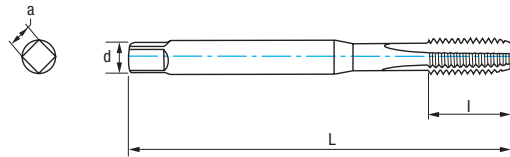
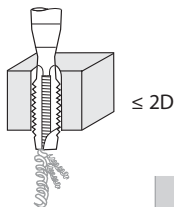


Ref. 3134

Gwintownik maszynowy prosty UNC ze wzmocnionym trzpieniem



HSSE 5%Co	DIN 371	B 3,5-5h	Tol. 2B		α 10-14°		Norma amerykańska dla gwintu grubego
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UNC	Hilos Threads	Filets	L mm	l mm	d mm	a mm	Z	N° Art. 5% Co	€
UNC N°5	40		56	9	3,50	2,70	3	75627	28,85
UNC N°6	32		56	11	4,00	3,00	3	75628	27,49
UNC N°8	32		63	12	4,50	3,40	3	75629	27,49
UNC N°10	24		70	13	6,00	4,90	3	75630	28,85
UNC N°12	24		80	15	6,00	4,90	3	75631	30,27
UNC 1/4	20		80	15	7,00	5,50	3	75527	23,31
UNC 5/16	18		90	18	8,00	6,20	3	75531	27,17
UNC 3/8	16		90	20	9,00	7,00	3	75529	29,32

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.5	12-15

Prędkość posuwu $f = P$

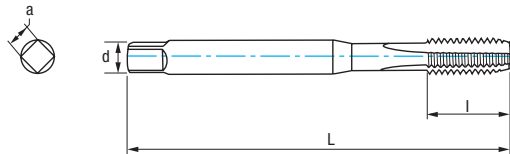
$$P = \frac{25,40}{\text{Hilos Threads - Filets}}$$

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

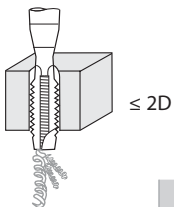
$$\text{r.p.m.} = \frac{V_c \times 1.000}{\pi \times \phi}$$

Ref. 3234

Gwintownik maszynowy prosty UNC



HSSE 5%Co	DIN 376	B 3,5-5h	Tol. 2B		α 10-14°		Norma amerykańska dla gwintu grubego
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UNC	Hilos Threads	Filets	L mm	l mm	d mm	a mm	Z	N° Art. 5% Co	€
UNC 7/16	14		100	20	8,00	6,20	3	70521	41,61
UNC 1/2	13		110	23	9,00	7,00	3	70512	45,61
UNC 9/16	12		110	25	11,00	9,00	3	70522	62,11
UNC 5/8	11		110	25	12,00	9,00	3	70516	60,50
UNC 3/4	10		125	30	14,00	11,00	3	70513	80,02
UNC 7/8	9		140	30	18,00	14,50	3	70519	105,22
UNC 1"	8		160	36	18,00	14,50	3	70524	138,22

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.5	12-15

Prędkość posuwu $f = P$

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

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

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