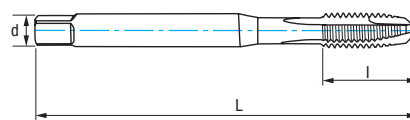
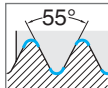
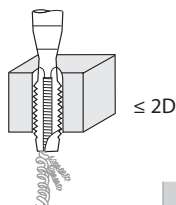


Ref. **3102**

Gwintownik maszynowy prosty z trzonkiem wzmocnionym BSW

HSSE  
5%CoDIN  
371 $\alpha$   
10-12°

Norma brytyjska dla gwintu grubego

 $\leq 2D$ 

BSW	Hilos Threads Filets	L mm	l mm	d mm	a mm	Z	N° Art. 5% Co	€
W1/8	40	56	11	3,50	2,70	3	62897	19,47
W5/32	32	63	13	4,50	3,40	3	62915	19,47
W3/16	24	70	15	6,00	4,90	3	62903	19,47
W1/4	20	80	17	7,00	5,50	3	62894	22,17
W5/16	18	90	20	8,00	6,20	3	62912	25,95
W3/8	16	100	22	9,00	7,00	3	73766	28,68

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  $f = P$ 

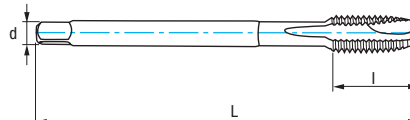
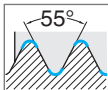
$$P = \frac{25,40}{\text{Hilos Threads - Filets}}$$

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

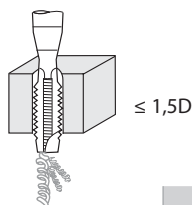
$$\text{r.p.m.} = \frac{V_c \times 1.000}{\pi \times \phi}$$

Ref. **3202**

Gwintownik maszynowy prosty BSW

HSSE  
5%CoDIN  
376 $\alpha$   
10-12°

Norma brytyjska dla gwintu grubego

 $\leq 1,5D$ 

BSW	Hilos Threads Filets	L mm	l mm	d mm	a mm	Z	N° Art. 5% Co	€
W1/4	20	80	17	4,50	3,40	3	59861	17,91
W5/16	18	90	20	6,00	4,90	3	14979	20,97
W3/8	16	100	22	7,00	5,50	3	70420	23,17
W7/16	14	100	22	8,00	6,20	3	70446	29,26
W1/2	12	110	24	9,00	7,00	3	70417	30,62
W9/16	12	110	26	11,00	9,00	3	70447	42,07
W5/8	11	110	27	12,00	9,00	3	70443	39,75
W3/4	10	125	30	14,00	11,00	4	70419	59,30
W7/8	9	140	32	18,00	14,50	4	70444	72,12
W1"	8	160	36	20,00	16,00	4	70449	90,67

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  $f = P$ 

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

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

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

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