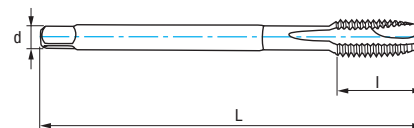
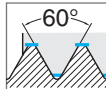
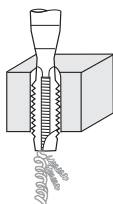


Ref. **3204**

Gwintownik maszynowy prosty UNF

HSSE  
5%CoDIN  
374Tol.  
2B $\alpha$   
10 -14°Norma amerykańska dla gwintów  
drobnozwojowych

&lt;math&gt;&lt; 2D&lt;/math&gt;

UNF	Hilos Threads Filets	L mm	l mm	d mm	a mm	Z	N° Art. 5% Co	€
UNF N°5	44	56	9	2,20		3	59868	18,28
UNF N°6	40	56	11	2,50	2,10	3	59869	16,53
UNF N°8	36	63	12	2,80	2,10	3	59870	16,53
UNF N°10	32	70	13	3,50	2,70	3	59073	17,13
UNF N°12	28	80	15	4,00	3,00	3	59871	20,21
UNF 1/4	28	80	15	4,50	3,40	3	75744	17,84
UNF 5/16	24	90	18	6,00	4,90	3	75751	20,55
UNF 3/8	24	90	20	7,00	5,50	3	62933	20,97
UNF 7/16	20	100	20	8,00	6,20	3	70461	30,33
UNF 1/2	20	100	22	9,00	7,00	3	70465	32,33
UNF 9/16	18	100	22	11,00	9,00	3	70467	39,65
UNF 5/8	18	100	22	12,00	9,00	3	70468	44,64
UNF 3/4	16	100	25	14,00	11,00	3	70470	57,18
UNF 7/8	14	125	24	18,00	14,50	3	59872	63,72
UNF 1"	12	140	26	18,00	14,50	3	59873	83,49
UNF 1 1/8"	12	150	28	22,00	18,00	4	59874	113,86

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  $f = P$ 

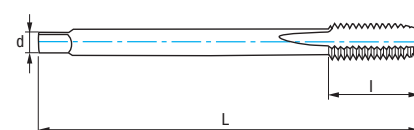
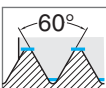
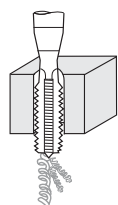
$$P = \frac{25,40}{\text{Hilos Threads - Filets}}$$

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

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

Ref. **3224**

Gwintownik maszynowy prosty UNF

HSSE  
5%CoDIN  
374Tol.  
2B $\alpha$   
10° ± 2Norma amerykańska dla gwintów  
drobnozwojowych

&lt;math&gt;\leq 1,5D&lt;/math&gt;

UNF	Hilos Threads Filets	L mm	l mm	d mm	a mm	Z	N° Art. 5% Co	€
UNF 5/16	24	90	22	6,00	4,90	3	22576	16,86
UNF 3/8	24	90	20	7,00	5,50	3	20655	18,13
UNF 7/16	20	100	20	8,00	6,20	3	22578	24,92
UNF 1/2	20	100	22	9,00	7,00	3	22579	26,54
UNF 9/16	18	100	22	11,00	9,00	3	70543	32,62
UNF 5/8	18	100	22	12,00	9,00	3	70537	36,71
UNF 3/4	16	110	25	14,00	11,00	3	70534	46,97
UNF 7/8	14	125	25	18,00	14,50	3	70540	59,08

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. x f

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