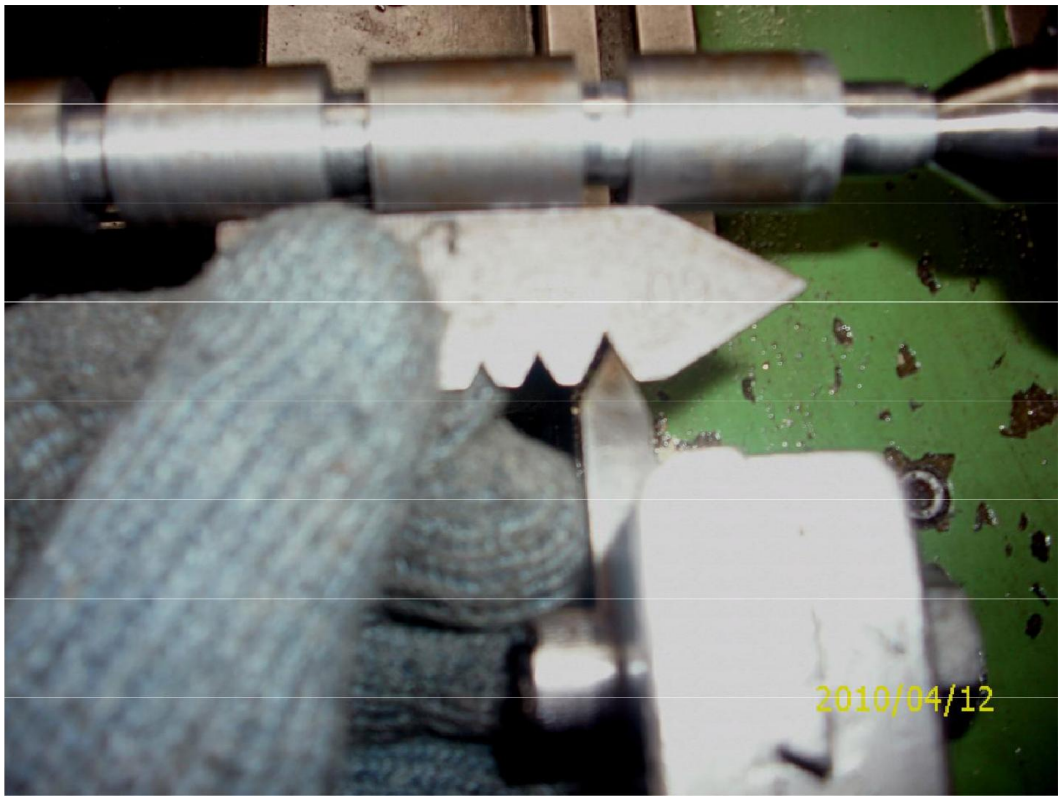


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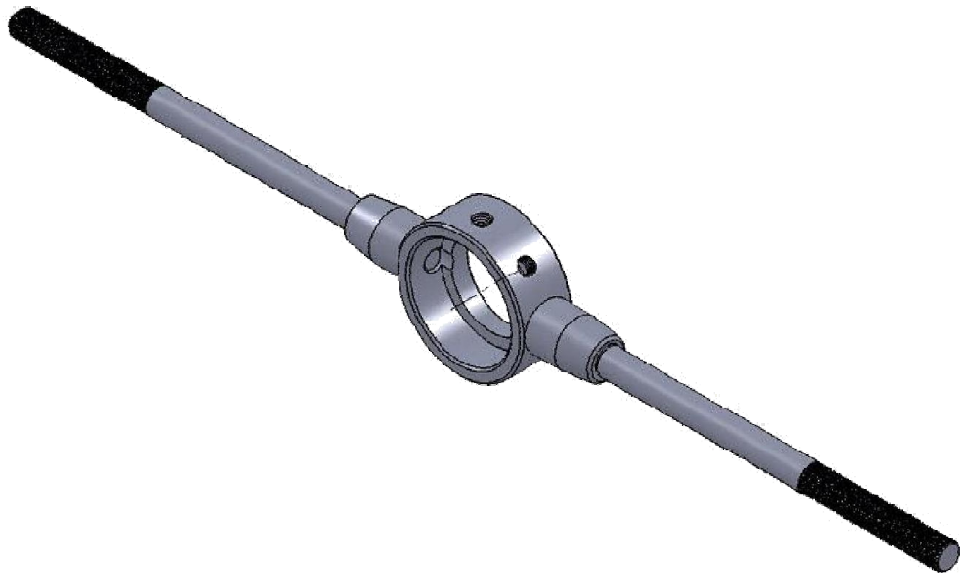
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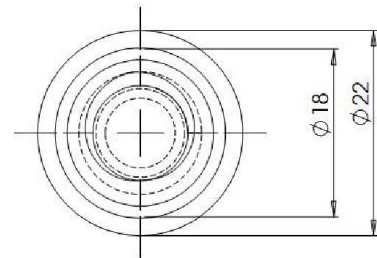


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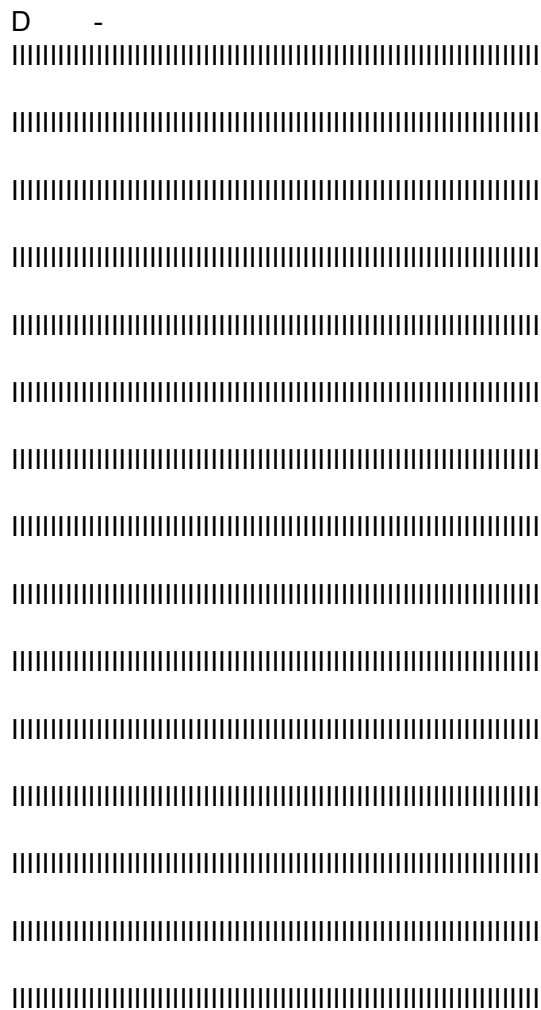
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