

# STROJNÍ ZÁVITNÍK SE ŠROUBOVITOU DRÁŽKOU 40°

Machine tap with right-hand spiral flutes 40°

 Maschinengewindebohrer mit 40° RSP, rechtsschneidend

 Maschi a macchina con taglienti elicoidali destri 40°

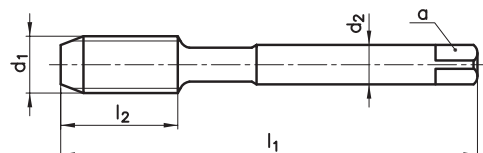
 Машинный метчик со спиральной канавкой 40°

 40° Helis Makina Kılavuzu

TYPE  
VA

4295

4265



UNF



HSSE

≈DIN  
374

2BX



OX

TiN

| d <sub>1</sub> | tpi | l <sub>1</sub> | l <sub>2</sub> | d <sub>2</sub> | a    | z | Ø     |   |   |
|----------------|-----|----------------|----------------|----------------|------|---|-------|---|---|
| UNF No.5       | 44  | 56             | 5              | 2,2            | -    | 3 | 2,7   | • | • |
| UNF No.6       | 40  | 56             | 7              | 2,5            | 2,1  | 3 | 3     | • | • |
| UNF No.8       | 36  | 63             | 7              | 2,8            | 2,1  | 3 | 3,5   | • | • |
| UNF No.10      | 32  | 70             | 8              | 3,5            | 2,7  | 3 | 4,1   | • | • |
| UNF No.12      | 28  | 80             | 10             | 4              | 3    | 3 | 4,65  | • | • |
| UNF 1/4        | 28  | 80             | 10             | 4,5            | 3,4  | 3 | 5,5   | • | • |
| UNF 5/16       | 24  | 90             | 13             | 6              | 4,9  | 3 | 6,9   | • | • |
| UNF 3/8        | 24  | 90             | 15             | 7              | 5,5  | 3 | 8,5   | • | • |
| UNF 7/16       | 20  | 100            | 15             | 8              | 6,2  | 3 | 9,9   | • | • |
| UNF 1/2        | 20  | 100            | 14             | 9              | 7    | 3 | 11,5  | • | • |
| UNF 9/16       | 18  | 100            | 16             | 11             | 9    | 3 | 12,9  | • | • |
| UNF 5/8        | 18  | 100            | 16             | 12             | 9    | 3 | 14,5  | • | • |
| UNF 3/4        | 16  | 110            | 20             | 14             | 11   | 4 | 17,5  | • | • |
| UNF 7/8        | 14  | 125            | 20             | 18             | 14,5 | 4 | 20,5  | • | • |
| UNF 1          | 12  | 140            | 22             | 18             | 14,5 | 4 | 23,25 | • | • |

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

|       |                                                                 |     |       |
|-------|-----------------------------------------------------------------|-----|-------|
| P3.1  | Cement. a nitr. / Case hardened and nitriding steels            | 3-5 | 6-8   |
| P3.3  | Nástrojové oceli / Tool steels                                  |     | 6-8   |
| M5.1  | Nerezavějící oceli / Stainless steels 450-800N/mm <sup>2</sup>  | 4-7 | 8-14  |
| M5.2  | Nerezavějící oceli / Stainless steels 600-1000N/mm <sup>2</sup> | 3-5 | 6-10  |
| K6.2  | Tvárná a temper. litina / Spher. graphite and mall. cast iron   |     | 7-10  |
| N9.1  | Měď čistá / Pure copper                                         |     | 8-12  |
| N10.2 | Slitiny mědi s dlouhou třískou / Long chipping copper alloys    |     | 10-15 |

**narex**  
žďanice