

# STROJNÍ ZÁVITNÍK S PŘÍMOU DRÁŽKOU A LAMAČEM

Machine tap with straight flutes and spiral point

 Maschinengewindebohrer mit geraden Nuten und Schälanschnitt, Form B

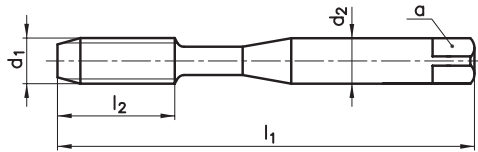
 Maschi a macchina con taglienti dritti e imbocco corretto

 Машинный метчик с прямой канавкой и со стружколомом

 Düz Kanal ve Eğik Ağız Bilemeli Makina Kılavuzu

TYPE  
UNI

1710



TIN

M

60°  
P

DIN  
13


HSSE  
V3

DIN  
371

ISO 2  
6H

B  
3,5-6

  $R_a < 1,33$

| d <sub>1</sub> | P    | l <sub>1</sub> | l <sub>2</sub> | d <sub>2</sub> | a   | z |  |   |
|----------------|------|----------------|----------------|----------------|-----|---|---|---|
| M 3            | 0,5  | 56             | 9              | 3,5            | 2,7 | 3 | 2,5   | • |
| M 3,5          | 0,6  | 56             | 11             | 4              | 3   | 3 | 2,9   |   |
| M 4            | 0,7  | 63             | 12             | 4,5            | 3,4 | 3 | 3,3   | • |
| M 4,5          | 0,75 | 70             | 13             | 6              | 4,9 | 3 | 3,7   |   |
| M 5            | 0,8  | 70             | 13             | 6              | 4,9 | 3 | 4,2   | • |
| M 6            | 1    | 80             | 15             | 6              | 4,9 | 3 | 5   | • |
| M 7            | 1    | 80             | 15             | 7              | 5,5 | 3 | 6   |   |
| M 8            | 1,25 | 90             | 18             | 8              | 6,2 | 3 | 6,8   | • |
| M 9            | 1,25 | 90             | 18             | 9              | 7   | 3 | 7,8   |   |
| M 10           | 1,5  | 100            | 20             | 10             | 8   | 3 | 8,5   | • |

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

|       |   |       |
|-------|---|-------|
| P2.1  | Automatové oceli / Free-cutting steels <800N/mm <sup>2</sup>    | 10-12 |
| P2.2  | Konstrukční oceli / Structural steels <800N/mm <sup>2</sup>     | 10-12 |
| P3.1  | Cement. a nitr. / Case hardened and nitriding steels            | 4-6   |
| P3.2  | Zušlechtnuté oceli / Heat-treated steels <1200N/mm <sup>2</sup> | 4-6   |
| P3.3  | Nástrojové oceli / Tool steels                                  | 4-6   |
| M5.1  | Nerezavějící oceli / Stainless steels 450-800N/mm <sup>2</sup>  | 6-10  |
| M5.2  | Nerezavějící oceli / Stainless steels 600-1000N/mm <sup>2</sup> | 4-7   |
| K6.1  | Šedá litina / Grey cast iron                                    | 8-12  |
| K6.2  | Tvárná a temper. litina / Spher. graphite and mall. cast iron   | 7-10  |
| N8.1  | Legovaný hliník / Aluminium alloys Si<10%                       | 12-20 |
| N8.2  | Legovaný hliník / Aluminium alloys Si>10%                       | 12-20 |
| N10.2 | Slitiny mědi s dlouhou třískou / Long chipping copper alloys    | 12-20 |

**narex**  
žďanice