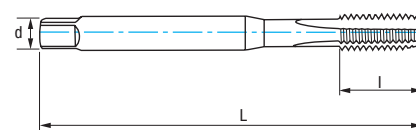
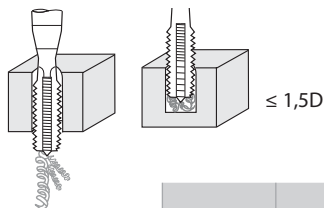


Ref. **3112**

Gwintownik maszynowy prosty z trzonkiem wzmocnionym BSW



HSSE 5%Co	DIN 371	C 2-3h		α $10^\circ \pm 2$		Norma brytyjska dla gwintu grubego
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BSW	Hilos Threads Filets	L mm	l mm	d mm	a mm	Z	N° Art. 5% Co	€
W3/32	48	50	9	2,80	2,10	3	75415	21,12
W1/8	40	56	11	3,50	2,70	3	75413	17,63
W5/32	32	63	13	4,50	3,40	3	75129	17,63
W3/16	24	70	15	6,00	4,90	3	75414	17,63
W7/32	24	80	16	6,00	4,90	3	75418	26,80
W1/4	20	80	17	7,00	5,50	3	75412	20,11
W5/16	18	90	20	8,00	6,20	3	75458	18,03
W3/8	16	100	22	9,00	7,00	3	75456	26,13

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 $f = P$

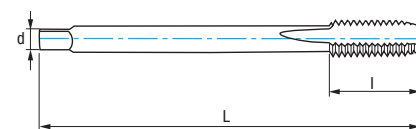
$$P = \frac{25,40}{\text{Hilos Threads - Filets}}$$

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

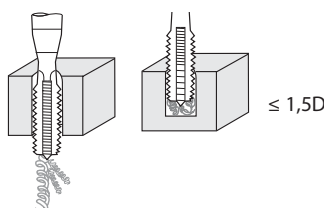
$$\text{r.p.m.} = \frac{V_c \times 1.000}{\pi \times \phi}$$

Ref. **3212**

Gwintownik maszynowy prosty BSW



HSSE 5%Co	DIN 376	C 2-3h		α $10^\circ \pm 2$		Norma brytyjska dla gwintu grubego
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BSW	Hilos Threads Filets	L mm	l mm	d mm	a mm	Z	N° Art. 5% Co	€
W3/8	16,00	100	22	7,00	5,50	3	70395	22,20
W7/16	14,00	100	22	8,00	6,20	3	70396	29,24
W1/2	12,00	110	24	9,00	7,00	3	70398	28,07
W9/16	12,00	110	26	11,00	9,00	3	70399	40,25
W5/8	11,00	110	27	12,00	9,00	3	70401	38,09
W3/4	10,00	125	30	14,00	11,00	4	70402	53,94
W7/8	9,00	140	32	18,00	14,50	4	70416	69,00
W1"	8,00	160	36	20,00	16,00	4	70404	86,75
W1"1/8	7,00	180	40	22,00	18,00	4	70450	132,38
W1"1/4	7,00	180	40	22,00	18,00	4	70452	192,17
W1"3/8	6,00	200	50	28,00	22,00	4	70453	315,95
W1"1/2	6,00	200	50	32,00	24,00	4	70455	343,02
W1"5/8	5,00	220	58	36,00	29,00	4	70456	478,96
W1"7/8	4,50	220	58	36,00	29,00	4	70458	625,50

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 $f = P$

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

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

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