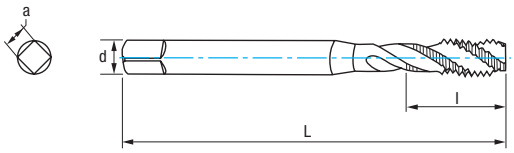
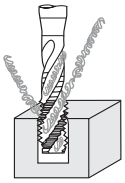
Ref. 3160

Gwintownik maszynowy spiralny uniwersalny ze wzmocnionym chwytem



HSSE V	TIN	DIN 371	C 2-3h	35°	Tol. 6H	α 6° ± 2	60°



< 2D

M	P	L mm	l mm	d mm	a mm	Z	N° Art. TIN	€
M3	**0,50**	56	11	3,50	2,70	3	28052	**25,24**
M4	**0,70**	63	13	4,50	3,40	3	28053	**25,24**
M5	**0,80**	70	16	6,00	4,90	3	28054	**25,86**
M6	**1,00**	80	17	6,00	4,90	3	28055	**26,98**
M8	**1,25**	90	20	8,00	6,20	3	28056	**31,30**
M10	**1,50**	100	24	10,00	8,00	3	28057	**36,84**

Materiały		Vc (m/min)
Grupa	Sub.	TIN
P	P.1	10-12
	P.2	4-6
	P.5	4-7
M		6-10
K	K.1	8-12
	K.2	7-10
N	N.1	8-12
	N.2	12-20
	N.4	12-20
	N.5	12-20
	N.6	10-15

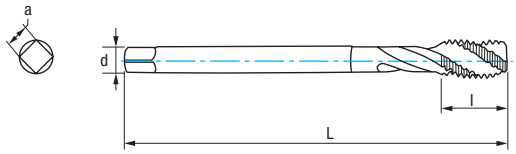
Prędkość posuwu f = P

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

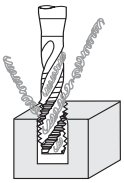
$$\text{r.p.m.} = \frac{Vc \times 1.000}{\pi \times ø}$$

Ref. 3260

Gwintownik maszynowy spiralny uniwersalny



HSSE V	TIN	DIN 376	C 2-3h	35°	Tol. 6H	α 6° ± 2	60°



< 2D

M	P	L mm	l mm	d mm	a mm	Z	N° Art. TIN	€
M12	**1,75**	110	24	9,00	7,00	3	28076	**48,12**
M14	**2,00**	110	26	11,00	9,00	3	28078	**60,13**
M16	**2,00**	110	27	12,00	9,00	4	28080	**66,09**
M18	**2,50**	125	30	14,00	11,00	4	28082	**95,21**
M20	**2,50**	140	32	16,00	12,00	4	28084	**98,30**

Materiały		Vc (m/min)
Grupa	Sub.	TIN
P	P.1	10-12
	P.2	4-6
	P.5	4-7
M		6-10
K	K.1	8-12
	K.2	7-10
N	N.1	8-12
	N.2	12-20
	N.4	12-20
	N.5	12-20
	N.6	10-15

Prędkość posuwu f = P

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

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