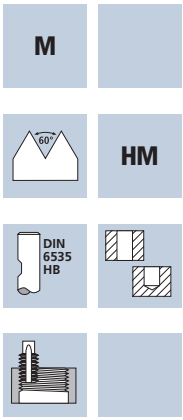
## Alkalmazás

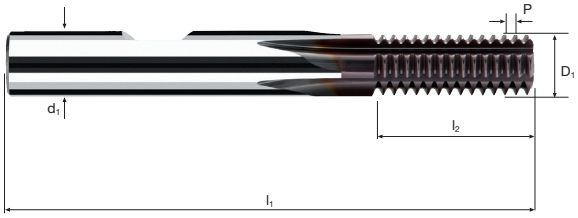
| Alapanyag | M | D1 [mm] | P [mm] | z | $v_c$ [m/min] | $f_z$ [mm] | n [mm$^{-1}$] | $v_{fc}$ [mm/min] | $v_f$ [mm/min] |
|---|---|---|---|---|---|---|---|---|---|
| Acél 850 - 1100 N/mm² | M 1.6 | 1.00 | 0.35 | 3 | 30 | 0.0015 | 9550 | 17 | 45 |
| | M 2 | 1.30 | 0.40 | 3 | 30 | 0.0020 | 7345 | 16 | 45 |
| | M 2.5 | 1.50 | 0.45 | 3 | 30 | 0.0025 | 6365 | 20 | 50 |
| | M 3 | 2.10 | 0.50 | 3 | 30 | 0.0035 | 4545 | 15 | 50 |
| | M 4 | 2.60 | 0.70 | 3 | 30 | 0.0065 | 3675 | 25 | 70 |
| | M 5 | 3.60 | 0.80 | 3 | 30 | 0.0090 | 2655 | 20 | 70 |
| | M 6 | 4.00 | 1.00 | 3 | 30 | 0.0100 | 2385 | 23 | 70 |
| | M 8 | 5.00 | 1.25 | 3 | 30 | 0.0125 | 1910 | 26 | 70 |
| | M 10 | 5.90 | 1.50 | 5 | 30 | 0.0150 | 1620 | 49 | 120 |
| Acél 850 - 1100 N/mm² | M 12 | 7.90 | 1.75 | 5 | 30 | 0.0200 | 1210 | 41 | 120 |
| | M 16 | 9.90 | 2.00 | 5 | 30 | 0.0250 | 965 | 46 | 120 |
| Acél 1100 - 1300 N/mm² | M 1.6 | 1.00 | 0.35 | 3 | 20 | 0.0015 | 6365 | 11 | 30 |
| | M 2 | 1.30 | 0.40 | 3 | 20 | 0.0020 | 4895 | 11 | 30 |
| | M 2.5 | 1.50 | 0.45 | 3 | 20 | 0.0025 | 4245 | 12 | 30 |
| | M 3 | 2.10 | 0.50 | 3 | 20 | 0.0035 | 3030 | 9 | 30 |
| | M 4 | 2.60 | 0.70 | 3 | 20 | 0.0065 | 2450 | 18 | 50 |
| | M 5 | 3.60 | 0.80 | 3 | 20 | 0.0090 | 1770 | 14 | 50 |
| | M 6 | 4.00 | 1.00 | 3 | 20 | 0.0100 | 1590 | 17 | 50 |
| | M 8 | 5.00 | 1.25 | 3 | 20 | 0.0125 | 1275 | 19 | 50 |
| | M 10 | 5.90 | 1.50 | 5 | 20 | 0.0150 | 1080 | 33 | 80 |
| Acél 1100 - 1300 N/mm² | M 12 | 7.90 | 1.75 | 5 | 20 | 0.0200 | 805 | 27 | 80 |
| | M 16 | 9.90 | 2.00 | 5 | 20 | 0.0250 | 645 | 31 | 80 |

| Alapanyag | M | D1 [mm] | P [mm] | z | $v_c$ [m/min] | $f_z$ [mm] | n [mm$^{-1}$] | $v_{fc}$ [mm/min] | $v_f$ [mm/min] |
|---|---|---|---|---|---|---|---|---|---|
| Alumínium ötvözet Si < 6% | M 1.6 | 1.00 | 0.35 | 3 | 60 | 0.0015 | 19100 | 32 | 85 |
| | M 2 | 1.30 | 0.40 | 3 | 60 | 0.0020 | 14690 | 32 | 90 |
| | M 2.5 | 1.50 | 0.45 | 3 | 60 | 0.0025 | 12735 | 38 | 95 |
| | M 3 | 2.10 | 0.50 | 3 | 60 | 0.0035 | 9095 | 29 | 95 |
| | M 4 | 2.60 | 0.70 | 3 | 60 | 0.0065 | 7345 | 51 | 145 |
| | M 5 | 3.60 | 0.80 | 3 | 60 | 0.0090 | 5305 | 41 | 145 |
| | M 6 | 4.00 | 1.00 | 3 | 60 | 0.0100 | 4775 | 48 | 145 |
| | M 8 | 5.00 | 1.25 | 3 | 60 | 0.0125 | 3820 | 54 | 145 |
| | M 10 | 5.90 | 1.50 | 5 | 60 | 0.0150 | 3235 | 100 | 245 |
| Alumínium ötvözet Si < 6% | M 12 | 7.90 | 1.75 | 5 | 60 | 0.0200 | 2420 | 82 | 240 |
| | M 16 | 9.90 | 2.00 | 5 | 60 | 0.0250 | 1930 | 92 | 240 |
| Acélöntvény GG(G) | M 1.6 | 1.00 | 0.35 | 3 | 50 | 0.0015 | 15915 | 26 | 70 |
| | M 2 | 1.30 | 0.40 | 3 | 50 | 0.0020 | 12245 | 26 | 75 |
| | M 2.5 | 1.50 | 0.45 | 3 | 50 | 0.0025 | 10610 | 32 | 80 |
| | M 3 | 2.10 | 0.50 | 3 | 50 | 0.0035 | 7580 | 24 | 80 |
| | M 4 | 2.60 | 0.70 | 3 | 50 | 0.0065 | 6120 | 42 | 120 |
| | M 5 | 3.60 | 0.80 | 3 | 50 | 0.0090 | 4420 | 34 | 120 |
| | M 6 | 4.00 | 1.00 | 3 | 50 | 0.0100 | 3980 | 40 | 120 |
| | M 8 | 5.00 | 1.25 | 3 | 50 | 0.0125 | 3185 | 45 | 120 |
| | M 10 | 5.90 | 1.50 | 5 | 50 | 0.0150 | 2700 | 84 | 205 |
| Acélöntvény GG(G) | M 12 | 7.90 | 1.75 | 5 | 50 | 0.0200 | 2015 | 68 | 200 |
| | M 16 | 9.90 | 2.00 | 5 | 50 | 0.0250 | 1610 | 76 | 200 |

# Menetmaró

1.5xd




| Rm < 850 | Rm 850-1100 | Rm 1100-1300 | Rm 1300-1500 | | | | Inox Stainless | Ti Titanium | Aluminium GG(G) |
|---|---|---|---|---|---|---|---|---|---|

Példa: **Rendelési szám** Cikkszám **EU2010** ø-Kód **.022**

| ø Code | d | P | $l_1$ | $l_2$ | $d_1$ h6 | $D_1$ | $R_k$ 6H | | UNICUT-4X EU2010 |
|---|---|---|---|---|---|---|---|---|---|
| .022* | M 1.6 | 0.35 | 38 | 2.4 | 3 | 1.0 | 0.483 | 3 | ● |
| .034* | M 2 | 0.40 | 38 | 3.2 | 3 | 1.3 | 0.630 | 3 | ● |
| .040* | M 2.5 | 0.45 | 38 | 3.6 | 3 | 1.5 | 0.728 | 3 | ● |
| .044* | M 3 | 0.50 | 38 | 4.5 | 3 | 2.1 | 1.025 | 3 | ● |
| .058* | M 4 | 0.70 | 38 | 6.3 | 3 | 2.6 | 1.265 | 3 | ● |
| .084* | M 5 | 0.80 | 42 | 8.0 | 4 | 3.6 | 1.760 | 3 | ● |
| .088 | M 6 | 1.00 | 57 | 9.0 | 6 | 4.0 | 1.950 | 3 | ● |
| .160 | M 8 | 1.25 | 57 | 12.5 | 6 | 5.0 | 2.438 | 3 | ● |
| .174 | M10 | 1.50 | 57 | 15.0 | 6 | 5.9 | 2.875 | 5 | ● |
| .240 | M12 | 1.75 | 63 | 19.2 | 8 | 7.9 | 3.863 | 5 | ● |
| .246 | M16 | 2.00 | 72 | 24.0 | 10 | 9.9 | 4.850 | 5 | ● |

* csak weldon nélkül

TM

## Alkalmazás

| Alapanyag | G | D1 [mm] | P (TPI) | z | $v_c$ [m/min] | $f_z$ [mm] | n [min⁻¹] | $v_{fc}$ $d/D_1$ 3/2 | $v_{fc}$ $d/D_1$ 2/1 | $v_{fc}$ $d/D_1$ 3/1 | $v_{fc}$ $d/D_1$ 4/1 | $v_{fc}$ $d/D_1$ > 5/1 | $v_f$ [mm/min] |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Acél < 850 N/mm² | G1/16-G1/8 | 5.90 | 28 | 5 | 30 | 0.0150 | 1620 | 40 | 60 | 80 | 90 | 96 | 120 |
| | G1/4 -G3/8 | 7.90 | 19 | 5 | 30 | 0.0200 | 1210 | 40 | 60 | 80 | 90 | 96 | 120 |
| | G1/2 -G7/8 | 11.90 | 14 | 5 | 30 | 0.0300 | 800 | 40 | 60 | 80 | 90 | 96 | 120 |
| | G1 -G3 | 15.90 | 11 | 5 | 30 | 0.0400 | 600 | 40 | 60 | 80 | 90 | 96 | 120 |
| Acél 850 - 1100 N/mm² | G1/16-G1/8 | 5.90 | 28 | 5 | 20 | 0.0150 | 1080 | 27 | 40 | 53 | 60 | 64 | 80 |
| | G1/4 -G3/8 | 7.90 | 19 | 5 | 20 | 0.0200 | 805 | 27 | 40 | 53 | 60 | 64 | 80 |
| | G1/2 -G7/8 | 11.90 | 14 | 5 | 20 | 0.0300 | 535 | 27 | 40 | 53 | 60 | 64 | 80 |
| | G1 -G3 | 15.90 | 11 | 5 | 20 | 0.0400 | 400 | 27 | 40 | 53 | 60 | 64 | 80 |
| Korrózióálló acél [Cr-Ni/1.4301] | G1/16-G1/8 | 5.90 | 28 | 5 | 25 | 0.0100 | 1350 | 23 | 35 | 47 | 53 | 56 | 70 |
| | G1/4 -G3/8 | 7.90 | 19 | 5 | 25 | 0.0130 | 1005 | 22 | 33 | 43 | 49 | 52 | 65 |
| | G1/2 -G7/8 | 11.90 | 14 | 5 | 25 | 0.0200 | 670 | 22 | 33 | 43 | 49 | 52 | 65 |
| | G1 -G3 | 15.90 | 11 | 5 | 25 | 0.0265 | 500 | 22 | 33 | 43 | 49 | 52 | 65 |
| Acélöntvény GG(G) | G1/16-G1/8 | 5.90 | 28 | 5 | 50 | 0.0150 | 2700 | 68 | 103 | 137 | 154 | 164 | 205 |
| | G1/4 -G3/8 | 7.90 | 19 | 5 | 50 | 0.0200 | 2015 | 67 | 100 | 133 | 150 | 160 | 200 |
| | G1/2 -G7/8 | 11.90 | 14 | 5 | 50 | 0.0300 | 1335 | 67 | 100 | 133 | 150 | 160 | 200 |
| | G1 -G3 | 15.90 | 11 | 5 | 50 | 0.0400 | 1000 | 67 | 100 | 133 | 150 | 160 | 200 |

| Alapanyag | G | D1 [mm] | P (TPI) | z | $v_c$ [m/min] | $f_z$ [mm] | n [min⁻¹] | $v_{fc}$ $d/D_1$ 3/2 | $v_{fc}$ $d/D_1$ 2/1 | $v_{fc}$ $d/D_1$ 3/1 | $v_{fc}$ $d/D_1$ 4/1 | $v_{fc}$ $d/D_1$ > 5/1 | $v_f$ [mm/min] |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Alumínium ötvözet Si < 6% | G1/16-G1/8 | 5.90 | 28 | 5 | 60 | 0.0150 | 3235 | 82 | 123 | 163 | 184 | 196 | 245 |
| | G1/4 -G3/8 | 7.90 | 19 | 5 | 60 | 0.0200 | 2420 | 80 | 120 | 160 | 180 | 192 | 240 |
| | G1/2 -G7/8 | 11.90 | 14 | 5 | 60 | 0.0300 | 1605 | 80 | 120 | 160 | 180 | 192 | 240 |
| | G1 -G3 | 15.90 | 11 | 5 | 60 | 0.0400 | 1200 | 80 | 120 | 160 | 180 | 192 | 240 |
| Alumínium öntvény | G1/16-G1/8 | 5.90 | 28 | 5 | 80 | 0.0150 | 4315 | 108 | 163 | 217 | 244 | 260 | 325 |
| | G1/4 -G3/8 | 7.90 | 19 | 5 | 80 | 0.0200 | 3225 | 108 | 163 | 217 | 244 | 260 | 325 |
| | G1/2 -G7/8 | 11.90 | 14 | 5 | 80 | 0.0300 | 2140 | 107 | 160 | 213 | 240 | 256 | 320 |
| | G1 -G3 | 15.90 | 11 | 5 | 80 | 0.0400 | 1600 | 107 | 160 | 213 | 240 | 256 | 320 |
| Színréz (vörös) | G1/16-G1/8 | 5.90 | 28 | 5 | 70 | 0.0150 | 3775 | 95 | 143 | 190 | 214 | 228 | 285 |
| | G1/4 -G3/8 | 7.90 | 19 | 5 | 70 | 0.0200 | 2820 | 93 | 140 | 187 | 210 | 224 | 280 |
| | G1/2 -G7/8 | 11.90 | 14 | 5 | 70 | 0.0300 | 1870 | 93 | 140 | 187 | 210 | 224 | 280 |
| | G1 -G3 | 15.90 | 11 | 5 | 70 | 0.0400 | 1400 | 93 | 140 | 187 | 210 | 224 | 280 |
| Hőre lágyuló műanyag | G1/16-G1/8 | 5.90 | 28 | 5 | 100 | 0.0150 | 5395 | 135 | 203 | 270 | 304 | 324 | 405 |
| | G1/4 -G3/8 | 7.90 | 19 | 5 | 100 | 0.0200 | 4030 | 135 | 203 | 270 | 304 | 324 | 405 |
| | G1/2 -G7/8 | 11.90 | 14 | 5 | 100 | 0.0300 | 2675 | 133 | 200 | 267 | 300 | 320 | 400 |
| | G1 -G3 | 15.90 | 11 | 5 | 100 | 0.0400 | 2000 | 133 | 200 | 267 | 300 | 320 | 400 |

# Menetmaró

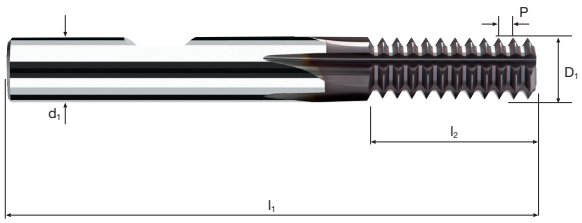
1.5xd

G

55°

HM

DIN 6535 HB




| Rm < 850 | Rm 850-1100 | Rm 1100-1300 | | | | | Inox Stainless | Ti Titanium | Aluminium GG(G) |
|---|---|---|---|---|---|---|---|---|---|

Példa:
**Rendelési szám** Cikkszám **EU2060** ø-Kód **.550**

| ø Code | d | P(TPI) | $l_1$ | $l_2$ | $d_1$ h6 | $D_1$ | | UNICUT-4X EU2060 |
|---|---|---|---|---|---|---|---|---|
| .550 | G 1/16 - G1/8 | 28 | 57 | 14.5 | 6 | 5.9 | 5 | ● |
| .552 | G 1/4 - G3/8 | 19 | 63 | 18.7 | 8 | 7.9 | 5 | ● |
| .554 | G 1/2 - G7/8 | 14 | 83 | 29.0 | 12 | 11.9 | 5 | ● |
| .558 | G1" - G3" | 11 | 92 | 34.6 | 16 | 15.9 | 6 | ● |

TM

## Alkalmazás

| Alapanyag | UNC | UNF | D1 [mm] | P (TPI) | z | $v_c$ [m/min] | $f_z$ [mm] | n [min⁻¹] | $v_{fc}$ $d/D_1$ 3/2 | $v_{fc}$ $d/D_1$ 2/1 | $v_{fc}$ $d/D_1$ 3/1 | $v_{fc}$ $d/D_1$ 4/1 | $v_{fc}$ $d/D_1$ > 5/1 | $v_f$ [mm/min] |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Acél < 850 N/mm² | 2 | 3 | 1.50 | 56 | 3 | 30 | 0.0025 | 6365 | 17 | 25 | 33 | 38 | 40 | 50 |
| | 3 | 4 | 1.50 | 48 | 3 | 30 | 0.0025 | 6365 | 17 | 25 | 33 | 38 | 40 | 50 |
| | 4-5 | 6 | 2.10 | 40 | 3 | 30 | 0.0035 | 4545 | 17 | 25 | 33 | 38 | 40 | 50 |
| | 8 | 10 | 3.00 | 32 | 3 | 30 | 0.0050 | 3185 | 17 | 25 | 33 | 38 | 40 | 50 |
| | 12 | 5/16-3/8 | 4.00 | 24 | 3 | 30 | 0.0065 | 2385 | 15 | 23 | 30 | 34 | 36 | 45 |
| | 1/4 | 7/16-1/2 | 4.00 | 20 | 3 | 30 | 0.0065 | 2385 | 15 | 23 | 30 | 34 | 36 | 45 |
| | 5/16 | 9/16-5/8 | 5.00 | 18 | 3 | 30 | 0.0085 | 1910 | 17 | 25 | 33 | 38 | 40 | 50 |
| | 3/8 | 3/4 | 5.90 | 16 | 5 | 30 | 0.0100 | 1620 | 27 | 40 | 53 | 60 | 64 | 80 |
| | 7/16 | 7/8 | 7.90 | 14 | 5 | 30 | 0.0130 | 1210 | 27 | 40 | 53 | 60 | 64 | 80 |
| Acél < 850 N/mm² | 1/2 | | 7.90 | 13 | 5 | 30 | 0.0130 | 1210 | 27 | 40 | 53 | 60 | 64 | 80 |
| | 9/16 | 1- 1 1/2 | 9.90 | 12 | 5 | 30 | 0.0165 | 965 | 27 | 40 | 53 | 60 | 64 | 80 |
| | 5/8 | | 9.90 | 11 | 5 | 30 | 0.0165 | 965 | 27 | 40 | 53 | 60 | 64 | 80 |
| Acél 850 - 1100 N/mm² | 2 | 3 | 1.50 | 56 | 3 | 20 | 0.0025 | 4245 | 10 | 15 | 20 | 23 | 24 | 30 |
| | 3 | 4 | 1.50 | 48 | 3 | 20 | 0.0025 | 4245 | 10 | 15 | 20 | 23 | 24 | 30 |
| | 4-5 | 6 | 2.10 | 40 | 3 | 20 | 0.0035 | 3030 | 10 | 15 | 20 | 23 | 24 | 30 |
| | 8 | 10 | 3.00 | 32 | 3 | 20 | 0.0050 | 2120 | 10 | 15 | 20 | 23 | 24 | 30 |
| | 12 | 5/16-3/8 | 4.00 | 24 | 3 | 20 | 0.0065 | 1590 | 10 | 15 | 20 | 23 | 24 | 30 |
| | 1/4 | 7/16-1/2 | 4.00 | 20 | 3 | 20 | 0.0065 | 1590 | 10 | 15 | 20 | 23 | 24 | 30 |
| | 5/16 | 9/16-5/8 | 5.00 | 18 | 3 | 20 | 0.0085 | 1275 | 12 | 18 | 23 | 26 | 28 | 35 |
| | 3/8 | 3/4 | 5.90 | 16 | 5 | 20 | 0.0100 | 1080 | 18 | 28 | 37 | 41 | 44 | 55 |
| | 7/16 | 7/8 | 7.90 | 14 | 5 | 20 | 0.0130 | 805 | 17 | 25 | 33 | 38 | 40 | 50 |
| Acél 850 - 1100 N/mm² | 1/2 | | 7.90 | 13 | 5 | 20 | 0.0130 | 805 | 17 | 25 | 33 | 38 | 40 | 50 |
| | 9/16 | 1- 1 1/2 | 9.90 | 12 | 5 | 20 | 0.0165 | 645 | 18 | 28 | 37 | 41 | 44 | 55 |
| | 5/8 | | 9.90 | 11 | 5 | 20 | 0.0165 | 645 | 18 | 28 | 37 | 41 | 44 | 55 |

| Alapanyag | UNC | UNF | D1 [mm] | P (TPI) | z | $v_c$ [m/min] | $f_z$ [mm] | n [min⁻¹] | $v_{fc}$ $d/D_1$ 3/2 | $v_{fc}$ $d/D_1$ 2/1 | $v_{fc}$ $d/D_1$ 3/1 | $v_{fc}$ $d/D_1$ 4/1 | $v_{fc}$ $d/D_1$ > 5/1 | $v_f$ [mm/min] |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Alumínium ötvözet Si < 6% | 2 | 3 | 1.50 | 56 | 3 | 50 | 0.0025 | 10610 | 27 | 40 | 53 | 60 | 64 | 80 |
| | 3 | 4 | 1.50 | 48 | 3 | 50 | 0.0025 | 10610 | 27 | 40 | 53 | 60 | 64 | 80 |
| | 4-5 | 6 | 2.10 | 40 | 3 | 50 | 0.0035 | 7580 | 27 | 40 | 53 | 60 | 64 | 80 |
| | 8 | 10 | 3.00 | 32 | 3 | 50 | 0.0050 | 5305 | 27 | 40 | 53 | 60 | 64 | 80 |
| | 12 | 5/16-3/8 | 4.00 | 24 | 3 | 50 | 0.0065 | 3980 | 27 | 40 | 53 | 60 | 64 | 80 |
| | 1/4 | 7/16-1/2 | 4.00 | 20 | 3 | 50 | 0.0065 | 3980 | 27 | 40 | 53 | 60 | 64 | 80 |
| | 5/16 | 9/16-5/8 | 5.00 | 18 | 3 | 50 | 0.0085 | 3185 | 27 | 40 | 53 | 60 | 64 | 80 |
| | 3/8 | 3/4 | 5.90 | 16 | 5 | 50 | 0.0100 | 2700 | 45 | 68 | 90 | 101 | 108 | 135 |
| | 7/16 | 7/8 | 7.90 | 14 | 5 | 50 | 0.0130 | 2015 | 43 | 65 | 87 | 98 | 104 | 130 |
| Alumínium ötvözet Si < 6% | 1/2 | | 7.90 | 13 | 5 | 50 | 0.0130 | 2015 | 43 | 65 | 87 | 98 | 104 | 130 |
| | 9/16 | 1- 1 1/2 | 9.90 | 12 | 5 | 50 | 0.0165 | 1610 | 45 | 68 | 90 | 101 | 108 | 135 |
| | 5/8 | | 9.90 | 11 | 5 | 50 | 0.0165 | 1610 | 45 | 68 | 90 | 101 | 108 | 135 |
| Acélöntvény GG(G) | 2 | 3 | 1.50 | 56 | 3 | 40 | 0.0025 | 8490 | 22 | 33 | 43 | 49 | 52 | 65 |
| | 3 | 4 | 1.50 | 48 | 3 | 40 | 0.0025 | 8490 | 22 | 33 | 43 | 49 | 52 | 65 |
| | 4-5 | 6 | 2.10 | 40 | 3 | 40 | 0.0035 | 6065 | 22 | 33 | 43 | 49 | 52 | 65 |
| | 8 | 10 | 3.00 | 32 | 3 | 40 | 0.0050 | 4245 | 22 | 33 | 43 | 49 | 52 | 65 |
| | 12 | 5/16-3/8 | 4.00 | 24 | 3 | 40 | 0.0065 | 3185 | 20 | 30 | 40 | 45 | 48 | 60 |
| | 1/4 | 7/16-1/2 | 4.00 | 20 | 3 | 40 | 0.0065 | 3185 | 20 | 30 | 40 | 45 | 48 | 60 |
| | 5/16 | 9/16-5/8 | 5.00 | 18 | 3 | 40 | 0.0085 | 2545 | 22 | 33 | 43 | 49 | 52 | 65 |
| | 3/8 | 3/4 | 5.90 | 16 | 5 | 40 | 0.0100 | 2160 | 37 | 55 | 73 | 83 | 88 | 110 |
| | 7/16 | 7/8 | 7.90 | 14 | 5 | 40 | 0.0130 | 1610 | 35 | 53 | 70 | 79 | 84 | 105 |
| Acélöntvény GG(G) | 1/2 | | 7.90 | 12 | 5 | 40 | 0.0130 | 1610 | 35 | 53 | 70 | 79 | 84 | 105 |
| | 9/16 | 1- 1 1/2 | 9.90 | 12 | 5 | 40 | 0.0165 | 1285 | 35 | 53 | 70 | 79 | 84 | 105 |
| | 5/8 | | 9.90 | 11 | 5 | 40 | 0.0165 | 1285 | 35 | 53 | 70 | 79 | 84 | 105 |

# Menetmaró

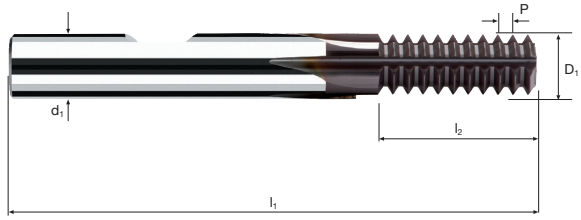
1.5xd

UN

60°

HM

DIN 6535 HB




| Rm < 850 | Rm 850-1100 | Rm 1100-1300 | | | | | Inox Stainless | Ti Titanium | Aluminium GG(G) |
|---|---|---|---|---|---|---|---|---|---|

Példa: **Rendelési szám** Cikkszám **EU2110** ø-Kód **.750**

| ø Code | UNC | UNF | P(TPI) | l1 | l2 | d1 h6 | D1 | | UNICUT-4X EU2110 |
|---|---|---|---|---|---|---|---|---|---|
| .750* | | Nr. 2 | 64 | 38 | 3.1 | 3 | 1.5 | 3 | ● |
| .751* | Nr. 2 | Nr. 3 | 56 | 38 | 3.1 | 3 | 1.5 | 3 | ● |
| .752* | Nr. 3 | Nr. 4 | 48 | 38 | 3.7 | 3 | 1.5 | 3 | ● |
| .753* | | Nr. 5 | 44 | 38 | 4.6 | 3 | 2.1 | 3 | ● |
| .754* | Nr. 4 - 5 | Nr. 6 | 40 | 38 | 4.4 | 3 | 2.1 | 3 | ● |
| .755* | | Nr. 8 | 36 | 42 | 6.3 | 4 | 3.0 | 3 | ● |
| .756* | Nr. 8 | Nr. 10 | 32 | 42 | 6.3 | 4 | 3.0 | 3 | ● |
| .759* | | Nr. 12 - 1/4 | 28 | 42 | 8.1 | 4 | 3.6 | 3 | ● |
| .761 | Nr. 12 | 5/16 - 3/8 | 24 | 57 | 8.4 | 6 | 4.0 | 3 | ● |
| .762 | 1/4 | 7/16 - 1/2 | 20 | 57 | 10.1 | 6 | 4.0 | 3 | ● |
| .764 | 5/16 | 9/16 - 5/8 | 18 | 57 | 12.7 | 6 | 5.0 | 3 | ● |
| .766 | 3/8 | 3/4 | 16 | 57 | 14.2 | 6 | 5.9 | 5 | ● |
| .769 | 7/16 | 7/8 | 14 | 63 | 16.3 | 8 | 7.9 | 5 | ● |
| .770 | 1/2 | | 13 | 63 | 19.5 | 8 | 7.9 | 5 | ● |
| .771 | 9/16 | 1" - 1 1/2 | 12 | 72 | 23.2 | 10 | 9.9 | 5 | ● |
| .773 | 5/8 | | 11 | 72 | 23.0 | 10 | 9.9 | 5 | ● |

* csak weldon nélkül

TM

## Alkalmazás

| Alapanyag | NPT / NPTF | D1 [mm] | P (TPI) | z | $v_c$ [m/min] | $f_z$ [mm] | n [min⁻¹] | $v_{fc}$ d/$D_1$ 3/2 | $v_{fc}$ d/$D_1$ 2/1 | $v_{fc}$ d/$D_1$ 3/1 | $v_{fc}$ d/$D_1$ 4/1 | $v_{fc}$ d/$D_1$ > 5/1 | $v_f$ [mm/min] |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Acél < 850 N/mm² | 1/16 - 1/8 | 5.90 | 27 | 5 | 30 | 0.0100 | 1620 | 27 | 40 | 53 | 60 | 64 | 80 |
| | 1/4 - 3/8 | 7.90 | 18 | 5 | 30 | 0.0130 | 1210 | 27 | 40 | 53 | 60 | 64 | 80 |
| | 1/2 - 3/4 | 11.90 | 14 | 5 | 30 | 0.0200 | 800 | 27 | 40 | 53 | 60 | 64 | 80 |
| | 1 - 2 | 15.90 | 12 | 6 | 30 | 0.0265 | 600 | 32 | 48 | 63 | 71 | 76 | 95 |
| Acél 850 - 1100 N/mm² | 1/16 - 1/8 | 5.90 | 27 | 5 | 20 | 0.0100 | 1080 | 18 | 28 | 37 | 41 | 44 | 55 |
| | 1/4 - 3/8 | 7.90 | 18 | 5 | 20 | 0.0130 | 805 | 17 | 25 | 33 | 38 | 40 | 50 |
| | 1/2 - 3/4 | 11.90 | 14 | 5 | 20 | 0.0200 | 535 | 18 | 28 | 37 | 41 | 44 | 55 |
| | 1 - 2 | 15.90 | 12 | 6 | 20 | 0.0265 | 400 | 22 | 33 | 43 | 49 | 52 | 65 |
| Korrózióálló acél [Cr-Ni/1.4301] | 1/16 - 1/8 | 5.90 | 27 | 5 | 15 | 0.0100 | 810 | 13 | 20 | 27 | 30 | 32 | 40 |
| | 1/4 - 3/8 | 7.90 | 18 | 5 | 15 | 0.0130 | 605 | 13 | 20 | 27 | 30 | 32 | 40 |
| | 1/2 - 3/4 | 11.90 | 14 | 5 | 15 | 0.0200 | 400 | 13 | 20 | 27 | 30 | 32 | 40 |
| | 1 - 2 | 15.90 | 12 | 6 | 15 | 0.0265 | 300 | 17 | 25 | 33 | 38 | 40 | 50 |
| Acélöntvény GG(G) | 1/16 - 1/8 | 5.90 | 27 | 5 | 40 | 0.0100 | 2160 | 37 | 55 | 73 | 83 | 88 | 110 |
| | 1/4 - 3/8 | 7.90 | 18 | 5 | 40 | 0.0130 | 1610 | 35 | 53 | 70 | 79 | 84 | 105 |
| | 1/2 - 3/4 | 11.90 | 14 | 5 | 40 | 0.0200 | 1070 | 35 | 53 | 70 | 79 | 84 | 105 |
| | 1 - 2 | 15.90 | 12 | 6 | 40 | 0.0265 | 800 | 42 | 63 | 83 | 94 | 100 | 125 |

| Alapanyag | NPT / NPTF | D1 [mm] | P (TPI) | z | $v_c$ [m/min] | $f_z$ [mm] | n [min⁻¹] | $v_{fc}$ d/$D_1$ 3/2 | $v_{fc}$ d/$D_1$ 2/1 | $v_{fc}$ d/$D_1$ 3/1 | $v_{fc}$ d/$D_1$ 4/1 | $v_{fc}$ d/$D_1$ > 5/1 | $v_f$ [mm/min] |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Alumínium ötvözet Si < 6% | 1/16 - 1/8 | 5.90 | 27 | 5 | 50 | 0.0100 | 2700 | 45 | 68 | 90 | 101 | 108 | 135 |
| | 1/4 - 3/8 | 7.90 | 18 | 5 | 50 | 0.0130 | 2015 | 43 | 65 | 87 | 98 | 104 | 130 |
| | 1/2 - 3/4 | 11.90 | 14 | 5 | 50 | 0.0200 | 1335 | 45 | 68 | 90 | 101 | 108 | 135 |
| | 1 - 2 | 15.90 | 12 | 6 | 50 | 0.0265 | 1000 | 53 | 80 | 107 | 120 | 128 | 160 |
| Alumínium öntvény | 1/16 - 1/8 | 5.90 | 27 | 5 | 60 | 0.0100 | 3235 | 53 | 80 | 107 | 120 | 128 | 160 |
| | 1/4 - 3/8 | 7.90 | 18 | 5 | 60 | 0.0130 | 2420 | 52 | 78 | 103 | 116 | 124 | 155 |
| | 1/2 - 3/4 | 11.90 | 14 | 5 | 60 | 0.0200 | 1605 | 53 | 80 | 107 | 120 | 128 | 160 |
| | 1 - 2 | 15.90 | 12 | 6 | 60 | 0.0265 | 1200 | 63 | 95 | 127 | 143 | 152 | 190 |
| Színréz (vörös) | 1/16 - 1/8 | 5.90 | 27 | 5 | 70 | 0.0100 | 3775 | 63 | 95 | 127 | 143 | 152 | 190 |
| | 1/4 - 3/8 | 7.90 | 18 | 5 | 70 | 0.0130 | 2820 | 62 | 93 | 123 | 139 | 148 | 185 |
| | 1/2 - 3/4 | 11.90 | 14 | 5 | 70 | 0.0200 | 1870 | 62 | 93 | 123 | 139 | 148 | 185 |
| | 1 - 2 | 15.90 | 12 | 6 | 70 | 0.0265 | 1400 | 75 | 113 | 150 | 169 | 180 | 225 |
| Hőre lágyuló műanyag | 1/16 - 1/8 | 5.90 | 27 | 5 | 90 | 0.0100 | 4855 | 82 | 123 | 163 | 184 | 196 | 245 |
| | 1/4 - 3/8 | 7.90 | 18 | 5 | 90 | 0.0130 | 3625 | 78 | 118 | 157 | 176 | 188 | 235 |
| | 1/2 - 3/4 | 11.90 | 14 | 5 | 90 | 0.0200 | 2405 | 80 | 120 | 160 | 180 | 192 | 240 |
| | 1 - 2 | 15.90 | 12 | 6 | 90 | 0.0265 | 1800 | 95 | 143 | 190 | 214 | 228 | 285 |

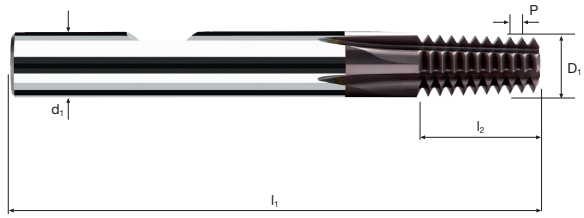
# Menetmaró

NPT
NPTF

60°
h
1 : 16

HM

DIN 6535 HB




| Rm < 850 | Rm 850-1100 | Rm 1100-1300 | | | | | Inox Stainless | Ti Titanium | Aluminium GG(G) |
|---|---|---|---|---|---|---|---|---|---|

Példa:
Rendelési szám **EU2200** (Cikkszám) **.840** (ø-Kód)

| ø Code | d | P(TPI) | l1 | l2 | d1 h6 | D1 | | UNICUT-4X EU2200 |
|---|---|---|---|---|---|---|---|---|
| .840 | NPT 1/16 - 1/8 | 27 | 57 | 9.4 | 6 | 5.9 | 5 | ● |
| .842 | NPT 1/4 - 3/8 | 18 | 63 | 14.1 | 8 | 7.9 | 5 | ● |
| .844 | NPT 1/2 - 3/4 | 14 | 83 | 19.9 | 12 | 11.9 | 5 | ● |
| .846 | NPT 1" - 2" | 11.5 | 92 | 26.5 | 16 | 15.9 | 6 | ● |

Példa:
Rendelési szám **EU2210** (Cikkszám) **.840** (ø-Kód)

| ø Code | d | P(TPI) | l1 | l2 | d1 h6 | D1 | | UNICUT-4X EU2210 |
|---|---|---|---|---|---|---|---|---|
| .840 | NPTF 1/16 - 1/8 | 27 | 57 | 9.4 | 6 | 5.9 | 5 | ● |
| .842 | NPTF 1/4 - 3/8 | 18 | 63 | 14.1 | 8 | 7.9 | 5 | ● |
| .844 | NPTF 1/2 - 3/4 | 14 | 83 | 19.9 | 12 | 11.9 | 5 | ● |
| .846 | NPTF 1" - 2" | 11.5 | 92 | 26.5 | 16 | 15.9 | 6 | ● |

TM