

Tvářecí závitníky

Tvářecí závitníky z práškové oceli PM10 (HSSCo 10%) s povlakem CrCN, nit+TiN, TiSiN

Form C, mazací drážka, profil závitů 60°, tolerance 6HX / ISO 2X

Kategorie		BKR90-91	BKC90-91	BKS90-91	BKR90-91 CH	BKC90-91 CH	BKS90-91 CH							
Materiál - provedení		PM10	PM10	PM10	PM10	PM10	PM10							
<p>MF</p>														
Typ otvoru														
Povlak		CrCN	nit+TiN	TiSiN	CrCN	nit+TiN	TiSiN							
Tolerance		ISO 2X / 6HX	ISO 2X / 6HX	ISO 2X / 6HX	ISO 2X / 6HX	ISO 2X / 6HX	ISO 2X / 6HX							
Form / počet náběhů		C / 2-3	C / 2-3	C / 2-3	C / 2-3	C / 2-3	C / 2-3							
		d 1	P	L 2	L 1	d 2	a		PM10	PM10	PM10	PM10	PM10	PM10
DIN 371	M 8	1,0	18	90	8,0	6,2	7,55		0290-086H-120	0290-086H-130	0290-086H-140	0290-086H-121	0290-086H-131	0290-086H-141
	M 10	1,0	20	100	10,0	8,0	9,55		0290-116H-120	0290-116H-130	0290-116H-140	0290-116H-121	0290-116H-131	0290-116H-141
	M 10	1,5	20	100	10,0	8,0	9,45		0290-136H-120	0290-136H-130	0290-136H-140	0290-136H-121	0290-136H-131	0290-136H-141
DIN 374	M 12	1,0	22	90	9,0	7,0	11,55		0291-646H-120	0291-646H-130	0291-646H-140	0291-646H-121	0291-646H-131	0291-646H-141
	M 12	1,25	22	100	9,0	7,0	11,45		0291-656H-120	0291-656H-130	0291-656H-140	0291-656H-121	0291-656H-131	0291-656H-141
	M 12	1,5	22	100	9,0	7,0	11,35		0291-666H-120	0291-666H-130	0291-666H-140	0291-666H-121	0291-666H-131	0291-666H-141
	M 14	1,0	22	100	11,0	9,0	13,55		0291-676H-120	0291-676H-130	0291-676H-140	0291-676H-121	0291-676H-131	0291-676H-141
	M 14	1,5	22	100	11,0	9,0	13,55		0291-696H-120	0291-696H-130	0291-696H-140	0291-696H-121	0291-696H-131	0291-696H-141
	M 16	1,0	22	100	11,0	9,0	15,55		0291-726H-120	0291-726H-130	0291-726H-140	0291-726H-121	0291-726H-131	0291-726H-141
	M 16	1,5	22	100	12,0	9,0	15,35		0291-736H-120	0291-736H-130	0291-736H-140	0291-736H-121	0291-736H-131	0291-736H-141

povlak KC (nit-TiN) - první volba pro ocel

Doporučené řezné podmínky Vc (m/min.)

PM10	Ocel		Litina		Nerezová ocel		Hliník	
	<800 Mpa	>800 Mpa	HB <180	HB >180	<800 Mpa	>800 Mpa	Si < 8 %	Si > 8 %
BKR	12 - 25	12 - 20	-	-	12 - 25	12 - 20	12 - 35	12 - 30
BKC	12 - 25	12 - 20	-	-	12 - 25	12 - 20	12 - 35	12 - 30
BKS	-	-	-	-	-	-	12 - 40	12 - 35

Doporučené řezné podmínky Vc (m/min.)

PM10	Ocel		Litina		Nerezová ocel		Hliník	
	<800 Mpa	>800 Mpa	HB <180	HB >180	<800 Mpa	>800 Mpa	Si < 8 %	Si > 8 %
BKR CH	12 - 25	12 - 20	-	-	12 - 25	12 - 20	12 - 35	12 - 30
BKC CH	12 - 25	12 - 20	-	-	12 - 25	12 - 20	12 - 35	12 - 30
BKS CH	-	-	-	-	-	-	12 - 40	12 - 35