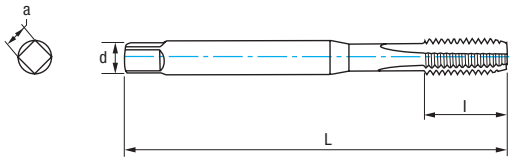
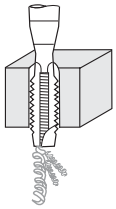
Ref. 3129

Gwintownik maszynowy prosty z wewnętrznym chłodzeniem



PMX | HARD | DIN 371/376 | B 3,5-6h | Tol. 6HX | 60°



≤ 2D

M	P	L mm	l mm	d mm	a mm	Z	N° Art. HARD	€
M6	**1,00**	80	19	6,00	4,90	3	70087	**97,60**
M8	**1,25**	90	22	8,00	6,20	3	70089	**116,19**
M10	**1,50**	100	24	10,00	8,00	3	70094	**116,18**
M12	**1,75**	110	28	9,00	7,00	3	70101	**151,05**
M16	**2,00**	110	32	12,00	9,00	4	70163	**213,06**

Materiały		Vc (m/min)
Grupa	Sub.	HARD
P	P.1	22-26
	P.2	22-26
	P.3	18-22
	P.4	18-22
	P.5	12-15
M		12-15
K	K.1	18-22
	K.2	15-18
N	N.1	10-12
	N.2	10-12
	N.3	18-22
	N.4	15-18
	N.5	15-18

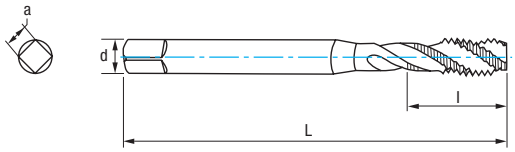
Prędkość posuwu f = P

Vf (mm/min.) = r.p.m. x f

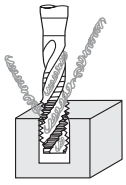
$$\text{r.p.m.} = \frac{\text{Vc x 1.000}}{\pi \times \text{ø}}$$

Ref. 3169

Gwintownik maszynowy spiralny z wewnętrznym chłodzeniem



PMX | HARD | DIN 371/376 | C 2-3h | 50° | Tol. 6HX | 60°



< 2D

M	P	L mm	l mm	d mm	a mm	Z	N° Art. HARD	€
M6	**1,00**	80	19	6,00	4,90	3	70173	**78,07**
M8	**1,25**	90	22	8,00	6,20	3	70175	**105,63**
M10	**1,50**	100	24	10,00	8,00	3	70178	**105,62**
M12	**1,75**	110	28	9,00	7,00	3	70182	**137,31**
M16	**2,00**	110	32	12,00	9,00	4	70195	**193,68**

Materiały		Vc (m/min)
Grupa	Sub.	HARD
P	P.1	18-22
	P.2	18-22
	P.3	10-12
	P.4	10-12
	P.5	10-12
M		10-12
K	K.1	15-18
	K.2	12-16
N	N.1	10-12
	N.2	10-12
	N.3	15-18
	N.4	12-16
	N.5	12-16

Prędkość posuwu f = P

Vf (mm/min.) = r.p.m. x f

$$\text{r.p.m.} = \frac{\text{Vc x 1.000}}{\pi \times \text{ø}}$$