

# STROJNÍ ZÁVITNÍK SE ŠROUBOVITOU DRÁŽKOU 40°

Machine tap with right-hand spiral flutes 40°



Maschinengewindebohrer mit 40° RSP, rechtsschneidend



Машинный метчик со спиральной канавкой 40°



Maschi a macchina con taglienti elicoidali destri 40°

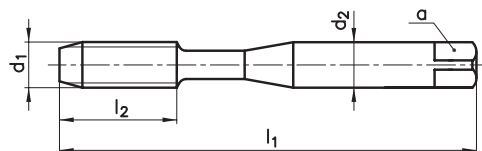


40° Helis Makina Kılavuzu

TYPE  
H

2690

2680



OX

TICN

| 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             | 5              | 3,5            | 2,7 | 3 | 2,5 | • | • |
| M 3,5          | 0,6  | 56             | 6              | 4              | 3   | 3 | 2,9 | • | • |
| M 4            | 0,7  | 63             | 7              | 4,5            | 3,4 | 3 | 3,3 | • | • |
| M 4,5          | 0,75 | 70             | 8              | 6              | 4,9 | 3 | 3,7 | • | • |
| M 5            | 0,8  | 70             | 8              | 6              | 4,9 | 3 | 4,2 | • | • |
| M 6            | 1    | 80             | 10             | 6              | 4,9 | 3 | 5   | • | • |
| M 7            | 1    | 80             | 10             | 7              | 5,5 | 3 | 6   | • | • |
| M 8            | 1,25 | 90             | 13             | 8              | 6,2 | 3 | 6,8 | • | • |
| M 9            | 1,25 | 90             | 13             | 9              | 7   | 3 | 7,8 | • | • |
| M 10           | 1,5  | 100            | 15             | 10             | 8   | 3 | 8,5 | • | • |

M

60°

DIN  
13

HSSE  
V3

DIN  
371

ISO 2  
6H

C

2-3

40°

<20μ

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

|      |                                                               |     |       |
|------|---------------------------------------------------------------|-----|-------|
| P3.1 | Cement. a nitr. / Case hardened and nitriding steels          | 3-5 | 3-5   |
| P3.2 | Zuštětžené oceli / Heat-treated steels <1200N/mm <sup>2</sup> | 3-5 | 6-8   |
| P3.3 | Nástrojové oceli / Tool steels                                |     | 3-5   |
| K6.2 | Tvárná a temper. litina / Spher. graphite and mall. cast iron |     | 7-10  |
| N8.2 | Legovaný hliník / Aluminium alloys Si>10%                     |     | 12-20 |

**narex**  
žďanice