

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 55°, tolerance 2B

| Kategorie | | WCR10-11 | WKR10-11 | WKS10-11 | WCR10-11 | WKR10-11 | WKS10-11 | | | | | | |
|----------------------|------|-----------|-----------|-----------|-----------|-----------|-----------|---------------|---------------|---------------|---------------|---------------|---------------|
| Materiál - provedení | | PM5 | PM5 | PM5 | PM8 | PM8 | PM8 | | | | | | |
| | | | | | | | | | | | | | |
| Typ otvoru | | | | | | | | | | | | | |
| Povlak | | Cr | CrCN | TiSiN | Cr | CrCN | TiSiN | | | | | | |
| Tolerance | | 2B | 2B | 2B | 2B | 2B | 2B | | | | | | |
| Form / počet náběhů | | B / 3,5-5 | B / 3,5-5 | B / 3,5-5 | B / 3,5-5 | B / 3,5-5 | B / 3,5-5 | | | | | | |
| DIN 371 | d 1 | P/1" | L 2 | L 1 | d 2 | a | | PM5 | PM5 | PM5 | PM8 | PM8 | PM8 |
| | 1/8 | 40 | 10 | 56 | 3,5 | 2,7 | 2,5 | 0610-032B-510 | 0610-032B-520 | 0610-032B-540 | 0610-032B-810 | 0610-032B-820 | 0610-032B-840 |
| | 3/16 | 24 | 13 | 70 | 6,0 | 4,9 | 3,6 | 0610-052B-510 | 0610-052B-520 | 0610-052B-540 | 0610-052B-810 | 0610-052B-820 | 0610-052B-840 |
| | 1/4 | 20 | 16 | 80 | 7,0 | 5,5 | 5,0 | 0610-072B-510 | 0610-072B-520 | 0610-072B-540 | 0610-072B-810 | 0610-072B-820 | 0610-072B-840 |
| | 5/16 | 18 | 18 | 90 | 8,0 | 6,2 | 6,5 | 0610-082B-510 | 0610-082B-520 | 0610-082B-540 | 0610-082B-810 | 0610-082B-820 | 0610-082B-840 |
| | 3/8 | 16 | 20 | 100 | 10,0 | 8,0 | 7,9 | 0610-092B-510 | 0610-092B-520 | 0610-092B-540 | 0610-092B-810 | 0610-092B-820 | 0610-092B-840 |
| DIN 376 | 7/16 | 14 | 20 | 100 | 8,0 | 6,2 | 9,2 | 0611-502B-510 | 0611-502B-520 | 0611-502B-540 | 0611-502B-810 | 0611-502B-820 | 0611-502B-840 |
| | 1/2 | 12 | 25 | 110 | 9,0 | 7,0 | 10,5 | 0611-512B-510 | 0611-512B-520 | 0611-512B-540 | 0611-512B-810 | 0611-512B-820 | 0611-512B-840 |
| | 9/16 | 12 | 28 | 110 | 11,0 | 9,0 | 12,0 | 0611-522B-510 | 0611-522B-520 | 0611-522B-540 | 0611-522B-810 | 0611-522B-820 | 0611-522B-840 |
| | 5/8 | 11 | 28 | 110 | 12,0 | 9,0 | 13,4 | 0611-532B-510 | 0611-532B-520 | 0611-532B-540 | 0611-532B-810 | 0611-532B-820 | 0611-532B-840 |
| | 3/4 | 10 | 32 | 125 | 14,0 | 11,0 | 16,4 | 0611-542B-510 | 0611-542B-520 | 0611-542B-540 | 0611-542B-810 | 0611-542B-820 | 0611-542B-840 |
| | 7/8 | 9 | 32 | 140 | 18,0 | 14,5 | 19,25 | 0611-552B-510 | 0611-552B-520 | 0611-552B-540 | 0611-552B-810 | 0611-552B-820 | 0611-552B-840 |
| | 1" | 8 | 36 | 160 | 18,0 | 14,5 | 22,0 | 0611-562B-510 | 0611-562B-520 | 0611-562B-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 % |
| WCR | 12 - 18 | 12 - 15 | - | - | 8 - 12 | 6 - 8 | 12 - 18 | - |
| WKR | 12 - 25 | 12 - 20 | - | - | 12 - 20 | 12 - 18 | 12 - 25 | 12 - 20 |
| WKS | 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 % |
| WCR | 12 - 18 | 12 - 15 | - | - | 8 - 12 | 6 - 8 | 12 - 18 | - |
| WKR | 12 - 25 | 12 - 20 | - | - | 12 - 20 | 12 - 18 | 12 - 25 | 12 - 20 |
| WKS | 12 - 35 | 12 - 30 | - | - | 12 - 25 | 12 - 20 | 12 - 35 | 12 - 30 |