





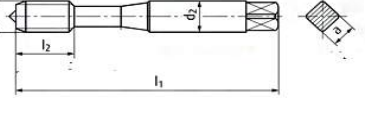
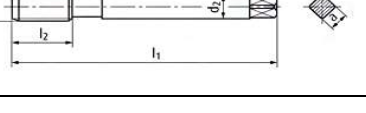








Strojní závitníky

Strojní závitníky z práškové oceli PM5 (HSSCo 5%) a PM8 (HSSCo 8%) s povlakem Cr, CrCN, TiSiN
Form C, drážka ve šroubovici 20°, profil závitů 60° / ISO 2

Kategorie	ACR30-31	AKR30-31	AKS30-31	ACR30-31	AKR30-31	AKS30-31						
Materiál - provedení	PM5	PM5	PM5	PM8	PM8	PM8						
M												
DNI 371												
DIN 376												
Typ otvoru												
Povlak	Cr	CrCN	TiSiN	Cr	CrCN	TiSiN						
Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H						
Form / počet nábehů	C / 2-3	C / 2-3	C / 2-3	C / 2-3	C / 2-3	C / 2-3						
	PM5	PM5	PM5	PM8	PM8	PM8						
DIN 371												
M 3	0,5	10	56	3,5	2,7	2,5	0130-016H-510	0130-016H-520	0130-016H-540	0130-016H-810	0130-016H-820	0130-016H-840
M 4	0,7	13	63	4,5	3,4	3,3	0130-036H-510	0130-036H-520	0130-036H-540	0130-036H-810	0130-036H-820	0130-036H-840
M 5	0,8	15	70	6,0	4,9	4,2	0130-056H-510	0130-056H-520	0130-056H-540	0130-056H-810	0130-056H-820	0130-056H-840
M 6	1,0	16	80	6,0	4,9	5,0	0130-066H-510	0130-066H-520	0130-066H-540	0130-066H-810	0130-066H-820	0130-066H-840
M 8	1,25	18	90	8,0	6,2	6,75	0130-086H-510	0130-086H-520	0130-086H-540	0130-086H-810	0130-086H-820	0130-086H-840
M 10	1,5	20	100	10,0	8,0	8,5	0130-106H-510	0130-106H-520	0130-106H-540	0130-106H-810	0130-106H-820	0130-106H-840
DIN 376												
M 12	1,75	25	110	9,0	7,0	10,25	0131-506H-510	0131-506H-520	0131-506H-540	0131-506H-810	0131-506H-820	0131-506H-840
M 14	2,0	25	110	11,0	9,0	12,0	0131-516H-510	0131-516H-520	0131-516H-540	0131-516H-810	0131-516H-820	0131-516H-840
M 16	2,0	28	110	12,0	9,0	14,0	0131-526H-510	0131-526H-520	0131-526H-540	0131-526H-810	0131-526H-820	0131-526H-840
M 18	2,5	32	125	14,0	11,0	15,5	0131-536H-510	0131-536H-520	0131-536H-540	0131-536H-810	0131-536H-820	0131-536H-840
M 20	2,5	32	140	16,0	12,0	17,5	0131-546H-510	0131-546H-520	0131-546H-540	0131-546H-810	0131-546H-820	0131-546H-840
M 22	2,5	32	140	18,0	14,5	19,5	0131-556H-510	0131-556H-520	0131-556H-540			
M 24	3,0	36	160	18,0	14,5	21,0	0131-566H-510	0131-566H-520	0131-566H-540			
M 27	3,0	36	160	20,0	16,0	24,0	0131-576H-510	0131-576H-520	0131-576H-540			
M 30	3,5	40	180	22,0	18,0	26,5	0131-586H-510	0131-586H-520	0131-586H-540			
M 33	3,5	40	180	25,0	20,0	29,5						
M 36	4,0	55	200	28,0	22,0	32,0						
M 39	4,0	60	200	32,0	24,0	35,0						
M 42	4,5	60	200	32,0	24,0	37,5						
M 45	4,5	65	220	36,0	29,0	40,5						
M 48	5,0	70	250	36,0	29,0	43,0						
M 52	5,0	70	250	40,0	32,0	47,0						

povlak KR (CrCN) - první volba pro oceli

Doporučené řezné podmínky Vc (m/min.)

PM5	Ocel		Litina		Nerezová ocel		Hliník	
	<800 Mpa	>800 Mpa	HB <180	HB >180	<800 Mpa	>800 Mpa	Si < 8 %	Si > 8 %
ACR	12 - 18	12 - 15	-	-	8 - 12	6 - 8	12 - 18	-
AKR	12 - 25	12 - 20	-	-	12 - 20	12 - 18	12 - 25	12 - 20
AKS	12 - 35	12 - 30	-	-	12 - 25	12 - 20	12 - 35	12 - 30

Doporučené řezné podmínky Vc (m/min.)

PM8	Ocel		Litina		Nerezová ocel		Hliník	
	<800 Mpa	>800 Mpa	HB <180	HB >180	<800 Mpa	>800 Mpa	Si < 8 %	Si > 8 %
ACR	12 - 18	12 - 15	-	-	8 - 12	6 - 8	12 - 18	-
AKR	12 - 25	12 - 20	-	-	12 - 20	12 - 18	12 - 25	12 - 20
AKS	12 - 35	12 - 30	-	-	12 - 25	12 - 20	12 - 35	12 - 30