

Strojní závitníky

Strojní závitníky z práškové oceli PM5 (HSSCo 5%) a PM8 (HSSCo 8%) s povlakem Cr, CrCN, TiSiN

Form B, přímá drážka s lamačem, profil závitů 60°, tolerance 6H / ISO 2

Kategorie		BCR10-11	BKR10-11	BKS10-11	BCR10-11	BKR10-11	BKS10-11						
Materiál - provedení		PM5	PM5	PM5	PM8	PM8	PM8						
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		B / 3,5-5	B / 3,5-5	B / 3,5-5	B / 3,5-5	B / 3,5-5	B / 3,5-5						
		d 1	P	L2	L1	d 2	a	PM5	PM5	PM5	PM8	PM8	PM8
DIN 371	M 8	1,0	18	90	8,0	6,2	7,0	0210-086H-510	0210-086H-520	0210-086H-540	0210-086H-810	0210-086H-820	0210-086H-840
	M 10	1,0	20	100	10,0	8,0	9,0	0210-116H-510	0210-116H-520	0210-116H-540	0210-116H-810	0210-116H-820	0210-116H-840
	M 10	1,25	20	100	10,0	8,0	8,75	0210-126H-510	0210-126H-520	0210-126H-540	0210-126H-810	0210-126H-820	0210-126H-840
DIN 374	M 8	1,0	18	90	6,0	4,9	7,0	0211-586H-510	0211-586H-520	0211-586H-540	0211-586H-810	0211-586H-820	0211-586H-840
	M 10	1,0	20	100	7,0	5,5	9,0	0211-616H-510	0211-616H-520	0211-616H-540	0211-616H-810	0211-616H-820	0211-616H-840
	M 10	1,25	20	100	7,0	5,5	8,75	0211-626H-510	0211-626H-520	0211-626H-540	0211-626H-810	0211-626H-820	0211-626H-840
	M 12	1,0	22	100	9,0	7,0	11,0	0211-646H-510	0211-646H-520	0211-646H-540	0211-646H-810	0211-646H-820	0211-646H-840
	M 12	1,25	22	100	9,0	7,0	10,75	0211-656H-510	0211-656H-520	0211-656H-540	0211-656H-810	0211-656H-820	0211-656H-840
	M 12	1,5	22	100	9,0	7,0	10,5	0211-666H-510	0211-666H-520	0211-666H-540	0211-666H-810	0211-666H-820	0211-666H-840
	M 14	1,0	22	100	11,0	9,0	13,0	0211-676H-510	0211-676H-520	0211-676H-540	0211-676H-810	0211-676H-820	0211-676H-840
	M 14	1,5	22	100	11,0	9,0	12,5	0211-696H-510	0211-696H-520	0211-696H-540	0211-696H-810	0211-696H-820	0211-696H-840
	M 16	1,0	22	100	12,0	9,0	15,0	0211-726H-510	0211-726H-520	0211-726H-540	0211-726H-810	0211-726H-820	0211-726H-840
	M 16	1,5	22	100	12,0	9,0	14,5	0211-736H-510	0211-736H-520	0211-736H-540	0211-736H-810	0211-736H-820	0211-736H-840
	M 18	1,0	25	110	14,0	11,0	17,0	0211-746H-510	0211-746H-520	0211-746H-540	0211-746H-810	0211-746H-820	0211-746H-840
	M 18	1,5	25	110	14,0	11,0	16,5	0211-756H-510	0211-756H-520	0211-756H-540	0211-756H-810	0211-756H-820	0211-756H-840
	M 20	1,0	25	125	16,0	12,0	19,0	0211-776H-510	0211-776H-520	0211-776H-540	0211-776H-810	0211-776H-820	0211-776H-840
	M 20	1,5	25	125	16,0	12,0	18,5	0211-786H-510	0211-786H-520	0211-786H-540	0211-786H-810	0211-786H-820	0211-786H-840
	M 22	1,0	25	125	18,0	14,5	21,0	0211-806H-510	0211-806H-520	0211-806H-540			
	M 22	1,5	25	125	18,0	14,5	20,5	0211-816H-510	0211-816H-520	0211-816H-540			
	M 24	1,0	25	140	18,0	14,5	23,0	0211-836H-510	0211-836H-520	0211-836H-540			
	M 24	1,5	25	140	18,0	14,5	22,5	0211-846H-510	0211-846H-520	0211-846H-540			
	M 24	2,0	25	140	18,0	14,5	22,0	0211-856H-510	0211-856H-520	0211-856H-540			
	M 27	1,0	28	140	20,0	16,0	26,0	0211-886H-510	0211-886H-520	0211-886H-540			
M 27	1,5	28	140	20,0	16,0	25,5	0211-896H-510	0211-896H-520	0211-896H-540				
M 27	2,0	28	140	20,0	16,0	25,0	0211-906H-510	0211-906H-520	0211-906H-540				
M 30	1,0	28	150	22,0	18,0	29,0	0211-936H-510	0211-936H-520	0211-936H-540				
M 30	1,5	28	150	22,0	18,0	28,5	0211-946H-510	0211-946H-520	0211-946H-540				
M 30	2,0	28	150	22,0	18,0	28,0	0211-956H-510	0211-956H-520	0211-956H-540				

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 %
BCR	12 - 18	12 - 15	-	-	8 - 12	6 - 8	12 - 18	-
BKR	12 - 25	12 - 20	-	-	12 - 20	12 - 18	12 - 25	12 - 20
BKS	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 %
BCR	12 - 18	12 - 15	-	-	8 - 12	6 - 8	12 - 18	-
BKR	12 - 25	12 - 20	-	-	12 - 20	12 - 18	12 - 25	12 - 20
BKS	12 - 35	12 - 30	-	-	12 - 25	12 - 20	12 - 35	12 - 30