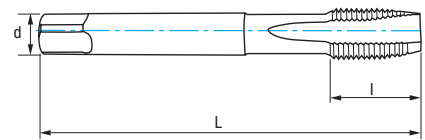
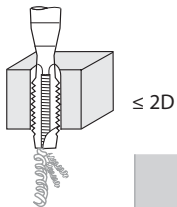


Ref. **3106**

Gwintownik maszynowy prosty BSP (gaz)



HSSE 5%Co	DIN 5156	B 3,5-5h		$\alpha$ $10^\circ \pm 2$		Gwint równoległy (BSPP)
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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  $f = P$ 

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

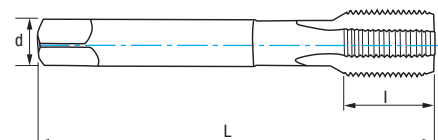
$$V_f (\text{mm/min.}) = \text{r.p.m.} \times f$$

$$\text{r.p.m.} = \frac{V_c \times 1.000}{\pi \times \phi}$$

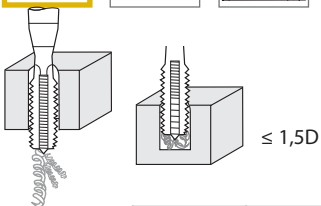
G	Hilos Threads Filets	L mm	l mm	d mm			N° Art. 5% Co	€
G1/8	28	90	20	7	5,50	3	75479	33,69
G1/4	19	100	22	11	9,00	3	62936	45,40
G3/8	19	100	22	12	9,00	3	75481	53,87
G1/2	14	125	25	16	12,00	3	75478	67,99
G5/8	14	125	24	18	14,50	4	75482	85,93
G3/4	14	140	28	20	16,00	4	75480	106,53
G1"	11	160	30	25	20,00	4	75483	165,30
G1"1/2	11	190	32	36	29,00	6	76221	460,89

Ref. **3116**

Gwintownik maszynowy prosty BSP (gaz)



HSSE 5%Co	DIN 5156	C 2-3h		$\alpha$ $10^\circ \pm 2$		Gwint równoległy = (BSPP)
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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  $f = P$ 

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

$$V_f (\text{mm/min.}) = \text{r.p.m.} \times f$$

$$\text{r.p.m.} = \frac{V_c \times 1.000}{\pi \times \phi}$$

G	Hilos Threads Filets	L mm	l mm	d mm			N° Art. 5% Co	€
G1/8	28	90	20	7	5,50	3	75467	29,60
G1/4	19	100	22	11	9,00	3	75466	40,89
G3/8	19	100	22	12	9,00	3	75143	48,94
G1/2	14	125	25	16	12,00	3	75465	61,85
G5/8	14	125	25	18	14,50	4	75469	77,07
G3/4	14	140	28	20	16,00	4	75468	96,85
G7/8	14	150	28	22	18,00	4	77647	142,00
G1"	11	160	30	25	20,00	4	75470	150,26
G1"1/8	11	170	30	28	22,00	4	76197	229,56
G1"1/4	11	170	30	32	24,00	4	76205	269,15
G1"1/2	11	190	32	36	29,00	6	76219	427,48
G1"3/4	11	190	32	40	32,00	6	76227	508,09
G2"	11	220	40	45	35,00	6	76233	647,43