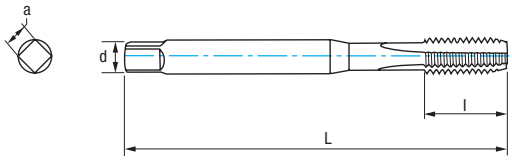
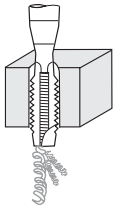
Ref. 3174

Gwintownik maszynowy prosty



HSSE 5%Co	DIN 371	B 3,5-5h	GUN	Tol. 6H	α 17-20°	60°



≤ 2D

M	P	L mm	l mm	d mm	a mm	Z	N° Art. 5% Co	€
M3	0,50	56	11	3,50	2,70	3	69390	18,71
M4	0,70	63	13	4,50	3,40	3	69393	18,71
M5	0,80	70	16	6,00	4,90	3	69394	18,71
M6	1,00	80	19	6,00	4,90	3	69396	19,69
M8	1,25	90	22	8,00	6,20	3	69397	23,56
M10	1,50	100	24	10,00	8,00	3	69399	27,75

Materiały		Vc (m/min)
Grupa	Sub.	5% Co
P	P.1	20-25
	P.2	8-18
	P.5	8-10
M		8-10
N	N.1	10-25
	N.2	10-25
	N.3	12-25
	N.4	12-25
	N.5	15-20
	N.6	20-25

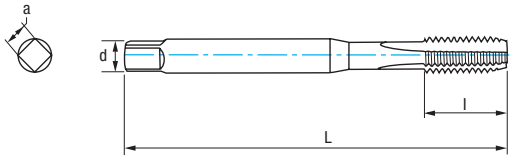
Prędkość posuwu f = P

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

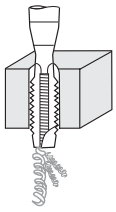
$$r.p.m. = \frac{Vc \times 1.000}{\pi \times ø}$$

Ref. 3274

Gwintownik maszynowy prosty



HSSE 5%Co	DIN 376	B 3,5-5h	GUN	Tol. 6H	α 17-20°	60°



≤ 2D

M	P	L mm	l mm	d mm	a mm	Z	N° Art. 5% Co	€
M5	0,80	70	16	3,50	2,70	3	69853	18,71
M6	1,00	80	19	4,50	3,40	3	69855	23,56
M8	1,25	90	22	6,00	4,90	3	69856	23,56
M10	1,50	100	24	7,00	5,50	3	69858	27,75
M12	1,75	110	29	9,00	7,00	3	69859	34,65
M14	2,00	110	30	11,00	9,00	3	69861	62,75
M16	2,00	110	32	12,00	9,00	3	69862	63,14

Materiały		Vc (m/min)
Grupa	Sub.	5% Co
P	P.1	20-25
	P.2	8-18
	P.5	8-10
M		8-10
N	N.1	10-25
	N.2	10-25
	N.3	12-25
	N.4	12-25
	N.5	15-20
	N.6	20-25

Prędkość posuwu f = P

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

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