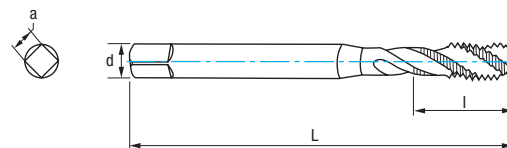
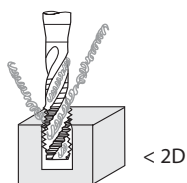


Ref. **3154**Gwintownik maszynowy spiralny UNC
ze wzmocnionym trzonkiem

| | | | | | | | |
|--------------|------------|-----------|------------|--|------------------------------|--|--------------------------------------|
| HSSE 5%Co | DIN 371 | C 2-3h | Tol. 2B | | α $10^\circ \pm 2$ | | Norma amerykańska dla gwintu grubego |
|--------------|------------|-----------|------------|--|------------------------------|--|--------------------------------------|



| UNC | Hilos Threads Filets | L mm | l mm | d mm | a mm | Z | N° Art. 5% Co | € |
|----------|-------------------------|---------|---------|---------|---------|---|------------------|-------|
| UNC N°5 | 40 | 56 | 5 | 3,50 | 2,70 | 3 | 10621 | 31,33 |
| UNC N°6 | 32 | 56 | 7 | 4,00 | 3,00 | 3 | 75634 | 31,33 |
| UNC N°8 | 32 | 63 | 7 | 4,50 | 3,40 | 3 | 59071 | 31,33 |
| UNC N°10 | 24 | 70 | 8 | 6,00 | 4,90 | 3 | 75636 | 32,87 |
| UNC N°12 | 24 | 80 | 10 | 6,00 | 4,90 | 3 | 10624 | 31,33 |
| UNC 1/4 | 20 | 80 | 10 | 7,00 | 5,20 | 3 | 75537 | 31,69 |
| UNC 5/16 | 18 | 90 | 13 | 8,00 | 6,20 | 3 | 75541 | 35,77 |
| UNC 3/8 | 16 | 90 | 15 | 9,00 | 7,00 | 3 | 75539 | 40,25 |

| 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 $f = P$

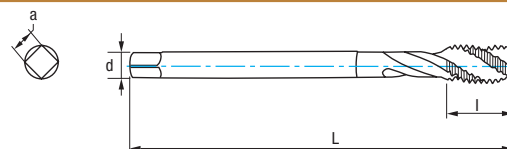
$$P = \frac{25,40}{\text{Hilos Threads - Filets}}$$

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

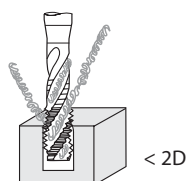
$$r.p.m. = \frac{V_c \times 1.000}{\pi \times \phi}$$

Ref. **3254**

Gwintownik maszynowy spiralny UNC



| | | | | | | | |
|--------------|------------|-----------|------------|--|------------------------------|--|--------------------------------------|
| HSSE 5%Co | DIN 376 | C 2-3h | Tol. 2B | | α $10^\circ \pm 2$ | | Norma amerykańska dla gwintu grubego |
|--------------|------------|-----------|------------|--|------------------------------|--|--------------------------------------|



| UNC | Hilos Threads Filets | L mm | l mm | d mm | a mm | Z | N° Art. 5% Co | € |
|-----------|-------------------------|---------|---------|---------|---------|---|------------------|--------|
| UNC 7/16 | 14 | 100 | 18 | 8,00 | 6,20 | 3 | 70507 | 48,79 |
| UNC 1/2 | 13 | 110 | 20 | 9,00 | 7,00 | 3 | 70495 | 53,34 |
| UNC 9/16 | 12 | 110 | 20 | 11,00 | 9,00 | 3 | 70509 | 72,42 |
| UNC 5/8 | 11 | 110 | 20 | 12,00 | 9,00 | 3 | 70500 | 70,47 |
| UNC 3/4 | 10 | 125 | 25 | 14,00 | 11,00 | 4 | 70497 | 93,31 |
| UNC 7/8 | 9 | 140 | 25 | 18,00 | 14,50 | 4 | 70506 | 146,01 |
| UNC 1" | 8 | 160 | 30 | 18,00 | 14,50 | 4 | 70510 | 183,17 |
| UNC 1"1/8 | 7 | 180 | 35 | 22,00 | 18,00 | 4 | 10627 | 227,25 |

| 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 $f = P$

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

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

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