
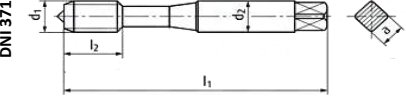
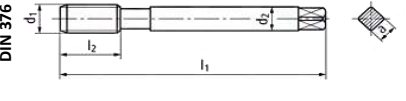




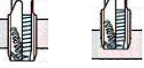
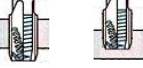
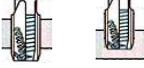
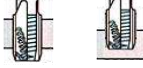


Strojní závitníky - pro litinu

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

Form C, přímá drážka, profil závitů 60°, pro průchozí i neprůchozí otvory, tolerance 2B

Kategorie		CKS70-71	CKS70-71 CH	CKS70-71	CKS70-71 CH						
Materiál - provedení		PM5	PM5	PM8	PM8						
<p>UNC ASME-B1.1</p>  <p>DIN 371</p>  <p>DIN 376</p> 											
Typ otvoru											
Povlak		TiSiN	TiSiN	TiSiN	TiSiN						
Tolerance		2B	2B	2B	2B						
Form / počet náběhů		C / 2-3	C / 2-3	C / 2-3	C / 2-3						
		PM5	PM5	PM8	PM8						
DIN 371	Nr. 6	32	13	56	4,0	3,0	2,85	0370-052B-540		0370-052B-840	
	Nr. 8	32	13	63	4,5	3,4	3,5	0370-062B-540		0370-062B-840	
	Nr. 10	24	15	70	6,0	4,9	3,9	0370-072B-540		0370-072B-840	
	Nr. 12	24	16	80	6,0	4,9	4,5	0370-082B-540		0370-082B-840	
	1/4	20	16	80	7,0	5,5	5,2	0370-092B-540	0370-092B-541	0370-092B-840	0370-092B-841
DIN 376	5/16	18	18	90	6,0	4,9	6,6	0371-512B-540	0371-512B-541	0371-512B-840	0371-512B-841
	3/8	16	20	100	7,0	5,5	8,0	0371-522B-540	0371-522B-541	0371-522B-840	0371-522B-841
	7/16	14	25	110	9,0	7,0	9,4	0371-532B-540	0371-532B-541	0371-532B-840	0371-532B-841
	1/2	13	25	110	9,0	7,0	10,75	0371-542B-540	0371-542B-541	0371-542B-840	0371-542B-841
	9/16	12	28	110	11,0	9,0	12,25	0371-552B-540	0371-552B-541	0371-552B-840	0371-552B-841
	5/8	11	28	110	12,0	9,0	13,5	0371-562B-540	0371-562B-541	0371-562B-840	0371-562B-841
	3/4	10	32	140	14,0	11,0	16,5	0371-572B-540	0371-572B-541	0371-572B-840	0371-572B-841
	7/8	9	32	140	18,0	14,5	19,5	0371-582B-540	0371-582B-541		
	1"	8	36	160	20,0	16,0	22,25	0371-592B-540	0371-592B-541		
	1" 1/8	7	40	180	22,0	18,0	25,0	0371-602B-540			
	1" 1/4	7	45	180	25,0	20,0	28,25	0371-612B-540			
	1" 1/2	6	45	200	32,0	24,0	34,0	0371-632B-540			

povlak KS (TiSiN) - první volba pro litinu

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 %
CKS	-	-	12 - 35	12 - 30	-	-	-	-
CKS CH	-	-	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 %
CKS	-	-	12 - 35	12 - 30	-	-	-	-
CKS CH	-	-	12 - 35	12 - 30	-	-	-	-