



**ESCUELA SUPERIOR POLITÉCNICA DE CHIMBORAZO**  
**FACULTAD DE MECÁNICA**  
**CARRERA INGENIERÍA AUTOMOTRIZ**

**“MANUFACTURA DE UNA BIELA PARA UN PROTOTIPO DE  
MOTOR DE DOS TIEMPOS APLICANDO INGENIERIA INVERSA  
Y LAS HERRAMIENTAS CAD/CAM/CAE”**

**Trabajo de Titulación**

**Tipo:** Proyecto Técnico

Presentado para optar el grado académico de:

**INGENIERO AUTOMOTRIZ**

**AUTOR**

**WILSON GEOVANNY TOAPAXI VELASQUE**

Riobamba – Ecuador

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**DIRECTOR:** Ing. VICTOR DAVID BRAVO MOROCHO

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Riobamba, 7 de mayo de 2021



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**Wilson Geovanny Toapaxi Velásquez**

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**ESCUELA SUPERIOR POLITÉCNICA DE CHIMBORAZO**  
**FACULTAD DE MECÁNICA**  
**CARRERA INGENIERÍA AUTOMOTRIZ**

El Tribunal del Trabajo de Titulación certifica que: El Trabajo de Titulación: Tipo: Proyecto Técnico, **MANUFACTURA DE UNA BIELA PARA UN PROTOTIPO DE MOTOR DE DOS TIEMPOS APLICANDO INGENIERÍA INVERSA Y LAS HERRAMIENTAS CAD/CAM/CAE**, realizado por el señor: **WILSON GEOVANNY TOAPAXI VELASQUE**, ha sido minuciosamente revisado por los Miembros del Trabajo de Titulación, el mismo que cumple con los requisitos científicos, técnicos, legales, en tal virtud el Tribunal Autoriza su presentación.

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## **DEDICATORIA**

Este trabajo de titulación va dedicado a Dios, mis padres, sobrinas y hermanas. A Dios porque siempre fue la luz que ilumino mi camino, a mis padres quienes fueron y serán siempre los pilares y apoyo incondicional en todo momento, más aún en las adversas, a mis sobrinas por ser la alegría y motivación para seguir adelante y finalmente a mis hermanas por ser un complemento de apoyo en mi vida.

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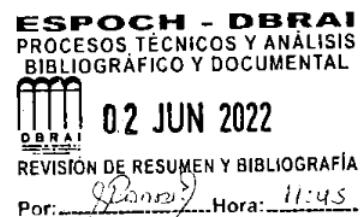
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## RESUMEN

El presente trabajo de titulación tiene como objetivo la fabricación de una biela de motocicleta de dos tiempos, aplicando metodologías como CAD, CAE, CAM, para ello se empezó con una revisión bibliográfica de conceptos como: diseño y manufactura de partes mecánicas. Para el desarrollo metodológico se establecieron distintos pasos a seguir empezando por el diseño de la biela de un motor perteneciente a un Suzuki AX100, al cual se le aplicó ingeniería inversa para obtener sus dimensiones que sirvieron de guía. A continuación, se realizaron ensayos de espectrometría, dureza y una micrografía a la muestra para determinar su composición, resistencia y geometría respectivamente, con todos estos datos se elaboró un diseño en CAD usando el software SOLIDWORKS. El modelo obtenido fue exportado al software NX SIEMENS para las simulaciones del proceso de manufactura los cuales al ser terminados entregaron códigos de fabricación que fueron ingresados en la máquina CNC FADAL 88HS. Con el programa dentro de la máquina el último paso fue colocar el material y controlar el proceso de manufactura bajo las normas ISO 286-1, que regula las tolerancias permitidas en este tipo de trabajos. Al tener la biela terminada se le realizaron ensayos y simulaciones de deformaciones unitaria y esfuerzos obteniendo valores máximos de 0.02mm y 63.9 respectivamente, teniendo un factor de seguridad de 7,2 lo cual se considera aceptable. También se realizaron mediciones geométricas obteniendo una tabla de datos iguales a la muestra usada. Con los resultados obtenidos se concluyó que en la actualidad se cuenta con la tecnología suficiente para realizar todo el proceso constructivo de un elemento mecánico. También recomendó un análisis de espectrometría al bloque de material para evitar la aparición de poros en el acabado del material.

**PALABRAS CLAVE:** <DISEÑO AUTOMOTRIZ >, <MANUFACTURA POR COMPUTADORA >, <ANÁLISIS DE ESFUERZOS>, <ESPECTROMETRÍA>

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## SUMMARY

This degree work aimed to manufacture a two-stroke motorcycle connecting rod applying methodologies such as CAD, CAE, and CAM. It began with a bibliographic review of concepts such as the design and manufacture of mechanical parts. Different steps were established to follow for the methodological development starting with the design of the connecting rod of an engine belonging to a Suzuki AX100. Reverse engineering was applied to obtain its dimensions that served as a guide. Next, spectrometry, hardness, and micrograph tests were given to the sample to determine its composition, resistance, and geometry respectively. With all these data, a CAD design was created using SOLIDWORKS software. The obtained model was exported to the NX SIEMEN12 software for the simulations of the manufacturing process when finished, delivered manufacturing codes that were entered into the FADAL 88HS CNC machine. With the program inside the machine, the last step was to place the material and control the manufacturing process under ISO 286-1 standards, which regulates the tolerances allowed in this type of work. When the connecting rod was finished, tests and simulations of unitary deformations and stresses were carried out, obtaining maximum values of 0.02mm and 63.9 respectively, having a safety factor of 7.2, which is considered acceptable. Geometric measurements were also achieved, obtaining a table of data equal to the sample used. With the results obtained, it was concluded that at present there is sufficient technology to carry out the entire construction process of a mechanical element. A spectrometry analysis of the block of material is recommended to avoid the appearance of pores in the material.

Keywords: <AUTOMOTIVE DESIGN> <COMPUTER-BASED MANUFACTURING>  
<STRESS ANALYSIS> <SPECTROMETRY> <SOLIDWORKS (SOFTWARE)>.

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## INTRODUCCIÓN

En la actualidad el desarrollo de algunos productos complejos de producir se los puede, desarrollar mediante los métodos de CAD/CAM, estos son muy importantes al igual que el control numérico los cuales tienen gran impacto en la industria, esto eleva el nivel tecnológico.

Se puede mencionar como ventaja principal la calidad de vida debido a la producción de elementos o componentes a menor costo, mejor calidad del producto y optimización de tiempo.

El desarrollo de la manufactura permite la fabricación de elementos o productos de mejor calidad y con mayor valor agregado al producto terminado, es uno de los sectores industriales más importantes de un país, este también aporta a la reducción de costos en elementos ya manufacturados. Este sector económico genera fuentes de trabajo el mismo que fortalece la economía del país. Según el INEC, a septiembre de 2017 esta actividad origina el 11% del empleo global total de país (Revista Ekos, 2018)

A la vista de falta de manufactura de elementos o componentes mecánicos a nivel nacional la propuesta es la manufactura de elementos mecánicos integrando procesos de manufactura y de esta manera adecuarnos a la nueva matriz productiva y dejar poco a poco el papel de consumidor y poder crear una biela de dos tiempos de motor de moto para luego mejorar el diseño y que se pueda producir de forma progresiva para generar movimiento económico.

Este trabajo está inmiscuido en relación con autopartes y equipos que usen motores de combustión interna que requieran dentro de su funcionamiento una biela para ofertar como un elemento mecánico alternativo en el mercado nacional; con estos antecedentes se utilizará la biela de un motor de moto de 2 tiempos.

# CAPÍTULO I

## 1. DIAGNÓSTICO DEL PROBLEMA

### 1.1. Antecedentes

En 1942 año en el cual nace y da origen al control numérico debido a la necesidad que surgió de la industria aeronáutica para fabricar elementos mecánicos específicamente hélices de helicópteros con variedad de configuraciones; ya en el año de 1956 se realizó un llamado de parte de la fuerza aérea americana para iniciar un proyecto ambicioso el cual consistía en generar un lenguaje de programación regido bajo el control numérico, este se basaba en equipos hechos en base a controladores de válvula de vacío, en los cuales su consumo de energía era demasiado alto así como su temperatura (Gómez et al., 2017).

El desarrollo del control numérico es muy notorio, como ejemplo se puede mencionar las múltiples técnicas las cuales han aumentado notoriamente, como en el caso del diseño donde sus posibilidades de manera técnicas han subido, entre ellas tenemos. una programación mucho más rápida con la ayuda de interfaces de usuario, diseño múltiple, mayor cantidad de ejes para la construcción de componentes más difíciles de manufacturar, y se obtiene una mejorada y satisfactoria interfaz del operario mejorando la programación (Gómez et al., 2017).

Las funciones tales como. controlar la posición y velocidad se pueden apreciar como las principales diferencias que se encuentra entre una maquina CNC y uno de operación manual, existe una computadora que controla los diferentes parámetros en un CNC y en uno de uso manual todo está a cargo de la experiencia de la persona que lo operara, la ayuda computarizada facilita la realización de múltiples movimientos con una precisión extraordinaria y se puede fabricar figuras muy complicadas de formas tridimensionales, líneas longitudinales y círculos (Acuña et al., 2005).

Se puede concluir que los equipos CNC mediante los sistemas CAD/CAM permiten a la manufactura de la industria en general la automatización a partir de un diseño generado en uno de los sistemas mencionados, siendo de gran aporte para las industrias dedicadas a manufactura de elementos o piezas con mejor calidad, mayor rapidez y siempre con un mejoramiento continuo (Gómez et al., 2017).

### 1.2. Planteamiento del problema

El presente proyecto busca verificar la capacidad tecnológica actual, con el fin de mejorar la industria y el modo de vida de la población, por otro lado, existe un mercado potencial por la escasa manufactura de elementos o componentes mecánicos a nivel nacional, por estas razones se plantea la manufactura e ingeniería inversa de un elemento como lo es una biela. Además, se

ha observado que la producción de elementos mediante ingeniería inversa generar un valor elevado cuando se manufactura componentes mecánicos como el del presente trabajo.

### **1.3. Justificación.**

#### ***1.3.1. Justificación Teórica***

Mediante el presente trabajo de titulación se aplicarán y estudiarán conceptos que tienen relación estrecha con el medio de la ingeniería automotriz, y que unido a conocimientos y conceptos como simulación, análisis y paquetes de modelación será posible la manufactura y conceptualización de elemento mediante conocimientos y procesos de CAD/CAM, que nos permitan obtener mejor acabado.

#### ***1.3.2. Justificación Metodológica***

Inicialmente se procede a efectuar el marco teórico con sus debidas referencias bibliográficas reglamentarias. El presente trabajo usara este tipo de procedimiento en el cual requiere acudir a fuentes bibliográficas con la información idónea adquiridas de libros, folletos, publicaciones, revistas, además de fuentes que contenga información de manera primaria que se puede encontrar en archivos o documentos con alta confiabilidad y totalmente válidos.

Las herramientas metodológicas que se usa dentro de este trabajo de titulación se encuentra pruebas del equipo, guía de observación, registro en video, fotografías y grabaciones de las diferentes simulaciones.

#### ***1.3.3. Justificación Práctica***

Se justifica el trabajo de titulación de forma práctica cuando se genera el código de manufactura y diseño del prototipo, además se justifica con la inclusión de conocimientos en el diseño y manufactura del componente, este a su vez aportara de manera significativa de una manera tecnológica y técnica a la Escuela Superior Politécnica de Chimborazo como también aportara de manera teórica práctica a los estudiantes que conforman la Escuela de Ingeniería Automotriz.

### **1.4. Objetivos.**

#### ***1.4.1. Objetivo general.***

Manufacturar un prototipo de biela de motor empleando ingeniería inversa y los métodos CAD/CAM/CAE, para un motor de dos tiempos 100cc.

#### ***1.4.2. Objetivos específicos.***

- Obtener referencias bibliográficas relacionadas a diseño, materiales y manufactura de bielas de motor, para establecer una base teórica de la investigación.
- Realizar ensayos destructivos para determinar las propiedades mecánicas del elemento original.
- Diseñar y simular un prototipo de biela de un motor de dos tiempos de 100 cc basada en ingeniería inversa.
- Manufacturar un prototipo de biela de un motor de 2 tiempos empleando técnicas de mecanización CAD/CAM/CAE.
- Realizar una comprobación e inspección de medidas y tolerancias utilizando la norma ISO 286-1 y ISO 2768-1

## CAPÍTULO II

### 2. FUNDAMENTOS TEÓRICOS

#### 2.1. CAD (Diseño Asistido por Ordenador)

Usa paquetes informáticos y además es un método de trabajo que sirve para desempeñar tareas de diseño, análisis y modificación del diseño que se requiera esto se puede realizar por medio de modelos geométricos y un análisis de elementos finitos: (Navarro, 2005)

#### 2.2. CAM (Manufactura Asistida por Ordenador)

Son paquetes informáticos que son capaces de controlar procesos de fabricación de elementos por medio de procesos ordenados y sistemas informáticos los mismos que controlarían las máquinas herramientas: (Navarro, 2005)

#### 2.3. Métodos CAD/CAM para ingeniería inversa

Por medio del escaneo de puntos 3D de un modelo físico ya existente se logra obtener modelo geométrico denominado CAD, a esto llamaremos ingeniería inversa.

#### 2.4. Control numérico computarizado (CNC)

La obtención de objetos de buena calidad y de manera precisa se logra mediante la mecanización con instrucciones mediante el control de máquinas herramientas y la aplicación de un código ISO:

#### 2.5. Sintaxis de un programa CNC

Cuatro expresiones son necesarias conocer para entender la programación CNC, estas serán parte de la estructura del programa (Sánchez Fulgueira, 2012).

- Carácter: “Es un símbolo, letra, o un dígito y es la unidad más pequeña de un programa CNC.” (Sánchez Fulgueira, 2012).



**Figura 1-2:** Ejemplo de carácter.

**Fuente:** (Sánchez Fulgueira, 2012)

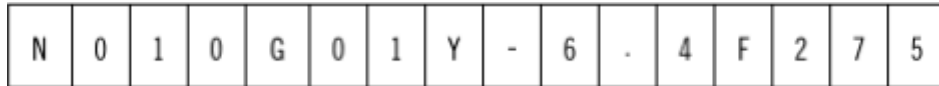
- Palabra (función o instrucción): “Es una combinación de caracteres alfanuméricos para crear instrucciones de control del sistema”: (Sánchez Fulgueira, 2012) : Se puede decir que de manera general cada una de las palabras empieza en mayúscula y luego un número.



**Figura 2-2:** Ejemplos de Palabra.

Fuente: (Sánchez Fulgueira, 2012)

- Bloque: estos bloques están conformados por una o dos palabras que serán las instrucciones y estas de dos o más caracteres y son formados por varias instrucciones. (Sánchez Fulgueira, 2012)



**Figura 3-2:** Ejemplos de Bloques.

Fuente: (Sánchez Fulgueira, 2012)

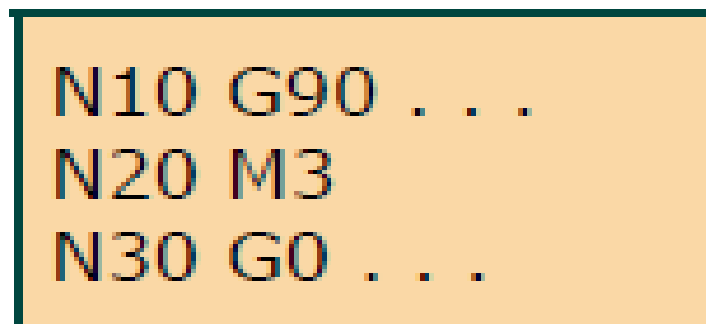
- Programa: Son escritas de manera ordenada y lógica compuestas de bloques o líneas de código separadas entre sí con un espacio a la siguiente línea, esto nos indica que en cada línea hay un inicio y un fin: “En el formato que se utilizara, la letra en cada uno de los bloques define el significado de la palabra y, por lo tanto, siempre se debe escribir primero (por ejemplo, X2:75 es correcto, mientras que 2:75Xno lo es).” (Sánchez Fulgueira, 2012)

## 2.6. Programación ISO

El sistema de programación CNC es normalizado por la ISO, ya que este tiene como función general la estandarización de las normas de fabricación: La mayor parte de fabricantes usan el sistema de programación ISO, pero debido a que día a día la tecnología avanza constantemente ha hecho que no todos los fabricantes usen este sistema, pero la programación es similar (Serrano, 2011).

## 2.7. Cabeceras de bloque (N)

Se encuentran dentro del rango de 1 hasta 99999 depende del límite de bloques del software, por lo general se muestran con múltiplos de 10 se denominan con la letra (N) como se muestra en la figura.



**Figura 4-2:** Cabecera de bloque

Fuente: (Tornero, 2012)

Si tenemos que añadir otro bloque con el respectivo orden en una programación que ya se terminó se puede incluir una nueva como se aprecia en la figura:

```
N10 G90 . . . .
N15 G94 . . . .
N20 M3
N30 G0 . . . .
```

**Figura 5-2:** Cabecera de bloque modificado  
Fuente: (Tornero, 2012)

### 2.8. Funciones preparatorias (G)

Se denominan con la letra G, son funciones que hacen referencia a la forma y modo de las trayectorias además se complementa con el dígito que corresponda a la línea, se detalla de mejor manera en la tabla cada una de las funciones: (Tornero, 2012)

**Tabla 1-2:** Funciones preparatorias

Función	Características
<b>G40</b>	Anulación de compensación radial
<b>G17</b>	Plano principal X-Y y longitudinal Z
<b>G90</b>	Programación Absoluta
<b>G71</b>	Programación en milímetros
<b>G91</b>	Programación incremental
<b>G28</b>	Selección segundo cabezal o conmutación de ejes

Fuente: (Tornero, 2012)

Fuente: Wilson Toapaxi 2020

### 2.9. Funciones auxiliares (M)

Se las denomina con la letra M e indican la forma del funcionamiento de la máquina al igual que del programa CNC va acompañado del dígito correspondiente a la función que se necesite, se procede a mostrar las más representativas (Tornero, 2012).

- M00, parada programa.
- M01, parada condicional. Análoga a M00.
- M02, final de programa. Después de esta, se realiza una función RESET del CNC.
- M03, acciona el motor principal en sentido horario.
- M04, acciona el motor principal en sentido antihorario.
- M05, parada del cabezal.



- M06, cambio de herramienta
- M30, fin de programa con vuelta al comienzo. Idéntica a M02 salvo que el CNC vuelve al primer bloque del programa.
- M41, M42, M43, M44, cambio de gamas del cabezal.
- M45, cabezal auxiliar/ herramienta motorizada.

## **2.10. Velocidad de avance (F)**

Va acompañado por la magnitud del avance, se lo identifica con la letra F, podemos añadir a la línea de programación una función preparatoria esto estará en función de la cual vaya a cumplir, si se necesita un avance en escala milimétrica sobre la revolución se tendrá el G95, otra opción a tomar es el avance en milímetros sobre minuto tenemos el G94, ejemplo.

- N20 G94 F350

La interpretación de este ejemplo es la siguiente. se tiene un avance de 350 en milímetros sobre revolución (Tornero, 2012).

## **2.11. Numero de herramienta (T) y corredor (D)**

Viene acompañada del número de herramienta y se le denomina con la letra “T”, en ocasiones es necesario usar varias herramientas para la manufactura y la programación necesita identificar la herramienta útil para de acuerdo al procedimiento que se vaya a utilizar por lo que la función T nos ayudara a escoger la herramienta más adecuada. (Tornero, 2012)

## **2.12. Herramientas en el CNC**

Las herramientas se encuentran ubicadas todo el tiempo en el portaherramientas el mismo que se encuentra en la torreta, estas se las pueden encontrar en disposición automática como se ve en la figura, al momento de realizar nuestra programación es importante debido a que si se tuviera uno de cambio manual se tendrá necesariamente que realizar e insertar paradas usando M00, en cambio si la torreta es automática el CNC estará encargado en realzar el giro de la herramienta hasta ubicar la correcta. (Tornero, 2012)



**Figura 6-2:** Cambio manual (derecha) y cambio automático (izquierda).  
 Fuente: (Tornero, 2012)

### 2.13. Desbaste

Con esta función se elimina gran cantidad de material sobrante con un mínimo tiempo para tener como resultado el elemento final y con una mayor dimensión esto se obtiene después de realizar varias pasadas hasta conseguir la forma que necesitamos para después pasar a otra etapa llamado acabado: (Tornero, 2012).



**Figura 7-2:** Desbastados en control numérico  
 Fuente: (Tornero, 2012))

### 2.14. Acabado

Es similar al proceso anterior, pero a diferencia del desbaste aquí se debe dejar la menor cantidad de material sobrante esto se lleva a cabo usando funciones tales como G1, G2, G3: (Tornero, 2012))

## 2.15. Parámetros tecnológicos

Se requiere de tres movimientos para proceder con el mecanizado estos se clasifican en movimientos de corte, penetración y avance: (Tornero, 2012))



**Figura 8-2:** Herramientas en corte  
Fuente: (Tornero, 2012))

### 2.15.1. Movimiento de corte

Proporciona la fuerza de corte debido a un movimiento relativo de nuestra herramienta esto respecto del elemento a fabricar, es denotado por una característica denominada velocidad de corte: (Tornero, 2012)).

### 2.15.2. Movimiento de avance

Se denota por tener la herramienta más pequeña que el elemento a manufacturar para ello es necesario realizar varias pasadas hasta terminar con la forma final de la pieza.



**Figura 9-2:** Avance  
Fuente: (Tornero, 2012))

### 2.15.3. Movimiento de penetración

“Se llama así al movimiento que se da a la herramienta, en dirección perpendicular a la superficie trabajada y que se caracteriza por el espesor de material arrancado:” (Tornero, 2012)) Profundidad de pasada o corte: el valor está en función del desgaste, estado de la herramienta, potencia y estado de la maquina viene a ser el valor del movimiento de penetración y se encuentra en milímetros como la unidad (Tornero, 2012).

**Tabla 2-2:** Valores de profundidad

	Valores Recomendados de profundidad
Desbaste	2 a 4 mm
Acabado	0,5 a 2 mm

Fuente: (Tornero, 2012))

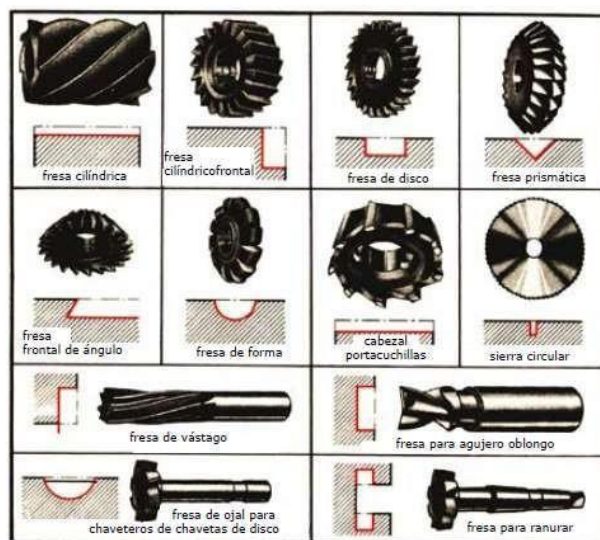
Fuente: Wilson Toapaxi, 2020

## 2.16. Optimización de los programas de mecanizado de CNC

Como base de producción de los diferentes tipos de proceso tenemos la eficiencia usando la menor cantidad de recursos, se tiene para ello diferentes parámetros de un lote de piezas (Nb) para de esta manera alcanzar la optimización (Sánchez Fulgueira, 2012)

## 2.17. Herramientas de la fresadora

Se usan variedad de herramientas y tienen diversos filos con cualidades que debemos tomar en cuenta a la hora de la producción por su gran importancia una de ellas es el que no se emboten demasiado rápido y que su temperatura no llegue a altas temperaturas esto debido a que cada filo realiza el proceso de cortado en una fracción por revolución y por ende la otra parte del filo debe enfriarse muy aceleradamente: (Tornero, 2012)



**Figura 10-2:** Tipos de fresas y su utilización

Fuente: (Tornero, 2012)

## 2.18. Montaje de herramientas

“Como los centros de mecanizado de fresadoras de control numérico trabajan, por lo general con cabeza giratoria, para la sujeción de fresas se utilizan preferentemente los sistemas de portapinzas o de conos”: (Tornero, 2012)

### 2.18.1. Procedimiento de montaje de herramientas

- Las herramientas se las coloca en el eje horizontal sobre el eje pertinente de fresado en una fresadora universal:
- Cuando tenemos fresas de vástago las herramientas se ubican en las pinzas:
- En fresas con disposición frontal las plaquitas intercambiables y cabezales que portan las cuchillas usan conos:

### 2.19. Datos para el corte en fresadoras

Si se requiere los datos de la herramienta, los fabricantes los proveen en tablas, los siguientes valores están en función al material que cual se va a mecanizar y también en función de la fresa: Otros en cambio añaden valores del avance de la fresa en función de cada filo: (Tornero, 2012)

**Tabla 3-2:** Tabla de avances

Material a mecanizar			Avance por diente (Fz)							Condiciones	
Denominación	Resistencia a la tracción		Diámetro de la fresa							V (m/min)	Refrig. E: emulsión O: aceite D: seco
	desde	hasta	Ø4	Ø6	Ø8	Ø10	Ø12	Ø16	Ø20		
Acero de fácil mecanizado	370	600	0,02	0,03	0,035	0,05	0,1	0,1	0,1	30/40	E
Acero de construcción en general	550	1.000	0,02	0,03	0,035	0,05	0,06	0,1	0,1	30/35	E
Acero inoxidable	450	950	0,012	0,025	0,03	0,045	0,045	0,045	0,065	15/20	O
Hierro fundido con grafito laminar	100	240	0,02	0,03	0,035	0,05	0,06	0,1	0,1	20/30	E/O
Fundición maleable	100	270	0,02	0,03	0,035	0,05	0,06	0,1	0,1	15/20	E/O
Aleaciones maleables de aluminio (Si < 10%)	10	180	0,025	0,042	0,062	0,067	0,08	0,11	0,13	168/200	E
Aleaciones fundidas de aluminio (Si > 10%)	150	250	0,02	0,03	0,035	0,05	0,06	0,1	0,1	50/80	E
Cobre	200	400	0,02	0,03	0,035	0,05	0,06	0,1	0,1	60/100	E
Latón con viruta corta	200	550	0,02	0,03	0,035	0,05	0,06	0,1	0,1	50/90	E
Bronce con viruta corta	250	850	0,02	0,03	0,035	0,05	0,06	0,1	0,1	50/90	E
Aleaciones con titanio	100	700	0,025	0,042	0,062	0,067	0,08	0,11	0,13	10/20	

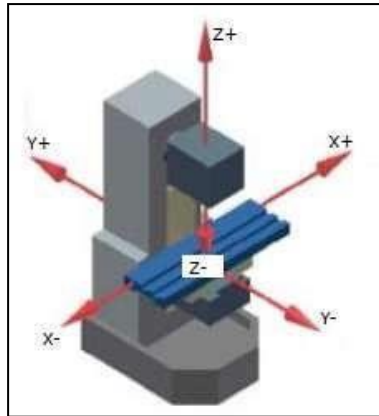
Fuente: (Martínez, 2012)

Fuente: Martínez, 2012

### 2.19.1. Ejes de referencia

“Los sistemas de ejes empleados por las fresadoras y centros de mecanizado están normalizados según las normas UNE 71-018 e ISO 841:” (Tornero Martínez, 2012, p: 190)

Se usan los ejes del plano cartesiano (X, Y y Z) respectivamente, la pieza a manufacturar debe estar ubicada de manera paralela con los planos antes mencionados: El movimiento de subir y bajar mientras se manufactura el elemento está a cargo del eje Z, la sujeción de la pieza esta de forma paralela al eje X: (Tornero Martínez), 2012, p:190).



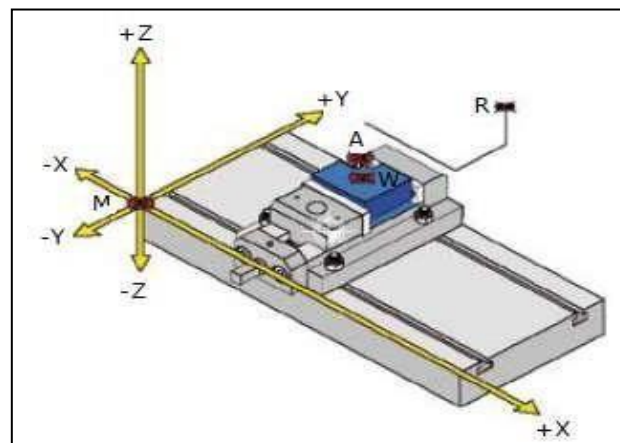
**Figura 11-2:** Ejes en la fresadora.  
**Fuente:** (Tornero, 2012)

### 2.19.2. Puntos de referencia

El sistema de coordenadas tiene puntos que son convencionales y son de mucha ayuda para realizar reglajes de la maquina los cuales son establecidos por el fabricante y otros hechos por el programador: En la maquina se pueden encontrar puntos de referencia y también en la herramienta y pieza: (Tornero, 2012)

### 2.19.3. Puntos de referencia en la máquina:

“Los puntos de referencia de la maquina son puntos establecidos por los fabricantes y que no pueden ser modificados: Generalmente se usan para reglajes internos de la propia máquina:”  
 (Tornero, 2012)



**Figura 12-2:** Puntos de referencia de la máquina:  
**Fuente:** (Tornero, 2012)

### 2.20. Cero maquina (M)

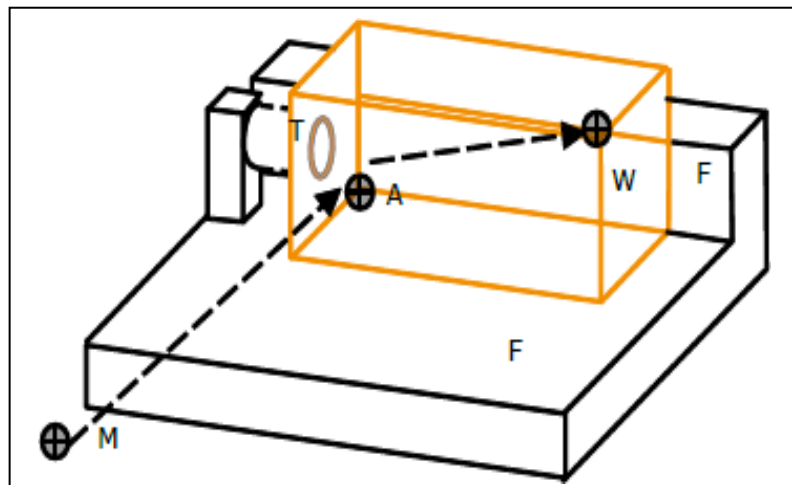
El fabricante de la maquina fija un punto de referencia el cual no puede ser modificado por el programador: Los valores de fábrica se establecen junto con el de referencia (R) (Tornero, 2012)

### 2.20.1. Punto de referencia de la maquina (R)

“Punto igualmente fijado por el fabricante y que no se puede modificar: Desde el se comunica al control la posición de la mesa: Es necesario establecerlo después de cada corte de corriente:”  
(Tornero, 2012)

### 2.20.2. Punto de referencia en la pieza

“Son puntos establecidos por el programador en función de la geometría de la pieza y su fijación a la maquina”: (Tornero, 2012)



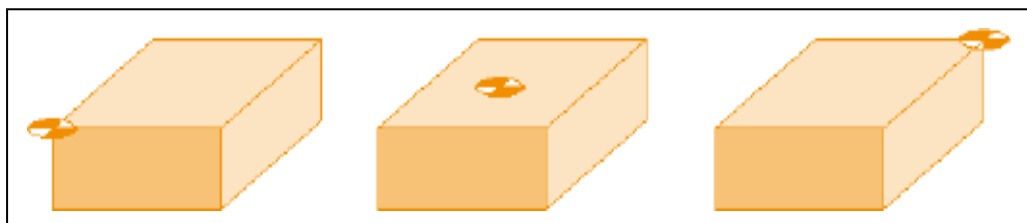
**Figura 13-2:** Puntos de referencia en la pieza  
Fuente: (Tornero, 2012)

### 2.20.3. Punto de tope (A)

En la mordaza tenemos un punto de contacto al ubicar la pieza esto es indicado mediante topes el cual será un punto fijo entre ambos: El programador indica este punto debido al estado de la mordaza y sus topes: (Tornero, 2012)

### 2.20.4. Cero piezas (W)

En la pieza a manufacturar se encuentra usualmente este punto en la figura 23-2, el programador indica este punto y es usado como referencia de toda la programación: (Tornero, 2012)



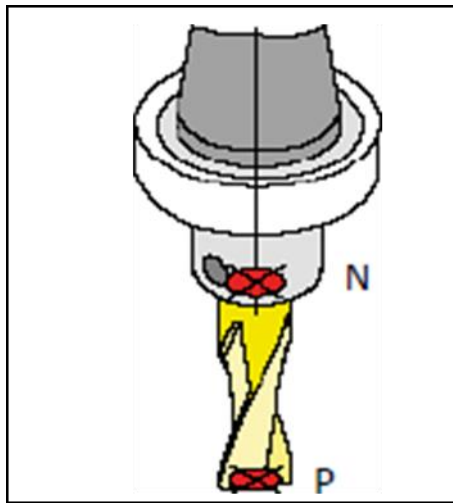
**Figura 14-2:** Puntos de referencia de la pieza: Cero piezas (W)  
Fuente: (Tornero, 2012)

### 2.20.5. Puntos de referencia de la herramienta(N)

“Son los puntos necesarios para los reglajes de las herramientas y para programar desplazamientos de la misma en programación incremental:” (Tornero, 2012)

### 2.20.6. Punto guía de la fresa (P)

“Punto donde se cortan el eje de la fresa y el plano de corte de la misma: Depende de la longitud de la herramienta y será el utilizado para efectuar los desplazamientos incrementales:” (Tornero, 2012)



**Figura 15-2:** Puntos de referencia de la herramienta:  
Fuente: (Tornero, 2012)

## 2.21. Tolerancias dimensionales

Las tolerancias dimensionales determinan los valores superior e inferior entre los que se deben encontrar los valores del modelo, estas tolerancias pueden estar indicadas en la propia cota: Los límites pueden ser definidos de dos maneras, la primera es la norma ISO 286-1 distingue entre las 18 calidades o grados de tolerancia (UNE-EN, 2011).

- Las cantidades IT0 hasta IT3: para piezas de alta precisión,
- De IT4 a IT11 son para piezas con ajustes
- De IT12 a IT18 para piezas sin ajuste y sin acabado

Dimensión Nominal ( $d_N$  para ejes y  $D_N$  para agujeros): Es el valor teórico que muestra una medida:

Dimensión efectiva ( $d_e$  para ejes y  $D_e$  para agujeros): Es el valor real del elemento fabricado:

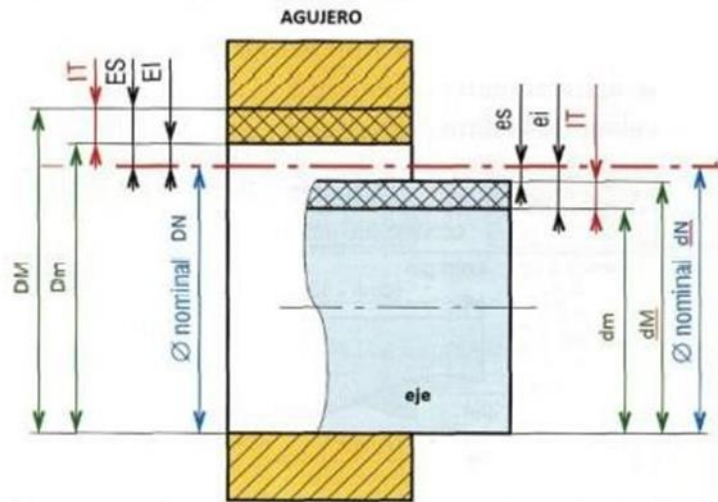
Dimensión límite superior ( $d_M$  para ejes y  $D_M$  para agujeros): Valor máximo permitido de la dimensión efectiva:

Dimensión límite inferior ( $d_m$  para ejes y  $D_m$  para agujeros): Valor mínimo permitido para la



dimensión efectiva:

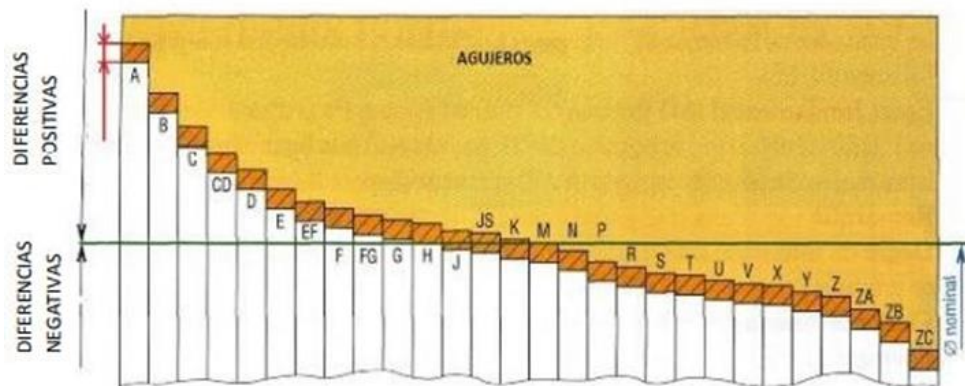
Tolerancia (it para ejes y IT para agujeros): Es el cambio que puede tener una medida de una pieza, también puede ser la diferencia entre el límite superior e inferior:



**Figura 16-2:** Nomenclatura de las tolerancias:

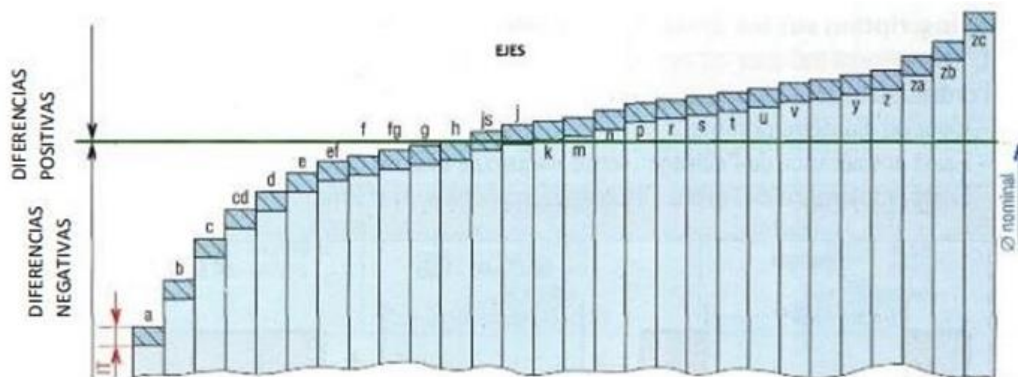
Fuente: (Tornero, 2012)

La norma ISO 286-1 define 28 posibles zonas tanto para ejes como para agujeros, estas se observan a continuación:



**Figura 17-2:** Posición de las zonas en agujeros

Fuente: (Tornero, 2012)



**Figura 18-2:** Posición de las zonas en ejes

Fuente: (Tornero, 2012)

## 2.22. Tolerancias generales

La norma ISO 2768-1 es la encargada sobre definir las tolerancias lineales de forma general, en la norma se define las tolerancias y características dimensionales de acuerdo a la función que realice el elemento: Con base en esto se define cuatro tipos de tolerancia fundamentales con su respectiva simbología: Fina (f), Media (m), Grosera (c), Muy Grosera (v), bajo estas tolerancias se procede a definir si la dimensión sea apropiada (UNE-EN, 2005): La selección de la tolerancia general está relacionada con el proceso de fabricación: En planos se indica la tolerancia en el cajetín o bien junto a él, escribiendo la norma y la designación de la calidad seleccionada es decir f, m, c, v: Por ejemplo: ISO 2768-c.

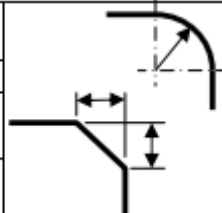
En el caso de que la pieza fabricada, no cumpla con la tolerancia definida esta debe ser rechazada, o se indique que no es apta para su funcionamiento.

Clase de Tolerancia		Desviaciones admisibles respecto al valor nominal $d$ (en mm.)							
	Descripción	0,5 < $d$ ≤ 3	3 < $d$ ≤ 6	6 < $d$ ≤ 30	30 < $d$ ≤ 120	120 < $d$ ≤ 400	400 < $d$ ≤ 1000	1000 < $d$ ≤ 2000	2000 < $d$ ≤ 4000
<b>f</b>	fina	±0,05	±0,05	±0,1	±0,15	±0,2	±0,3	±0,5	-
<b>m</b>	media	±0,1	±0,1	±0,2	±0,3	±0,5	±0,8	±1,2	±2
<b>c</b>	grosera	±0,2	±0,3	±0,5	±0,8	±1,2	±2	±3	±4
<b>v</b>	muy grosera	-	±0,5	±1	±1,5	±2,5	±4	±6	±8

**Figura 19-2:** Tolerancias para dimensiones lineales, excepto aristas matadas

Fuente: (UNE-EN, 2005)

Clase de Tolerancia		Desviaciones admisibles respecto al valor nominal $d$ (en mm.)		
	Descripción	3< $d$ ≤6	6< $d$ ≤30	30< $d$ ≤120
<b>f</b>	fina	±0,2	±0,5	±1
<b>m</b>	media			
<b>c</b>	grosera	±0,4	±1	±2
<b>v</b>	muy grosera			



**Figura 20-2:** Tolerancias para dimensiones lineales de aristas matadas

Fuente: (UNE-EN, 2011)

Clase de Tolerancia		Desviaciones admisibles en función de la longitud del lado menor del ángulo considerado $d$ (en mm.)				
	Descripción	$d$ ≤10	10< $d$ ≤50	50< $d$ ≤120	120< $d$ ≤400	400< $d$
<b>f</b>	fina	±1°	±0°30'	±0°20'	±0°10'	±0°5'
<b>m</b>	media					
<b>c</b>	grosera	±1°30'	±1°	±0°30'	±0°15'	±0°10'
<b>v</b>	muy grosera	±3°	±2°	±1°	±0°30'	±0°20'

**Figura 21-2:** Tolerancias para dimensiones angulares

Fuente: (UNE-EN, 2011)

## CAPÍTULO III

### 3. MARCO METODOLÓGICO

Se detallara en el presente capitulo el proceso del diseño y la construcción de la biela de un motor Suzuki de dos tiempos de una motocicleta, se inicia con la búsqueda y compra de la biela para luego aplicar la ingeniería inversa, a continuación se procede con el proceso de diseño usando un paquete informático aliado con el CAD, este diseño será enviado a otro paquete informático de diseño aplicando el CAM el mismo que permitirá proceder con la simulación del modelo a mecanizar y optimizando con estrategias CAM, todo esto permitirá reducir tiempo y costo en la manufactura mejorando la calidad de manera importante superficialmente: Elegimos las herramientas adecuadas con sus respectivos portaherramientas para la fabricación de la biela cabe mencionar que todo esto se llevara a cabo en un centro de mecanizado (fresa CNC).

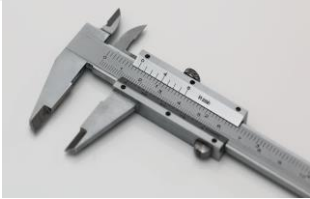


#### 3.1. Recursos y Herramienta

##### 3.1.1.Herramientas

Para la realización del proyecto técnico se utilizaron una serie de máquinas y herramientas, tanto para metrología, diseño y manufactura las cuales se detallarán a continuación en la Tabla 1-3:

**Tabla 3-1:** Herramientas y Maquinas utilizadas:

#### *HERRAMIENTAS*

<i>Nombre</i>	<i>Descripción</i>	<i>Figura</i>
<i>Calibrador pie de Rey</i>	Se utiliza para realizar mediciones de manera precisa, tanto en el sistema métrico internacional y americano:	
<i>Caja de Herramientas</i>	Consta de una serie de herramientas, como dados rachas, dados, llaves inglesas, desarmadores, entre otras que se utilizan para el trabajo manual:	
<i>Lija</i>	Se utilizan para el desbaste de material y para el proceso de pulido dependiendo de la robustes de las mismas:	

*Equipo de protección*

Es fundamental para resguardar la integridad física del operario y para reducir el riesgo de lesión en caso de algún accidente:



## MAQUINAS

*CNC*

Son maquinas controladas por computadora, se utilizan para el mecanizado de diversos materiales como: madera, plástico, metales: S funcionamiento está controlado por líneas de programación previamente establecidas:



*Laptop*

Se utiliza para el diseño de los prototipos que van a ser mecanizados a posterior, además de los análisis de esfuerzo y deformaciones:



*Medidor de dureza  
ROCKWELL*

Su función es la de determinar la dureza de un material, esto se consigue con un ensayo rápido de deformación, con ayuda de una punta penetrante que deforma la superficie del material:



*Microscopio Viewmet  
Buehler:*

Para determinar la estructura de los materiales que componen un elemento, se utiliza un microscopio que nos ayuda a visualizar la estructura superficial del mismo:



*Pulidora*

Es una herramienta que nos permite dar un mejor acabado superficial a los elementos fabricados, esto por medio del desbaste de material:



*Balanza*

Para realizar mediciones de pesos, se utiliza una balanza digital:



Realizado por: Toapaxi Wilson 2020

### 3.1.2. Recursos

#### 3.1.2.1. Recursos Humanos:

El trabajo en equipo forma parte fundamental del proyecto para lo cual se cuenta con un grupo conformado por las siguientes personas:

- Director
- Miembro
- Asesores externos

#### 3.1.2.2. Recursos Económicos

El aspecto de costos es importante para conocer si será rentable o no el mismo después de determinar los costos tales como: directos e indirectos:

- **Costos directos de manufactura**

Estos interfieren en el proyecto de manera directa en el transcurso del proyecto y dentro de estos son tomados en cuenta tales como:

**Tabla 2-3:** Materiales/Trabajo

DESCRIPCION	CANTIDAD	COSTO UNITARIO	COSTO
BIELA DE MOTO DE2T	1	25	25
BURIL 6 mm	2	18	36
Buril 3 mm	2	12	24
Bloque de acero AISI4130	2	10	20
Fresado en CNC	1	67	67
Torneado	1	67	67
SUBTOTAL			239

Realizado por: Toapaxi Wilson 2020

- **Costos indirectos**

Se denomina gastos indirectos a los empleados en la elaboración del proyecto estos a su vez no influyen en los resultados:

**Tabla 3-2:** Costos indirectos

DESCRIPCION	COSTO
Costo ingenieril	160
Transporte	100
Imprevistos	100

Documentación	50
Total	410

Realizado por: Toapaxi Wilson 2020

- **Costos totales**

Esta viene a ser la sumatoria de los costos mencionados anteriormente:

**Tabla 4-3:** Costo Total

DESCRIPCION	COSTO
COSTOS DIRECTOS	239
COSTOS INDIRECTOS	410
TOTAL	649

Realizado por: Toapaxi Wilson, 2020

### 3.2. Ingeniería inversa

Es todo lo opuesto a la ingeniería de manera convencional ya conocida, en este tipo de ingeniería se trata de conseguir la mayor cantidad de información que sea posible como, por ejemplo: su construcción, funcionamiento, diseño y parte de un elemento o producto ya terminado: (Lisintuña Toapanta y Molina Molina 2017, p:30):



**Figura 1-3:** Medición del modelo.  
Realizado por: Autor

#### 3.2.1. Biela de motor de moto de dos tiempos

La biela es un componente mecánico que sirve de unión entre el pistón y el cigüeñal adicional a esto permite la transformación de movimiento lineal a circular, el mismo debe soportar el torque y potencia producida en la cámara de combustión: Esta biela prestaba la función en un motor de dos tiempos de 100cc.



**Figura 2-3:** Biela de un motor de moto de dos tiempos

Realizado por: Toapaxi Wilson: 2020

### 3.3. Ensayo de espectrometría

Con el fin de conocer el material de la pieza se realiza este ensayo de espectrometría de tipo óptico Bruker: Con el mismo analizaremos el material deseado cubriendo un rango de sub-ppm hasta concentraciones grandes, el ensayo no mostrara la composición del cual está formado el material bajo la norma ASTM E10-85: (Cadena et al., 2019)

#### Bruker Analysis Report



Sample:					
Analysis Time: 12.11.2019 12:24:14			Method: Fe110		
	C [%]	Si [%]	Mn [%]	P [%]	S [%]
∅	0,252	0,296	1,103	0,0073	<0,0030
	Cr [%]	Mo [%]	Ni [%]	Cu [%]	Al [%]
∅	1,179	0,034	0,056	0,084	0,061
	Co [%]	Nb [%]	Ti [%]	V [%]	W [%]
∅	0,0072	<0,0050	0,061	0,010	<0,020
	B [%]	Sn [%]	Fe [%]		
∅	<0,0010	0,033	96,82		

**Figura 3-3:** Resultados de la prueba de espectrometría del componente original

Realizado por: Toapaxi Wilson: 2020

### 3.4. Ensayo de dureza

Es un ensayo de mucha ayuda el cual nos brindara información para identificar el grado de dureza que tiene un material, este grado se lo mide en dureza Brinell, Rockwell y Vickers y se lo realiza en una maquina universal, para tener mayor fiabilidad de este ensayo se debe realizartres veces el ensayo en diferentes puntos: Con la ayuda de este ensayo sabremos el nivel de dureza que tiene este prototipo y el elemento base, a continuación, mostraremos el nivel de dureza de cada elemento: La norma usada fue ASTM E18.



**Figura 4-3:** Maquina universal en escala ROCKWELL  
Realio po: Toapaxi Wilson: 2020



**Figura 5-3:** Valor de dureza de la biela de motor de moto Suzuki x100  
Realizado por: Toapaxi Wilson: 2020



### 3.5. Ensayo micrografía

El ensayo de metalografía permite identificar el tipo de microestructura, de un material por medio de varios pasos consecutivos, además podemos identificar características del material una vez identificado el tipo de grano.

La biela fue sometida al ensayo metalográfico para identificar el tipo de grano y por medio de este saber las propiedades mecánicas que presenta el mismo:

Para este ensayo debemos seguir un proceso: Primero demos lijar nuestra probeta con lijas de agua iniciando con una de grano mayor hastallegar a una con grano fino, esto es bajo la norma ASTM E112



**Figura 6-3:** Proceso de lijado:

**Realizado por:** Toapaxi Wilson: 2020

El siguiente paso es pulir el área lijada hasta obtener un efecto espejo: Para ello usares la maquina pulidora junto con la alúmina.



**Figura 7-3:** Maquina pulidora

**Realizado por:** Toapaxi Wilson: 2020



**Figura 8-3:** Alumina  
Realizado por: Toapaxi Wilson: 2020

Al finalizar el pulido se procede a realizar el ataque químico para este proceso se usó nital, luego de atacarle químicamente se limpió con agua el área atacada.



**Figura 9-3:** Ataque químico con Nital:  
Realizado por: Toapaxi Wilson: 2020

Finalmente nos dirigimos al microscopio para poder observar el tipo de microestructura continente el elemento: Se puede apreciar claramente la presencia de cobre en la microestructura



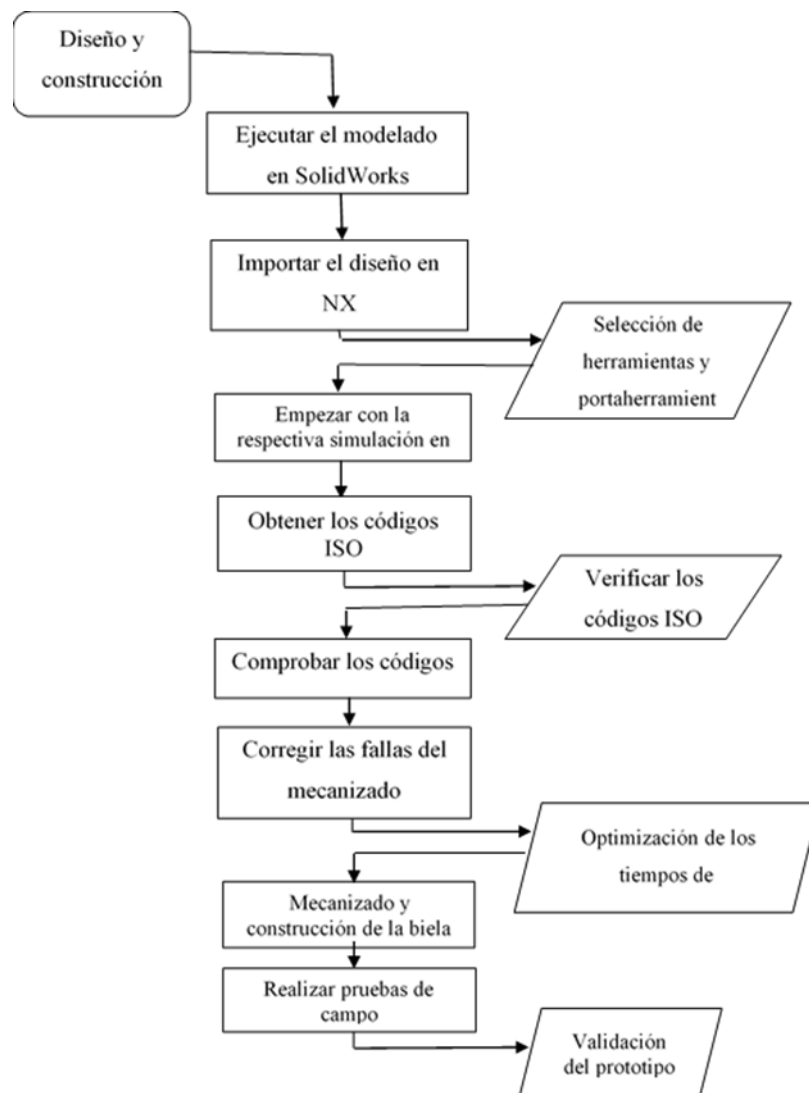
**Figura 10-3:** Ubicación de la biela en el microscopio viewmet buehler:  
Realizado por: Toapaxi Wilson: 2020



**Figura 11-3:** Microestructura compuesta por martensita y austenita en la biela original

Realizado por: Toapaxi Wilson: 2020

### 3.6. Diagrama de procesos para el diseño y construcción del prototipo:



**Figura 12-3:** Diagrama de procesos

Realizado por: Toapaxi Wilson: 2020

### 3.7. Modelado

Se usa un software CAD llamado SOLIDWORKS debido a su gran versatilidad y facilidad de uso, se debe empezar desde un punto ingenieril en este caso será la ingeniería inversa la cual se detallará con más profundidad más adelante y obviamente tomando en cuenta el elemento a diseñar que para el caso será la biela de dos tiempos de un motor de moto.

#### 3.7.1. Solidworks:

Su principal función es el modelado, es un tipo de software CAD, se pueden realizar piezas en 2D Y 3D además es muy versátil ya que nos permite exportar los planos técnicos del modelado incluido la información necesaria para realizar la producción, podemos decir que la herramienta CAD nos permite de buena manera modelar el diseño propuesto de manera virtual.



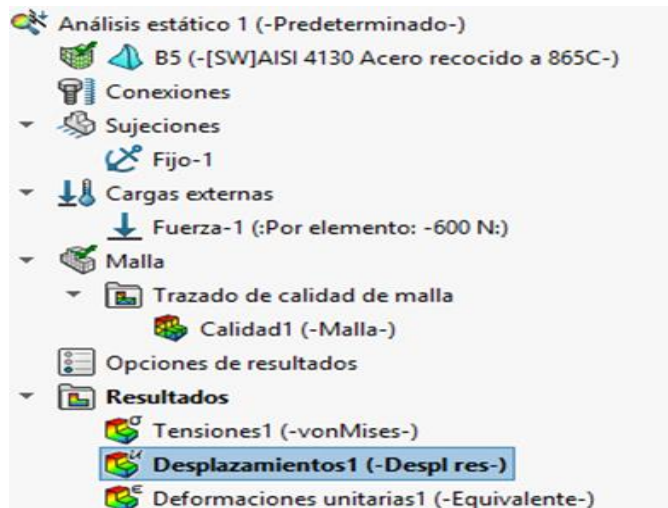
**Figura 13-3:** Modelado del prototipo del block realizado en SOLIDWORKS

Realizado por: Toapaxi Wilson: 2020

#### 3.7.1.1. Análisis Dinámico

La Ingeniería Asistida por Computador (CAE) permite analizar las cargas que recae sobre un elemento a través del análisis de elementos finitos (MEF) con ello se obtendrá las deformaciones del componente en función a las cargas que se somete: Para el caso en estudio se sometió a cargas al cual está sometido la biela de moto de dos tiempos en el momento de su funcionamiento que para el caso es de 600 N: Todo este análisis conlleva un proceso que se detalla a continuación.

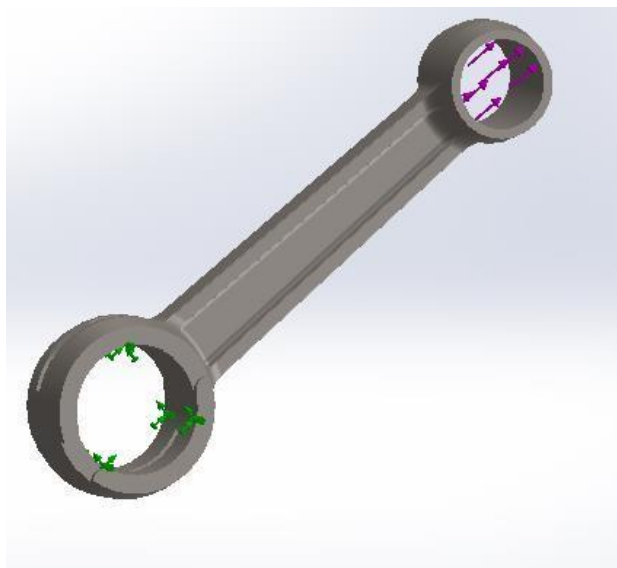
Una vez con el elemento introducido en el software de análisis de elementos finitos se debe llevar a cabo la selección del material para que el resultado del análisis sea lo más cercano posible, para el caso de estudio se selecciona el material aluminio, se aprecia en la figura.



**Figura 14-3:** Selección de material en el software para el análisis correspondiente

Realizado por: Toapaxi Wilson: 2020

Para el análisis correspondiente se debe fijar o tener puntos fijos el cual funcionara como anclaje para proceder más tarde a ubicar la fuerza correspondiente en el lado contrario simulando una carga axial para el caso se usa 600 N en este caso se simula carga axial denominada tracción.

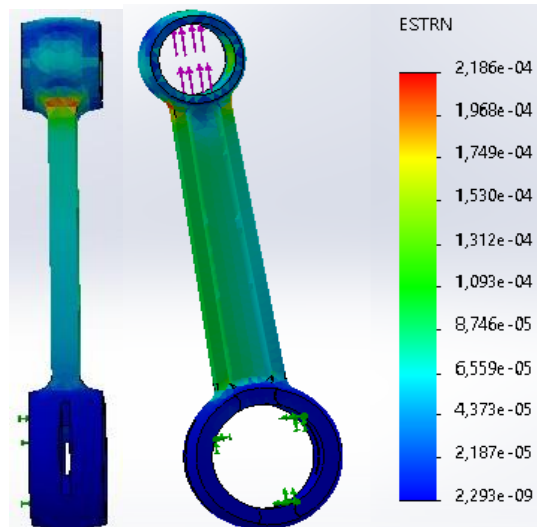


**Figura 15-3:** Solicitaciones sobre la biela

Realizado por: Toapaxi Wilson: 2020

### 3.7.1.2. *Equivalente Elástico*

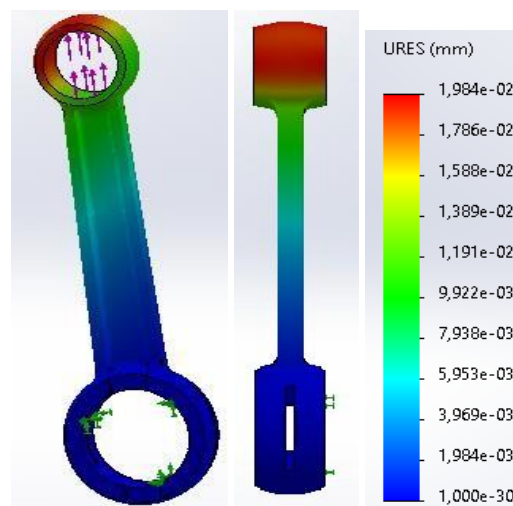
El equivalente elástico está relacionado con las propiedades elásticas de los materiales tiene estrecha relación con la tensión y deformación de los mismos, los resultados arrojados del análisis MEF nos muestra que en la biela prototipo tendremos los valores de 0,0002186 como valor máximo de equivalente elástico y un valor de  $2:293 \times 10^{-9}$  como valor mínimo.



**Figura 16-3:** Deformaciones unitarias sobre la biela  
**Fuente:** Toapaxi Wilson: 2020

### 3.7.1.3. Deformación total

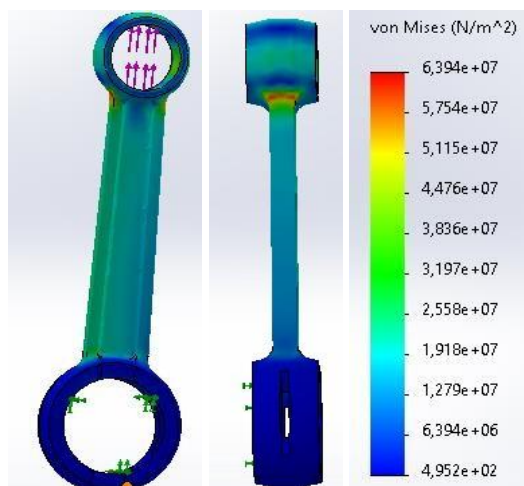
La deformación total hace referencia a un cambio de dimensión en las correspondientes medidas de un componente al estar el mismo bajo cargas, en este caso de estudio el elemento está sometido bajo cargas de tracción, compresión y flexión, en los resultados arroja se observa una deformación máxima de 0,01984 mm después de este valor el elemento procederá a la fractura.



**Figura 17-3:** Deformaciones sobre la biela  
**Realizado por:** Toapaxi Wilson: 2020

### 3.7.1.4. Análisis de esfuerzos

También se realiza en análisis del esfuerzo que soporta la biela bajo las cargas de trabajo, donde se determina que el esfuerzo máximo es de  $6,3945 \times 10^7$  [N/m<sup>2</sup>]



**Figura 18-3:** Esfuerzo de Von Mises  
Realizado por: Toapaxi Wilson: 2020

### 3.7.2. Identificación de características del prototipo (Acero AISI 4130)

El acero AISI 4130 es un acero al Cr-Mo con un porcentaje de carbono de 0:3%, es utilizado ampliamente en la construcción, posee buenas características de soldabilidad, posee buena maquinabilidad y no es susceptible de fragilidad de revenido (AZO Materials, 2014): A continuación, se procede a definir las propiedades mecánicas del acero AISI 4130.

**Tabla 3-3:** Propiedades mecánicas

Propiedades	Unidades métricas	Unidades Imperiales
Esfuerzo último a la tracción	560 MPa	81200 psi
Esfuerzo de fluencia	460 MPa	66700 psi
Módulo de elasticidad	190-210 GPa	27557-30458 psi
Módulo de compresibilidad	140 GPa	20300 ksi
Módulo de cizallamiento	80 GPa	11600 ksi
Módulo de Poisson	0:27-0:30	0:27-0:30
Alargamiento a la rotura	21:50%	21:50%
Reducción de superficie	59:60%	59:60%
Dureza Brinell	217	217
Dureza Knoop	240	240
Dureza Rockwell B	95	95
Dureza Rockwell C	17	17
Dureza Vickers	228	228
Maquinabilidad	70%	70%

Fuente: (AZO Materials, 2014)

Realizado por: Toapaxi Wilson 2020

Mientras que la composición química es este acero es la siguiente:

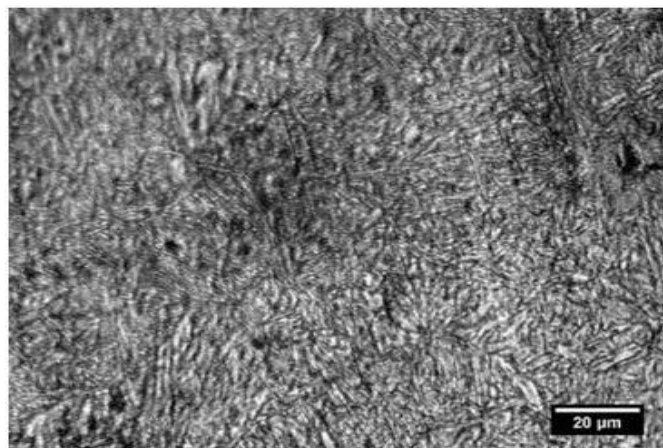
**Tabla 4-3:** Composición acero AISI 4130

Elemento	Contenido %
Hierro, Fe	97,03-98,22
Cromo, Cr	0:80- 1:10
Manganeso, Mn	0:40- 0:60
Carbono, C	0:28- 0:33
Silicio, Si	0:15- 0:30
Molibdeno, Mo	0:15- 0:25
Azufre, S	0:040
Fosforo, P	0:035

**Fuente:** (AZO Materials, 2014)

**Realizado por:** Toapaxi Wilson 2020

La estructura presente generalmente en este acero es martensítica revenida con una alta estabilidad producida en gran medida por el manganeso y el silicio contenido en la estructura, formando además una estructura compleja de carburos de tipo  $\epsilon$ , se observa en la Figura 24-3 (Álvarez et al., 2019):



**Figura 19-3:** Resultados de la prueba de espectrometría del componente original

**Fuente:** (Álvarez et al., 2019)

### 3.7.3. Factor de seguridad

Al conocer el esfuerzo de fluencia del material y la carga a la que está sometida la pieza, se procede a determinar el valor del factor de seguridad del prototipo:

$$\eta = \frac{\sigma}{S_y}$$
$$\eta = \frac{460 \text{ MPa}}{63,94 \text{ MPa}}$$
$$= 7:2$$



### 3.8. Características de la maquina CNC

La máquina usada para el mecanizado es un CNC FADAL 88HS, A continuación, se procede a definir las características de esta.

**Tabla 5-3:** Características de la maquina CNC



Características	
Fabricante:	Fadal
Modelo:	VMC 4020A
Peso:	10 T
Ejes:	3
Control:	Fadal CNC 88HS
Dimensiones mesa:	1219 X 508 mm
Recorridos x/y/z:	1016/508/508 mm
Cono:	BT-40
Rpm cabezal:	7500
Cargador herramienta:	21 herramientas

Realizado por: Wilson Toapaxi 2019

### 3.9. Selección de herramientas

Para iniciar con la mecanización se inicia con la selección de herramientas recurriendo a un catálogo para el caso fue de la marca SANDVICK COROMANT, la selección fue en base a la superficie de las caras y el tipo de proceso, también se tomó la decisión del uso de los mismos debido al tipo de material a manufacturar que para el caso es una aleación de aluminio-cobre el cual está definido en la figura 29-3:

**Tabla 6-3:** Fresas utilizadas para la manufactura del prototipo

Diámetro (mm)	Longitud (mm)	N de herramienta	Longitud de ranura (mm)	Dureza (HRC)	Foto
6	62	2	16	48	
3	38	4	13	48	

Realizado por: Wilson Toapaxi 2019

### 3.10. Cálculo de velocidades de husillo para las herramientas

Se procederá a calcular las velocidades de las herramientas usadas indicadas en la tabla 1-3, los datos a tomarse en cuenta son: la velocidad de corte de 60mm/min a causa de que tenemos un bloque con una aleación de aluminio-cobre.

#### 3.10.1. Velocidad para la herramienta 1

Datos:

$$d=6 \text{ mm}$$

$$V_c = 60 \text{ mm/min}$$

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

$$n = \frac{60:1000}{\pi:6} (\text{rpm})$$

$$n = 3183:09 (\text{rpm})$$

#### 3.10.2. Velocidad para la herramienta 2

Datos:

$$d = 3 \text{ mm}$$

$$V_c = 60 \text{ mm/min}$$

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

$$n = \frac{V_c:1000}{\pi:3} (\text{rpm})$$

$$n = 6366:19 (\text{rpm})$$

### 3.11. Cálculo de avances para las herramientas

Se define avance a un sucesivo movimiento de la cuchilla a usar por cada pasada en la mecanización del elemento, el mismo nos aporta un rango de utilización y así evitar un prematuro desgaste de este

**3.11.1. Avance de la herramienta 1**

$$f = n: a: n_z$$

$$f = 3183:4:0,016$$

$$f = 203:71 \left( \frac{mm}{min} \right)$$

**3.11.2. Avance de la herramienta 2:**

$$f = n: a: n_z$$

$$f = 6366:4:0,008$$

$$f = 203:71 \left( \frac{mm}{min} \right)$$

**3.11.3. Tiempos de mecanizado**

**Tabla 7-3:** Tiempos de mecanizado

Biela	
Caras	Tiempo en minutos
Cara 1	4.24
Cara 2	11.12
Cara 3	1.43
Cara 4	2.94
Cara 5	1.16
Cara 6	7.03
Cara 7	1.22
Cara 8	0.74
Cara 9	10.23
Total	456.34

Realizado por: Toapaxi Wilson 2020

### 3.12. Selección de portaherramientas

Se usa para el mecanizado un portaherramientas tipo cono de la marca DIEBOLD con numeración Sk40XER32, la numeración es muy importante ya que tendremos más datos en el software y proceder con la simulación de mejor manera y más eficiente, según sea el requerimiento del diseño.

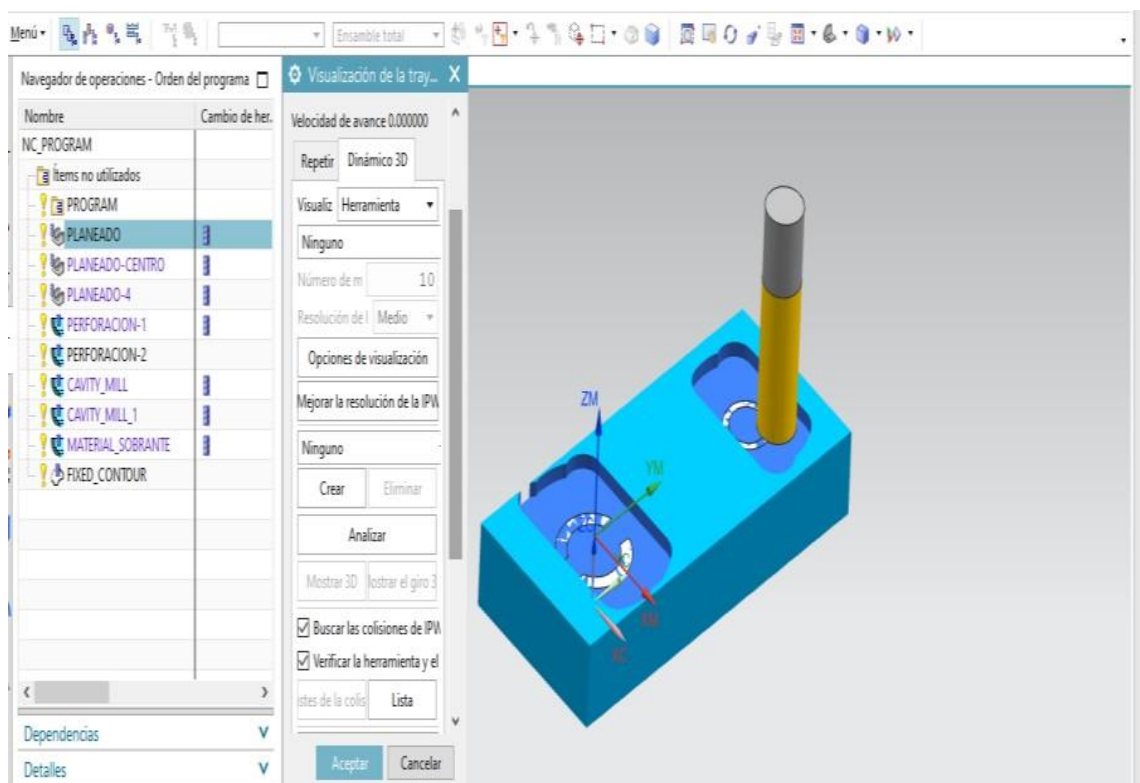
### 3.13. Optimizado de mecanizado

Se optimizo la manufactura al dividir en diferentes secciones el proceso mediante el software NX y con la generación del código ISO, además de la simulación, para ello se decidió optar por estrategias que sean de mejor eficiencia y en base a lo que se requiera en el diseño.

#### 3.13.1. Estrategias CAM

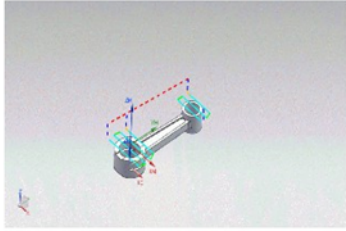
Con el software se tiene la versatilidad de usar múltiples estrategias o la que se necesite a la hora obtener mejor acabado y menor consumo de tiempo.


En la figura se puede visualizar el tipo de estrategia usada para el mecanizado, para el caso concerniente a las caras planas de biela sea decidido usar una estrategia de planeado.



**Figura 20-3:** Mecanizado de caras planas con la opción PISO Y PARED  
Realizado por: Toapaxi Wilson: 2020

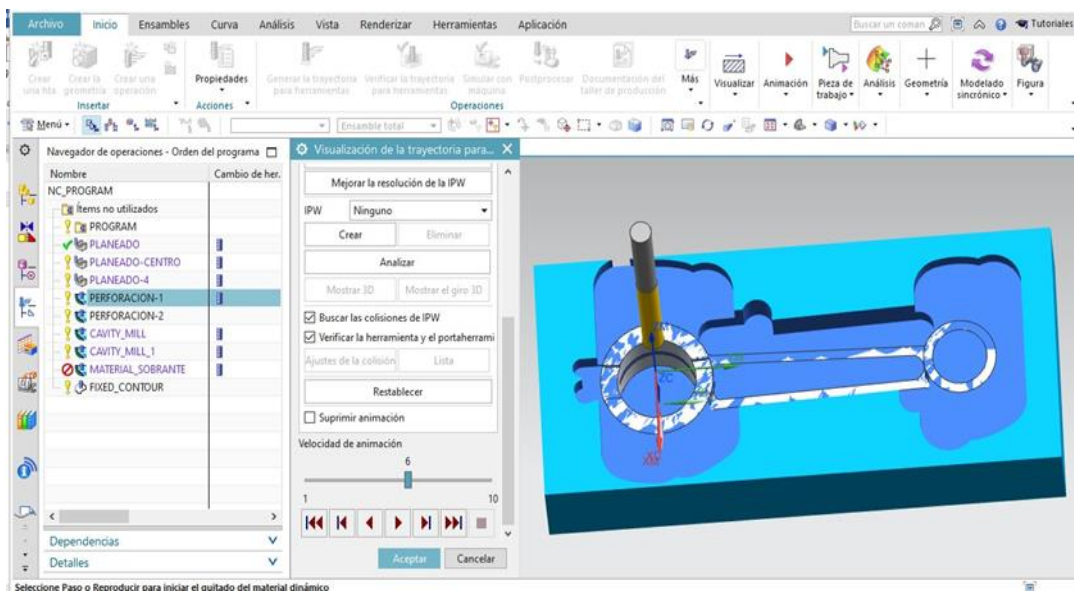
## Program Sheet

Part name: BIELASSS	Drawing name: _____
Unit: MM	Part number: _____
Pictures :	Description :
	

Index	Operation Name	Type	Program	Machine Mode	Tool Name	Tool Path Time in Minutes	Path Image
1	PLANEADO	Volume Based 2.5D Milling	NC_PROGRAM	MILL	FRESA-19MM	1.61	

**Figura 21-3:** Tiempo de mecanizado.

Realizado por: Toapaxi Wilson: 2020



**Figura 22-3:** Mecanización con la opción FRESADO DE CABIDADES.

Realizado por: Toapaxi Wilson: 2020

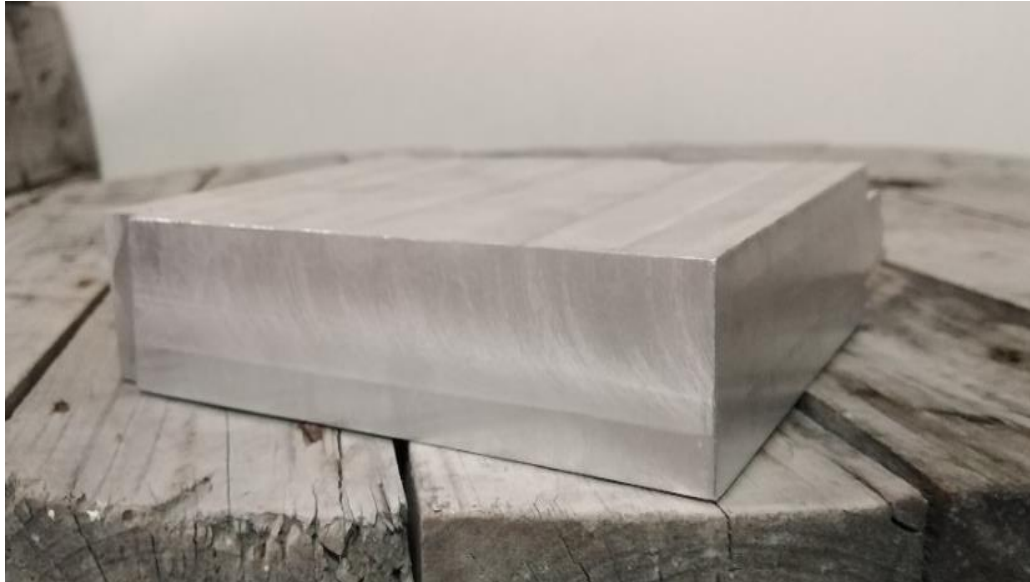
### 3.13.2. Optimización de los procesos

#### Optimización de código ISO

El código ISO (Anexo F) es una parte fundamental para la mecanización este código será obtenido del software NX 12 después que se haya revisado y por último simulado la manufactura, en función al torno CNC debemos modificar determinados parámetros del respectivo código como, por ejemplo: los ejes y coordenadas para la respectiva manufactura: Y la optimización del código se observa en el Anexo G.

### 3.14. Manufactura del prototipo de biela

- Se inicia con el proceso de fundición del bloque con las medidas correspondientes, cabe recalcar que este bloque debe tener una tolerancia de sobredimensionamiento para poder tener un mejor agarre en el centro de mecanizado.



**Figura 23-3:** Bloque fundido  
Realizado por: Toapaxi Wilson: 2020

- El siguiente paso es cuadrar el bloque en el centro de mecanizado tratando de nivelar al bloque de todos los lados y verificar las medidas.



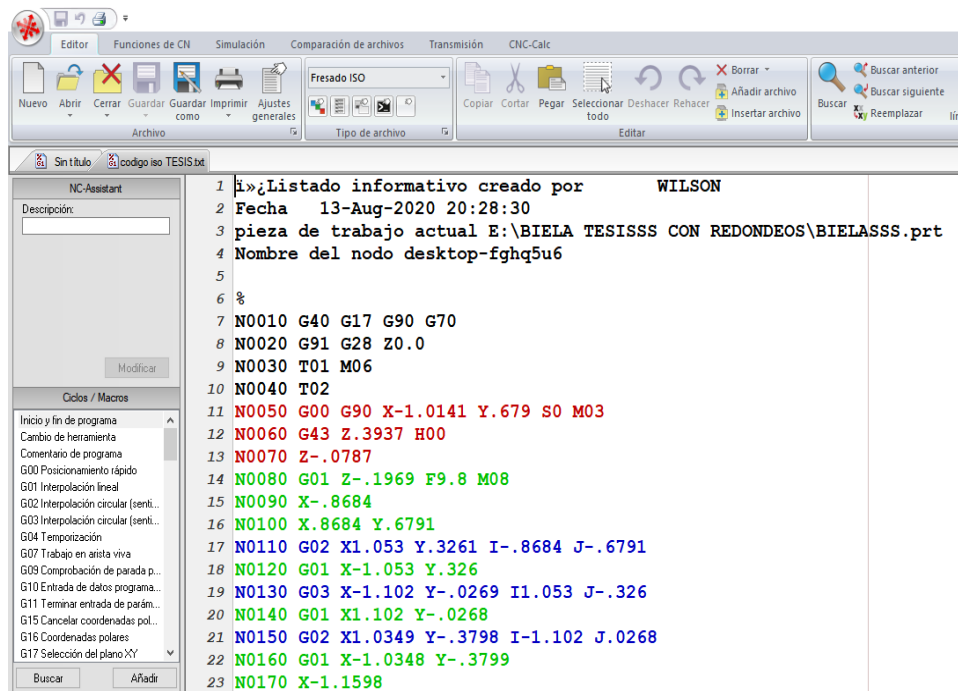
**Figura 24-3:** Centrado del bloque  
Realizado por: Toapaxi Wilson: 2020

- El centro de mecanizado usado para la mecanización es un CNC FADAL CNC 88HS contres ejes.



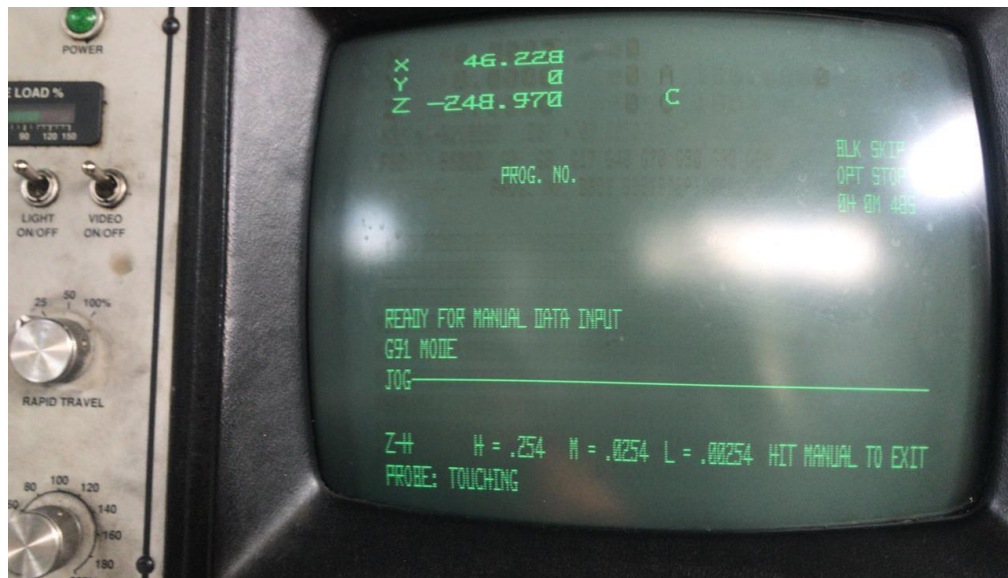
**Figura 25-3:** Fresadora CNC FADAL 88HS  
Realizado por: Toapaxi Wilson: 2020

- Se debe realizar una previsión del código ISO, para ello se usó un software denominado CIMCO.



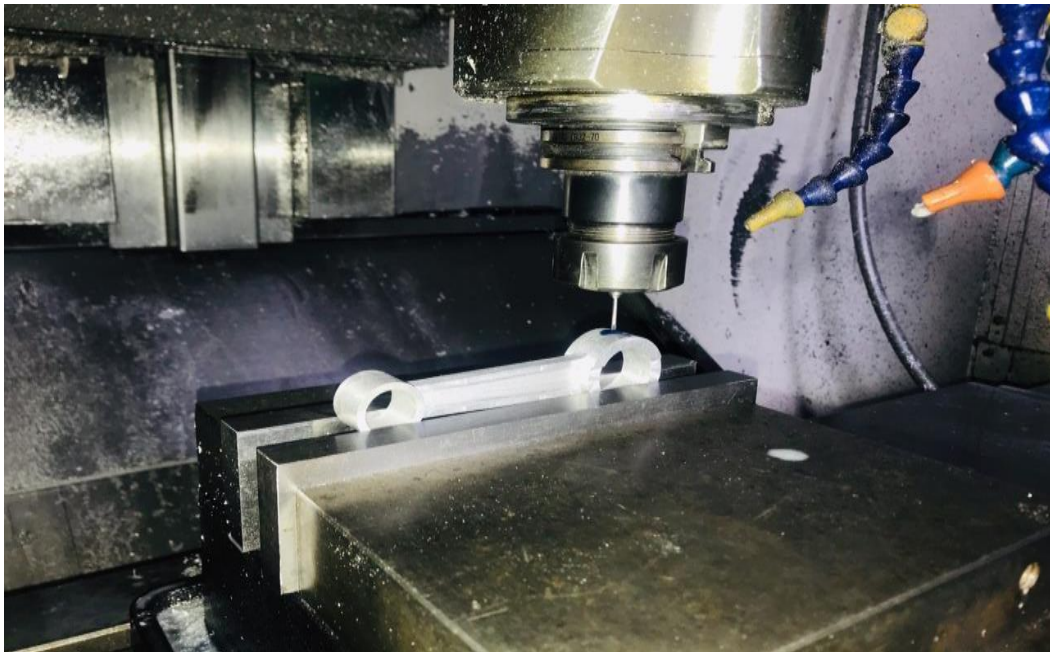
**Figura 26-3:** Fresadora CNC FADAL 88HS  
Realizado por: Toapaxi Wilson: 2020

- Una vez revisado el código ISO se procede a la maquina CNC para asignar el cero pieza el cual será el inicio de partida de referencia para la manufactura.



**Figura 27-3:** Cero piezas:  
Realizado por: Toapaxi Wilson: 2020

- Para la manufactura se debe tener en cuenta el agarre del bloque con respecto al centro de mecanización y elegir el orden de las caras sin que haya de existir choques.



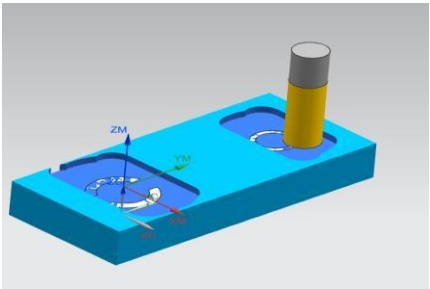

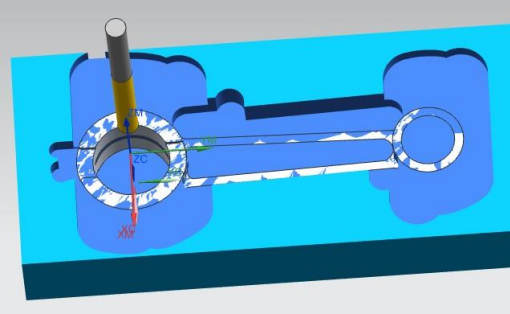

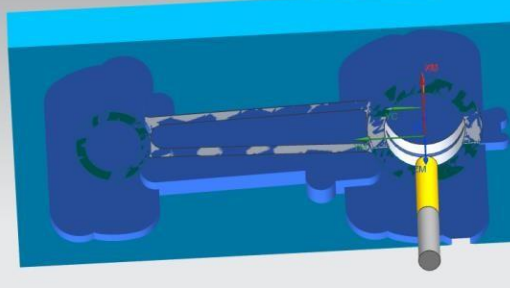

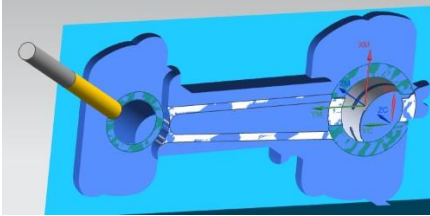

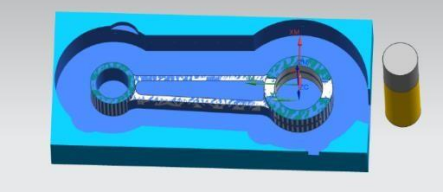

**Figura 28-3:** Mecanización de orificio  
Realizado por: Toapaxi Wilson: 2020

### 3.15. Resultados del mecanizado

A continuación, se muestra por medio de una tabla los resultados de la mecanización en forma ordenada.



**Tabla: 8-3:** Resultados de mecanización.

Imagen del mecanizado	Imagen de construcción
	
	
	
	
	

Realizado por: Toapaxi Wilson 2020

### 3.16. Comparación del prototipo

Para la comparación del elemento se basa en características de construcción se inicia mencionando que el prototipo es de un acero AISI 4130, además una principal característica de diferenciación es el peso de la biela prototipo con respecto a la biela de dos tiempos de moto el cual se usó como base del presente prototipo: A continuación, los valores de peso marcados en la balanza digital con alta precisión, se puede observar que hay una diferencia importante de peso.



**Figura 29-3:** Peso del prototipo de la biela de motor de moto.  
Realizado por: Toapaxi Wilson: 2020



**Figura 30-3:** Peso de la biela de motor de moto Suzuki x100  
Realizado por: Toapaxi Wilson: 2020

El peso de la biela del motor y la biela prototipo es de 131:5 gramos y 122:5 gramos respectivamente.

## CAPÍTULO IV

### 4. RESULTADOS

Para el agujero de la biela según la norma ISO 286-1 es necesario un giro de poco juego que hace referencia al ajuste de H7: Para diámetros entre 18 y 30 mm, se determina que la desviación inferior es 0 y la superior es de 21  $\mu m$ . Se observa la tabla de tolerancias en el Anexo II.

**Tabla 1-4:** Desviación de las medidas del agujero del prototipo [mm]

Cota	Radio	Diámetro prototipo	Dimensión real	Desviación inferior	Desviación superior	Desviación	Error relativo	Nomenclatura cota
1	9	17,75	18 0	0,021	0,025	-	1,39 %	$\phi 18$ H7
2	13	25,75	26 0	0,021	0,025	-	0,96 %	$\phi 26$ H7

Fuente: Autor

Realizado por: Toapaxi Wilson 2020

Para las dimensiones generales de la biela según la norma ISO 2768-1, según el método de fabricación que es el mecanizado en CNC y no es una cota de alta precisión se define como una tolerancia media (m): Donde para las medidas de 6 a 30 mm la desviación de la medida puede ser  $\pm 0,2 mm$  mientras que de 30 hasta 120 mm es de  $\pm 0,3 mm$ , para dimensiones menores es de  $\pm 0,1 mm$ : Por otro lado, para radios exteriores entre 6 y 30 mm la desviación es de  $\pm 0,5 mm$ . A continuación, se procede a verificar las medidas obtenidas en el modelo con las medidas del diseño realizado:


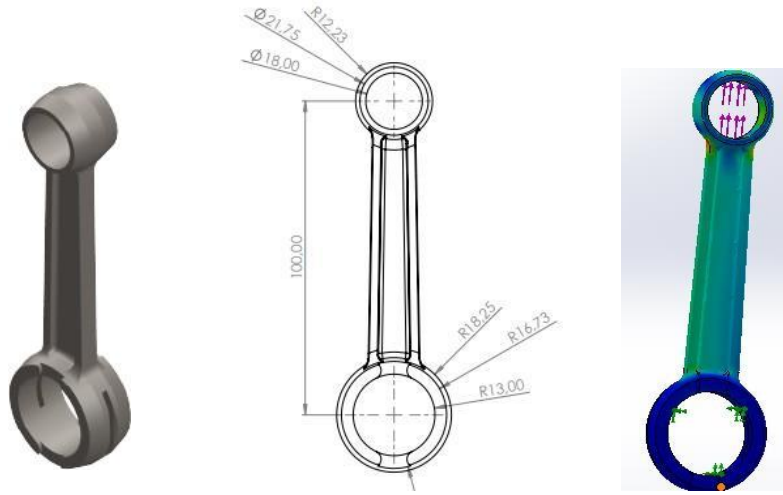
**Tabla 2-4 :** Desviación de las medidas del prototipo [mm]

Cota	Dimensión nominal	Dimensión real	Desviación máxima permitida ISO 2768-m	Desviación	Error relativo
1	16,39	16,40	0,2	0,01	0,06%
2	17,91	17,90	0,2	0,01	0,06%
3	17,01	17,00	0,2	0,01	0,06%
4	13,63	13,80	0,2	0,17	1,25%

Realizado por: Toapaxi Wilson 2021

A continuación, en la tabla 3-4 se presenta la hoja de verificación, la misma que es producto de los resultados antes descritos.

**Tabla 3-4:** Ficha de verificación

	ESCUELA POLITÉCNI CADE CHIMBORAZO	CÓDIGO	FCP- AB- HL- MM1	
	FACULTAD DE MECÁNICA	Versión	2021	
	HOJA DE VERIFICACI	Página	1 de 1	
DATOS GENERALES				
NOMBRE:	Biela	MATERIAL:	Acero AISI 4130	
RESPONSABLE	Toapaxi Wilson	SERIE:	001	
MODELO:	X100	MARCA:	ESPOCH	
INFORMACIÓN	NORMA ISO 286-1		NORMA ISO ISO 2768-1	
	CUMPLE	NO CUMPLE	CUMPLE	NO CUMPLE
	X		X	
				
	Dimensión Prototipo	Dimensión real	Desviación	Error
NORMA ISO 286-1	17,75	1 8	-0,25	1,39%
	25,75	2 6	-0,25	0,96%
NORMA ISO ISO 2768-1	16,39	16,40	0,01	0,06%
	17,91	17,90	0,01	0,06%
	17,01	17,00	0,01	0,06%
	13,63	13,80	0,17	1,25%

Realizado por: Toapaxi Wilson 2021

## CONCLUSIONES

- Se recopiló la bibliografía necesaria y suficiente para la manufactura y modelado las mismas que permitieron direccionar el prototipado del elemento y conocer las diferentes especificaciones que debe cumplir una biela.
- SolidWorks fue el software usado para la posterior modelación por su gran versatilidad y variedad de herramientas aplicadas al CAD que brindan ayuda al prototipado, además al realizar una simulación estática se logró conocer las deformaciones unitarias y los lugares de mayores cargas en la biela, el valor de la deformación total fue de 0,01984 mm, mientras que el esfuerzo de Von Mises máximo 63,9 MPa generando un factor de seguridad de 7,2.
- Con la ayuda del software NX se procedió con la simulación del mecanizado para posteriormente realizar la fabricación, fue pertinente la utilización de un centro de mecanizado de tres ejes con la distribución pertinente.
- Se recurrió a las estrategias de manufactura CAM para obtener mejores resultados en el acabado superficial. En el momento de la simulación se fue optimizando tiempos en cada proceso de manufactura y validando los mismos y ganar tiempo en el centro de mecanizado.
- Al analizar el material de la biela original se determina porcentajes de cada material del cual constituía carbono 0.252%, Mn 1.103%, Cr 1.179% entre otros, siendo un acero maquinable, por lo cual se selecciona para el prototipo el acero AISI 4130.
- Se comparó el elemento original con el prototipo en cuestión de pesos dando como resultado que el elemento original pesa 0.13 kg y el prototipo pesa 0.12 kg esto debido a la constitución de cada elemento mecánico, además se verificó que la biela cumpla con las normas de tolerancias dimensionales ISO 286-1 y ISO 2768-1
- Se diseñó una ficha de verificación con el fin de comprobar tanto las dimensiones críticas que son los agujeros y las demás medidas generales dando como resultado que se cumplen las normas para estas tolerancias.

## **RECOMENDACIONES**

- Para la mecanización es de suma importancia de tener una aleación idónea que permita la manufactura de este debido a que se tiene procesos de orificios y se puede fisurar en el momento de perforar.
- Para el proceso de modelado se debe dominar un software CAD
- Se recomendaría la simulación del proceso de manufactura para optimizar tiempos y posibles choques de herramienta.
- Para obtener mejores resultados en acabados superficiales y evitar que nuestras herramientas se desgasten rápidamente es recomendable realizar de manera precisa el cálculo de avances y velocidades.
- Es necesario y recomendable realizar la espectrometría al bloque que será usado para el prototipado para verificar si hay presencia de poros y la calidad de la aleación.

## **GLOSARIO**

**CAD:** Se le conoce de esta manera al diseño asistido por computadora, por sus siglas en inglés, como su nombre lo expresa su principal función es la ayuda al diseño de planos o modelos ya sean en 2D o 3D.

**CAE:** Se la conoce de esta manera a la ingeniería asistida por computadora, de igual manera por sus siglas en inglés: Su principal aplicación es la de ayudar a simular el rendimiento de un objeto, para mejorar su diseño.

**CAM:** La manufactura asistida por computadora es la parte final de un proceso en el cual se utilizan tanto el CAD como el CAE, consiste en la fabricación de un objeto con la ayuda de máquinas automatizadas que por medio de códigos pueden realizar el trabajo de manera precisa y controlada.

**CNC:** Control numérico por computadora, consiste en generar un diseño en un software que conste de varios movimientos ya serán lineales o rotacionales consecutivos.

**Tolerancia:** En ingeniería el término tolerancia se utiliza para describir el valor de error máximo permitido, teniendo en cuenta que siempre se va a presentar una desviación con respecto al diseño real y el teórico.

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## ANEXOS

### ANEXO A:

AMPLITUD DE LA ZONA DE TOLERANCIA SEGÚN EL DIÁMETRO Y EL GRADO DE CALIDAD

CALIDADES  $\mu\text{m}$  (1000  $\mu\text{m}$  = 1 mm)

Grado Tolerancia Diámetro (mm.)	IT 01	IT 0	IT 1	IT 2	IT 3	IT 4	IT 5	IT 6	IT 7	IT 8	IT 9	IT 10	IT 11	IT 12	IT 13	IT 14	IT 15	IT 16	IT 17	IT 18												
	Muy alta precisión																															
$d \leq 3$	0,3	0,5	0,8	1,2	2	3	4	6	10	14	25	40	60	100	140	250	400	600	1000	1400												
$3 < d \leq 6$	0,4	0,6	1	1,5	2,5	4	5	8	12	18	30	48	75	120	180	300	480	750	1200	1800												
$6 < d \leq 10$	0,4	0,6	1	1,5	2,5	4	6	9	15	22	36	58	90	150	220	360	580	900	1500	2200												
$10 < d \leq 18$	0,5	0,8	1,2	2	3	5	8	11	18	27	43	70	110	180	270	430	700	1100	1800	2700												
$18 < d \leq 30$	0,6	1	1,5	2,5	4	6	9	13	21	33	52	84	130	210	330	520	840	1300	2100	3300												
$30 < d \leq 50$	0,6	1	1,5	2,5	4	7	11	16	25	39	62	100	160	250	390	620	1000	1600	2500	3900												
$50 < d \leq 80$	0,8	1,2	2	3	5	8	13	19	30	46	74	120	190	300	460	740	1200	1900	3000	4600												
$80 < d \leq 120$	1	1,5	2,5	4	6	10	15	22	35	54	87	140	220	350	540	870	1400	2200	3500	5400												
$120 < d \leq 180$	1,2	2	3,5	5	8	12	18	25	40	63	100	160	250	400	630	1000	1600	2500	4000	6300												
$180 < d \leq 250$	2	3	4,5	7	10	14	20	29	46	72	115	185	290	460	720	1150	1850	2900	4600	7200												
$250 < d \leq 315$	2,5	4	6	8	12	16	23	32	52	81	130	210	320	520	810	1300	2100	3200	5200	8100												
$315 < d \leq 400$	3	5	7	9	13	18	25	36	57	89	140	230	360	570	890	1400	2300	3600	5700	8900												
$400 < d \leq 500$	4	6	8	10	15	20	27	40	63	97	155	250	400	630	970	1550	2500	4000	6300	9700												
$500 < d \leq 630$			9	11	16	22	32	44	70	110	175	280	440	700	1100	1750	2800	4400	7000	11000												
$630 < d \leq 800$			10	13	18	25	36	50	80	125	200	320	500	800	1250	2000	3200	5000	8000	12500												
$800 < d \leq 1000$			11	15	21	28	40	56	90	140	230	360	560	900	1400	2300	3300	5600	9000	14000												
$1000 < d \leq 1250$			13	18	24	33	47	66	105	165	260	420	660	1050	1650	2600	4200	6600	10500	16500												
$1250 < d \leq 1600$			15	21	29	39	55	78	125	195	310	500	780	1250	1950	3100	5000	7800	12500	19500												
$1600 < d \leq 2000$			18	25	35	46	65	92	150	230	370	600	920	1500	2300	3700	6000	9200	15000	23000												
$2000 < d \leq 2500$			22	30	41	55	78	110	175	280	440	700	1100	1750	2800	4400	7000	11000	17500	28000												
$2500 < d \leq 3150$			26	36	50	68	96	135	210	330	540	860	1350	2100	3300	5400	8600	13500	21000	33000												
			Equipos metrología y piezas de gran precisión										Piezas o elementos que han de ajustar										Superficies libres									

**ANEXO B:**

**DIFERENCIAS FUNDAMENTALES PARA AGUJEROS (EN MICRAS)**

Calidad	H7	s6	r6	n6	k6	j6	h6	g6	f7	H8	x8	u8	h9	f7	e8	d9	H11	h9	h11	c11	a11
<b>d ≤ 3</b>	+10	+20	+16	+10	+6	+4	0	-2	-6	+14	+34	+32	0	-6	-14	-20	+60	0	0	-60	-270
	0	+14	+10	+4	0	-2	-6	-8	-16	0	+20	+18	-25	-16	-28	-45	0	-25	-60	-120	-330
<b>3 &lt; d ≤ 6</b>	+12	+27	+23	+16	+9	+6	0	-4	-10	+18	+46	+41	0	-10	-20	-30	+75	0	0	-70	-270
	0	+19	+15	+8	+1	-2	-8	-12	-22	0	+28	+23	-30	-22	-38	-60	0	-30	-75	-145	-345
<b>6 &lt; d ≤ 10</b>	+15	+32	+28	+19	+10	+7	0	-5	-13	+22	+56	+50	0	-13	-25	-40	+90	0	0	-80	-280
	0	+23	+19	+10	+1	-2	-9	-14	-28	0	+34	+28	-36	-28	-47	-76	0	-36	-90	-170	-370
<b>10 &lt; d ≤ 14</b>	+18	+39	+34	+23	+12	+8	0	-6	-16	+27	+40	+60	0	-16	-32	-50	+110	0	0	-95	-290
	0	+28	+23	+12	+1	-3	-11	-17	-34	0	+72	+33	-43	-34	-59	-93	0	-43	-110	-205	-400
<b>14 &lt; d ≤ 18</b>										+45											
<b>18 &lt; d ≤ 24</b>	+21	+48	+41	+28	+15	+9	0	-7	-20	+33	+54	+41	0	-20	-40	-65	+130	0	0	-110	-300
	0	+35	+28	+15	+2	-4	-13	-20	-41	0	+97	+81	-52	-41	-73	-117	0	-52	-130	-240	-430
<b>24 &lt; d ≤ 30</b>											+64	+48									
	+25	+59	+50	+33	+18	+11	0	-9	-25	+39	+119	+99	0	-25	-50	-80	+160	0	0	-120	-310
	0	+43	+34	+17	+2	-5	-16	-25	-50	0	+136	+109	-62	-50	-89	-142	0	-62	-160	-280	-470
<b>30 &lt; d ≤ 40</b>											+97	+70									
	+30	+72	+60	+39	+21	+12	0	-10	-30	+46	+168	+133	0	-30	-60	-100	+190	0	0	-140	-340
	0	+53	+41	+20	+2	-7	-19	-29	-60	0	+122	+87	-74	-60	-106	-174	0	-74	-190	-330	-530
<b>40 &lt; d ≤ 50</b>											+192	+148									
	+35	+78	+62	+20	+2	-7	-19	-29	-60	0	+146	+102	-87	-71	-126	-207	0	-87	-220	-180	-410
	0	+59	+43	+20	+2	-7	-19	-29	-60	0	+264	+198	-87	-71	-126	-207	0	-87	-220	-180	-410
<b>50 &lt; d ≤ 65</b>											+210	+144									
	+35	+91	+73	+45	+25	+13	0	-12	-36	+54	+232	+178	0	-36	-72	-120	+220	0	0	-170	-380
	0	+71	+51	+23	+3	-9	-22	-34	-71	0	+178	+124	-87	-71	-126	-207	0	-87	-220	-390	-600
<b>65 &lt; d ≤ 80</b>											+264	+198									
	+40	+101	+76	+23	+3	-9	-22	-34	-71	0	+210	+144	-87	-71	-126	-207	0	-87	-220	-400	-630
	0	+79	+54	+23	+3	-9	-22	-34	-71	0	+311	+233	-87	-71	-126	-207	0	-87	-220	-400	-630
<b>80 &lt; d ≤ 100</b>											+248	+170									
	+40	+117	+88	+52	+28	+14	0	-14	-43	+63	+343	+253	0	-43	-85	-145	+250	0	0	-200	-460
	0	+92	+63	+27	+3	-11	-25	-39	-83	0	+280	+190	-100	-83	-148	-245	0	-100	-250	-450	-710
<b>100 &lt; d ≤ 120</b>											+373	+273									
	+40	+125	+90	+27	+3	-11	-25	-39	-83	0	+373	+273	-100	-83	-148	-245	0	-100	-250	-460	-770
<b>120 &lt; d ≤ 140</b>											+310	+210									
	0	+100	+65	+27	+3	-11	-25	-39	-83	0	+310	+210	-100	-83	-148	-245	0	-100	-250	-460	-770
<b>140 &lt; d ≤ 160</b>											+310	+210									
	0	+133	+93	+27	+3	-11	-25	-39	-83	0	+310	+210	-100	-83	-148	-245	0	-100	-250	-460	-770
<b>160 &lt; d ≤ 180</b>											+310	+210									
	0	+108	+68	+27	+3	-11	-25	-39	-83	0	+310	+210	-100	-83	-148	-245	0	-100	-250	-460	-770
	0	+108	+68	+27	+3	-11	-25	-39	-83	0	+310	+210	-100	-83	-148	-245	0	-100	-250	-460	-770



## ANEXO D: CÓDIGO C DEL PROTOTIPO

N102 G0 G17 G40 G49 G80	N284 X59:433 Y-15:982	N472 X-43:251 Y-22:946
G90	N286 X58:364 Y-16:372	N474 X-41:933 Y-22:691
N104 T1 M6:	N288 X57:272 Y-16:69	N476 X-40:631 Y-22:361
N106 G0 G90 G55 X14:945	N290 X56:162 Y-16:936	N478 X-39:351 Y-21:956
Y-46:392 S1700 M3	N292 X55:037 Y-17:108	N480 X-38:096 Y-21:478
N108 G43 H1 Z25:	N294 X53:904 Y-17:205	N482 X-36:871 Y-20:928
N110 Z:2	N296 X52:767 Y-17:227	N484 X-35:68 Y-20:308
N112 G1 Z-:57 F200:	N298 X51:631 Y-17:175	N486 X-34:527 Y-19:621
N114 Y-16:392 F1200:	N300 X50:501 Y-17:047	N488 X-33:415 Y-18:868
N116 Y-6:75	N302 X49:381 Y-16:845	N490 X-32:348 Y-18:052
N118 X-2:686	N304 X48:278 Y-16:57	N492 X-31:331 Y-17:177
N120 Y-16:119	N306 X47:195 Y-16:223	N494 X-30:365 Y-16:243
N122 Y-46:119	N308 X46:137 Y-15:805	N496 X-29:455 Y-15:256
N124 Z-1:14 F200:	N310 X45:109 Y-15:318	N498 X-28:604 Y-14:218
N126 Y-16:119 F1200:	N312 X44:115 Y-14:764	N500 X-27:814 Y-13:132
N128 Y-6:75	N314 X43:161 Y-14:146	N502 X40:569 Y-11:934
N130 X14:945	N316 X42:249 Y-13:466	N504 X41:384 Y-12:728
N132 Y-16:392	N318 X41:384 Y-12:728	N506 X42:249 Y-13:466
N134 Y-46:392	N320 X40:569 Y-11:934	N508 X43:161 Y-14:146
N136 Z-1:71 F200:	N322 X-27:814 Y-13:132	N510 X44:115 Y-14:764
N138 Y-16:392 F1200:	N324 X-28:604 Y-14:218	N512 X45:109 Y-15:318
N140 Y-6:75	N326 X-29:455 Y-15:256	N514 X46:137 Y-15:805
N142 X-2:686	N328 X-30:365 Y-16:243	N516 X47:195 Y-16:223
N144 Y-16:119	N330 X-31:331 Y-17:176	N518 X48:278 Y-16:57
N146 Y-46:119	N332 X-32:348 Y-18:052	N520 X49:381 Y-16:846
N148 Z-2:28 F200:	N334 X-33:415 Y-18:868	N522 X50:5 Y-17:047
N150 Y-16:119 F1200:	N336 X-34:527 Y-19:621	N524 X51:631 Y-17:175
N152 Y-6:75	N338 X-35:68 Y-20:308	N526 X52:767 Y-17:228
N154 X14:945	N340 X-36:871 Y-20:928	N528 X53:904 Y-17:205
N156 Y-16:392	N342 X-38:096 Y-21:477	N530 X55:037 Y-17:108
N158 Y-46:392	N344 X-39:351 Y-21:956	N532 X56:162 Y-16:936
N160 Z-2:85 F200:	N346 X-40:631 Y-22:36	N534 X57:272 Y-16:69
N162 Y-16:392 F1200:	N348 X-41:933 Y-22:691	N536 X58:364 Y-16:372
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N182 Y-46:392	N368 X-55:144 Y-21:777	N556 X67:278 Y-9:64
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N186 Y-16:392 F1200:	N372 X-57:6 Y-20:693	N560 X68:424 Y-7:676
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N194 Y-46:119	N380 X-62:056 Y-17:716	N568 X69:893 Y-3:384
N196 Z-4:56 F200:	N382 X-63:054 Y-16:817	N570 X70:08 Y-2:262
N198 Y-16:119 F1200:	N384 X-63:998 Y-15:863	N572 X70:192 Y-1:13
N200 Y-6:75	N386 X-64:885 Y-14:855	N574 X70:229 Y:007
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N218 Y-46:119	N404 X-69:902 Y-4:008	N588 X68:896 Y-6:642
N220 Z-5:7 F200:	N406 X-70:095 Y-2:68	N590 X68:423 Y-7:676
N222 Y-16:119 F1200:	N408 X-70:211 Y-1:342	N592 X67:883 Y-8:677
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N226 X14:945	N412 Z-:594 F100:	N596 X66:611 Y-10:561
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N232 G0 Z25:	N416 X-70:095 Y-2:68	N602 X64:266 Y-13:033
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Y:007 S2500 M3	N428 X-67:812 Y-10:365	N614 X58:364 Y-16:372
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N2544 X67:644 Y4:174	N2744 X-63:757 Y13:068	N2940 X48:417
N2546 X67:899 Y3:147	N2746 X-62:94 Y14:053	Y14:524
N2548 X68:082 Y2:104	N2748 X-62:065 Y14:986	N2942 X47:419
N2550 X68:192 Y1:052	N2750 X-61:136 Y15:866	Y14:171
N2552 X68:229 Y-:006	N2752 X-60:156 Y16:688	N2944 X46:448
N2554 X68:228 Y-3:606	N2754 X-59:128 Y17:449	Y13:749
N2556 Z-8:1 F200:	N2756 X-58:056 Y18:147	N2946 X45:509
N2558 X68:229 Y-:006	N2758 X-56:944 Y18:78	Y13:261
F1200:	N2760 X-55:796 Y19:344	N2948 X44:606
N2560 X68:192 Y1:052	N2762 X-54:616 Y19:838	Y12:709
N2562 X68:083 Y2:104	N2764 X-53:408 Y20:261	N2950 X43:743
N2564 X67:9 Y3:147	N2766 X-52:177 Y20:61	Y12:096
N2566 X67:645 Y4:174	N2768 X-50:928 Y20:884	N2952 X42:925
N2568 X67:32 Y5:181	N2770 X-49:664 Y21:082	Y11:424
N2570 X66:925 Y6:163	N2772 X-48:39 Y21:204	N2954 X42:156
N2572 X66:463 Y7:116	N2774 X-47:112 Y21:25	Y10:697
N2574 X65:936 Y8:034	N2776 X-45:833 Y21:218	N2956 X41:44
N2576 X65:347 Y8:913	N2778 X-44:558 Y21:109	Y9:918
N2578 X64:698 Y9:749	N2780 X-43:292 Y20:924	N2958 X-28:911
N2580 X63:993 Y10:538	N2782 X-42:04 Y20:663	Y11:151
N2582 X63:234 Y11:276	N2784 X-40:805 Y20:327	N2960 X-29:615
N2584 X62:426 Y11:96	N2786 X-39:593 Y19:917	Y12:219
N2586 X61:573 Y12:585	N2788 X-38:408 Y19:436	N2962 X-30:382
N2588 X60:678 Y13:151	N2790 X-37:254 Y18:883	Y13:243
N2590 X59:746 Y13:652	N2792 X-36:135 Y18:263	N2964 X-31:209
N2592 X58:781 Y14:088	N2794 X-35:056 Y17:576	Y14:219
N2594 X57:789 Y14:456	N2796 X-34:02 Y16:825	N2966 X-32:093
N2596 X56:773 Y14:753	N2798 X-33:031 Y16:014	Y15:144
N2598 X55:74 Y14:98	N2800 X-32:093 Y15:144	N2968 X-33:031
N2600 X54:693 Y15:134	N2802 X-31:209 Y14:219	Y16:014
N2602 X53:637 Y15:216	N2804 X-30:382 Y13:243	N2970 X-34:02
N2604 X52:579 Y15:223	N2806 X-29:615 Y12:219	Y16:825
N2606 X51:523 Y15:157	N2808 X-28:911 Y11:151	N2972 X-35:056
N2608 X50:473 Y15:018	N2810 X41:44 Y9:918	Y17:576
N2610 X49:436 Y14:807	N2812 X42:157 Y10:697	N2974 X-36:136
N2612 X48:417 Y14:524	N2814 X42:926 Y11:424	Y18:263
N2614 X47:419 Y14:171	N2816 X43:744 Y12:095	N2976 X-37:254
		Y18:883
		N2978 X-38:408
		Y19:435
		N2980 X-39:593
		Y19:917
		N2982 X-40:805
		Y20:327
		N2984 X-42:04
		Y20:663
		N2986 X-43:292
		Y20:924
		N2988 X-44:558
		Y21:109
		N2990 X-45:833
		Y21:218
		N2992 X-47:112
		Y21:25
		N2994 X-48:39
		Y21:204
		N2996 X-49:664
		Y21:082
		N2998 X-50:928
		Y20:884
		N3000 X-52:177
		Y20:61
		N3002 X-53:408
		Y20:261
		N3004 X-54:616
		Y19:838
		N3006 X-55:796
		Y19:344
		N3008 X-56:944
		Y18:78
		N3010 X-58:056
		Y18:147
		N3012 X-59:128
		Y17:449
		N3014 X-60:156
		Y16:688
		N3016 X-61:136
		Y15:866



N3018 X-62:065 Y14:986  
N3020 X-62:94 Y14:053  
N3022 X-63:757 Y13:068  
N3024 X-64:513  
Y12:036N3026 X-  
65:205 Y10:96  
N3028 X-65:832  
Y9:845N3030 X-  
66:39 Y8:694

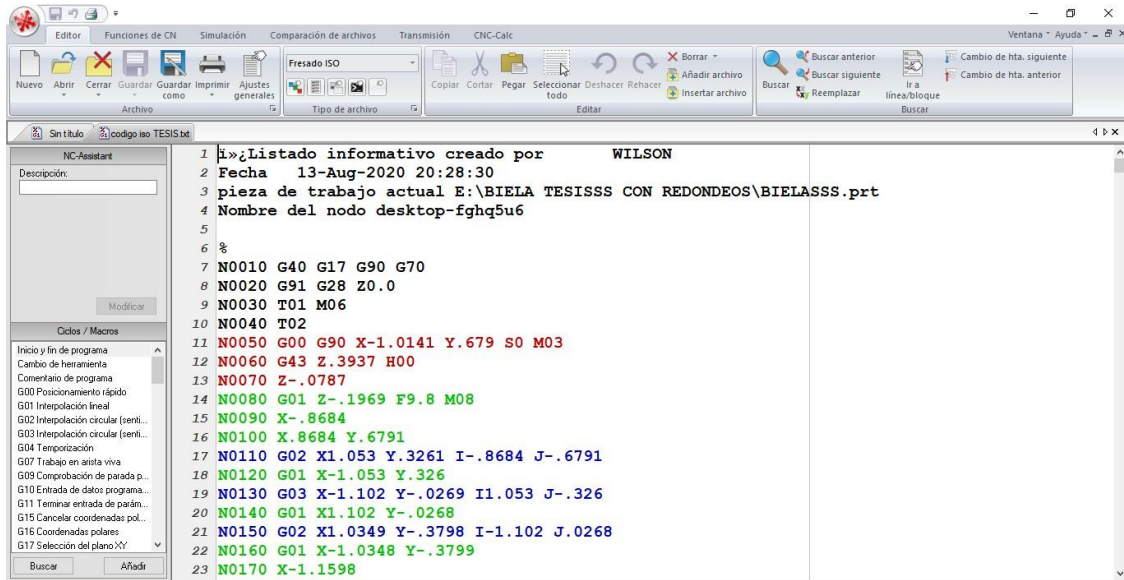
N3032 X-66:878 Y7:511  
N3034 X-67:294 Y6:301  
N3036 X-67:636 Y5:069  
N3038 X-67:904  
Y3:818N3040 X-  
68:096 Y2:553  
N3042 X-68:211  
Y1:279N3044 X-  
68:25 Y0:

N3046 Y-  
3:6  
N3048 G0  
Z125:  
N3050 M5  
N3056 M30

## ANEXO E:

### PASOS PARA OPTIMIZAR EL CÓDIGO C

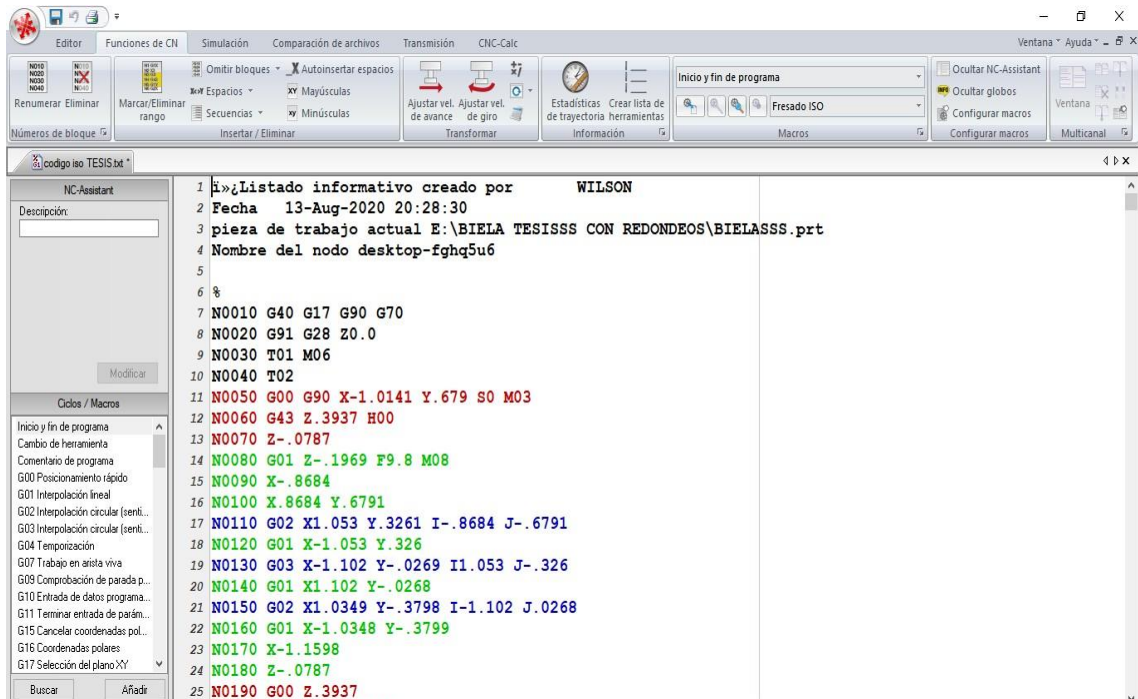
- a) Procedemos a ingresar el código ISO en CIMCO el cual es un software de manufactura, esto después de guardar el código en extensión del tipo block:



The screenshot shows the CIMCO software interface with the following ISO code:

```
1 ¿Listado informativo creado por WILSON
2 Fecha 13-Aug-2020 20:28:30
3 pieza de trabajo actual E:\BIELA TESISSS CON REDONDEOS\BIELASSS.prt
4 Nombre del nodo desktop-fghq5u6
5
6 %
7 N0010 G40 G17 G90 G70
8 N0020 G91 G28 Z0.0
9 N0030 T01 M06
10 N0040 T02
11 N0050 G00 G90 X-1.0141 Y.679 S0 M03
12 N0060 G43 Z.3937 H00
13 N0070 Z-.0787
14 N0080 G01 Z-.1969 F9.8 M08
15 N0090 X-.8684
16 N0100 X.8684 Y.6791
17 N0110 G02 X1.053 Y.3261 I-.8684 J-.6791
18 N0120 G01 X-1.053 Y.326
19 N0130 G03 X-1.102 Y-.0269 I1.053 J-.326
20 N0140 G01 X1.102 Y-.0268
21 N0150 G02 X1.0349 Y-.3798 I-1.102 J.0268
22 N0160 G01 X-1.0348 Y-.3799
23 N0170 X-1.1598
```

- b) Removemos las N del código ISO con la opción eliminar



The screenshot shows the CIMCO software interface with the following ISO code after removing the 'N' characters:

```
1 ¿Listado informativo creado por WILSON
2 Fecha 13-Aug-2020 20:28:30
3 pieza de trabajo actual E:\BIELA TESISSS CON REDONDEOS\BIELASSS.prt
4 Nombre del nodo desktop-fghq5u6
5
6 %
7 0010 G40 G17 G90 G70
8 0020 G91 G28 Z0.0
9 0030 T01 M06
10 0040 T02
11 0050 G00 G90 X-1.0141 Y.679 S0 M03
12 0060 G43 Z.3937 H00
13 0070 Z-.0787
14 0080 G01 Z-.1969 F9.8 M08
15 0090 X-.8684
16 0100 X.8684 Y.6791
17 0110 G02 X1.053 Y.3261 I-.8684 J-.6791
18 0120 G01 X-1.053 Y.326
19 0130 G03 X-1.102 Y-.0269 I1.053 J-.326
20 0140 G01 X1.102 Y-.0268
21 0150 G02 X1.0349 Y-.3798 I-1.102 J.0268
22 0160 G01 X-1.0348 Y-.3799
23 0170 X-1.1598
24 0180 Z-.0787
25 0190 G00 Z.3937
```

Editor Funciones de CN Simulación Comparación de archivos Transmisión CNC-Calc Ventana Ayuda

Renumerar Eliminar Marcar/Eliminar rango Secuencias Insertar / Eliminar Autoinsertar espacios Espacios XY Mayúsculas Minúsculas Ajustar vel. de avance Transformar Estadísticas Crear lista de de trayectoria herramientas Información Inicio y fin de programa Ocultar NC-Assistant Ocultar globos Ventana Configurar macros Multicanal Fresado ISO Macros

Eliminar Eliminar números de bloque

Descripción

Modificar

Ciclos / Macros

- Inicio y fin de programa
- Cambio de herramienta
- Comentario de programa
- G00 Posicionamiento rápido
- G01 Interpolación lineal
- G02 Interpolación circular (senk...
- G03 Interpolación circular (senk...
- G04 Temporización
- G07 Trabajo en arista viva
- G09 Comprobación de parada p...
- G10 Entrada de datos programa...
- G11 Terminar entrada de parám...
- G15 Cancelar coordenadas pol...
- G16 Coordenadas polares
- G17 Selección del plano XY

Buscar Añadir

listado informativo creado por WILSON  
a 13-Aug-2020 20:28:30

pieza de trabajo actual E:\BIELA TESISSS CON REDONDEOS\BIELASSS.prt  
nombre del nodo desktop-fghq5u6

```
3  
4  
5  
6 %  
7 G40 G17 G90 G70  
8 G91 G28 Z0.0  
9 T01 M06  
10 T02  
11 G00 G90 X-1.0141 Y.679 S0 M03  
12 G43 Z.3937 H00  
13 Z-.0787  
14 G01 Z-.1969 F9.8 M08  
15 X-.8684  
16 X.8684 Y.6791  
17 G02 X1.053 Y.3261 I-.8684 J-.6791  
18 G01 X-1.053 Y.326  
19 G03 X-1.102 Y-.0269 I1.053 J-.326  
20 G01 X1.102 Y-.0268  
21 G02 X1.0349 Y-.3798 I-1.102 J.0268  
22 G01 X-1.0348 Y-.3799  
23 X-1.1598  
24 Z-.0787  
25 G00 Z.3937
```

**ANEXO F:**  
**PLANOS DE LA BIELA**

