

EQUIVALENCIAS APROXIMADAS ENTRE DIFERENTES NORMAS Y MARCAS

FORTUNA	AISI NOM.	W/Nr	ASSAB	ATLAS	BOEHLER	C.H.	DEW	SOLAR	PALME
W18	T1	3355	HSP11	SPARTAN	Super Rapid Extra		Rapid Especial	Beta V B	25
Mo500	M2	3343	HSP41	Six 1X	Super Rapid Extra Mo		Mo20	Alfa V A	29
CA1220	D3	2080	XW5	NN		CHD3	Bora	Tarasco II F	62
CA1215	D2	2379	XW41	RNS	ESP KNL	CHD2	Bora Especial V	Nahoa II C	63/364
SW55	O1	2510	DF2	Keewatin	Amulit S	CHO1	Veresta V	Azteca II A	16
WA255	S1	2550	M4	Falsch 6	S1 Extra	CHS1	Durax H	Urano III B	18
W10V	W2	2835	K100V	Special	Extra H	CHW2	NPU	Acemex IA	121
MoG510V	H13	2344	8407	Crovan	US Ultra 2	CHH13	E38V	Omicron IV-F	
MoG511	H12	2606		Crodi	ISODISC US-Ultra4	CHH12	E38W	Omega IV-C	67
NG2Supra	6F3/L6	2714	M14	Ultimo 6	6F3 GNME	6F3	AMS Extra	Kripton VI-J	
EWX 40 M	P5	2341	8416		P-4 EL	CHP4	WES	Polux VI-A	8416
W11 Plata	W2	1650	K115	Acero Plata	Acero Plata	Acero Plata	ES3	Acero Plata	
TX10R T	9840	6511	7310	SPS 245	VSP 40 VCH150	CN35	9840	Orion VI-D	10
TCMO4R T	4140	7225	709	4140	4140 VCL 140	4140	4140	Dellos VI-M	

CALCULO DEL RECORTE PARA DOBLEZ

Handwritten notes: 1/2" 1/4" 3/8" 1/2" 3/4" 1" 1 1/4" 1 1/2" 1 3/4" 2" 2 1/4" 2 1/2" 3" 3 1/4" 3 1/2" 4" 4 1/4" 4 1/2" 5" 5 1/4" 5 1/2" 6" 6 1/4" 6 1/2" 7" 7 1/4" 7 1/2" 8" 8 1/4" 8 1/2" 9" 9 1/4" 9 1/2" 10" 10 1/4" 10 1/2" 11" 11 1/4" 11 1/2" 12" 12 1/4" 12 1/2" 13" 13 1/4" 13 1/2" 14" 14 1/4" 14 1/2" 15" 15 1/4" 15 1/2" 16" 16 1/4" 16 1/2" 17" 17 1/4" 17 1/2" 18" 18 1/4" 18 1/2" 19" 19 1/4" 19 1/2" 20" 20 1/4" 20 1/2" 21" 21 1/4" 21 1/2" 22" 22 1/4" 22 1/2" 23" 23 1/4" 23 1/2" 24" 24 1/4" 24 1/2" 25" 25 1/4" 25 1/2" 26" 26 1/4" 26 1/2" 27" 27 1/4" 27 1/2" 28" 28 1/4" 28 1/2" 29" 29 1/4" 29 1/2" 30" 30 1/4" 30 1/2" 31" 31 1/4" 31 1/2" 32" 32 1/4" 32 1/2" 33" 33 1/4" 33 1/2" 34" 34 1/4" 34 1/2" 35" 35 1/4" 35 1/2" 36" 36 1/4" 36 1/2" 37" 37 1/4" 37 1/2" 38" 38 1/4" 38 1/2" 39" 39 1/4" 39 1/2" 40" 40 1/4" 40 1/2" 41" 41 1/4" 41 1/2" 42" 42 1/4" 42 1/2" 43" 43 1/4" 43 1/2" 44" 44 1/4" 44 1/2" 45" 45 1/4" 45 1/2" 46" 46 1/4" 46 1/2" 47" 47 1/4" 47 1/2" 48" 48 1/4" 48 1/2" 49" 49 1/4" 49 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RADIO INCH	E 0.015	S 0.018	P 0.020	E 0.024	S 0.025	O 0.030	R 0.032	D 0.036	O 0.040	E 0.047	L 0.051	M 0.060	A 0.081	T 0.102	E 0.125	R 0.134	I 0.187	AL 0.250
1/32	.032	.035	.038	.043	.044	.052	.055	.060	.065	.074	.080	.091	.102	.125	.134	.187	.250	
1/16	.045	.049	.057	.056	.057	.063	.066	.070	.075	.084	.089	.105	.132	.159	.189			
3/32	.058	.062	.064	.069	.071	.077	.079	.084	.089	.097	.102	.113	.142	.173	.203	.214	.283	.365
1/8	.072	.076	.078	.083	.084	.090	.093	.097	.102	.111	.116	.126	.152	.177	.216	.228	.297	.378
5/32	.085	.089	.091	.096	.097	.104	.106	.111	.116	.124	.129	.140	.166	.191	.219	.230	.310	.392
3/16	.099	.102	.105	.110	.111	.117	.119	.124	.129	.138	.142	.153	.179	.204	.232	.243	.324	.405
7/32	.112	.116	.118	.123	.125	.130	.133	.138	.142	.151	.152	.167	.192	.218	.246	.257	.329	.419
1/4	.126	.129	.132	.136	.138	.144	.146	.151	.156	.164	.169	.180	.206	.231	.259	.270	.350	.432
9/32	.139	.143	.145	.150	.151	.157	.160	.164	.169	.178	.183	.194	.219	.244	.272	.284	.364	.446
5/16	.152	.156	.158	.163	.164	.170	.173	.178	.183	.191	.196	.207	.232	.258	.286	.297	.377	.459
11/32	.166	.169	.172	.177	.178	.184	.186	.191	.196	.205	.209	.220	.246	.271	.299	.310	.383	.472
3/8	.179	.183	.185	.190	.191	.197	.200	.205	.210	.218	.223	.234	.259	.285	.313	.324	.388	.486
7/16	.206	.210	.212	.217	.218	.224	.227	.232	.236	.245	.250	.261	.286	.312	.340	.351	.415	.502
1/2	.233	.236	.239	.244	.245	.251	.254	.258	.263	.272	.276	.287	.313	.338	.366	.377	.442	.518

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CALCULO DEL TONELAJE PARA TROQUELAR

AVERAGE TENSILE STRENGTH OF MATERIALS
TONS PER SQUARE INCH

MATERIAL	TENSILE STRENGTH (T.S.)	YIELD POINT (Y.P.)
ALUMINUM, 25-O	12.0	8.0
H-25	12.0	8.0
H-25-H	12.0	8.0
245-O	12.0	8.0
245-T	12.0	8.0
245-O	12.0	8.0
245-H	12.0	8.0
245-H	12.0	8.0
ASBESTOS, SHEET	12.0	8.0
BRA'S, CARTRIDGE, C. 70% Z. 30% SOFT	12.0	8.0
ROLLED STRIP & SHEET, C. 65% Z. 35% SOFT	12.0	8.0
HARD	12.0	8.0
COOPER, SOFT	12.0	8.0
HARD	12.0	8.0
FIBRE, HARD	12.0	8.0
GOLD, 14 CARAT	12.0	8.0
RAWHIDE	12.0	8.0
NICKEL (GERMAN SILVER)	12.0	8.0
PAPER, HOLLOW CUTTER	12.0	8.0
SILVER, STERLING, SOFT	12.0	8.0
STEEL, MILD	12.0	8.0
BOILER PLATE	12.0	8.0
SILICON	12.0	8.0
STAINLESS, 8% NICKEL	12.0	8.0
CUTLERY, KNIFE, 410 STAINLESS	12.0	8.0
CUTLERY, FORK & SPOON	12.0	8.0
SOFT, DEEP DRAWING	12.0	8.0
HARD	12.0	8.0
HARD	12.0	8.0
HARD	12.0	8.0
S.A.E. 1010, COLD ROLLED	12.0	8.0
1020 COLD ROLLED	12.0	8.0
1030 COLD ROLLED	12.0	8.0
1050 COLD ROLLED	12.0	8.0

Figure 1-16 Strength of materials

CALCULO DEL TONELAJE NECESARIO PARA TROQUELAR.

La fórmula general para encontrar las toneladas necesarias para hacer un recorte, es la siguiente:

$$T = P \times E \times CTE.$$

DONDE:

T= TONELAJE EN TONELADAS

P= PERIMETRO EN PULGADAS

E= ESPESOR EN PULGADAS

CTE= CONSTANTE DE RESISTENCIA AL CORTE EN TONELADAS / PULGADA CUADRADA

AVERAGE ULTIMATE STRENGTH OF MATERIALS TONS PER SQUARE INCH

MATERIAL	SHEAR	TENSILE
ALUMINUM, 2S-0	4.8	6.5
2S-½H	5.5	8.5
2S-H	6.5	12.
24S-0	9.	13.5
24S-T	20.5	34.
52S-0	9.	14.5
52S-½H	10.5	18.5
52S-H	12.	20.5
ASBESTOS, SHEET	2.	
BRA 3S, CARTRIDGE, Cu 70%, Zn 30%, SOFT	16.	23.5
ROLLED STRIP & SHEET, Cu 65%, Zn 35%, SOFT	16.	23.
½ HARD	22.	32.5
HARD	25.	39.
SPRING	28.5	47.5
BRONZE, PHOSPHOR, GRADE A SHEET, ANNEALED	20.	27.5
SPRING TEMPER	32.5	52.5
COPPER, SOFT	12.	16.
HARD	18.5	27.5
FIBRE, HARD	12.	
GOLD, 14 CARAT, SOFT	21.	29.
LEATHER, CHROME	3.5	5.
RAWHIDE	6.5	
NICKEL (GERMAN) SILVER, Ni 18%, Cu 65%, Zn 17%, SOFT	17.5	29.
PAPER, HOLLOW CUTTER	6.	
SILVER, STERLING, SOFT	13.5	18.5
STEEL, MILD	25.	30.
BOILER PLATE	27.5	35.
SILICON	30.	36.
STAINLESS, 18-8, ANNEALED	37.5	47.5
CUTLERY, KNIFE 410, FULL HARD	72.5	
CUTLERY, FORK & SPOON 420½ HARD	32.5	
SOFT, DEEP DRAWING	21.	26.5
½ HARD	22.5	30.
½ HARD	25.	36.
HARD	30.5	46.
S.A.E. 1010, COLD ROLLED	21.	28.
1020 COLD ROLLED	26.	34.5
1030 COLD ROLLED	31.5	42.5
1050 COLD ROLLED	41.	55.

Figure 1-16 Strength of materials.

