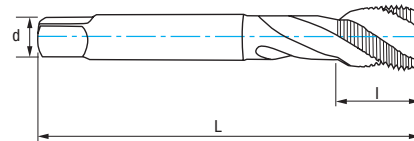
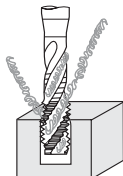


Ref. **3156**

Gwintownik maszynowy spiralny BSP (gaz)



HSSE 5%Co	DIN 5156	C 2-3h	35°	α 10° ± 2	55°	Gwint równoległy (BSPP)
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< 2D

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 $f = P$

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

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

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

G	Hilos Threads Filets	L mm	l mm	d mm	a mm	Z	N° Art. 5% Co	€
G1/8	28	90	20	7	5,50	3	63188	35,76
G1/4	19	100	22	11	9,00	3	63185	51,34
G3/8	19	100	22	12	9,00	3	75142	61,27
G1/2	14	125	25	16	12,00	4	75484	77,32
G3/4	14	140	28	20	16,00	4	75485	121,01
G1"	11	160	30	25	20,00	4	75487	187,79
G1"1/4	11	170	30	32	24,00	5	76208	273,36
G1"1/2	11	190	32	36	29,00	5	76222	494,29