



Стандарт Norm Norma	DIN-371 / DIN-376 DIN-371 / DIN-374														
M	30 / 31	30 / 31	30 / 31	30 / 31	32	32 / 33	32 / 33	32	32	32	32	34 / 35	34 / 35	34 / 35	34 / 35
MF							54								
UNC							62								
UNF							66								
G							70								
Rp															
Rc															
BSW															
BSF															
NPT															
Pg															
Tr															
НАИМЕНОВАНИЕ Name Bezeichnung	S-NC	S-NC	S-NC	S-NC	WGA	WGN	WGN	WGN	WGN	WGN	WGC	HRC60	GAL	WGN	WGN
ИСПОЛНЕНИЕ Execution Ausführung	B	B IKR	R45	R45 IK	SR		SR	SR	SR	SR IK	SR IKR	IK	R15 IK	SR IK	SR IKR
МАТЕРИАЛ Material Werkstoff	HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM	HSS/PM	HSSE/PM	HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM	VHM	VHM	VHM	VHM
ПОКРЫТИЕ Coating Beschichtung	TiCN	HL	TiCN	HL	TiN	TiN	TiN	TiCN	TiCN	TiCN	TiCN	TiCN	TiCN	HL	HL
СБЕГ РЕЗЬБЫ Chamfer Anschnitt	B / 4-5P	B / 4-5P	C / 2-3P	E / 1,5-2P	C / 2-3P	C / 2-3P	C / 2-3P	C / 2-3P	E / 1,5-2P	E / 1,5-2P	C / 2-3P	D / 4-5P	C / 2-3P	C / 2-3P	C / 2-3P
ТИП ОТВЕРСТИЯ Hole type Lochform															
ОХЛАЖДЕНИЕ Coolant Kühlmittel	E/O/P	E/O	E/O/P	E/O	E/O	E/O	E/O	E/O	E/O	E/O	E/O	E/O	E/O	E/O	E/O

Vc [m/min]

P															
1.1	20-50	25-60	20-50	25-60	20-40	10-30	20-40	20-50	20-50	20-50				25-60	25-60
1.2	20-50	25-60	20-50	25-60	10-30	10-30	20-40	20-50	20-50	20-50				25-60	25-60
1.3	15-40	20-45	15-40	20-45	10-30	10-30	15-30	15-40	15-40	15-40				25-60	25-60
1.4	15-30	15-35	15-30	15-35				10-25	10-25	10-25	10-25				
1.5	10-20	10-20	10-20	10-20											
1.6															
M															
2.1	5-15	5-15	5-15	5-15	10-25	10-25	10-25	10-25	10-25	10-25				10-25	10-25
2.2	5-15	5-15	5-15	5-15	10-25	10-25	10-25	10-25	10-25	10-25				10-25	10-25
2.3	5-15	5-15	5-15	5-15	10-25	10-25	10-25	10-25	10-25	10-25				10-25	10-25
K															
3.1				15-25									30-70		
3.2	15-25	15-25	15-25	15-25											
3.3	15-25	15-25	15-25	15-25											
N															
4.1					20-40	20-40	20-40	20-40	20-40	20-40				20-60	20-60
4.2	20-35	30-40	20-35	30-40	20-40	20-40	20-40	20-40	20-40	20-40			30-70	20-60	20-60
4.3							20-40	20-40	20-40	20-40	20-40		30-70	20-60	20-60
4.4	20-35	30-40	20-30	30-40	20-40	20-40	20-40	20-40	20-40	20-40				20-60	20-60
4.5	20-35	30-40	20-30	30-40	20-40	20-40	20-40	20-40	20-40	20-40				20-60	20-60
4.6													30-70		
4.7	20-35		20-30												
4.8	20-35		20-30												
4.9															
4.10													50-70		
4.11															
4.12															
4.13													5-20		
S															
5.1					10-20	10-20	10-20	10-20	10-20	10-20				10-25	10-25
5.2															
5.3															
5.4															
H															
6.1													1-4		
6.2													1-4		
6.3													1-4		
6.4															

ГРУППЫ ОБРАБАТЫВАЕМЫХ МАТЕРИАЛОВ / Material group / Werkstoffgruppe