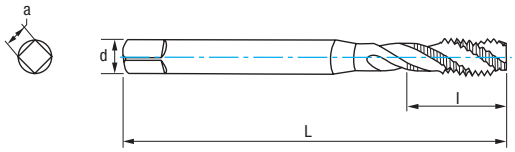
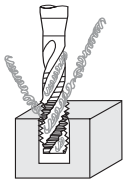
Ref. 3152

Gwintownik maszynowy spiralny ze wzmocnionym chwytem BSW



HSSE 5%Co | DIN 371 | C 2-3h | 35° | α 10° ± 2 | 55° | Norma brytyjska dla gwintu grubego



< 2D

BSW	Hilos Threads Filets	L mm	l mm	d mm	a mm	Z	N° Art. 5% Co	€
W1/8	40	56	5	3,50	2,70	3	63152	22,17
W5/32	32	63	7	4,50	3,40	3	63170	22,17
W3/16	24	70	8	6,00	4,90	3	63161	22,17
W1/4	20	80	10	7,00	5,50	3	63149	25,02
W5/16	18	90	12	8,00	6,20	3	63167	29,33
W3/8	16	100	14	9,00	7,00	3	63158	33,50

Materiały		Vc (m/min)
Grupa	Sub.	5%Co
P	P.1	6-10
K	K.1	7-10
	K.2	4-7
N	N.1	5-8
	N.2	8-12
	N.3	15-35
	N.4	14-20
	N.5	12-15

Prędkość posuwu $f = P$

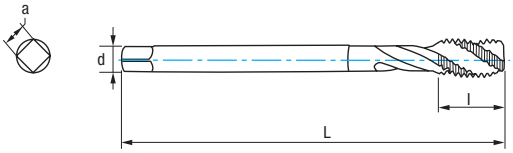
$$P = \frac{25{,}40}{\text{Hilos Threads - Filets}}$$

$$Vf\ (mm/min.) = r.p.m. \times f$$

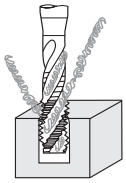
$$r.p.m. = \frac{Vc \times 1.000}{\pi \times \varnothing}$$

Ref. 3252

Gwintownik maszynowy spiralny BSW



HSSE 5%Co | DIN 376 | C 2-3h | 35° | α 10° ± 2 | 55° | Norma brytyjska dla gwintu grubego



< 2D

BSW	Hilos Threads Filets	L mm	l mm	d mm	a mm	Z	N° Art. 5% Co	€
W3/16	24	70	8	3,50	2,70	3	59857	17,06
W1/4	20	80	13	4,50	3,40	3	59858	23,11
W5/16	18	90	14	6,00	4,90	3	59859	27,09
W3/8	16	100	16	7,00	5,50	3	70408	29,91
W7/16	14	100	16	8,00	6,20	3	70411	43,07
W1/2	12	110	18	9,00	7,00	3	70405	41,28
W9/16	12	110	20	11,00	9,00	3	70413	58,69
W5/8	11	110	20	12,00	9,00	3	70410	55,97
W3/4	10	125	25	14,00	11,00	4	70407	74,97
W7/8	9	140	27	18,00	14,50	4	10909	80,03
W1"	8	160	30	20,00	16,00	4	70414	127,32

Materiały		Vc (m/min)
Grupa	Sub.	5%Co
P	P.1	6-10
K	K.1	7-10
	K.2	4-7
N	N.1	5-8
	N.2	8-12
	N.3	15-35
	N.4	14-20
	N.5	12-15

Prędkość posuwu $f = P$

$$P = \frac{25{,}40}{\text{Hilos Threads - Filets}}$$

$$Vf\ (mm/min.) = r.p.m. \times f$$

$$r.p.m. = \frac{Vc \times 1.000}{\pi \times \varnothing}$$

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