



STROJNÍ ZÁVITNÍK SE ŠROUBOVITOU DRÁŽKOU 50°

Machine tap with right-hand spiral flutes 50°

 Maschinengewindebohrer mit 50° RSP, rechtsschneidend

 Maschi a macchina con taglienti elicoidali destri 50°

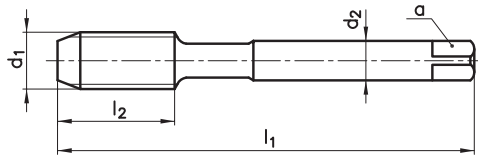
 Машинный метчик со спиральной канавкой 50°

 50° Helis Makina Kılavuzu

TYPE
UNI

4220NX

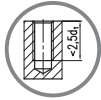
4220NXIKZ



HL

HL

d ₁	P	l ₁	l ₂	d ₂	a	z	∅	HL	HL
M 12	1,75	110	18	9	7	3	10,2	•	•
M 14	2	110	20	11	9	3	12	•	•
M 16	2	110	20	12	9	3	14	•	•
M 20	2,5	140	25	16	12	3	17,5	•	•
M 24	3	160	30	18	14,5	4	21	•	•
M 27	3	160	30	20	16	5	24	•	•
M 30	3,5	180	35	22	18	5	26,5	•	•



Řezné podmínky / Cutting conditions / V_c

P1	Oceli / Steels <500N/mm ²	18-22	18-22
P2	Oceli / Steels <800N/mm ²	10-12	10-12
P3	Oceli / Steels <1200N/mm ²	10-12	10-12
P4	Oceli / Steels <1400N/mm ²	10-12	10-12
M5	Nerezavějící oceli / Stainless steels	10-12	10-12
K6	Šedá a temperovaná litina / Grey and spheroidal cast iron	12-18	12-18
N7	Čistý hliník / Unalloyed aluminium	26-32	26-32
N8	Legovaný hliník / Aluminium alloys	12-18	12-18
N9	Měď čistá / Pure copper	18-22	18-22
N10	Slitiny mědi / Copper alloys	10-12	10-12
N11	Zinek a slitiny zinku / Zinc and zinc alloys	10-12	10-12

