

| Gwint metryczny ISO DIN-13   |      |                |                |                |                 |     |      |         |       | GG   |           |           |           |           | GAL       |             |     |
|------------------------------|------|----------------|----------------|----------------|-----------------|-----|------|---------|-------|--|-----------|-----------|-----------|-----------|-----------|-------------|-----|
|                              |      |                |                |                |                 |     |      |         |       | C-TS   | C-IK-TS   | E-TS      | E-IK-TS   | E-IKR-TS  | C-R15-TS  | E-R15-IK-TS |     |
|                              |      |                |                |                |                 |     |      |         |       |  |           |           |           |           |           |             |     |
|                              |      |                |                |                |                 |     |      |         |       |  |           |           |           |           |           |             |     |
| Rodzaj materiału obrabianego |      |                |                |                |                 |     |      |         |       |  |           |           |           |           |           |             |     |
| Typ otworu                   |      |                |                |                |                 |     |      |         |       |  |           |           |           |           |           |             |     |
| Rodzaj materiału             |      |                |                |                |                 |     |      |         |       | HSSE-PM HSSE-PM HSSE-PM HSSE-PM HSSE-PM HSSE-PM HSSE-PM                |           |           |           |           |           |             |     |
| Rodzaj powłoki               |      |                |                |                |                 |     |      |         |       | TS TS TS TS TS TS TS   |           |           |           |           |           |             |     |
| Nakrój                       |      |                |                |                |                 |     |      |         |       | C / 2-3P C / 2-3P E / 1,5-2P E / 1,5-2P E / 1,5-2P C / 2-3P E / 1,5-2P |           |           |           |           |           |             |     |
| M<br>Ød <sub>1</sub>         | P    | l <sub>1</sub> | l <sub>2</sub> | l <sub>3</sub> | Ød <sub>2</sub> | a   |      | Norma   |       |  |           |           |           |           |           |             |     |
|                              |      |                |                |                |                 |     |      | DIN-371 |       |  |           |           |           |           |           | 6HX         | 6HX |
|                              |      |                |                |                |                 |     |      |         | Tol.  | 6HX  | 6HX       | 6HX       | 6HX       | 6HX       | 6HX       | 6HX         | 6HX |
|                              |      |                |                |                |                 |     |      |         | INDEX | C2-125501  | C4-125551 | C2-145501 | C4-145551 | C4-145561 | C2-505601 | C4-655651   |     |
| M 3                          | 0,50 | 56             | 10             | 18             | 3,5             | 2,7 | 2,50 | 0030    | ●     | -  | ○         | -         | -         | ●         | -         |             |     |
| M 4                          | 0,70 | 63             | 12             | 21             | 4,5             | 3,4 | 3,30 | 0040    | ●     | -  | ●         | -         | -         | ●         | -         |             |     |
| M 5                          | 0,80 | 70             | 14             | 25             | 6,0             | 4,9 | 4,20 | 0050    | ●     | ●  | ●         | ●         | ●         | ●         | ○         |             |     |
| M 6                          | 1,00 | 80             | 18             | 30             | 6,0             | 4,9 | 5,00 | 0060    | ●     | ●  | ●         | ●         | ●         | ●         | ○         |             |     |
| M 7                          | 1,00 | 80             | 18             | 30             | 7,0             | 5,5 | 6,00 | 0070    | ○     | ○  | ○         | ○         | ○         | ○         | ○         |             |     |
| M 8                          | 1,25 | 90             | 20             | 35             | 8,0             | 6,2 | 6,80 | 0080    | ●     | ●  | ●         | ●         | ●         | ●         | ○         |             |     |
| M 9                          | 1,25 | 90             | 20             | 35             | 9,0             | 7,0 | 7,80 | 0090    | ○     | ○  | ○         | ○         | ○         | ○         | ○         |             |     |
| M10                          | 1,50 | 100            | 20             | 39             | 10,0            | 8,0 | 8,50 | 0100    | ●     | ●  | ●         | ●         | ●         | ●         | ○         |             |     |

  

| M<br>Ød <sub>1</sub> | P    | l <sub>1</sub> | l <sub>2</sub> | l <sub>3</sub> | Ød <sub>2</sub> | a    |       | Norma   |           |           |           |           |           |           |           |
|----------------------|------|----------------|----------------|----------------|-----------------|------|-------|---------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|
|                      |      |                |                |                |                 |      |       | DIN-376 |           |           |           |           |           |           | 6HX       |
|                      |      |                |                |                |                 |      |       | Tol.    | 6HX       | 6HX       | 6HX       | 6HX       | 6HX       | 6HX       | 6HX       |
|                      |      |                |                |                |                 |      |       | INDEX   | D2-125501 | D4-125551 | D2-145501 | D4-145551 | D4-145561 | D2-505601 | D4-655651 |
| M6                   | 1,00 | 80             | 18             | -              | 4,5             | 3,4  | 5,00  | 0060    | ●         | ○         | ●         | ○         | ○         | ●         | ○         |
| M8                   | 1,25 | 90             | 20             | -              | 6,0             | 4,9  | 6,80  | 0080    | ●         | ●         | ●         | ●         | ○         | ●         | ○         |
| M10                  | 1,50 | 100            | 20             | -              | 7,0             | 5,5  | 8,50  | 0100    | ●         | ●         | ●         | ●         | ○         | ●         | ○         |
| M12                  | 1,75 | 110            | 24             | -              | 9,0             | 7,0  | 10,20 | 0120    | ●         | ●         | ●         | ●         | ●         | ●         | ●         |
| M14                  | 2,00 | 110            | 25             | -              | 11,0            | 9,0  | 12,00 | 0140    | ●         | ○         | ○         | ○         | ○         | ●         | ○         |
| M16                  | 2,00 | 110            | 32             | -              | 12,0            | 9,0  | 14,00 | 0160    | ●         | ●         | ○         | ●         | ●         | ●         | ●         |
| M18                  | 2,50 | 125            | 32             | -              | 14,0            | 11,0 | 15,50 | 0180    | ●         | ○         | ○         | ○         | ○         | ●         | ○         |
| M20                  | 2,50 | 140            | 32             | -              | 16,0            | 12,0 | 17,50 | 0200    | ●         | ○         | ○         | ○         | ○         | ●         | ○         |

  

| ISO | Vc (m/min) |      |      |      |      |       |       |
|-----|------------|------|------|------|------|-------|-------|
| P   | -          | -    | -    | -    | -    | -     | -     |
| M   | -          | -    | -    | -    | -    | -     | -     |
| K   | 1-60       | 5-60 | 1-60 | 5-60 | 5-60 | -     | -     |
| N   | -          | -    | -    | -    | -    | 10-30 | 10-30 |
| S   | -          | -    | -    | -    | -    | -     | -     |