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	M	23 / 27	23 / 27	23 / 27	17 / 20	17 / 20	23 / 27	27	23 / 27	24 / 28	24 / 28	18 / 21	18 / 21	24 / 28	24 / 28	18 / 21
	MF	50 / 52	50 / 52	50 / 52	46 / 49		51 / 53	53	51 / 53							
	UNC															
	UNF															
	G		69													
	Rp															
	Rc															
	BSW															
	BSF															
	NPT															
	Pg															
	Tr															
НАИМЕНОВАНИЕ Name Bezeichnung	INOX	INOX	INOX	FAN	FAN	FAN	FAN	FAN	FAN	FAN	Ti	Ti	Ti	Ti	Ni	
ИСПОЛНЕНИЕ Execution Ausführung	R40	R40	R40	B	B IKR	R15	R15 LF IK	R40	R45	R45 IK	B	B	R15	R15	B	
МАТЕРИАЛ Material Werkstoff	HSSE	HSSE	HSSE	HSSE-PM	HSSE-PM	HSSE-PM	HSSE	HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM	
ПОКРЫТИЕ Coating Beschichtung	OX	TIN	HL	TICN	HL	TICN	HL	TICN	TICN	HL	OX	TICN	OX	TICN		
СБЕГ РЕЗЬБЫ Chamfer Anschnitt	C / 2-3P	C / 2-3P	C / 2-3P	B / 4-5P	B / 4-5P	C / 2-3P	C / 2-3P	C / 2-3P	E / 1,5-2P	E / 1,5-2P	B / 4-5P	B / 4-5P	C / 2-3P	C / 2-3P	B / 4-5P	
ТИП ОТВЕРСТИЯ Hole type Lochform																
ОХЛАЖДЕНИЕ Coolant Kühlmittel	E/O/P	E/O/P	E/O/P	E/O/P	E/O	E/O/P	E/O	E/O/P	E/O/P	E/O	E/O/P	E/O/P	E/O/P	E/O/P	O/P	

Vc [m/min]

ГРУППЫ ОБРАБАТЫВАЕМЫХ МАТЕРИАЛОВ / Material group / Werkstoffgruppe

Группа	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	
P																
1.1																
1.2																
1.3				10-25	10-30		10-25		25-35	30-40						
1.4	6-15	6-15	6-15	10-25	10-30	10-25	10-25	10-25	20-30	25-35						
1.5				5-15	5-15	5-15	5-15	5-15	5-15	5-15						
1.6					5-10		5-10				1-5	1-5	1-5	1-5	1-5	
M																
2.1	5-12	8-20	8-20	5-15	5-20	5-15		5-15	5-15	5-15						
2.2	5-12	8-20	8-20	5-12	5-12											
2.3		5-12	5-12	4-10	4-10	4-10		4-10	4-10	4-10	2-8	4-10	2-8	4-10		
K																
3.1			10-20			15-25	15-25									
3.2	6-15	10-20	10-20	10-20	10-20	10-20	10-20	10-20	10-20	10-20						
3.3	6-15	10-20	10-20	10-20	10-20	10-20	10-20	10-20	10-20	10-20						
N																
4.1			15-25													
4.2		15-25	15-25				10-20	10-20	20-30	30-40						
4.3		15-25	15-25				10-20	10-20	20-30	30-40						
4.4		10-20	10-20	10-20	10-20			10-20	20-30	30-40						
4.5		10-20	10-20	10-20	10-20	10-20		10-20	20-30	30-40						
4.6				10-20	10-20											
4.7		10-20		10-20	10-20	10-20		10-20	20-30	30-40	5-15	10-20	5-15	10-20		
4.8		10-20				10-20		10-20	20-30	30-40	5-15	10-20	5-15	10-20		
4.9						10-20										
4.10							25-35								25-35	
4.11																
4.12		10-15									10-20			10-20		
4.13											10-20			10-20		
S																
5.1											2-8		2-8			
5.2											1-6	1-6	1-6	1-6		
5.3			5-12									2-8		2-8		
5.4																1-5
H																
6.1																
6.2																
6.3																
6.4																