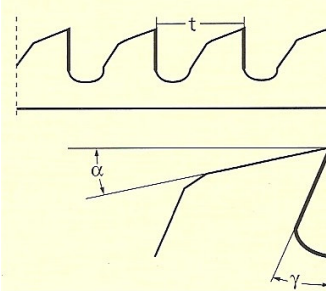
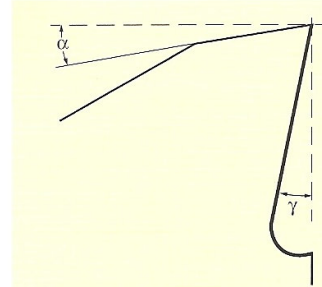


GEOMETRIA DA FERRAMENTA PARA LAMINAS DE SERRA



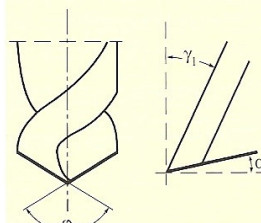
	PA, PE, POM, PET, PVDF, PVC	
	Band saw	Circular saw
α = Clearance angle (°)	30 - 40	10 - 15
γ = Effective cutting angle (°)	0 - 8	0 - 10
v = Cutting speed m/min	200 - 1000	1000 - 3500
t = Number of teeth	3 - 5 per inch	24 - 80

GEOMETRIA PARA CENTROS DE MAQUINAÇÃO



	PA, PE	PTFE	POM, PET PVDF, PVC
α = Clearance angle (°)	5 - 15	10 - 15	5 - 10
γ = Effective cutting angle (°)	0 - 15	15 - 20	0 - 10
v = Cutting speed m/min	up to 1000	up to 600	up to 1000
s_2 = Forward feed/tooth	up to 0,5	up to 0,5	up to 0,5
Angle of twist in °	0 - 40	0 - 40	0 - 40

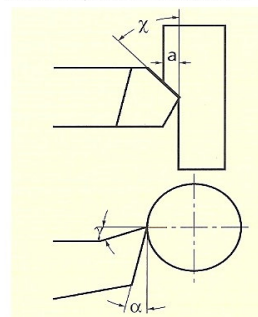
GEOMETRIA DA BROCA PARA FURAR



	PA, PE	PTFE	POM, PET PVDF, PVC
α = Clearance angle (°)	10 - 15	10 - 15	5 - 10
γ^1 = Effective cutting angle (°)	3 - 5	3 - 5	3 - 5
ϕ = Point angle (°)	60 - 90	130	60 - 90
v = Cutting speed m/min	50 - 100	100 - 300	50 - 100
s = Forward feed mm/rev.	0,1 - 0,5	0,1 - 0,3	0,1 - 0,3

The angle of twist of the drill should be at least 12 - 16°

GEOMETRIA DOS FERROS PI TORNEAR



	PA, PE	PTFE	POM, PET PVDF, PVC
α = Clearance angle (°)	5 - 15	10 - 15	5 - 10
γ = Effective cutting angle (°)	0 - 10	15 - 20	0 - 5
χ = Setting angle (°)	0 - 45	0 - 45	0 - 45
v = Cutting speed m/min	200 - 500	100 - 300	200 - 500
s = Forward feed mm/rev.	0,05 - 0,5	0,05 - 0,3	0,05 - 0,5
a = Rate of cut mm	up to 15	up to 15	up to 15

The point radius should be at least 0.5mm