

# Strojní závitníky - s vnitřním chlazením

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

Form C, drážka ve šroubovici 40°, profil závitů 60°, tolerance 6H / ISO 2

| Kategorie            |      | BKR40-41 CH |     | BKS40-41 CH |      | BKR40-41 CH |               | BKS40-41 CH   |               |               |               |
|----------------------|------|-------------|-----|-------------|------|-------------|---------------|---------------|---------------|---------------|---------------|
| Materiál - provedení |      | PM5         |     | PM5         |      | PM8         |               | PM8           |               |               |               |
| <p><b>MF</b></p>     |      |             |     |             |      |             |               |               |               |               |               |
| Typ otvoru           |      |             |     |             |      |             |               |               |               |               |               |
| Povlak               |      | CrCN        |     | TiSiN       |      | CrCN        |               | TiSiN         |               |               |               |
| Tolerance            |      | ISO 2 / 6H  |     | ISO 2 / 6H  |      | ISO 2 / 6H  |               | ISO 2 / 6H    |               |               |               |
| Form / počet náběhů  |      | C / 2-3     |     | C / 2-3     |      | C / 2-3     |               | C / 2-3       |               |               |               |
|                      |      | PM5         |     | PM5         |      | PM8         |               | PM8           |               |               |               |
| DIN 371              | M 8  | 1,0         | 18  | 90          | 8,0  | 6,2         | 7,0           | 0240-086H-521 | 0240-086H-541 | 0240-086H-821 | 0240-086H-841 |
|                      | M 10 | 1,0         | 20  | 100         | 10,0 | 8,0         | 9,0           | 0240-116H-521 | 0240-116H-541 | 0240-116H-821 | 0240-116H-841 |
|                      | M 10 | 1,25        | 20  | 100         | 10,0 | 8,0         | 8,75          | 0240-126H-521 | 0240-126H-541 | 0240-126H-821 | 0240-126H-841 |
| DIN 374              | M 8  | 1,0         | 18  | 90          | 6,0  | 4,9         | 7,0           | 0241-586H-521 | 0241-586H-541 | 0241-586H-821 | 0241-586H-841 |
|                      | M 10 | 1,0         | 20  | 100         | 7,0  | 5,5         | 9,0           | 0241-616H-521 | 0241-616H-541 | 0241-616H-821 | 0241-616H-841 |
|                      | M 10 | 1,25        | 20  | 100         | 7,0  | 5,5         | 8,75          | 0241-626H-521 | 0241-626H-541 | 0241-626H-821 | 0241-626H-841 |
|                      | M 12 | 1,0         | 22  | 100         | 9,0  | 7,0         | 11,0          | 0241-646H-521 | 0241-646H-541 | 0241-646H-821 | 0241-646H-841 |
|                      | M 12 | 1,25        | 22  | 100         | 9,0  | 7,0         | 10,75         | 0241-656H-521 | 0241-656H-541 | 0241-656H-821 | 0241-656H-841 |
|                      | M 12 | 1,5         | 22  | 100         | 9,0  | 7,0         | 10,5          | 0241-666H-521 | 0241-666H-541 | 0241-666H-821 | 0241-666H-841 |
|                      | M 14 | 1,0         | 22  | 100         | 11,0 | 9,0         | 13,0          | 0241-676H-521 | 0241-676H-541 | 0241-676H-821 | 0241-676H-841 |
|                      | M 14 | 1,5         | 22  | 100         | 11,0 | 9,0         | 12,5          | 0241-696H-521 | 0241-696H-541 | 0241-696H-821 | 0241-696H-841 |
|                      | M 16 | 1,0         | 22  | 100         | 12,0 | 9,0         | 15,0          | 0241-726H-521 | 0241-726H-541 | 0241-726H-821 | 0241-726H-841 |
|                      | M 16 | 1,5         | 22  | 100         | 12,0 | 9,0         | 14,5          | 0241-736H-521 | 0241-736H-541 | 0241-736H-821 | 0241-736H-841 |
|                      | M 18 | 1,0         | 25  | 110         | 14,0 | 11,0        | 17,0          | 0241-746H-521 | 0241-746H-541 | 0241-746H-821 | 0241-746H-841 |
|                      | M 18 | 1,5         | 25  | 110         | 14,0 | 11,0        | 16,5          | 0241-756H-521 | 0241-756H-541 | 0241-756H-821 | 0241-756H-841 |
|                      | M 20 | 1,0         | 25  | 125         | 16,0 | 12,0        | 19,0          | 0241-776H-521 | 0241-776H-541 | 0241-776H-821 | 0241-776H-841 |
|                      | M 20 | 1,5         | 25  | 125         | 16,0 | 12,0        | 18,5          | 0241-786H-521 | 0241-786H-541 | 0241-786H-821 | 0241-786H-841 |
|                      | M 22 | 1,0         | 25  | 125         | 18,0 | 14,5        | 21,0          | 0241-806H-521 | 0241-806H-541 |               |               |
|                      | M 22 | 1,5         | 25  | 125         | 18,0 | 14,5        | 20,5          | 0241-816H-521 | 0241-816H-541 |               |               |
|                      | M 24 | 1,0         | 25  | 140         | 18,0 | 14,5        | 23,0          | 0241-836H-521 | 0241-836H-541 |               |               |
|                      | M 24 | 1,5         | 25  | 140         | 18,0 | 14,5        | 22,5          | 0241-846H-521 | 0241-846H-541 |               |               |
| M 24                 | 2,0  | 25          | 140 | 18,0        | 14,5 | 22,0        | 0241-856H-521 | 0241-856H-541 |               |               |               |
| M 27                 | 1,0  | 28          | 140 | 20,0        | 16,0 | 26,0        | 0241-886H-521 | 0241-886H-541 |               |               |               |
| M 27                 | 1,5  | 28          | 140 | 20,0        | 16,0 | 25,5        | 0241-896H-521 | 0241-896H-541 |               |               |               |
| M 27                 | 2,0  | 28          | 140 | 20,0        | 16,0 | 25,0        | 0241-906H-521 | 0241-906H-541 |               |               |               |
| M 30                 | 1,0  | 28          | 150 | 22,0        | 18,0 | 29,0        | 0241-936H-521 | 0241-936H-541 |               |               |               |
| M 30                 | 1,5  | 28          | 150 | 22,0        | 18,0 | 28,5        | 0241-946H-521 | 0241-946H-541 |               |               |               |
| M 30                 | 2,0  | 28          | 150 | 22,0        | 18,0 | 28,0        | 0241-956H-521 | 0241-956H-541 |               |               |               |

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 % |
| BKR CH | 12 - 25  | 12 - 20  | -       | -       | 12 - 20       | 12 - 18  | 12 - 25  | 12 - 20  |
| BKS CH | 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 % |
| BKR CH | 12 - 25  | 12 - 20  | -       | -       | 12 - 20       | 12 - 18  | 12 - 25  | 12 - 20  |
| BKS CH | 12 - 35  | 12 - 30  | -       | -       | 12 - 25       | 12 - 20  | 12 - 35  | 12 - 30  |