

SYSTEM ZNAČENÍ – UPICHOVÁNÍ, ZAPICHOVÁNÍ – VNĚJŠÍ NOŽE
 ОТРЕЗКА И ОБРАБОТКА НАРУЖНЫХ КАНАВОК - СИСТЕМА ОБОЗНАЧЕНИЯ
 SYSTEM OZNACZENIA ISO - UCINANIE I ROWKOWANIE - TOCZENIE ZEWNĘTRZNE
 SYSTEM OZNAČOVANIA ISO - UPICHOVANIE, ZAPICHOVANIE - VONKAJŠIE NOŽE

| ISO | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 |
|------|----------|----------|----------|----------|-----------|-----------|-------------|-------------|-------------|-------------|------------|
| | G | F | I | L | 25 | 25 | M | 0316 | R | 030 | 017 |
| ANSI | 1 | 2 | 3 | 4 | 5 & 6 | 7 | 8 | 9 | 10 | 11 | |
| | G | F | I | L | 16 | D | 0316 | R | 1.18 | .670 | |



| 1 | 1 | 2 | 2 | 3 | 3 | 4 | 4 | | | | | | | | | | | | | | | | | | | | | | | | | | |
|--|-------------|---|---|--|---|---|---------|---------|---------|---------|----------|---------|----------|---------|----------|---|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|--|--|
| Způsob upínání Обозначение системы крепления Sposób mocowania Spósob upinania | | Tvar držáku – úhel nastavení Главный угол в плане Kształt noża - kąt przystawienia Uhol nastawienie reznej hrany | | Maximální hloubka zapichování (soustružení) Максимальная глубина канавки Max. głębokość wcinania (toczenia) Maximálna hĺbka zapichovania (sústruženia) | | Verze (levá/pravá) R/L Исполнение (правое/левое) R/L Wykonanie (prawe/lewe) R/L Verzia (ľavá/pravá) R/L | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | <table border="1"> <tr><th colspan="2">α°</th></tr> <tr><td>G = 0°</td><td>K = 75°</td></tr> <tr><td>R = 15°</td><td>F = 90°</td></tr> <tr><td>T = 30°</td><td>B = 105°</td></tr> <tr><td>S = 45°</td><td>E = 120°</td></tr> <tr><td>W = 60°</td><td>D = 135°</td></tr> </table> | | α° | | G = 0° | K = 75° | R = 15° | F = 90° | T = 30° | B = 105° | S = 45° | E = 120° | W = 60° | D = 135° | <table border="1"> <tr><td>G = 2,0 x a</td><td>N = 5,5 x a</td></tr> <tr><td>H = 2,5 x a</td><td>O = 6,0 x a</td></tr> <tr><td>I = 3,0 x a</td><td>P = 6,5 x a</td></tr> <tr><td>J = 3,5 x a</td><td>Q = 7,0 x a</td></tr> <tr><td>K = 4,0 x a</td><td>R = 7,5 x a</td></tr> <tr><td>L = 4,5 x a</td><td>S = 8,0 x a</td></tr> <tr><td>M = 5,0 x a</td><td>T = 8,5 x a</td></tr> </table> | | G = 2,0 x a | N = 5,5 x a | H = 2,5 x a | O = 6,0 x a | I = 3,0 x a | P = 6,5 x a | J = 3,5 x a | Q = 7,0 x a | K = 4,0 x a | R = 7,5 x a | L = 4,5 x a | S = 8,0 x a | M = 5,0 x a | T = 8,5 x a | | |
| α° | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| G = 0° | K = 75° | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| R = 15° | F = 90° | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| T = 30° | B = 105° | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| S = 45° | E = 120° | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| W = 60° | D = 135° | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| G = 2,0 x a | N = 5,5 x a | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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| M = 5,0 x a | T = 8,5 x a | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

| 5 | 6 | 7 | 7 | 8 | 8 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|-----|---|-------|---|---|--|--|------------|--|---|-----|---|-------|---|-----|---|-------|---|-----|---|-------|---|-----|---|-------|---|-----|---|-------|---|-----|---|-------|---|-----|--|--|---|-----|--|--|---|-----|--|--|---|--|----------|--|----------|--|----|-----|--|------|----------------|-----|--|------|----------------|-----|--|------|----------|-----|--|------|----------|-----|--|------|----------|-----|--|------|
| Výška držáku [mm] Высота державки [мм] Wysokość uchwyty [mm] Výška držáka [mm] | | Šířka držáku [mm] Ширина державки [мм] Szerokość uchwyty [mm] Šírka držáka [mm] | | Celková délka držáku Общая длина резака Długość całkowita Celková dĺžka (mm) | | Šířka destičky Ширина пластины Szerokość płytki Šírka doštičky | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| <p>12 = 12 mm / [mm] 16 = 16 mm / [mm] 20 = 20 mm / [mm] atd./etc.</p> | | <p>12 = 12 mm / [mm] 16 = 16 mm / [mm] 20 = 20 mm / [mm] atd./etc.</p> | | <table border="1"> <tr><th colspan="2">l_1 [mm]</th><th colspan="2">l_1 [in]</th></tr> <tr><td>H</td><td>100</td><td>A</td><td>4.000</td></tr> <tr><td>J</td><td>110</td><td>B</td><td>4.500</td></tr> <tr><td>K</td><td>125</td><td>C</td><td>5.000</td></tr> <tr><td>L</td><td>140</td><td>D</td><td>6.000</td></tr> <tr><td>E</td><td>150</td><td>E</td><td>7.000</td></tr> <tr><td>N</td><td>160</td><td>F</td><td>8.000</td></tr> <tr><td>P</td><td>170</td><td></td><td></td></tr> <tr><td>Q</td><td>180</td><td></td><td></td></tr> <tr><td>R</td><td>200</td><td></td><td></td></tr> </table> | | l_1 [mm] | | l_1 [in] | | H | 100 | A | 4.000 | J | 110 | B | 4.500 | K | 125 | C | 5.000 | L | 140 | D | 6.000 | E | 150 | E | 7.000 | N | 160 | F | 8.000 | P | 170 | | | Q | 180 | | | R | 200 | | | <table border="1"> <tr><th colspan="2">a [mm]</th><th colspan="2">a [in]</th></tr> <tr><td>02</td><td>2,0</td><td></td><td>.079</td></tr> <tr><td>03, 0313, 0316</td><td>3,0</td><td></td><td>.118</td></tr> <tr><td>04, 0413, 0416</td><td>4,0</td><td></td><td>.157</td></tr> <tr><td>05, 0516</td><td>5,0</td><td></td><td>.197</td></tr> <tr><td>06, 0616</td><td>6,0</td><td></td><td>.236</td></tr> <tr><td>08, 0830</td><td>8,0</td><td></td><td>.315</td></tr> </table> | | a [mm] | | a [in] | | 02 | 2,0 | | .079 | 03, 0313, 0316 | 3,0 | | .118 | 04, 0413, 0416 | 4,0 | | .157 | 05, 0516 | 5,0 | | .197 | 06, 0616 | 6,0 | | .236 | 08, 0830 | 8,0 | | .315 |
| l_1 [mm] | | l_1 [in] | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| H | 100 | A | 4.000 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| J | 110 | B | 4.500 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| K | 125 | C | 5.000 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| L | 140 | D | 6.000 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| E | 150 | E | 7.000 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| N | 160 | F | 8.000 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| P | 170 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Q | 180 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| R | 200 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| a [mm] | | a [in] | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 02 | 2,0 | | .079 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 03, 0313, 0316 | 3,0 | | .118 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 04, 0413, 0416 | 4,0 | | .157 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 05, 0516 | 5,0 | | .197 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 06, 0616 | 6,0 | | .236 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 08, 0830 | 8,0 | | .315 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

| 6 & 7 | | | | | | | | |
|-------|--------|--------|--------|--------|--------|--------|-------|-------|
| | b [in] | h [in] | b [in] | h [in] | b [in] | h [in] | | |
| 05 | 5/16 | 5/16 | 12 | 3/4 | 3/4 | 20 | 1 1/4 | 1 1/4 |
| 06 | 3/8 | 3/8 | 16 | 1 | 1 | 24 | 1 1/2 | 1 1/2 |
| 08 | 1/2 | 1/2 | 85 | 1 | 1 1/4 | 32 | 2 | 2 |
| 10 | 5/8 | 5/8 | 86 | 1 | 1 1/2 | | | |

Pro čtvercové průřezy držáků je šířka i výška vyjádřena počtem šestnáctin palce. Pro obdelníkové průřezy držáků: první číslo (šířka) je počet osmin palce, druhé číslo (výška) je počet čtvrtin palce.

Для квадратного сечения державки номер означает шестнадцатую долю дюйма. Для прямоугольного сечения державки первая цифра означает восьмую часть дюйма ширины, а вторая цифра - четвертая часть дюйма высоты державки.

Dla chwytów kwadratowych jest to 16 części wysokości i szerokości w calach. Dla chwytów prostokątnych pierwsza cyfra jest 8 częścią szerokości w calach, a druga cyfra jest 4 częścią wysokości w calach.

Pre štvorcové prierezy držákov je šírka a výška vyjadrená šesťnadstinnami palca. Pre obdĺžnikové držáky: prvé číslo (šířka) je vyjadren osminami palca, druhé číslo (výška) je vyjadrená štvrtinami palca.

| 10 | 10 |
|--|----|
| | |
| Maximální průměr - čelní zápich Максимальный диаметр канавки для торцевых резов Maksymalna średnica Maximálny priemer - čelný zápich | |
| Doplnující informace pro axiální obrábění Дополнительная информация Informacje dodatkowe przy toczeniu od czoła Doplnujúce informácie pre axiálne obrábanie | |

| 9 | 9 | 11 | 11 |
|--|---|--|----|
| | | | |
| Směr zakřivení planžety Направление кривизны опорной части резака Kierunek zakrzywienia listwy Smer zakrivenia planžety | | Minimální průměr - čelní zápich Минимальный диаметр канавки для торцевых резов Minimalna średnica Minimálny priemer - čelný zápich | |
| Doplnující informace pro axiální obrábění Дополнительная информация Informacje dodatkowe przy toczeniu od czoła Doplnujúce informácie pre axiálne obrábanie | | Doplnující informace pro axiální obrábění Дополнительная информация Informacje dodatkowe przy toczeniu od czoła Doplnujúce informácie pre axiálne obrábanie | |

SYSTÉM ZNAČENÍ – UPICHOVÁNÍ, ZAPICHOVÁNÍ – VNITŘNÍ NOŽE
 ОБРАБОТКА ВНУТРЕННИХ КАНАВОК - СИСТЕМА ОБОЗНАЧЕНИЯ
 SYSTEM OZNACZENIA ISO - UCINANIE I ROWKOWANIE - TOCZENIE WEWNĘTRZNE
 SYSTEM OZNAČOVANIA ISO - UPICHOVANIE, ZAPICHOVANIE - VNÚTORNÉ NOŽE

| | | | | | | | | | |
|------|---|----|---|---|---|---|---|---|------|
| ISO | 1 | 2 | 3 | - | 4 | 5 | 6 | 7 | 8 |
| | A | 25 | S | - | G | G | H | L | 0313 |
| ANSI | 1 | 2 | 3 | - | 4 | 5 | 6 | 7 | 8 |
| | A | 16 | S | - | G | G | H | L | 0313 |



| 1 | 1 | 2 | 2 | 3 | 3 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|--|---|--------|--|--|--|--|---------------------|---------------------|--|---------------------|---------------------|---|-----|-------|---|-----|--------|---|-----|-------|---|-----|--------|---|-----|-------|---|-----|--------|---|-----|-------|---|-----|
| Provedení držáku Хвостовик Typ chwyty Drżiak | Průměr držáku Диаметр хвостовика Średnica chwyty Priemer drżiaku | Průměr držáku Диаметр хвостовика Średnica chwyty Priemer drżiaku | | Celková délka držáku Общая длина реза Długość całkowita Celková dĺžka | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| S Ocelový držák Стальной хвостовик Chwyt stalowy Ocelový drżiak | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | A Ocelový držák s chladícím otvorem Стальной хвостовик с внутренним подводом СОЖ Uchwyт stalowy z chłodzeniem wewnętrznym Ocelový drżiak s chładiacim otworem chłodzącym | d [mm] [mm] | d [in] | | <table border="1"> <thead> <tr> <th></th> <th>l₁ [mm]</th> <th>l₁ [in]</th> <th></th> <th>l₁ [mm]</th> <th>l₁ [in]</th> </tr> </thead> <tbody> <tr> <td>M</td> <td>150</td> <td>6.000</td> <td>S</td> <td>250</td> <td>10.000</td> </tr> <tr> <td>P</td> <td>170</td> <td>6.250</td> <td>T</td> <td>300</td> <td>12.000</td> </tr> <tr> <td>Q</td> <td>180</td> <td>7.250</td> <td>U</td> <td>350</td> <td>14.000</td> </tr> <tr> <td>R</td> <td>200</td> <td>8.000</td> <td>V</td> <td>400</td> <td>15.750</td> </tr> </tbody> </table> | | | l ₁ [mm] | l ₁ [in] | | l ₁ [mm] | l ₁ [in] | M | 150 | 6.000 | S | 250 | 10.000 | P | 170 | 6.250 | T | 300 | 12.000 | Q | 180 | 7.250 | U | 350 | 14.000 | R | 200 | 8.000 | V | 400 |
| | l ₁ [mm] | l ₁ [in] | | l ₁ [mm] | l ₁ [in] | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| M | 150 | 6.000 | S | 250 | 10.000 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| P | 170 | 6.250 | T | 300 | 12.000 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Q | 180 | 7.250 | U | 350 | 14.000 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| R | 200 | 8.000 | V | 400 | 15.750 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

| 4 | 4 | 5 | 5 | 6 | 6 | | | | | | | | | | | | | | | | | | | | | |
|---|---|----|---|---|---------|---------|---------|---------|----------|---------|----------|---------|----------|--|---|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Způsob upínání Способ крепления Sposób mocowania Spóсob upinania | Tvar držáku – úhel nastavení Главный угол в плане Kształт noża - kąt przystawienia Tvar drżiaku - uhol nastawienia | | | Maximální hloubka zapichování (soustružení) Макс. глубина прорезки (точения) Max. głębokość wcinania (toczenia) Maximálny hĺbka zapichovania | | | | | | | | | | | | | | | | | | | | | | |
| G | | | | | | | | | | | | | | | | | | | | | | | | | | |
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| α° | | | | | | | | | | | | | | | | | | | | | | | | | | |
| G = 0° | K = 75° | | | | | | | | | | | | | | | | | | | | | | | | | |
| R = 15° | F = 90° | | | | | | | | | | | | | | | | | | | | | | | | | |
| T = 30° | B = 105° | | | | | | | | | | | | | | | | | | | | | | | | | |
| S = 45° | E = 120° | | | | | | | | | | | | | | | | | | | | | | | | | |
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| E = 1,0 × a | J = 3,5 × a | | | | | | | | | | | | | | | | | | | | | | | | | |
| F = 1,5 × a | K = 4,0 × a | | | | | | | | | | | | | | | | | | | | | | | | | |
| G = 2,0 × a | L = 4,5 × a | | | | | | | | | | | | | | | | | | | | | | | | | |
| H = 2,5 × a | M = 5,0 × a | | | | | | | | | | | | | | | | | | | | | | | | | |
| I = 3,0 × a | N = 5,5 × a | | | | | | | | | | | | | | | | | | | | | | | | | |

| | | | |
|--|---|---|-----|
| 7 | 7 | 8 | 8 |
| Verze (levá/pravá) R/L Исполнение (правое/левое) R/L Wykonanie (prawe/lewe) R/L Verzia (ľavá/pravá) R/L | | Šířka destičky Ширина пластины Szerokość płytki Śirka doštičky | |
| | | | |
| | | a [mm] [mm] | |
| | | 0313 | 3,0 |
| | | 0413 | 4,0 |