

TEORIA DE CORTE

$C_p = T/6 \sigma$	$\gamma_n \equiv$ desprendimiento	$h_1 \equiv$ viruta no def	$f \equiv$ avance [mm/rev]
(malo)	$\alpha_n \equiv$ incidencia	$h_2 \equiv$ viruta def	$f_z \equiv$ avance filo [mm]
$3 \leq T/2l \leq 10$ (caro)	$\beta_n \equiv$ filo	$\varphi_n \equiv$ inclinacion del filo	$S \equiv$ vel del husillo [rpm]
$ap \equiv$ prof corte [mm]	$\mu = \text{tg} \varphi_n = F/N$	$R_t = f^2/8r$	$V \equiv$ vel de corte [m/min]
$S \equiv$ vel del husillo [rpm]	$T = K/(V^{1/n_1} f^{1/n_2} ap^{1/n_3})$	$1/n_1 > 1/n_2 > 1/n_3$	$\xi = h_2/h_1 \equiv$ fact recalado
$T = C/V^{1/n}$	$2\varphi_n + \rho_n - \gamma_n = \pi/2$	$l = N/N_0 * 100$ maquinabilidad	$h_1 = f * \text{sen} \kappa r$
$\text{tg} \varphi_n = \text{cos} \gamma_n / (\xi - \text{sen} \gamma_n)$	$\kappa r \equiv$ posición	$\epsilon r \equiv$ punta	$F_c \text{ filo} = k_s * A_0 - k_s * D/2 * f/2$
$F_a = N_c * \text{sen} \kappa r$	$P_a = F_a * V_f$	$F_r = N_c * \text{cos} \kappa r$	$V_f = V * f / (\pi * D)$
$F_c = k_s * A_0 - k_s * h_1^{-m}$	$P_c = F_c * V$	$N_c = F_c * \text{tg}(\rho_n - \gamma_n)$	
$F_c \text{ broca} = z * F_c \text{ filo}$	$P = z * F_c \text{ filo}$	$M = F_a * p / 2\pi$	
$\alpha \beta \gamma \equiv >$			

ECONOMIA DE MECANIZADO

Productividad = Produccion obtenida/factores utilizados	si $t_c < t_m \rightarrow t_m \approx t_c = l/V_f$
$t_{fi} = t_{prep}/n^{\circ} \text{pieza} + t_{carga} + t_{op} + t_{desc} + t_{np}$	$t_{op} = t_{conf} + t_{ch} + t_{no \text{ conf}} - t_t = t_m + t_c/T * t_{rf} + t_{np}$
$C_{tmec} = C_{mec} + C_{ch} + C_{np} + C_{pre} + C_{mat} + C_{utill}$	$C_{mec} = \dot{c} t_m - C_{ch} = \dot{a} c h - C_{np} = \dot{c} * t_{np}$
$A_m - \text{directa} = C_{maq}/\text{Años} - \text{simple} = D/(1 + t_{asaa})$	$\dot{c} t = \dot{c} t_m + t_c / T (\dot{c} t_{rf} + C_{hf}) + \dot{c} t_{np}$
-- compuesta = $D * (1 + t_{asaa})^a$	$\dot{c} = (A_m / n_{\text{turnos}} + n^{\circ} \text{oper} C_{telab}) / (1 - \eta - \text{costes}) / (\text{horasocup})$
enteriza -- $C_{hf} = (C_h + n_{\text{reaf}} * C_{reaf}) / (n_{\text{reaf}} + 1)$	plaquitas -- $C_{portah} / (n_{\text{pl}} - a_{qvidanfilos}) + z C_{plaq} / n_{\text{filos}}$
$T_{mp} = (1/n_1) * t_{rf}$	

