

# STROJNÍ ZÁVITNÍK S PŘÍMOU DRÁŽKOU A LAMAČEM

Machine tap with straight flutes and spiral point

 Maschinengewindebohrer mit geraden Nuten und Schälanschnitt, Form B

 Машинный метчик с прямой канавкой и со стружколомом

 Maschi a macchina con taglienti diritti e imbocco corretto

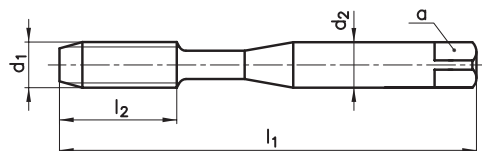
 Düz Kanal ve Eğik Ağz Bilemeli Makina Kılavuzu

TYPE  
N

1500NX

1540NX

1520NX



OX

TIAN

| d <sub>1</sub> | P    | l <sub>1</sub> | l <sub>2</sub> | d <sub>2</sub> | a   | z | Ø   |   |   |   |
|----------------|------|----------------|----------------|----------------|-----|---|-----|---|---|---|
| M 3            | 0,5  | 56             | 11             | 3,5            | 2,7 | 3 | 2,5 | • | • | • |
| M 4            | 0,7  | 63             | 13             | 4,5            | 3,4 | 3 | 3,3 | • | • | • |
| M 5            | 0,8  | 70             | 16             | 6              | 4,9 | 3 | 4,2 | • | • | • |
| M 6            | 1    | 80             | 19             | 6              | 4,9 | 3 | 5   | • | • | • |
| M 8            | 1,25 | 90             | 22             | 8              | 6,2 | 3 | 6,8 | • | • | • |
| M 10           | 1,5  | 100            | 24             | 10             | 8   | 3 | 8,5 | • | • | • |

M



DIN  
13

HSSE  
V3

DIN  
371

ISO 2  
6H

B  
3,5-6



## Řezné podmínky / Cutting conditions / V<sub>c</sub>

|      |                                                                 |       |       |       |
|------|-----------------------------------------------------------------|-------|-------|-------|
| P1.1 | Konstrukční oceli / Structural steels <500N/mm <sup>2</sup>     | 10-15 | 10-15 | 15-22 |
| P1.2 | Nelegované lité oceli / Plain cast steels <500N/mm <sup>2</sup> | 12-15 | 12-15 | 15-22 |
| P2.1 | Automatové oceli / Free-cutting steels <800N/mm <sup>2</sup>    | 10-15 | 10-15 | 12-20 |
| P2.2 | Konstrukční oceli / Structural steels <800N/mm <sup>2</sup>     | 10-15 | 10-15 | 12-20 |
| P2.3 | Nelegované lité oceli / Plain cast steels <800N/mm <sup>2</sup> | 10-15 | 10-15 | 12-20 |
| N7.1 | Čistý hliník / Unalloyed aluminium                              | 10-15 | 12-15 |       |
| N8.1 | Legovaný hliník / Aluminium alloys Si<10%                       | 10-15 | 12-15 |       |
| N8.2 | Legovaný hliník / Aluminium alloys Si>10%                       | 10-15 | 12-15 |       |



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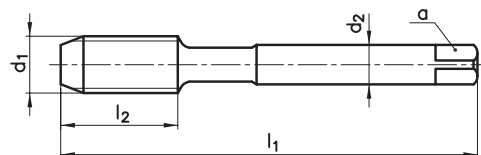
 Maschi a macchina con taglienti diritti e imbocco corretto

 Машинный метчик с прямой канавкой и со стружколомом

 Düz Kanal ve Eğik Ağz Bilemeli Makina Kılavuzu

TYPE  
N

3500NX 3540NX 3520NX



OX

TiAIN

M



DIN  
13

HSSE  
V3

DIN  
376

ISO 2  
6H

B  
3,5-6



| d <sub>1</sub> | P    | l <sub>1</sub> | l <sub>2</sub> | d <sub>2</sub> | a    | z | Ø    |
|----------------|------|----------------|----------------|----------------|------|---|------|
| M 3            | 0,5  | 56             | 11             | 2,2            | -    | 3 | 2,5  |
| M 4            | 0,7  | 63             | 13             | 2,8            | 2,1  | 3 | 3,3  |
| M 5            | 0,8  | 70             | 16             | 3,5            | 2,7  | 3 | 4,2  |
| M 6            | 1    | 80             | 19             | 4,5            | 3,4  | 3 | 5    |
| M 8            | 1,25 | 90             | 22             | 6              | 4,9  | 3 | 6,8  |
| M 10           | 1,5  | 100            | 24             | 7              | 5,5  | 3 | 8,5  |
| M 12           | 1,75 | 110            | 28             | 9              | 7    | 3 | 10,2 |
| M 14           | 2    | 110            | 30             | 11             | 9    | 3 | 12   |
| M 16           | 2    | 110            | 32             | 12             | 9    | 3 | 14   |
| M 18           | 2,5  | 125            | 34             | 14             | 11   | 3 | 15,5 |
| M 20           | 2,5  | 140            | 34             | 16             | 12   | 3 | 17,5 |
| M 22           | 2,5  | 140            | 34             | 18             | 14,5 | 3 | 19,5 |
| M 24           | 3    | 160            | 38             | 18             | 14,5 | 3 | 21   |
| M 27           | 3    | 160            | 38             | 20             | 16   | 4 | 24   |
| M 30           | 3,5  | 180            | 45             | 22             | 18   | 4 | 26,5 |
| M 33           | 3,5  | 180            | 50             | 25             | 20   | 4 | 29,5 |
| M 36           | 4    | 200            | 56             | 28             | 22   | 4 | 32   |

Řezné podmínky / Cutting conditions / V<sub>c</sub>

|      |                                                                 |       |       |       |
|------|-----------------------------------------------------------------|-------|-------|-------|
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| P2.2 | Konstrukční oceli / Structural steels <800N/mm <sup>2</sup>     | 10-15 | 10-15 | 12-20 |
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| N8.2 | Legovaný hliník / Aluminium alloys Si>10%                       | 10-15 | 12-15 |       |

