# SÚSTRUŽENIE ZÁVITOV

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## SÚSTRUŽENIE – VŠEOBECNÝ OBSAH

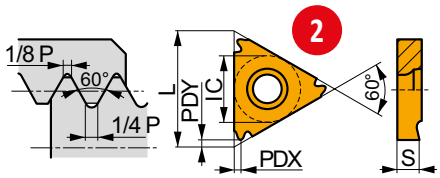

| | | |
|---|---|---|
| 6 | | WMG A ISO 13399 |
| 10 | ISO SÚSTRUŽENIE | INŠTRUKCIE |
| 18 | | SPRIEVODCOVIA |
| 57 | | POZITÍVNE DOŠTIČKY |
| 219 | | NEGATÍVNE DOŠTIČKY |
| 386 | | UPICHOVANIE A ZAPICHOVANIE |
| **482** | | **SÚSTRUŽENIE ZÁVITOV** |
| 528 | | OBRÁŽANIE |
| 536 | | VŠEOBECNÉ TECHNICKÉ INFORMÁCIE |

## 1 TN M INT

PRAMET

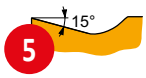
| | IC [mm] | L [mm] | S [mm] |
|---|---|---|---|
| 11 | 6.350 | 11.00 | 3.00 |
| 16 | 9.525 | 16.50 | 3.47 |
| 22 | 12.700 | 22.00 | 4.71 |

3




Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

4




5

1 U E 6

10 TN M NR vnútorné pravostranné prevedenie pre obrábanie ISO Metrických závitov a plynulý rez.

| Product | | RE [mm] | P vc [m/min] | M vc [m/min] | K vc [m/min] | N vc [m/min] | S vc [m/min] | H vc [m/min] | TP [mm] | TPI | PDX [mm] | PDY [mm] |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| TN 11NR050M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 0.50 | – | 0.8 | 0.8 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 0.50 | – | 0.8 | 0.8 |
| TN 1[illegible]75M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 0.75 | – | 0.8 | 0.8 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 0.75 | – | 0.8 | 0.8 |
| TN 11NR100M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 1.00 | – | 0.8 | 0.8 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.00 | – | 0.8 | 0.8 |
| TN 11NR125M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 1.25 | – | 0.8 | 0.8 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.25 | – | 0.8 | 0.8 |
| TN 11NR150M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 1.50 | – | 0.8 | 0.8 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.50 | – | 0.8 | 0.8 |
| TN 11NR200M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 2.00 | – | 0.9 | 0.8 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 2.00 | – | 0.9 | 0.8 |
| TN 16NR050M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 0.50 | – | 0.8 | 0.8 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 0.50 | – | 0.8 | 0.8 |
| TN 16NR075M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 0.75 | – | 0.8 | 0.8 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 0.75 | – | 0.8 | 0.8 |
| TN 16NR100M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 1.00 | – | 0.8 | 0.8 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.00 | – | 0.8 | 0.8 |
| TN 16NR125M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 1.25 | – | 0.8 | 0.8 |

7 8 9 11

**TN 16NR075M:T8010** Pri objednávke použite celý kód špecifikácie doštičky!

- Materiál
- Obsahuje dvojbodku
- ISO kód doštičky

Typická strana so zobrazenou závitovou doštičkou – špecifické podrobnosti strany sa budú líšiť.

# DOŠTIČKY NA SÚSTRUŽENIE ZÁVITOV – PREHĽAD STRANY

| Poz. | Popis |
|---|---|
| 1 | Označenie doštičky |
| 2 | Schematický nákres doštičky |
| 3 | Tabuľka s rozmermi doštičiek (mm) |
| 4 | Obrázok reprezentatívnej doštičky |
| 5 | Profil hlavnej reznej hrany |
| 6 | Ikony – špecifické vlastnosti a typ reznej hrany |

| Poz. | Popis |
|---|---|
| 7 | ISO kód doštičky |
| 8 | Materiál |
| 9 | Rohový rádius (mm) |
| 10 | Popis geometrie |
| 11 | Oblasť použitia doštičky |

1 **SI(RL)**

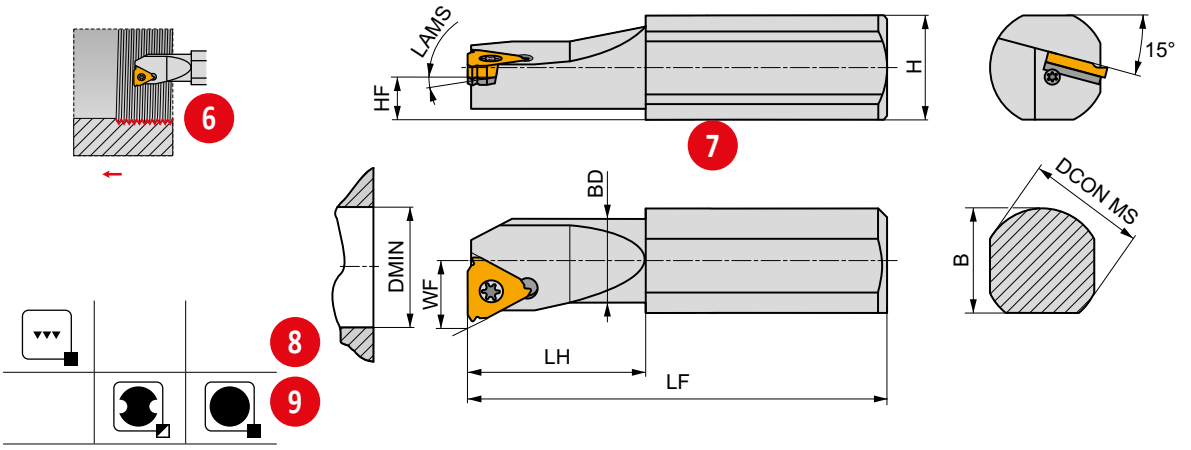
P M K N S H 2

PRAMET 3 S

**Vnútorný závitový nôž s upínaním skrutkou pre doštičky TN 11, 16 alebo 22**

Pravý/Ľavý nôž s upínaním skrutkou pre sústruženie vnútorných závitov s doštičkami TN11, 16 alebo 22 NR/NL. Vhodný pre výrobu závitov s metrickým alebo palcovým profilom. Taktiež vhodný pre zapichovanie do malých hĺbok. Dostupný s veľkosťou stopky Ø16 až Ø40mm. Teleso je povrchovo upravené pre predĺženie životnosti nástroja.

5




10

| | Product | B [mm] | DCON MS [mm] | DMIN [mm] | BD [mm] | WF [mm] | H [mm] | HF [mm] | LF [mm] | LH [mm] | LAMS [°] | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | **SIR 0010 K 11-0** | 14.5 | 16 | 13 | 10 | 7.45 | 14 | 7 | 125 | 25 | 0 | – | GI085 | Z11 |
| | **SIR 0010 K 11-1** | 14.5 | 16 | 13 | 10 | 7.45 | 14 | 7 | 125 | 25 | 1 | – | GI085 | Z11 |
| | **SIR 0013 M 11-0** | 14.5 | 16 | 16 | 13 | 9 | 14 | 7 | 150 | 32 | 0 | | | |
| 11 | **SIR 0013** 12 | 14.5 | 16 | 16 | 13 | 9 | 14 | 7 | 150 | 32 | 1 | 14 | 15 | 16 |
| | **SIR 1416 N 16-0** | 14 | 16 | 22 | 17 | 11.4 | 14.5 | 7.5 | 160 | – | 0 | – | GI022 | Z9 |
| | **SIR 1416 N 16-1** | 14 | 16 | 22 | 17 | 11.4 | 14.5 | 7.5 | 160 | – | 1 | – | GI022 | Z9 |
| R | **SIR 1416 N 16-2** | 14 | 16 | 16.5 | 15.5 | 10.6 | 14.5 | 7.5 | 160 | 40 | 2 | ✓ | GI022 | Z10 |
| | **SIR 1820 P 16** | 18.5 | 20 | 27 | 21 | 13.85 | 18 | 9 | 170 | – | – | – | GI022 | Z12 |
| | **SIR 2325 Q 16** | 23.5 | 25 | 29 | 26 | 16.55 | 23 | 11.5 | 180 | – | – | – | GI022 | Z12 |
| | **SIR 2532 S 16** | 30 | 32 | 36 | 32 | 19.75 | 25 | 12.5 | 250 | – | – | – | GI022 | Z12 |
| | **SIR 2532 S 22-2** | 30 | 32 | 25 | 25 | 16.65 | 25 | 12.5 | 250 | 80 | 2 | ✓ | GI076 | Z14 |
| | **SIR 2532 S 22-A** | 30 | 32 | 36 | 32 | 21.65 | 25 | 12.5 | 250 | – | – | – | GI076 | Z13 |
| | **SIR 3240 T 22-A** | 38 | 40 | 48 | 40 | 25.85 | 32 | 16 | 300 | – | – | – | GI076 | Z13 |

| | 17 | |
|---|---|---|
| GI022 | TN 16NR.. | TN 16NL.. |
| GI076 | TN 22NR.. | TN 22NL.. |
| GI085 | TN 11NR.. | TN 11NL.. |

| | | Nm | | | 18 | | | | |
|---|---|---|---|---|---|---|---|---|---|
| Z10 | US 3510A-T15P | 3.0 | M 3.5 | 10.6 | – | – | FLAG T15P | – | – |
| Z11 | US 2506-T07P | 0.9 | M 2.5 | 6.3 | – | – | FLAG T07P | – | – |
| Z12 | US 3512A-T15P | 3.0 | M 3.5 | 12.7 | – | HS 0304 | FLAG T15P | HXK 2.5 | Page xx |
| Z13 | US 4514A-T20 | 5.0 | M 4.5 | 14 | SP 0405 | – | FLAG T20 | – | Page xx |
| Z14 | US 4514A-T20 | 5.0 | M 4.5 | 14 | – | – | FLAG T20 | – | – |
| Z9 | US 3510A-T15P | 3.0 | M 3.5 | 10.6 | – | – | FLAG T15P | – | P-16 |

Typická strana so zobrazeným nožom na sústruženie závitov – špecifické podrobnosti strany sa budú líšiť.

| Poz. | Popis |
|---|---|
| 1 | Označenie nožov na sústruženie závitov |
| 2 | Odporúčania skupiny materiálov |
| 3 | Upínací systém doštičky |
| 4 | Ilustračný obrázok [1] |
| 5 | Popis nástroja |
| 6 | Profil obrobku |
| 7 | Schematický nákres nástroja |
| 8 | Dosiahnuteľná kvalita povrchu |
| 9 | Charakter rezu/pracovných podmienok |

| Poz. | Popis |
|---|---|
| 10 | Technologické možnosti nástroja |
| 11 | Prevedenie nástroja |
| 12 | ISO kód noža |
| 13 | Rozmery [mm] a uhly [2] [°] noža |
| 14 | Vnútorné chladenie |
| 15 | Skupina kompatibilných doštičiek [3] |
| 16 | Skupina náhradných dielov [3], [4] |
| 17 | Kompatibilné doštičky |
| 18 | Náhradné diely |

[1] Sústružnícky držiak je primárne zobrazený v pravom prevedení (R)

[2] GAMO = ortogonálny uhol čela ( pozri technickú časť )
LAMS = uhol skolnu hlavnej reznej hrany

[3] Označenie skupín doštičiek, náhradných dielov a špeciálneho príslušenstva slúži iba pre potreby tohto katalógu. Nieje možné ich použiť pre objednávku.

[4] Ikony náhradných dielov a špeciálneho príslušenstva sú zobrazené schematicky pre jednoduché pochopenie. Nie sú zahrnuté v zozname ikon. Skrutky sú v niektorých prípadoch doplnené o informáciu o ktútiacom monente v Nm , dĺžke skrutky a veľkosti závitu.

## VŠEOBECNÉ IKONY

| | |
|---|---|
| ■ | Hlavné použitie |
| ◪ | Možné použitie |
| ▼▼▼ | Dokončovanie – veľmi dobrá kvalita povrchu |
| ▼▼ | Stredné obrábanie – dobrá kvalita povrchu |
| ▼ | Hrubovanie – neobmedzená drsnosť povrchu |
| ● | Vhodné na stabilné pracovné podmienky |
| | Vhodné na nestabilné pracovné podmienky |
| | Vhodné na veľmi nestabilné pracovné podmienky |

## VLASTNOSTI

| | |
|---|---|
| | Sústruženie závitov – vonkajšie |
| | Sústruženie závitov – vnútorné |

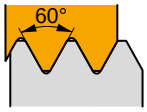
## POVLAK

| | |
|---|---|
| 1 | Prvá voľba |
| | Na húževnaté materiály (dlhé triesky) |
| U | Možnosť univerzálneho použitia |
| E | Zaoblená hrana |
| F | Ostrá hrana |

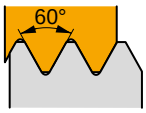
## OSTATNÉ

| | |
|---|---|
| Nm | Uťahovací moment skrutky [Nm] |
| | Vnútorné chladenie |

## M
Plný profil

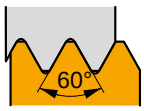
### TN M EXT NEW


495

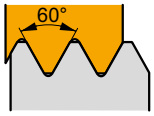
### TN M INT NEW


497

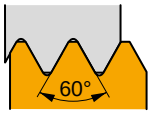
## M
Čiastočný profil

### TN 60° PP EXT


499

### TN 60° PP INT


500

### TN 60°-S PP EXT


501

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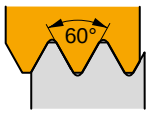
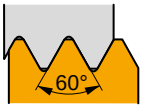


501

## MJ
Plný profil

### TN MJ EXT NEW


499

## UN
Plný profil

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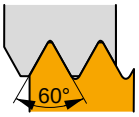
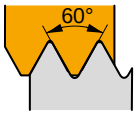
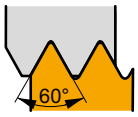


502

### TN UN INT


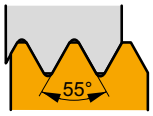
503

## UNJ
Plný profil

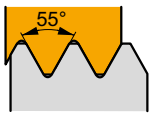
### TN UNJ EXT NEW


504

## W
Plný profil

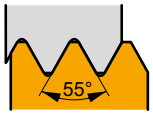
### TN W EXT


505

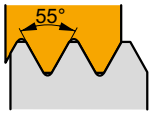
### TN W INT


506

## W
Čiastočný profil

### TN 55° PP EXT


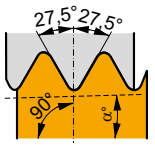
508

### TN 55° PP INT


509

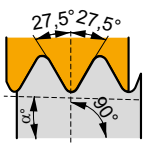
## BSPT
Plný profil

**TN BSPT EXT**




510

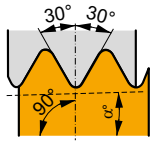
**TN BSPT INT**




510

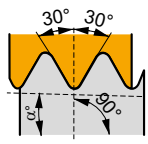
## NPT
Plný profil

**TN NPT EXT**




511

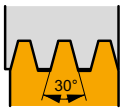
**TN NPT INT**




512

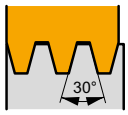
## TR
Plný profil

**TN TR EXT**



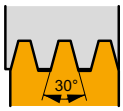

512

**TN TR INT**



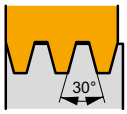

513

**TN TR-S EXT**




514

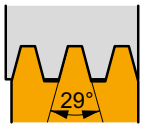
**TN TR-S INT**




514

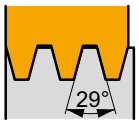
## ACME
Plný profil

**TN ACME EXT**




515

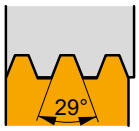
**TN ACME INT**




516

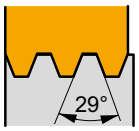
## STACME
Plný profil

**TN STACME EXT** NEW




517

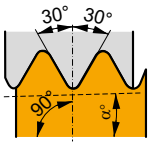
**TN STACME INT** NEW




518

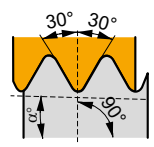
## API RD
Plný profil

**TN API RD EXT**




519

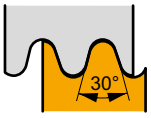
**TN API RD INT**




519

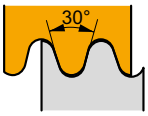
## RD
Plný profil

**TN RD EXT**




520

**TN RD INT**



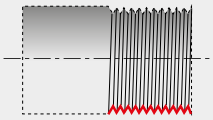

520

| Identifikácia materiálu | Oblasť použitia | Aplikácia | Posuv | Rezná rýchlosť | Odolnosť voči nepriaznivým pracovným podmienkam | Povlak | Farba | Substrát | Vplyv chladiacej kvapaliny | Popis materiálu |
|---|---|---|---|---|---|---|---|---|---|---|
| **T8010** | P05 - P15<br>M05 - M15<br>K10 - K20<br>S10 - S15 | ■<br>■<br>■<br>◪ | ◢◢◢□□ | ◢◢◢□□ | ◢◢◢□□ | PVD | | submicron H | + + + | Tento materiál je vhodný na kontinuálne vysoko presné sústruženie závitov do ocele, nehrdzavejúcej ocele, liatiny a superzliatin. Ponúka vynikajúcu odolnosť voči opotrebovaniu a zároveň zabezpečuje prevádzkovú spoľahlivosť. |
| **T8030** | P25 - P40<br>M20 - M35<br>K20 - K40<br>N15 - N30<br>S15 - S25<br>H15 - H25 | ■<br>■<br>■<br>◪<br>◪<br>◪ | ◢◢◢◢■ | ◢◢□□□ | ◢◢◢◢■ | PVD | | submicron H | + + + | Nepochybne najuniverzálnejší rezný materiál je vhodný na obrábanie všetkých typov materiálov a je použiteľný takmer pri všetkých sústružníckych operáciách. Jeho hlavnými výhodami sú vysoká prevádzková spoľahlivosť a vynikajúce trecie vlastnosti; je preto vhodný na aplikácie pri stredných a nízkych rezných rýchlostiach. |
| **HF7** | M10 - M20<br>K10 - K25<br>N10 - N25 | ◪<br>■<br>■ | ◢◢◢◢■ | ◢◢□□□ | ◢◢◢◢□ | × | | submicron H | + + | Materiál bez povlaku, ktorý je primárne určený na obrábanie neželezných kovov; ale môže sa použiť aj na iné obrábané materiály (okrem ocele). Tento materiál je možné použiť na sústruženie, frézovanie a dokonca na vyvrtávanie. |

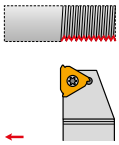
| Substrát | |
|---|---|
| **submicron H** | Jemnozrnný substrát na báze WC-Co (< 1 µm) |

| Povlak | |
|---|---|
| **PVD** | Fyzikálna metóda povrchovej úpravy pri nízkej teplote |

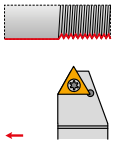
## SÚSTRUŽENIE ZÁVITOV ISO – VONKAJŠIE



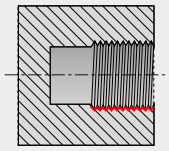
### SE(RL)

| | TN.. |
|---|---|
|  | 16<br>22 |
| 20×20 / 32×25 | |
| 522 | 459 – 521 |

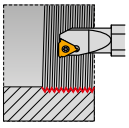
### SE(RL)-S

| | TN.. |
|---|---|
|  | 22 |
| 25×25 / 32×25 | |
| 523 | 459 – 521 |

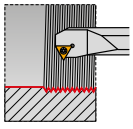
## SÚSTRUŽENIE ZÁVITOV ISO – VNÚTORNÉ



### SI(RL)

| | TN.. |
|---|---|
|  | 11<br>16<br>22 |
| ØDmin 13 / 48 | |
| 524 | 459 – 521 |

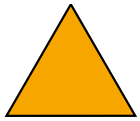
### SI(RL)-S

| | TN.. |
|---|---|
|  | 22 |
| ØDmin 39 / 48 | |
| 526 | 459 – 521 |

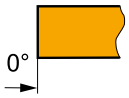
# VYMENITEĽNÉ REZNÉ DOŠTIČKY NA ZÁVITOVANIE ISO – KÓDOVÉ OZNAČOVANIE

| | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | 8 |
|---|---|---|---|---|---|---|---|---|---|
| **ISO** | T | N | 16 | E | R | 175 | M | – | P1 |
| **ANSI** | T | N | 16 | E | R | 120 | W | – | P1 |

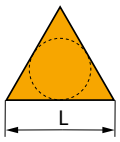
## 1 Tvar doštičky

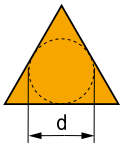
| | |
|---|---|
| T |  |

## 2 Uhol chrbta doštičky

| | |
|---|---|
| N |   |

## 3 Dĺžka reznej hrany




| L | | d = IC | |
|---|---|---|---|
| (mm) | (″) | (mm) | (″) |
| **11** | .433″ | **6,350** | 1/4″ |
| **16** | .650″ | **9,525** | 3/8″ |
| **22** | .866″ | **12,7** | 1/2″ |

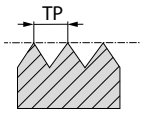
## 4 Vonkajšia - Vnútorná

| | |
|---|---|
| E | Vonkajšia |
| N | Vnútorná |

## 5 Smer rezu

| | |
|---|---|
| R | Pravý |
| L | Ľavý |
| N | Neutrálny |

## 6 Stúpanie závitu




s × 100

Stúpanie závitu mm × 100

## 6 Počet závitov

Počet závitov na palec × 10

## 7 Profil závitu

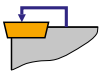
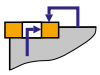
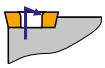
| | | | |
|---|---|---|---|
| M | Metrický 60° | TR | TR 30°<br>ISO 2901/3–1977 |
| MJ | SEA MA1370 | UN | Americký UN 60°<br>ISO 5864–1978 |
| W | Whitworth 55°<br>ISO 228–1982 | UNJ | SEA AS8879 |
| RD | Oblý 30° | ACME | ACME 29°<br>ANSI B1.5–1988 |
| BSPT | ISO 228/1<br>35 21 1959<br>ISO 7/1 | STACME | ASME/ANSI B1.8-1988 |
| NPT | ANSI B1.1–1983 | API RD | API |

## 8 Označenie utvárača

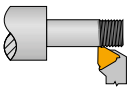
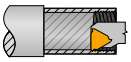
| | |
|---|---|
| P1 | Lisovaný |
| AL | Na neželezné |

| | 1 | 2 | 3 | | 4 | 5 | 6 | 7 | | 8 |
|---|---|---|---|---|---|---|---|---|---|---|
| **ISO** | S | E | R | – | S | 2525 | M | 16 | – | |
| **ANSI** | S | E | R | – | S | 16 | D | 16 | – | |

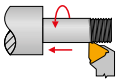
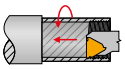
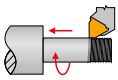
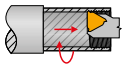
## 1 Spôsob upínania

| | |
|---|---|
| C |  |
| P | |
| M |  |
| S |  |

## 2 Spôsob obrábania

| | | |
|---|---|---|
| E | Vonkajšie |  |
| I | Vnútorné |  |

## 3 Smer rezu

| | | | |
|---|---|---|---|
| R | Pravý | Vonkajšie |  |
| | | Vnútorné |  |
| L | Ľavý | Vonkajšie |  |
| | | Vnútorné |  |

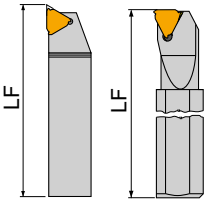
## 4 Typ konštrukcie

| | |
|---|---|
| – | Normálny |
| S | Špeciálny |

## 5 Rozmery stopky (mm)

| | | |
|---|---|---|
| Vonkajší nôž | **2525** | 25 × 25 mm |
| Vnútorný nôž | **1416** | Výška stopky – 14 mm<br>Výška stopky Ø – 16 mm |

## 6 Celková dĺžka (mm)

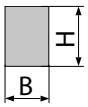



| | LF (mm) |
|---|---|
| K | 125 |
| L | 140 |
| M | 150 |
| N | 160 |
| P | 170 |
| Q | 180 |
| R | 200 |
| S | 250 |
| T | 300 |

## 7 Veľkosť doštičky

| d = IC (mm) | d = IC (″) | T |
|---|---|---|
| 6.350 | 1/4″ | 11 |
| 9.525 | 3/8″ | 16 |
| 12.700 | 1/2″ | 22 |

## 5 Rozmery nástroja (″)

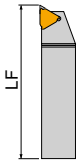



| | B (″) | H (″) |
|---|---|---|
| 10 | 5/8″ | 5/8″ |
| 12 | 3/4″ | 3/4″ |
| 16 | 1″ | 1″ |
| 85 | 1″ | 1 1/4″ |
| 86 | 1″ | 1 1/2″ |
| 20 | 1 1/4″ | 1 1/4″ |

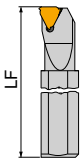
| | DCON (″) |
|---|---|
| 08 | .500″ |
| 10 | .625″ |
| 12 | .750″ |
| 16 | 1.000″ |
| 20 | 1.250″ |
| 24 | 1.500″ |

Pre štvorcové prierezy držiakov je šírka a výška vyjadrená šesnástinami palca. Pre obdĺžníkové držiaky: prvé číslo (šírka) je vyjadrená osminami palca, druhé číslo (výška) je vyjadrená štvrtinami palca.

## 6 Celková dĺžka (″)




| | LF (″) |
|---|---|
| C | 5.000″ |
| D | 6.000″ |
| E | 7.000″ |
| F | 8.000″ |




| | LF (″) |
|---|---|
| K | 5.000″ |
| M | 6.000″ |
| P | 6.250″ |
| Q | 7.250″ |
| R | 8.000″ |
| S | 10.000″ |
| T | 12.000″ |
| U | 14.000″ |

## 8 Uhol sklonu doštičky λ

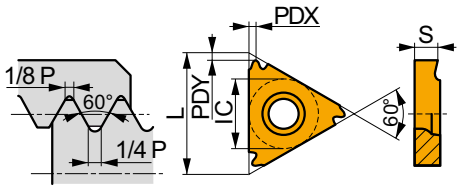
| | |
|---|---|
| 0 | Uhol λ = 0° |
| 1 | Uhol λ = 1° |
| 2 | Uhol λ = 2° |

NEW

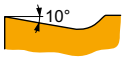
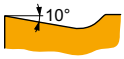
# TN M EXT

PRAMET

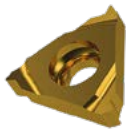
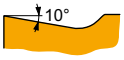
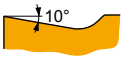
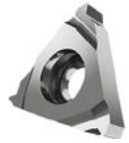
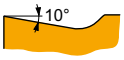
| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |
| 22 | 12.700 | 22.00 | 4.71 |




Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| |  | | | | | | | | | | | |
| TN M ER vonkajšie pravostranné prevedenie pre obrábanie ISO Metrických závitov a plynulý rez. | | | | | | | | | | | | |
| **TN 16ER050M** | **T8010** | – | 175 | 105 | 165 | – | 40 | – | 0.50 | – | 0.8 | 0.8 |
| | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | 0.50 | – | 0.8 | 0.8 |
| **TN 16ER075M** | **T8010** | – | 175 | 105 | 165 | – | 40 | – | 0.75 | – | 0.8 | 0.8 |
| | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | 0.75 | – | 0.8 | 0.8 |
| **TN 16ER080M** | **T8010** | – | 175 | 105 | 165 | – | 40 | – | 0.80 | – | 0.6 | 0.8 |
| | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | 0.80 | – | 0.6 | 0.8 |
| **TN 16ER100M** | **T8010** | – | 175 | 105 | 165 | – | 40 | – | 1.00 | – | 0.8 | 0.8 |
| | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | 1.00 | – | 0.8 | 0.8 |
| **TN 16ER125M** | **T8010** | – | 175 | 105 | 165 | – | 40 | – | 1.25 | – | 0.8 | 0.8 |
| | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | 1.25 | – | 0.8 | 0.8 |
| **TN 16ER150M** | **T8010** | – | 175 | 105 | 165 | – | 40 | – | 1.50 | – | 0.8 | 0.8 |
| | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | 1.50 | – | 0.8 | 0.8 |
| **TN 16ER175M** | **T8010** | – | 175 | 105 | 165 | – | 40 | – | 1.75 | – | 1.5 | 1.2 |
| | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | 1.75 | – | 1.5 | 1.2 |
| **TN 16ER200M** | **T8010** | – | 175 | 105 | 165 | – | 40 | – | 2.00 | – | 1.5 | 1.2 |
| | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | 2.00 | – | 1.5 | 1.2 |
| **TN 16ER250M** | **T8010** | – | 175 | 105 | 165 | – | 40 | – | 2.50 | – | 1.5 | 1.2 |
| | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | 2.50 | – | 1.5 | 1.2 |
| **TN 16ER300M** | **T8010** | – | 175 | 105 | 165 | – | 40 | – | 3.00 | – | 1.5 | 1.2 |
| | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | 3.00 | – | 1.5 | 1.2 |
| **TN 16ER350M** | **T8030**[1)] | – | 160 | 95 | 150 | 480 | 40 | – | 3.50 | – | 1.7 | 1.2 |
| **TN 22ER350M** | **T8010** | – | 175 | 105 | 165 | – | 40 | – | 3.50 | – | 2.5 | 1.8 |
| | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | 3.50 | – | 2.5 | 1.8 |
| **TN 22ER400M** | **T8010** | – | 175 | 105 | 165 | – | 40 | – | 4.00 | – | 2.5 | 1.8 |
| | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | 4.00 | – | 2.5 | 1.8 |
| **TN 22ER450M** | **T8010** | – | 175 | 105 | 165 | – | 40 | – | 4.50 | – | 2.5 | 1.8 |
| | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | 4.50 | – | 2.5 | 1.8 |
| **TN 22ER500M** | **T8010** | – | 175 | 105 | 165 | – | 40 | – | 5.00 | – | 2.5 | 1.8 |
| | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | 5.00 | – | 2.5 | 1.8 |
| |  | | | | | | | | | | | |
| TN M EL vonkajšie ľavostranné prevedenie pre obrábanie ISO Metrických závitov a plynulý rez. | | | | | | | | | | | | |
| **TN 16EL050M** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | 0.50 | – | 0.8 | 0.8 |
| **TN 16EL075M** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | 0.75 | – | 0.8 | 0.8 |
| **TN 16EL080M** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | 0.80 | – | 0.6 | 0.8 |
| **TN 16EL100M** | **T8010** | – | 175 | 105 | 165 | – | 40 | – | 1.00 | – | 0.8 | 0.8 |
| | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | 1.00 | – | 0.8 | 0.8 |
| **TN 16EL125M** | **T8010** | – | 175 | 105 | 165 | – | 40 | – | 1.25 | – | 0.8 | 0.8 |
| | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | 1.25 | – | 0.8 | 0.8 |

Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | | | | | | | | | | |
| TN M EL vonkajšie ľavostranné prevedenie pre obrábanie ISO Metrických závitov a plynulý rez. | | | | | | | | | | | | |
| **TN 16EL150M** | **T8010** | – | ■ 175 | ◪ 105 | ■ 165 | | ◪ 40 | – | 1.50 | – | 0.8 | 0.8 |
| | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.50 | – | 0.8 | 0.8 |
| **TN 16EL175M** | **T8010** | – | ■ 175 | ◪ 105 | ■ 165 | | ◪ 40 | – | 1.75 | – | 1.5 | 1.2 |
| | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.75 | – | 1.5 | 1.2 |
| **TN 16EL200M** | **T8010** | – | ■ 175 | ◪ 105 | ■ 165 | | ◪ 40 | – | 2.00 | – | 1.5 | 1.2 |
| | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 2.00 | – | 1.5 | 1.2 |
| **TN 16EL250M** | **T8010** | – | ■ 175 | ◪ 105 | ■ 165 | | ◪ 40 | – | 2.50 | – | 1.5 | 1.2 |
| | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 2.50 | – | 1.5 | 1.2 |
| **TN 16EL300M** | **T8010** | – | ■ 175 | ◪ 105 | ■ 165 | | ◪ 40 | – | 3.00 | – | 1.5 | 1.2 |
| | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 3.00 | – | 1.5 | 1.2 |
| **TN 16EL350M** | **T8030**[1] | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 3.50 | – | 1.7 | 1.2 |
| **TN 22EL350M** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 3.50 | – | 2.5 | 1.8 |
| **TN 22EL400M** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 4.00 | – | 2.5 | 1.8 |
| **TN 22EL450M** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 4.50 | – | 2.5 | 1.8 |
| **TN 22EL500M** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 5.00 | – | 2.5 | 1.8 |
| |  | | | | | | | | | | | |
| TN M-P1 ER lisované vonkajšie pravostranné prevedenie pre obrábanie ISO Metrických závitov a plynulý rez. | | | | | | | | | | | | |
| **TN 16ER100M-P1** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.00 | – | 0.8 | 0.8 |
| **TN 16ER125M-P1** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.25 | – | 0.8 | 0.8 |
| **TN 16ER150M-P1** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.50 | – | 0.8 | 0.8 |
| **TN 16ER175M-P1** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.75 | – | 1.5 | 1.2 |
| **TN 16ER200M-P1** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 2.00 | – | 1.5 | 1.2 |
| **TN 16ER250M-P1** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 2.50 | – | 1.5 | 1.2 |
| **TN 16ER300M-P1** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 3.00 | – | 1.5 | 1.2 |
|  |  | | | | | | | | | | | |
| TN M-AL ER vonkajšie pravostranné prevedenie pre obrábanie ISO Metrických závitov a plynulý rez. | | | | | | | | | | | | |
| **TN 16ER050M-AL** | **HF7** | – | – | ◪ 95 | – | ■ 480 | – | – | 0.50 | – | 0.8 | 0.8 |
| **TN 16ER075M-AL** | **HF7** | – | – | ◪ 95 | – | ■ 480 | – | – | 0.75 | – | 0.8 | 0.8 |
| **TN 16ER080M-AL** | **HF7** | – | – | ◪ 95 | – | ■ 480 | – | – | 0.80 | – | 0.6 | 0.8 |
| **TN 16ER100M-AL** | **HF7** | – | – | ◪ 95 | – | ■ 480 | – | – | 1.00 | – | 0.8 | 0.8 |
| **TN 16ER125M-AL** | **HF7** | – | – | ◪ 95 | – | ■ 480 | – | – | 1.25 | – | 0.8 | 0.8 |
| **TN 16ER150M-AL** | **HF7** | – | – | ◪ 95 | – | ■ 480 | – | – | 1.50 | – | 0.8 | 0.8 |
| **TN 16ER175M-AL** | **HF7** | – | – | ◪ 95 | – | ■ 480 | – | – | 1.75 | – | 1.5 | 1.2 |
| **TN 16ER200M-AL** | **HF7** | – | – | ◪ 95 | – | ■ 480 | – | – | 2.00 | – | 1.5 | 1.2 |
| **TN 16ER250M-AL** | **HF7** | – | – | ◪ 95 | – | ■ 480 | – | – | 2.50 | – | 1.5 | 1.2 |
| **TN 16ER300M-AL** | **HF7** | – | – | ◪ 95 | – | ■ 480 | – | – | 3.00 | – | 1.5 | 1.2 |

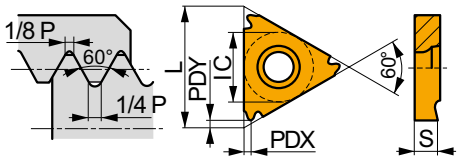
[1] Držiaky nástrojov sa musia upraviť.

NEW

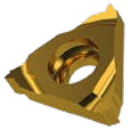
# TN M INT

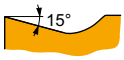
PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 11 | 6.350 | 11.00 | 3.00 |
| 16 | 9.525 | 16.50 | 3.47 |
| 22 | 12.700 | 22.00 | 4.71 |




Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

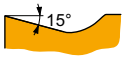
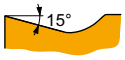
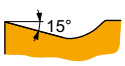





TN M NR vnútorné pravostranné prevedenie pre obrábanie ISO Metrických závitov a plynulý rez.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| TN 11NR050M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 0.50 | – | 0.8 | 0.8 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 0.50 | – | 0.8 | 0.8 |
| TN 11NR075M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 0.75 | – | 0.8 | 0.8 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 0.75 | – | 0.8 | 0.8 |
| TN 11NR100M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 1.00 | – | 0.8 | 0.8 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.00 | – | 0.8 | 0.8 |
| TN 11NR125M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 1.25 | – | 0.8 | 0.8 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.25 | – | 0.8 | 0.8 |
| TN 11NR150M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 1.50 | – | 0.8 | 0.8 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.50 | – | 0.8 | 0.8 |
| TN 11NR200M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 2.00 | – | 0.9 | 0.8 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 2.00 | – | 0.9 | 0.8 |
| TN 16NR050M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 0.50 | – | 0.8 | 0.8 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 0.50 | – | 0.8 | 0.8 |
| TN 16NR075M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 0.75 | – | 0.8 | 0.8 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 0.75 | – | 0.8 | 0.8 |
| TN 16NR100M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 1.00 | – | 0.8 | 0.8 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.00 | – | 0.8 | 0.8 |
| TN 16NR125M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 1.25 | – | 0.8 | 0.8 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.25 | – | 0.8 | 0.8 |
| TN 16NR150M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 1.50 | – | 0.8 | 0.8 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.50 | – | 0.8 | 0.8 |
| TN 16NR175M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 1.75 | – | 1.5 | 1.2 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.75 | – | 1.5 | 1.2 |
| TN 16NR200M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 2.00 | – | 1.5 | 1.2 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 2.00 | – | 1.5 | 1.2 |
| TN 16NR250M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 2.50 | – | 1.5 | 1.2 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 2.50 | – | 1.5 | 1.2 |
| TN 16NR300M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 3.00 | – | 1.5 | 1.2 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 3.00 | – | 1.5 | 1.2 |
| TN 16NR350M | T8030[1)] | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 3.50 | – | 1.6 | 1.2 |
| TN 22NR350M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 3.50 | – | 2.5 | 1.8 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 3.50 | – | 2.5 | 1.8 |
| TN 22NR400M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 4.00 | – | 2.5 | 1.8 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 4.00 | – | 2.5 | 1.8 |
| TN 22NR450M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 4.50 | – | 2.5 | 1.8 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 4.50 | – | 2.5 | 1.8 |
| TN 22NR500M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 5.00 | – | 2.5 | 1.8 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 5.00 | – | 2.5 | 1.8 |

Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| |  | | | | | | | | | | | |
| TN M NL vnútorné ľavostranné prevedenie pre obrábanie ISO Metrických závitov a plynulý rez. | | | | | | | | | | | | |
| TN 11NL050M | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 0.50 | – | 0.8 | 0.8 |
| TN 11NL075M | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 0.75 | – | 0.8 | 0.8 |
| TN 11NL100M | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.00 | – | 0.8 | 0.8 |
| TN 11NL125M | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.25 | – | 0.8 | 0.8 |
| TN 11NL150M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 1.50 | – | 0.8 | 0.8 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.50 | – | 0.8 | 0.8 |
| TN 11NL200M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 2.00 | – | 0.9 | 0.8 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 2.00 | – | 0.9 | 0.8 |
| TN 16NL050M | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 0.50 | – | 0.8 | 0.8 |
| TN 16NL075M | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 0.75 | – | 0.8 | 0.8 |
| TN 16NL100M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 1.00 | – | 0.8 | 0.8 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.00 | – | 0.8 | 0.8 |
| TN 16NL125M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 1.25 | – | 0.8 | 0.8 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.25 | – | 0.8 | 0.8 |
| TN 16NL150M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 1.50 | – | 0.8 | 0.8 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.50 | – | 0.8 | 0.8 |
| TN 16NL175M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 1.75 | – | 1.5 | 1.2 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.75 | – | 1.5 | 1.2 |
| TN 16NL200M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 2.00 | – | 1.5 | 1.2 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 2.00 | – | 1.5 | 1.2 |
| TN 16NL250M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 2.50 | – | 1.5 | 1.2 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 2.50 | – | 1.5 | 1.2 |
| TN 16NL300M | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 3.00 | – | 1.5 | 1.2 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 3.00 | – | 1.5 | 1.2 |
| TN 16NL350M | T8030[1] | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 3.50 | – | 1.6 | 1.2 |
| TN 22NL350M | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 3.50 | – | 2.5 | 1.8 |
| TN 22NL400M | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 4.00 | – | 2.5 | 1.8 |
| TN 22NL500M | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 5.00 | – | 2.5 | 1.8 |
| |  | | | | | | | | | | | |
| TN M-P1 NR lisované vnútorné pravostranné prevedenie pre obrábanie ISO Metrických závitov a plynulý rez. | | | | | | | | | | | | |
| TN 11NR100M-P1 | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.00 | – | 0.8 | 0.8 |
| TN 11NR150M-P1 | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.50 | – | 0.8 | 0.8 |
| TN 16NR100M-P1 | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.00 | – | 0.8 | 0.8 |
| TN 16NR150M-P1 | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.50 | – | 0.8 | 0.8 |
| TN 16NR200M-P1 | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 2.00 | – | 1.5 | 1.2 |
| TN 16NR250M-P1 | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 2.50 | – | 1.5 | 1.2 |
| TN 16NR300M-P1 | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 3.00 | – | 1.5 | 1.2 |
| |  | | | | | | | | | | | |
| TN M-AL NR vnútorné pravostranné prevedenie pre obrábanie ISO Metrických závitov a plynulý rez. | | | | | | | | | | | | |
| TN 16NR050M-AL | HF7 | – | – | ◪ 95 | – | ■ 480 | – | – | 0.50 | – | 0.8 | 0.8 |
| TN 16NR075M-AL | HF7 | – | – | ◪ 95 | – | ■ 480 | – | – | 0.75 | – | 0.8 | 0.8 |
| TN 16NR100M-AL | HF7 | – | – | ◪ 95 | – | ■ 480 | – | – | 1.00 | – | 0.8 | 0.8 |
| TN 16NR125M-AL | HF7 | – | – | ◪ 95 | – | ■ 480 | – | – | 1.25 | – | 0.8 | 0.8 |
| TN 16NR150M-AL | HF7 | – | – | ◪ 95 | – | ■ 480 | – | – | 1.50 | – | 0.8 | 0.8 |
| TN 16NR175M-AL | HF7 | – | – | ◪ 95 | – | ■ 480 | – | – | 1.75 | – | 1.5 | 1.2 |
| TN 16NR200M-AL | HF7 | – | – | ◪ 95 | – | ■ 480 | – | – | 2.00 | – | 1.5 | 1.2 |
| TN 16NR250M-AL | HF7 | – | – | ◪ 95 | – | ■ 480 | – | – | 2.50 | – | 1.5 | 1.2 |
| TN 16NR300M-AL | HF7 | – | – | ◪ 95 | – | ■ 480 | – | – | 3.00 | – | 1.5 | 1.2 |

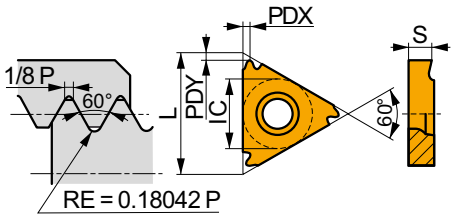
[1] Držiaky nástrojov sa musia upraviť.

NEW

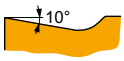
# TN MJ EXT

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |



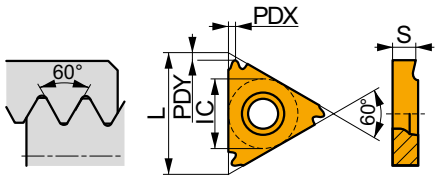

Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| |  | | 1 Ú E | | | | | | | | | |
| | | | TN MJ ER vonkajšie pravostranné prevedenie pre obrábanie Metrických "tvar J" závitov a plynulý rez. | | | | | | | | | |
| **TN 16ER100MJ** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.00 | – | 0.8 | 0.8 |
| **TN 16ER150MJ** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.50 | – | 0.8 | 0.8 |

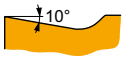
# TN 60° PP EXT

PRAMET

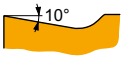
| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |
| 22 | 12.700 | 22.00 | 4.71 |




Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TPN (mm) | TPX (mm) | TPIN | TPIX | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| |  | | 1 Ú E | | | | | | | | | | | |
| | | | TN M60 PP ER vonkajšie pravostranné prevedenie pre obrábanie Metrických a Unifikovaných závitov a plynulý rez. | | | | | | | | | | | |
| **TN 16ERA60** | **T8010** | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 0.50 | 1.50 | 16 | 48 | 0.8 | 0.6 |
| | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 0.50 | 1.50 | 16 | 48 | 0.8 | 0.6 |
| **TN 16ERAG60** | **T8010** | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 0.50 | 3.00 | 8 | 48 | 1.5 | 1.1 |
| | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 0.50 | 3.00 | 8 | 48 | 1.5 | 1.1 |
| **TN 16ERG60** | **T8010** | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 1.75 | 3.00 | 8 | 14 | 1.5 | 1.1 |
| | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.75 | 3.00 | 8 | 14 | 1.5 | 1.1 |
| **TN 22ERN60** | **T8010** | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 3.50 | 5.00 | 5 | 7 | 2.5 | 1.8 |
| | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 3.50 | 5.00 | 5 | 7 | 2.5 | 1.8 |

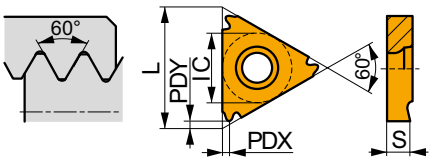
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TPN (mm) | TPX (mm) | TPIN | TPIX | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| |   | | | | | | | | | | | | | |
| | | | TN M60 PP EL vonkajšie ľavostranné prevedenie pre obrábanie Metrických a Unifikovaných závitov a plynulý rez. | | | | | | | | | | | |
| TN 16ELA60 | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | 0.50 | 1.50 | 16 | 48 | 0.8 | 0.6 |
| TN 16ELAG60 | T8010 | – | 175 | 105 | 165 | – | 40 | – | 0.50 | 3.00 | 8 | 48 | 1.5 | 1.1 |
| | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | 0.50 | 3.00 | 8 | 48 | 1.5 | 1.1 |
| TN 16ELG60 | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | 1.75 | 3.00 | 8 | 14 | 1.5 | 1.1 |
| TN 22ELN60 | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | 3.50 | 5.00 | 5 | 7 | 2.5 | 1.8 |

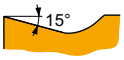
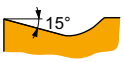
## TN 60° PP INT

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 11 | 6.350 | 11.00 | 3.00 |
| 16 | 9.525 | 16.50 | 3.47 |
| 22 | 12.700 | 22.00 | 4.71 |



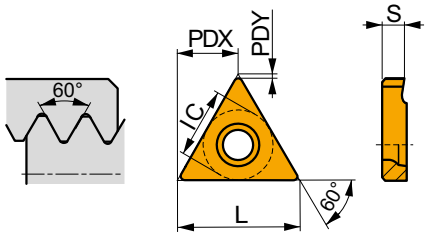

Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TPN (mm) | TPX (mm) | TPIN | TPIX | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| |   | | | | | | | | | | | | | |
| | | | TN M60 PP NR vnútorné pravostranné prevedenie pre obrábanie Metrických a Unifikovaných závitov a plynulý rez. | | | | | | | | | | | |
| TN 11NRA60 | T8010 | – | 175 | 105 | 165 | – | 40 | – | 0.50 | 1.50 | 16 | 48 | 0.8 | 0.7 |
| | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | 0.50 | 1.50 | 16 | 48 | 0.8 | 0.7 |
| TN 16NRA60 | T8010 | – | 175 | 105 | 165 | – | 40 | – | 0.50 | 1.50 | 16 | 48 | 0.8 | 0.7 |
| | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | 0.50 | 1.50 | 16 | 48 | 0.8 | 0.7 |
| TN 16NRAG60 | T8010 | – | 175 | 105 | 165 | – | 40 | – | 0.50 | 3.00 | 8 | 48 | 1.5 | 1.1 |
| | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | 0.50 | 3.00 | 8 | 48 | 1.5 | 1.1 |
| TN 16NRG60 | T8010 | – | 175 | 105 | 165 | – | 40 | – | 1.75 | 3.00 | 8 | 14 | 1.5 | 1.1 |
| | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | 1.75 | 3.00 | 8 | 14 | 1.5 | 1.1 |
| TN 22NRN60 | T8010 | – | 175 | 105 | 165 | – | 40 | – | 3.50 | 5.00 | 5 | 7 | 2.5 | 1.8 |
| | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | 3.50 | 5.00 | 5 | 7 | 2.5 | 1.8 |
| |   | | | | | | | | | | | | | |
| | | | TN M60 PP NL vnútorné ľavostranné prevedenie pre obrábanie Metrických a Unifikovaných závitov a plynulý rez. | | | | | | | | | | | |
| TN 11NLA60 | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | 0.50 | 1.50 | 16 | 48 | 0.8 | 0.7 |
| TN 16NLA60 | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | 0.50 | 1.50 | 16 | 48 | 0.8 | 0.7 |
| TN 16NLAG60 | T8010 | – | 175 | 105 | 165 | – | 40 | – | 0.50 | 3.00 | 8 | 48 | 1.5 | 1.1 |
| | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | 0.50 | 3.00 | 8 | 48 | 1.5 | 1.1 |
| TN 16NLG60 | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | 1.75 | 3.00 | 8 | 14 | 1.5 | 1.1 |
| TN 22NLN60 | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | 3.50 | 5.00 | 5 | 7 | 2.5 | 1.8 |

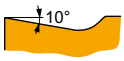
# TN 60°-S PP EXT

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 22 | 12.700 | 22.00 | 4.60 |




Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

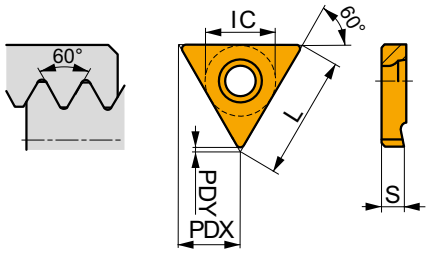
| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TPN (mm) | TPX (mm) | TPIN | TPIX | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| |   | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | |
| TN 22EN350-500M | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 3.50 | 5.00 | 5 | 7 | 11.0 | 0.5 |
| TN 22EN550-800M | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 5.50 | 8.00 | 3 | 4.5 | 11.0 | 0.8 |

TN M60-S PP EN vonkajšie ľavo a pravostranné prevedenie pre obrábanie Metrických a Unifikovaných závitov a plynulý rez.

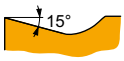
# TN 60°-S PP INT

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 22 | 12.700 | 22.00 | 4.60 |




Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

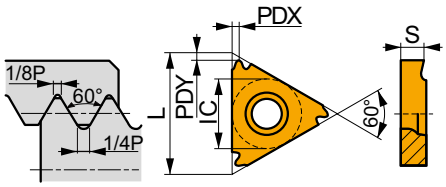
| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TPN (mm) | TPX (mm) | TPIN | TPIX | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| |   | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | |
| TN 22NN350-500M | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 3.50 | 5.00 | 5 | 7 | 11.0 | 0.2 |
| TN 22NN550-800M | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 5.50 | 8.00 | 3 | 4.5 | 11.0 | 0.5 |

TN M60-S PP NN vnútorné ľavo a pravostranné prevedenie pre obrábanie Metrických a Unifikovaných závitov a plynulý rez.

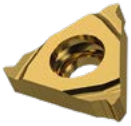
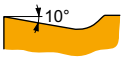
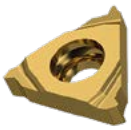
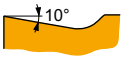
# TN UN EXT

PRAMET

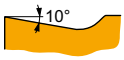
| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |
| 22 | 12.700 | 22.00 | 4.71 |




Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | | | | | | | | | | |
| TN UN ER vonkajšie pravostranné prevedenie pre obrábanie Unifikovaných závitov a plynulý rez. | | | | | | | | | | | | |
| TN 16ER320UN | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 32.0 | 0.8 | 0.8 |
| TN 16ER280UN | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 28.0 | 0.8 | 0.8 |
| TN 16ER240UN | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 24.0 | 0.8 | 0.8 |
| TN 16ER200UN | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | – | 20.0 | 0.8 | 0.8 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 20.0 | 0.8 | 0.8 |
| TN 16ER180UN | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 18.0 | 0.8 | 0.8 |
| TN 16ER160UN | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 16.0 | 0.8 | 0.8 |
| TN 16ER140UN | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 14.0 | 1.5 | 1.2 |
| TN 16ER130UN | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 13.0 | 1.5 | 1.2 |
| TN 16ER120UN | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 12.0 | 1.5 | 1.2 |
| TN 16ER115UN | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 11.5 | 1.5 | 1.2 |
| TN 16ER110UN | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 11.0 | 1.5 | 1.2 |
| TN 16ER100UN | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 10.0 | 1.5 | 1.2 |
| TN 16ER090UN | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 9.0 | 1.5 | 1.2 |
| TN 16ER080UN | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 8.0 | 1.5 | 1.2 |
| TN 22ER070UN | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 7.0 | 2.5 | 1.8 |
| TN 22ER060UN | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 6.0 | 2.5 | 1.8 |
| TN 22ER050UN | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 5.0 | 2.5 | 1.8 |
|  |  | | | | | | | | | | | |
| TN UN EL vonkajšie ľavostranné prevedenie pre obrábanie Unifikovaných závitov a plynulý rez. | | | | | | | | | | | | |
| TN 16EL320UN | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 32.0 | 0.8 | 0.8 |
| TN 16EL280UN | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 28.0 | 0.8 | 0.8 |
| TN 16EL240UN | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 24.0 | 0.8 | 0.8 |
| TN 16EL200UN | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 20.0 | 0.8 | 0.8 |
| TN 16EL180UN | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 18.0 | 0.8 | 0.8 |
| TN 16EL160UN | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 16.0 | 0.8 | 0.8 |
| TN 16EL140UN | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 14.0 | 1.5 | 1.2 |
| TN 16EL120UN | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 12.0 | 1.5 | 1.2 |
| TN 16EL110UN | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 11.0 | 1.5 | 1.2 |
| TN 16EL100UN | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 10.0 | 1.5 | 1.2 |
| TN 16EL090UN | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 9.0 | 1.5 | 1.2 |
| TN 16EL080UN | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 8.0 | 1.5 | 1.2 |
| TN 22EL070UN | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 7.0 | 2.5 | 1.8 |
| TN 22EL060UN | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 6.0 | 2.5 | 1.8 |
| TN 22EL050UN | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 5.0 | 2.5 | 1.8 |

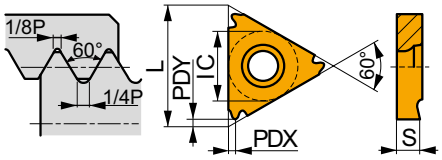
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| |  | | | | | | | | | | | |
| | | | TN UN-P1 ER lisované vonkajšie pravostranné prevedenie pre obrábanie Unifikovaných závitov a plynulý rez. | | | | | | | | | |
| TN 16ER200UN-P1 | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 20.0 | 0.8 | 0.8 |
| TN 16ER180UN-P1 | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 18.0 | 0.8 | 0.8 |
| TN 16ER160UN-P1 | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 16.0 | 0.8 | 0.8 |
| TN 16ER140UN-P1 | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 14.0 | 1.5 | 1.2 |
| TN 16ER120UN-P1 | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 12.0 | 1.5 | 1.2 |
| TN 16ER080UN-P1 | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 8.0 | 1.5 | 1.2 |

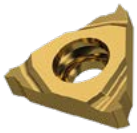
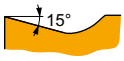
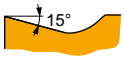
## TN UN INT

PRAMET

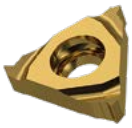
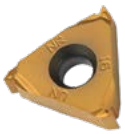
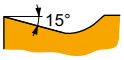
| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |
| 22 | 12.700 | 22.00 | 4.71 |




Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | | | | | | | | | | |
| | | | TN UN NR vnútorné pravostranné prevedenie pre obrábanie Unifikovaných závitov a plynulý rez. | | | | | | | | | |
| TN 16NR320UN | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 32.0 | 0.8 | 0.8 |
| TN 16NR280UN | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 28.0 | 0.8 | 0.8 |
| TN 16NR240UN | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 24.0 | 0.8 | 0.8 |
| TN 16NR200UN | T8010 | – | 175 | 105 | 165 | – | 40 | – | – | 20.0 | 0.8 | 0.8 |
| | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 20.0 | 0.8 | 0.8 |
| TN 16NR180UN | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 18.0 | 0.8 | 0.8 |
| TN 16NR160UN | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 16.0 | 0.8 | 0.8 |
| TN 16NR140UN | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 14.0 | 1.5 | 1.2 |
| TN 16NR130UN | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 13.0 | 1.5 | 1.2 |
| TN 16NR120UN | T8010 | – | 175 | 105 | 165 | – | 40 | – | – | 12.0 | 1.5 | 1.2 |
| | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 12.0 | 1.5 | 1.2 |
| TN 16NR115UN | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 11.5 | 1.5 | 1.2 |
| TN 16NR110UN | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 11.0 | 1.5 | 1.2 |
| TN 16NR100UN | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 10.0 | 1.5 | 1.2 |
| TN 16NR080UN | T8010 | – | 175 | 105 | 165 | – | 40 | – | – | 8.0 | 1.5 | 1.2 |
| | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 8.0 | 1.5 | 1.2 |
| TN 22NR070UN | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 7.0 | 2.5 | 1.8 |
| TN 22NR060UN | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 6.0 | 2.5 | 1.8 |
| TN 22NR050UN | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 5.0 | 2.5 | 1.8 |
| |  | | | | | | | | | | | |
| | | | TN UN NL vnútorné ľavostranné prevedenie pre obrábanie Unifikovaných závitov a plynulý rez. | | | | | | | | | |
| TN 16NL320UN | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 32.0 | 0.8 | 0.8 |

Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

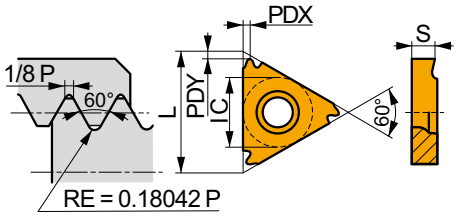
| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  | | | | | | | | | | | | |
| TN UN NL vnútorné ľavostranné prevedenie pre obrábanie Unifikovaných závitov a plynulý rez. | | | | | | | | | | | | |
| TN 16NL280UN | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 28.0 | 0.8 | 0.8 |
| TN 16NL240UN | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 24.0 | 0.8 | 0.8 |
| TN 16NL200UN | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 20.0 | 0.8 | 0.8 |
| TN 16NL180UN | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 18.0 | 0.8 | 0.8 |
| TN 16NL160UN | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 16.0 | 0.8 | 0.8 |
| TN 16NL140UN | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 14.0 | 1.5 | 1.2 |
| TN 16NL120UN | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 12.0 | 1.5 | 1.2 |
| TN 16NL110UN | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 11.0 | 1.5 | 1.2 |
| TN 16NL100UN | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 10.0 | 1.5 | 1.2 |
| TN 16NL080UN | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 8.0 | 1.5 | 1.2 |
| TN 22NL070UN | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 7.0 | 2.5 | 1.8 |
| TN 22NL060UN | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 6.0 | 2.5 | 1.8 |
|  |  | | | | | | | | | | | |
| TN UN-P1 NR lisované vnútorné pravostranné prevedenie pre obrábanie Unifikovaných závitov a plynulý rez. | | | | | | | | | | | | |
| TN 16NR200UN-P1 | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 20.0 | 0.8 | 0.8 |
| TN 16NR180UN-P1 | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 18.0 | 0.8 | 0.8 |
| TN 16NR160UN-P1 | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 16.0 | 0.8 | 0.8 |
| TN 16NR140UN-P1 | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 14.0 | 1.5 | 1.2 |
| TN 16NR120UN-P1 | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 12.0 | 1.5 | 1.2 |
| TN 16NR080UN-P1 | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 8.0 | 1.5 | 1.2 |

NEW

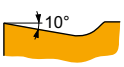
## TN UNJ EXT

PRAMET

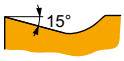
| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |




Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| |  | | | | | | | | | | | |
| TN UNJ ER vonkajšie pravostranné prevedenie pre obrábanie Unifikovaných "tvar J" závitov a plynulý rez. | | | | | | | | | | | | |
| TN 16ER320UNJ | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 32.0 | 0.8 | 0.8 |
| TN 16ER280UNJ | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 28.0 | 0.8 | 0.8 |
| TN 16ER240UNJ | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 24.0 | 0.8 | 0.8 |
| TN 16ER200UNJ | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 20.0 | 0.8 | 0.8 |
| TN 16ER180UNJ | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 18.0 | 0.8 | 0.8 |
| TN 16ER160UNJ | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 16.0 | 1.5 | 1.2 |
| TN 16ER120UNJ | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 12.0 | 1.5 | 1.2 |

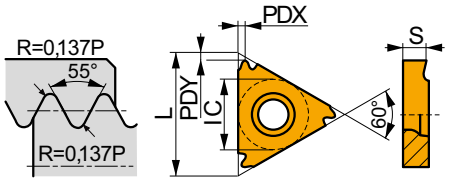
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| |  | | | | | | | | | | | |
| | | | TN UNJ EL vonkajšie ľavostranné prevedenie pre obrábanie Unifikovaných "tvar J" závitov a plynulý rez. | | | | | | | | | |
| TN 16EL320UNJ | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 32.0 | 0.8 | 0.8 |
| TN 16EL280UNJ | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 28.0 | 0.8 | 0.8 |
| TN 16EL240UNJ | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 24.0 | 0.8 | 0.8 |
| TN 16EL200UNJ | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 20.0 | 0.8 | 0.8 |
| TN 16EL180UNJ | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 18.0 | 0.8 | 0.8 |
| TN 16EL160UNJ | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 16.0 | 1.5 | 1.2 |
| TN 16EL120UNJ | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 12.0 | 1.5 | 1.2 |

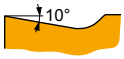
## TN W EXT

PRAMET

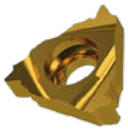
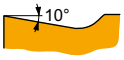
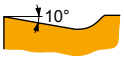
| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |
| 22 | 12.700 | 22.00 | 4.71 |




Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| |  | | | | | | | | | | | |
| | | | TN W ER vonkajšie pravostranné prevedenie pre obrábanie Whitworth závitov a plynulý rez. | | | | | | | | | |
| TN 16ER280W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 28.0 | 0.8 | 0.8 |
| TN 16ER260W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 26.0 | 0.8 | 0.8 |
| TN 16ER240W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 24.0 | 0.8 | 0.8 |
| TN 16ER200W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 20.0 | 0.8 | 0.8 |
| TN 16ER190W | T8010 | – | 175 | 105 | 165 | – | 40 | – | – | 19.0 | 0.8 | 0.8 |
| | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 19.0 | 0.8 | 0.8 |
| TN 16ER180W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 18.0 | 0.8 | 0.8 |
| TN 16ER160W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 16.0 | 0.8 | 0.8 |
| TN 16ER140W | T8010 | – | 175 | 105 | 165 | – | 40 | – | – | 14.0 | 1.5 | 1.2 |
| | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 14.0 | 1.5 | 1.2 |
| TN 16ER120W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 12.0 | 1.5 | 1.2 |
| TN 16ER110W | T8010 | – | 175 | 105 | 165 | – | 40 | – | – | 11.0 | 1.5 | 1.2 |
| | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 11.0 | 1.5 | 1.2 |
| TN 16ER100W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 10.0 | 1.5 | 1.2 |
| TN 16ER090W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 9.0 | 1.5 | 1.2 |
| TN 16ER080W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 8.0 | 1.5 | 1.2 |
| TN 22ER070W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 7.0 | 2.5 | 1.8 |
| TN 22ER060W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 6.0 | 2.5 | 1.8 |
| TN 22ER050W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 5.0 | 2.5 | 1.7 |

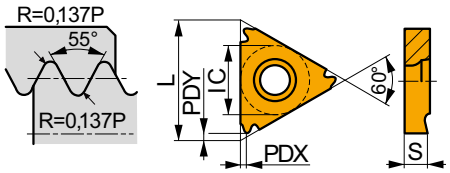
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | | | | | | | | | | |
| TN W EL vonkajšie ľavostranné prevedenie pre obrábanie Whitworth závitov a plynulý rez. | | | | | | | | | | | | |
| TN 16EL280W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 28.0 | 0.8 | 0.8 |
| TN 16EL260W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 26.0 | 0.8 | 0.8 |
| TN 16EL240W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 24.0 | 0.8 | 0.8 |
| TN 16EL200W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 20.0 | 0.8 | 0.8 |
| TN 16EL190W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 19.0 | 0.8 | 0.8 |
| TN 16EL160W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 16.0 | 0.8 | 0.8 |
| TN 16EL140W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 14.0 | 1.5 | 1.2 |
| TN 16EL120W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 12.0 | 1.5 | 1.2 |
| TN 16EL110W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 11.0 | 1.5 | 1.2 |
| TN 16EL100W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 10.0 | 1.5 | 1.2 |
| TN 16EL090W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 9.0 | 1.5 | 1.2 |
| TN 16EL080W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 8.0 | 1.5 | 1.2 |
| TN 22EL070W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 7.0 | 2.5 | 1.8 |
| TN 22EL060W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 6.0 | 2.5 | 1.8 |
| TN 22EL050W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 5.0 | 2.5 | 1.7 |
| |  | | | | | | | | | | | |
| TN W-P1 ER lisované vonkajšie pravostranné prevedenie pre obrábanie Whitworth závitov a plynulý rez. | | | | | | | | | | | | |
| TN 16ER190W-P1 | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 19.0 | 0.8 | 0.8 |
| TN 16ER140W-P1 | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 14.0 | 1.5 | 1.2 |
| TN 16ER110W-P1 | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 11.0 | 1.5 | 1.2 |

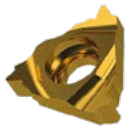
## TN W INT

PRAMET

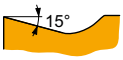
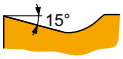
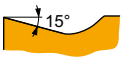
| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 11 | 6.350 | 11.00 | 3.00 |
| 16 | 9.525 | 16.50 | 3.47 |
| 22 | 12.700 | 22.00 | 4.71 |




Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  | | | | | | | | | | | | |
| TN W NR vnútorné pravostranné prevedenie pre obrábanie Whitworth závitov a plynulý rez. | | | | | | | | | | | | |
| TN 11NR190W | T8010 | – | 175 | 105 | 165 | – | 40 | – | – | 19.0 | 0.8 | 0.8 |
| | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 19.0 | 0.8 | 0.8 |
| TN 11NR140W | T8010 | – | 175 | 105 | 165 | – | 40 | – | – | 14.0 | 0.9 | 0.7 |
| | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 14.0 | 0.9 | 0.7 |
| TN 16NR280W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 28.0 | 0.8 | 0.8 |
| TN 16NR260W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 26.0 | 0.8 | 0.8 |
| TN 16NR240W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 24.0 | 0.8 | 0.8 |
| TN 16NR200W | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | – | 20.0 | 0.8 | 0.8 |

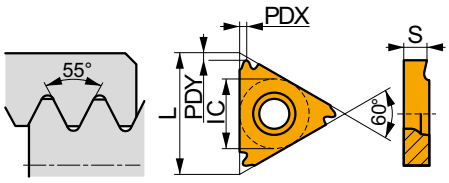
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| |  | | | | | | | | | | | |
| | | | TN W NR vnútorné pravostranné prevedenie pre obrábanie Whitworth závitov a plynulý rez. | | | | | | | | | |
| TN 16NR190W | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | | ◪ 40 | – | – | 19.0 | 0.8 | 0.8 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 19.0 | 0.8 | 0.8 |
| TN 16NR160W | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 16.0 | 0.8 | 0.8 |
| TN 16NR140W | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | – | 14.0 | 1.5 | 1.2 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 14.0 | 1.5 | 1.2 |
| TN 16NR120W | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 12.0 | 1.5 | 1.2 |
| TN 16NR110W | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | – | 11.0 | 1.5 | 1.2 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 11.0 | 1.5 | 1.2 |
| TN 16NR100W | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 10.0 | 1.5 | 1.2 |
| TN 16NR090W | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 9.0 | 1.5 | 1.2 |
| TN 16NR080W | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 8.0 | 1.5 | 1.2 |
| TN 22NR070W | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 7.0 | 2.5 | 1.8 |
| TN 22NR060W | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 6.0 | 2.5 | 1.8 |
| TN 22NR050W | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 5.0 | 2.5 | 1.7 |
| |  | | | | | | | | | | | |
| | | | TN W NL vnútorné ľavostranné prevedenie pre obrábanie Whitworth závitov a plynulý rez. | | | | | | | | | |
| TN 11NL190W | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 19.0 | 0.8 | 0.8 |
| TN 11NL140W | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 14.0 | 0.9 | 0.7 |
| TN 16NL280W | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 28.0 | 0.8 | 0.8 |
| TN 16NL260W | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 26.0 | 0.8 | 0.8 |
| TN 16NL240W | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 24.0 | 0.8 | 0.8 |
| TN 16NL200W | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 20.0 | 0.8 | 0.8 |
| TN 16NL190W | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 19.0 | 0.8 | 0.8 |
| TN 16NL160W | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 16.0 | 0.8 | 0.8 |
| TN 16NL140W | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 14.0 | 1.5 | 1.2 |
| TN 16NL120W | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 12.0 | 1.5 | 1.2 |
| TN 16NL110W | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 11.0 | 1.5 | 1.2 |
| TN 16NL100W | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 10.0 | 1.5 | 1.2 |
| TN 16NL090W | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 9.0 | 1.5 | 1.2 |
| TN 16NL080W | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 8.0 | 1.5 | 1.2 |
| TN 22NL070W | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 7.0 | 2.5 | 1.8 |
| TN 22NL060W | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 6.0 | 2.5 | 1.8 |
| TN 22NL050W | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 5.0 | 2.5 | 1.7 |
| |  | | | | | | | | | | | |
| | | | TN W-P1 NR lisované vnútorné pravostranné prevedenie pre obrábanie Whitworth závitov a plynulý rez. | | | | | | | | | |
| TN 11NR190W-P1 | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 19.0 | 0.8 | 0.8 |
| TN 11NR140W-P1 | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 14.0 | 0.9 | 0.7 |
| TN 16NR140W-P1 | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 14.0 | 1.5 | 1.2 |
| TN 16NR110W-P1 | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 11.0 | 1.5 | 1.2 |

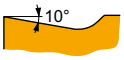
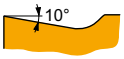
# TN 55° PP EXT

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |
| 22 | 12.700 | 22.00 | 4.71 |



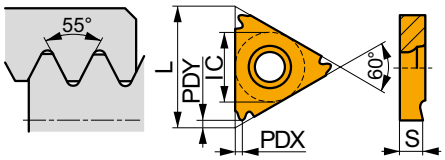

Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TPN (mm) | TPX (mm) | TPIN | TPIX | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| |  | | | | | | | | | | | | | |
| | | | 1 U E | | | | | | | | | | | |
| | | | TN W55 PP ER vonkajšie pravostranné prevedenie pre obrábanie Whitworth závitov a plynulý rez. | | | | | | | | | | | |
| **TN 16ERA55** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 0.50 | 1.50 | 16 | 48 | 0.8 | 0.6 |
| **TN 16ERAG55** | **T8010** | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 0.50 | 3.00 | 8 | 48 | 1.5 | 1.1 |
| | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 0.50 | 3.00 | 8 | 48 | 1.5 | 1.1 |
| **TN 16ERG55** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.75 | 3.00 | 8 | 14 | 1.5 | 1.1 |
| **TN 22ERN55** | **T8010** | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 3.50 | 5.00 | 5 | 7 | 2.5 | 1.8 |
| | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 3.50 | 5.00 | 5 | 7 | 2.5 | 1.8 |
| |  | | | | | | | | | | | | | |
| | | | 1 U E | | | | | | | | | | | |
| | | | TN W55 PP EL vonkajšie ľavostranné prevedenie pre obrábanie Whitworth závitov a plynulý rez. | | | | | | | | | | | |
| **TN 16ELA55** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 0.50 | 1.50 | 16 | 48 | 0.8 | 0.6 |
| **TN 16ELAG55** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 0.50 | 3.00 | 8 | 48 | 1.5 | 1.1 |
| **TN 16ELG55** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.75 | 3.00 | 8 | 14 | 1.5 | 1.1 |
| **TN 22ELN55** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 3.50 | 5.00 | 5 | 7 | 2.5 | 1.8 |

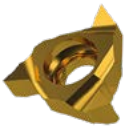
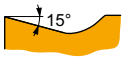
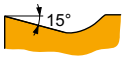
# TN 55° PP INT

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 11 | 6.350 | 11.00 | 3.00 |
| 16 | 9.525 | 16.50 | 3.47 |
| 22 | 12.700 | 22.00 | 4.71 |



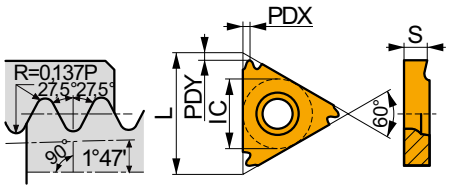

Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TPN (mm) | TPX (mm) | TPIN | TPIX | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | | | | | | | | | | | | |
| | | | 1 Ú E | | | | | | | | | | | |
| | | | TN W55 PP NR vnútorné pravostranné prevedenie pre obrábanie Whitworth závitov a plynulý rez. | | | | | | | | | | | |
| TN 11NRA55 | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 0.50 | 1.50 | 16 | 48 | 0.8 | 0.6 |
| TN 16NRA55 | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 0.50 | 1.50 | 16 | 48 | 0.8 | 0.6 |
| TN 16NRAG55 | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 0.50 | 3.00 | 8 | 48 | 1.5 | 1.1 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 0.50 | 3.00 | 8 | 48 | 1.5 | 1.1 |
| TN 16NRG55 | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.75 | 3.00 | 8 | 14 | 1.5 | 1.1 |
| TN 22NRN55 | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 3.50 | 5.00 | 5 | 7 | 2.5 | 1.8 |
| |  | | | | | | | | | | | | | |
| | | | 1 Ú E | | | | | | | | | | | |
| | | | TN W55 PP NL vnútorné ľavostranné prevedenie pre obrábanie Whitworth závitov a plynulý rez. | | | | | | | | | | | |
| TN 11NLA55 | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 0.50 | 1.50 | 16 | 48 | 0.8 | 0.6 |
| TN 16NLA55 | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 0.50 | 1.50 | 16 | 48 | 0.8 | 0.6 |
| TN 16NLAG55 | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 0.50 | 3.00 | 8 | 48 | 1.5 | 1.1 |
| TN 16NLG55 | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.75 | 3.00 | 8 | 14 | 1.5 | 1.1 |
| TN 22NLN55 | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 3.50 | 5.00 | 5 | 7 | 2.5 | 1.8 |

# TN BSPT EXT

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |



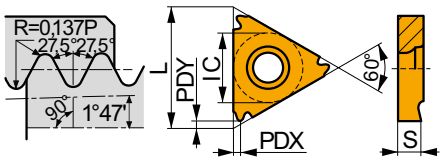

Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | 10° | | | | | | | | | | | |
| TN BSPT ER vonkajšie pravostranné prevedenie pre obrábanie BSPT závitov a plynulý rez. | | | | | | | | | | | | |
| TN 16ER280BSPT | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 28.0 | 0.8 | 0.8 |
| TN 16ER190BSPT | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 19.0 | 1.5 | 1.2 |
| TN 16ER140BSPT | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 14.0 | 1.5 | 1.2 |
| TN 16ER110BSPT | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 11.0 | 1.5 | 1.2 |
| | 10° | | | | | | | | | | | |
| TN BSPT EL vonkajšie ľavostranné prevedenie pre obrábanie BSPT závitov a plynulý rez. | | | | | | | | | | | | |
| TN 16EL280BSPT | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 28.0 | 0.8 | 0.8 |
| TN 16EL190BSPT | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 19.0 | 1.5 | 1.2 |
| TN 16EL140BSPT | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 14.0 | 1.5 | 1.2 |
| TN 16EL110BSPT | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 11.0 | 1.5 | 1.2 |

# TN BSPT INT

PRAMET

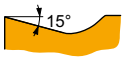
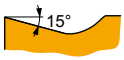
| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |




Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | 15° | | | | | | | | | | | |
| TN BSPT NR vnútorné pravostranné prevedenie pre obrábanie BSPT závitov a plynulý rez. | | | | | | | | | | | | |
| TN 16NR280BSPT | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 28.0 | 0.8 | 0.8 |
| TN 16NR190BSPT | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 19.0 | 1.5 | 1.2 |

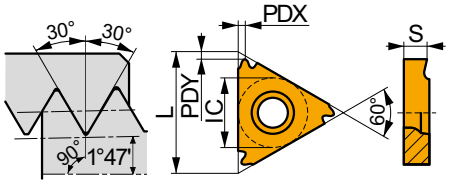
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| |  | | | | | | | | | | | |
| | | | TN BSPT NR vnútorné pravostranné prevedenie pre obrábanie BSPT závitov a plynulý rez. | | | | | | | | | |
| TN 16NR140BSPT | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 14.0 | 1.5 | 1.2 |
| TN 16NR110BSPT | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 11.0 | 1.5 | 1.2 |
| |  | | | | | | | | | | | |
| | | | TN BSPT NL vnútorné ľavostranné prevedenie pre obrábanie BSPT závitov a plynulý rez. | | | | | | | | | |
| TN 16NL280BSPT | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 28.0 | 0.8 | 0.8 |
| TN 16NL190BSPT | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 19.0 | 1.5 | 1.2 |
| TN 16NL140BSPT | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 14.0 | 1.5 | 1.2 |
| TN 16NL110BSPT | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 11.0 | 1.5 | 1.2 |

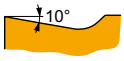
## TN NPT EXT

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |



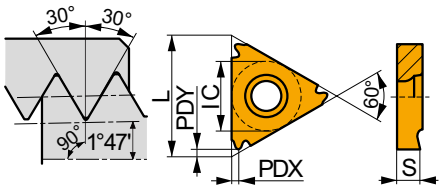

Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| |  | | | | | | | | | | | |
| | | | TN NPT ER vonkajšie pravostranné prevedeniepre obrábanie NPT závitov a plynulý rez. | | | | | | | | | |
| TN 16ER270NPT | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 27.0 | 0.8 | 0.7 |
| TN 16ER180NPT | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 18.0 | 0.8 | 0.7 |
| TN 16ER140NPT | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | – | 14.0 | 1.5 | 1.1 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 14.0 | 1.5 | 1.1 |
| TN 16ER115NPT | T8010 | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | – | 11.5 | 1.5 | 1.1 |
| | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 11.5 | 1.5 | 1.1 |
| TN 16ER080NPT | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 8.0 | 1.6 | 1.1 |

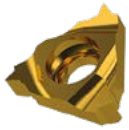
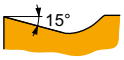
# TN NPT INT

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 11 | 6.350 | 11.00 | 3.00 |
| 16 | 9.525 | 16.50 | 3.47 |



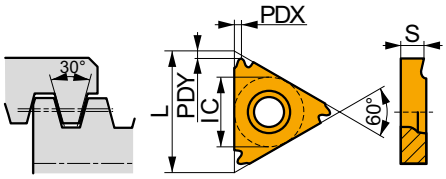

Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | | | | | | | | | | |
| | | | TN NPT NR vnútorné pravostranné prevedeniepre obrábanie NPT závitov a plynulý rez. | | | | | | | | | |
| **TN 11NR180NPT** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 18.0 | 0.8 | 0.7 |
| **TN 11NR140NPT** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 14.0 | 1.0 | 0.7 |
| **TN 16NR140NPT** | **T8010** | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | – | 14.0 | 1.5 | 1.1 |
| | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 14.0 | 1.5 | 1.1 |
| **TN 16NR115NPT** | **T8010** | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | – | 11.5 | 1.5 | 1.1 |
| | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 11.5 | 1.5 | 1.1 |
| **TN 16NR080NPT** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 8.0 | 1.6 | 1.1 |

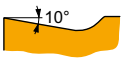
# TN TR EXT

PRAMET

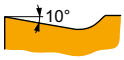
| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |
| 22 | 12.700 | 22.00 | 4.71 |




Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| |  | | | | | | | | | | | |
| | | | TN TR ER vonkajšie pravostranné prevedenie pre obrábanie Trapézových závitov a plynulý rez. | | | | | | | | | |
| **TN 16ER150TR** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.50 | – | 0.8 | 0.9 |
| **TN 16ER200TR** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 2.00 | – | 1.5 | 1.3 |
| **TN 16ER300TR** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 3.00 | – | 1.6 | 1.3 |
| **TN 22ER400TR** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 4.00 | – | 2.2 | 1.8 |
| **TN 22ER500TR** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 5.00 | – | 2.2 | 1.8 |

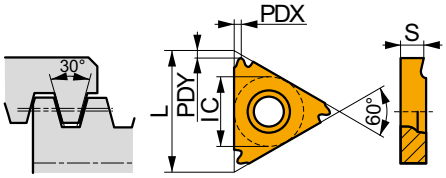
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| |  | | | | | | | | | | | |
| TN TR EL vonkajšie ľavostranné prevedenie pre obrábanie Trapézových závitov a plynulý rez. | | | | | | | | | | | | |
| TN 16EL150TR | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.50 | – | 0.8 | 0.9 |
| TN 16EL200TR | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 2.00 | – | 1.5 | 1.3 |
| TN 16EL300TR | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 3.00 | – | 1.6 | 1.3 |
| TN 22EL400TR | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 4.00 | – | 2.2 | 1.8 |
| TN 22EL500TR | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 5.00 | – | 2.2 | 1.8 |

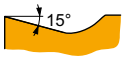
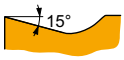
## TN TR INT

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |
| 22 | 12.700 | 22.00 | 4.71 |



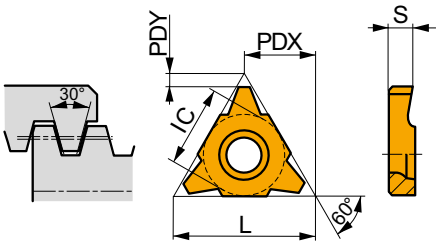

Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| |  | | | | | | | | | | | |
| TN TR NR nútorné pravostranné prevedenie pre obrábanie Trapézových závitov a plynulý rez. | | | | | | | | | | | | |
| TN 16NR150TR | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.50 | – | 0.8 | 0.9 |
| TN 16NR200TR | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 2.00 | – | 1.5 | 1.3 |
| TN 16NR300TR | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 3.00 | – | 1.6 | 1.3 |
| TN 22NR400TR | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 4.00 | – | 2.2 | 1.8 |
| TN 22NR500TR | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 5.00 | – | 2.2 | 1.8 |
| |  | | | | | | | | | | | |
| TN TR NL vnútorné ľavostranné prevedenie pre obrábanie Trapézových závitov a plynulý rez. | | | | | | | | | | | | |
| TN 16NL150TR | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.50 | – | 0.8 | 0.9 |
| TN 16NL200TR | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 2.00 | – | 1.5 | 1.3 |
| TN 16NL300TR | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 3.00 | – | 1.6 | 1.3 |
| TN 22NL400TR | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 4.00 | – | 2.2 | 1.8 |
| TN 22NL500TR | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 5.00 | – | 2.2 | 1.8 |

# TN TR-S EXT

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 22 | 12.700 | 22.00 | 4.60 |



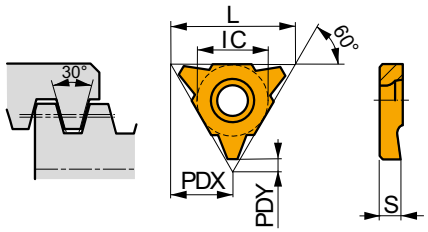

Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | 10° | | | | | | | | | | | |
| | | | 1 U E | | | | | | | | | |
| | | | TN TR-S PP EN vonkajšie ľavo a pravostranné prevedenie pre obrábanie Trápézových závitov a plynulý rez. | | | | | | | | | |
| TN 22EN600TR | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | 6.00 | – | 11.0 | 1.9 |
| TN 22EN700TR | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | 7.00 | – | 11.0 | 2.3 |

# TN TR-S INT

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 22 | 12.700 | 22.00 | 4.60 |

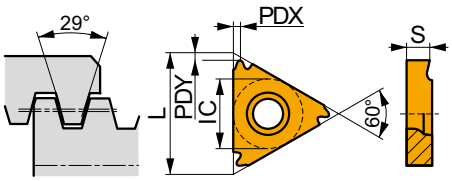



Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

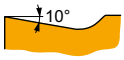
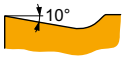
| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | 15° | | | | | | | | | | | |
| | | | 1 U E | | | | | | | | | |
| | | | TN M60-S PP NN vnútorné ľavo a pravostranné prevedenie pre obrábanie Metrických a Unifikovaných závitov a plynulý rez. | | | | | | | | | |
| TN 22NN600TR | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | 6.00 | – | 11.0 | 1.9 |
| TN 22NN700TR | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | 7.00 | – | 11.0 | 2.3 |

# TN ACME EXT

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |
| 22 | 12.700 | 22.00 | 4.71 |



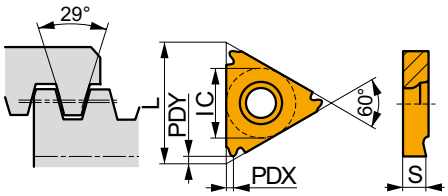

Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| |  | | | | | | | | | | | |
| TN ACME ER vonkajšie pravostranné prevedenie pre obrábanie ACME závitov a plynulý rez. | | | | | | | | | | | | |
| **TN 16ER120ACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 12.0 | 1.5 | 1.3 |
| **TN 16ER100ACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 10.0 | 1.5 | 1.3 |
| **TN 16ER080ACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 8.0 | 1.5 | 1.3 |
| **TN 22ER060ACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 6.0 | 2.5 | 2.0 |
| **TN 22ER050ACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 5.0 | 2.3 | 2.0 |
| |  | | | | | | | | | | | |
| TN ACME EL vonkajšie ľavostranné prevedenie pre obrábanie ACME závitov a plynulý rez. | | | | | | | | | | | | |
| **TN 16EL120ACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 12.0 | 1.5 | 1.3 |
| **TN 16EL100ACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 10.0 | 1.5 | 1.3 |
| **TN 16EL080ACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 8.0 | 1.5 | 1.3 |
| **TN 22EL060ACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 6.0 | 2.5 | 2.0 |
| **TN 22EL050ACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 5.0 | 2.3 | 2.0 |

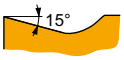
# TN ACME INT

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |
| 22 | 12.700 | 22.00 | 4.71 |




Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| |  | | | | | | | | | | | |
| TN ACME NR vnútorné pravostranné prevedenie pre obrábanie ACME závitov a plynulý rez. | | | | | | | | | | | | |
| **TN 16NR120ACME** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 12.0 | 1.5 | 1.3 |
| **TN 16NR100ACME** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 10.0 | 1.5 | 1.3 |
| **TN 16NR080ACME** | **T8030**[1] | – | 160 | 95 | 150 | 480 | 40 | – | – | 8.0 | 1.5 | 1.3 |
| **TN 22NR060ACME** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 6.0 | 2.5 | 2.0 |
| **TN 22NR050ACME** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 5.0 | 2.3 | 2.0 |
| | | | | | | | | | | | | |
| TN ACME NL vnútorné ľavostranné prevedenie pre obrábanie ACME závitov a plynulý rez. | | | | | | | | | | | | |
| **TN 16NL120ACME** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 12.0 | 1.5 | 1.3 |
| **TN 16NL100ACME** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 10.0 | 1.5 | 1.3 |
| **TN 16NL080ACME** | **T8030**[1] | – | 160 | 95 | 150 | 480 | 40 | – | – | 8.0 | 1.5 | 1.3 |
| **TN 22NL060ACME** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 6.0 | 2.5 | 2.0 |
| **TN 22NL050ACME** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 5.0 | 2.3 | 2.0 |

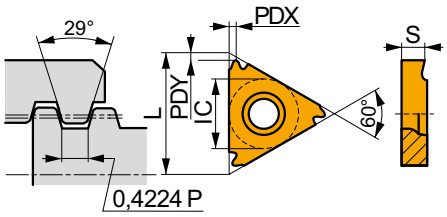
[1] Držiaky nástrojov sa musia upraviť.

NEW

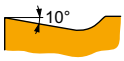
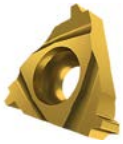
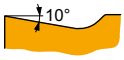
# TN STACME EXT

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |




Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

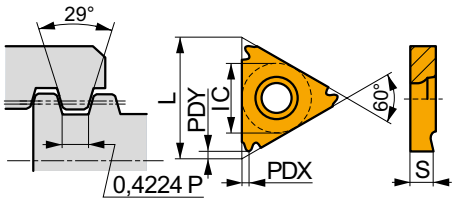
| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| |  | | | | | | | | | | | |
| TN STACME ER vonkajšie pravostranné prevedenie pre obrábanie plytkých ACME závitov a plynulý rez. | | | | | | | | | | | | |
| TN 16ER160STACME | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 16.0 | 0.8 | 0.8 |
| TN 16ER120STACME | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 12.0 | 0.8 | 0.8 |
| TN 16ER100STACME | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 10.0 | 1.5 | 1.3 |
| TN 16ER080STACME | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 8.0 | 1.5 | 1.3 |
| TN 16ER060STACME | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 6.0 | 1.4 | 1.3 |
|  |  | | | | | | | | | | | |
| TN STACME EL vonkajšie ľavostranné prevedenie pre obrábanie plytkých ACME závitov a plynulý rez. | | | | | | | | | | | | |
| TN 16EL160STACME | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 16.0 | 0.8 | 0.8 |
| TN 16EL120STACME | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 12.0 | 0.8 | 0.8 |
| TN 16EL100STACME | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 10.0 | 1.5 | 1.3 |
| TN 16EL080STACME | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 8.0 | 1.5 | 1.3 |
| TN 16EL060STACME | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 6.0 | 1.4 | 1.3 |

NEW

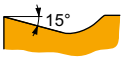
# TN STACME INT

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |




Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

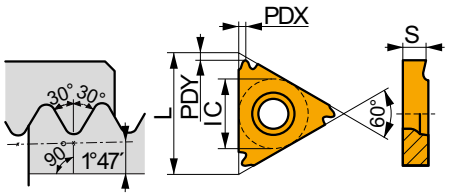
| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| |  | | | | | | | | | | | |
| TN STACME NR vnútorné pravostranné prevedenie pre obrábanie plytkých ACME závitov a plynulý rez. | | | | | | | | | | | | |
| TN 16NR160STACME | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 16.0 | 0.8 | 0.8 |
| TN 16NR120STACME | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 12.0 | 0.8 | 0.8 |
| TN 16NR100STACME | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 10.0 | 1.5 | 1.3 |
| TN 16NR080STACME | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 8.0 | 1.5 | 1.3 |
| TN 16NR060STACME | T8030[1] | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 6.0 | 1.3 | 1.3 |
| | | | | | | | | | | | | |
| TN STACME NL vnútorné ľavostranné prevedenie pre obrábanie plytkých ACME závitov a plynulý rez. | | | | | | | | | | | | |
| TN 16NL160STACME | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 16.0 | 0.8 | 0.8 |
| TN 16NL120STACME | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 12.0 | 0.8 | 0.8 |
| TN 16NL100STACME | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 10.0 | 1.5 | 1.3 |
| TN 16NL080STACME | T8030 | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 8.0 | 1.5 | 1.3 |
| TN 16NL060STACME | T8030[1] | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 6.0 | 1.3 | 1.3 |

[1] Držiaky nástrojov sa musia upraviť.

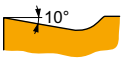
# TN API RD EXT

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |



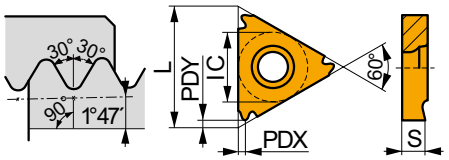

Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| |  | | | | | | | | | | | |
| | | | TN API ER vonkajšie pravostranné prevedenie pre obrábanie API závitov a plynulý rez. | | | | | | | | | |
| **TN 16ER100API-RD01** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 10.0 | 1.5 | 1.2 |
| **TN 16ER080API-RD01** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 8.0 | 1.5 | 1.2 |

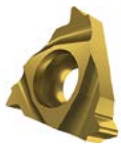
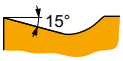
# TN API RD INT

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |



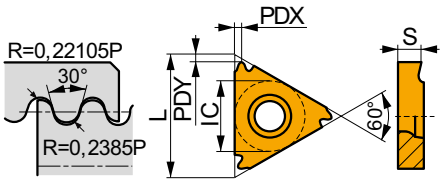

Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | | | | | | | | | | |
| | | | TN API NR vnútorné pravostranné prevedenie pre obrábanie API závitov a plynulý rez. | | | | | | | | | |
| **TN 16NR100API-RD01** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 10.0 | 1.5 | 1.2 |
| **TN 16NR080API-RD01** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 8.0 | 1.5 | 1.2 |

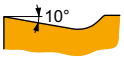
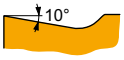
# TN RD EXT

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |
| 22 | 12.700 | 22.00 | 4.71 |




Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

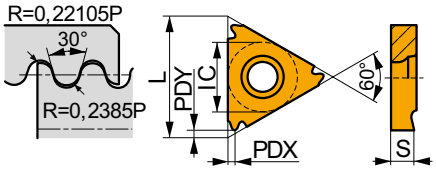
| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| |  | | | | | | | | | | | |
| TN RD ER vonkajšie pravostranné prevedenie pre obrábanie Metrických Oblých závitov a plynulý rez. | | | | | | | | | | | | |
| **TN 16ER100RD** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 10.0 | 1.5 | 1.2 |
| **TN 16ER080RD** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 8.0 | 1.5 | 1.2 |
| **TN 16ER060RD** | **T8030**[1] | – | 160 | 95 | 150 | 480 | 40 | – | – | 6.0 | 1.5 | 1.2 |
| **TN 22ER060RD** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 6.0 | 2.5 | 1.8 |
| |  | | | | | | | | | | | |
| TN RD EL vonkajšie ľavostranné prevedenie pre obrábanie Metrických Oblých závitov a plynulý rez. | | | | | | | | | | | | |
| **TN 16EL100RD** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 10.0 | 1.5 | 1.2 |
| **TN 16EL080RD** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 8.0 | 1.5 | 1.2 |
| **TN 16EL060RD** | **T8030**[1] | – | 160 | 95 | 150 | 480 | 40 | – | – | 6.0 | 1.5 | 1.2 |
| **TN 22EL060RD** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 6.0 | 2.5 | 1.8 |

[1] Držiaky nástrojov sa musia upraviť.

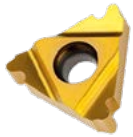
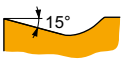
# TN RD INT

PRAMET

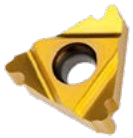
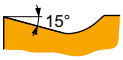
| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |
| 22 | 12.700 | 22.00 | 4.71 |




Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | | | | | | | | | | |
| TN RD NR vnútorné pravostranné prevedenie pre obrábanie Metrických Oblých závitov a plynulý rez. | | | | | | | | | | | | |
| **TN 16NR100RD** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 10.0 | 1.5 | 1.2 |
| **TN 16NR080RD** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 8.0 | 1.5 | 1.2 |

Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

| Produkt | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | | | | | | | | | | |
| TN RD NR vnútorné pravostranné prevedenie pre obrábanie Metrických Oblých závitov a plynulý rez. | | | | | | | | | | | | |
| **TN 16NR060RD** | **T8030**[1] | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 6.0 | 1.5 | 1.2 |
| **TN 22NR060RD** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 6.0 | 2.5 | 1.8 |
| | | | | | | | | | | | | |
| TN RD NR vonkajšie ľavostranné prevedenie pre obrábanie Metrických Oblých závitov a plynulý rez. | | | | | | | | | | | | |
| **TN 16NL100RD** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 10.0 | 1.5 | 1.2 |
| **TN 16NL080RD** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 8.0 | 1.5 | 1.2 |
| **TN 16NL060RD** | **T8030**[1] | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 6.0 | 1.5 | 1.2 |
| **TN 22NL060RD** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 6.0 | 2.5 | 1.8 |

[1] Držiaky nástrojov sa musia upraviť.

# SE(RL)

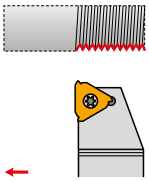
P M K N S H

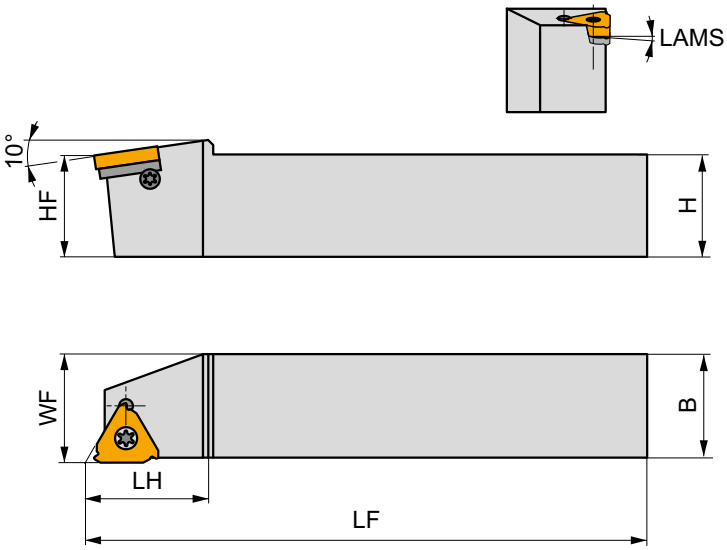
PRAMET

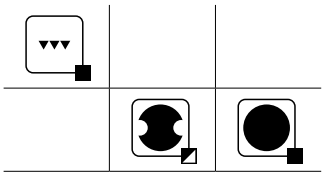
S

## Vonkajší závitový nôž s upínaním skrutkou pre doštičky TN 16 alebo 22

Pravý/Ľavý nôž s upínaním skrutkou pre sústruženie vonkajších závitov s doštičkami TN16 alebo 22 ER/EL. Vhodný pre výrobu závitov s metrickým alebo palcovým profilom. Taktiež vhodný pre zapichovanie do malých hĺbok. Teleso je povrchovo upravené pre predĺženie životnosti nástroja.





| | Produkt | H (mm) | HF (mm) | B (mm) | WF (mm) | LF (mm) | LH (mm) | LAMS (°) | | |
|---|---|---|---|---|---|---|---|---|---|---|
| R | **SER 2020 K 16** | 20 | 20 | 20 | 20 | 125 | 22.5 | – | GI068 | Z12 |
| | **SER 2525 M 16** | 25 | 25 | 25 | 25 | 150 | 24 | – | GI068 | Z12 |
| | **SER 3225 P 16** | 32 | 32 | 25 | 25 | 170 | 24.5 | – | GI068 | Z12 |
| | **SER 2525 M 22-A** | 25 | 25 | 25 | 25 | 150 | 25.5 | – | GI071 | Z13 |
| | **SER 3225 P 22-A** | 32 | 32 | 25 | 25 | 170 | 25.5 | – | GI071 | Z13 |
| L | **SEL 2020 K 16** | 20 | 20 | 20 | 20 | 125 | 22.5 | – | GI068 | Z12 |
| | **SEL 2525 M 16** | 25 | 25 | 25 | 25 | 150 | 24 | – | GI068 | Z12 |
| | **SEL 3225 P 16** | 32 | 32 | 25 | 25 | 170 | 24.5 | – | GI068 | Z12 |
| | **SEL 2525 M 22-A** | 25 | 25 | 25 | 25 | 150 | 25.5 | – | GI071 | Z13 |
| | **SEL 3225 P 22-A** | 32 | 32 | 25 | 25 | 170 | 25.5 | – | GI071 | Z13 |

| | | |
|---|---|---|
| GI068 | TN 16ER.. | TN 16EL.. |
| GI071 | TN 22ER.. | TN 22EL.. |

| | | Nm | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| Z12 | US 3512A-T15P | 3.0 | M 3.5 | 12.7 | – | HS 0304 | FLAG T15P | HXK 2.5 | 604 |
| Z13 | US 4514A-T20 | 5.0 | M 4.5 | 14 | SP 0405 | – | FLAG T20 | – | 604 |

# SE(RL)-S

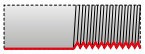
P M K N S H

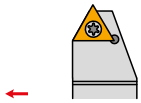
PRAMET

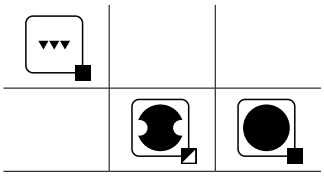
S

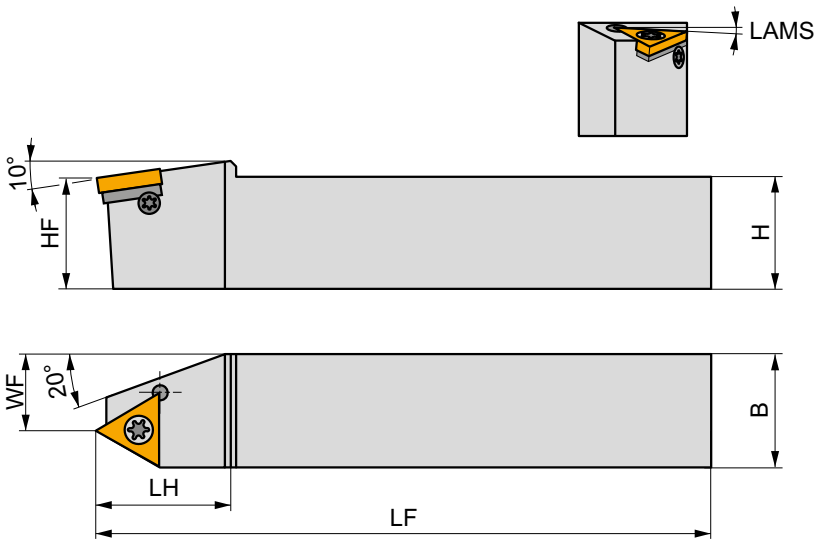
## Vonkajší závitový nôž s upínaním skrutkou pre neutrálne doštičky TN 22

Pravý/Ľavý nôž s upínaním skrutkou pre sústruženie veľkých vonkajších závitov s doštičkami TN22 EN. Vhodný pre výrobu závitov s metrickým alebo palcovým profilom. Teleso je povrchovo upravené pre predĺženie životnosti nástroja.









| | Produkt | H (mm) | HF (mm) | B (mm) | WF (mm) | LF (mm) | LH (mm) | LAMS (°) | | |
|---|---|---|---|---|---|---|---|---|---|---|
| R | SER-S 2525 M 22-A | 25 | 25 | 25 | 14 | 150 | 30 | – | GI086 | Z15 |
| | SER-S 3225 P 22-A | 32 | 32 | 25 | 14 | 170 | 30 | – | GI086 | Z15 |
| L | SEL-S 2525 M 22-A | 25 | 25 | 25 | 14 | 150 | 30 | – | GI086 | Z15 |
| | SEL-S 3225 P 22-A | 32 | 32 | 25 | 14 | 170 | 30 | – | GI086 | Z15 |

| | |
|---|---|
| GI086 | TN 22EN.. |

| | | | | | | | |
|---|---|---|---|---|---|---|---|
| Z15 | US 4514A-T20 | 5.0 Nm | M 4.5 | 14 | SP 0405 | FLAG T20 | 604 |

# SI(RL)

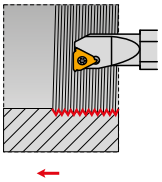
P M K N S H

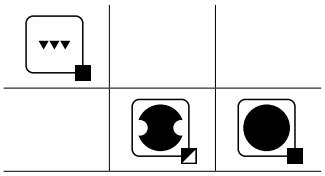
PRAMET

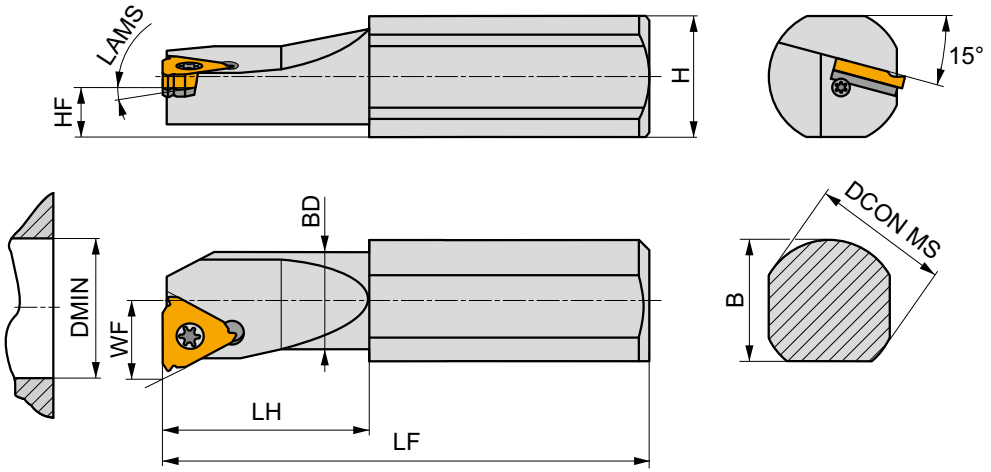
S

## Vnútorný závitový nôž s upínaním skrutkou pre doštičky TN 11, 16 alebo 22

Pravý/Ľavý nôž s upínaním skrutkou pre sústruženie vnútorných závitov s doštičkami TN11, 16 alebo 22 NR/NL. Vhodný pre výrobu závitov s metrickým alebo palcovým profilom. Taktiež vhodný pre zapichovanie do malých hĺbok. Dostupný s veľkosťou stopky Ø16 až Ø40mm. Teleso je povrchovo upravené pre predĺženie životnosti nástroja.








| | Produkt | B (mm) | DCON MS (mm) | DMIN (mm) | BD (mm) | WF (mm) | H (mm) | HF (mm) | LF (mm) | LH (mm) | LAMS (°) | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | SIR 0010 K 11-0 | 14.5 | 16 | 13 | 10 | 7.45 | 14 | 7 | 125 | 25 | 0 | – | GI085 | Z11 |
| | SIR 0010 K 11-1 | 14.5 | 16 | 13 | 10 | 7.45 | 14 | 7 | 125 | 25 | 1 | – | GI085 | Z11 |
| | SIR 0013 M 11-0 | 14.5 | 16 | 16 | 13 | 9 | 14 | 7 | 150 | 32 | 0 | – | GI085 | Z11 |
| | SIR 0013 M 11-1 | 14.5 | 16 | 16 | 13 | 9 | 14 | 7 | 150 | 32 | 1 | – | GI085 | Z11 |
| | SIR 1416 N 16-0 | 14 | 16 | 22 | 17 | 11.4 | 14.5 | 7.5 | 160 | – | 0 | – | GI022 | Z9 |
| | SIR 1416 N 16-1 | 14 | 16 | 22 | 17 | 11.4 | 14.5 | 7.5 | 160 | – | 1 | – | GI022 | Z9 |
| | SIR 1416 N 16-2 | 14 | 16 | 16.5 | 15.5 | 10.6 | 14.5 | 7.5 | 160 | 40 | 2 | ✓ | GI022 | Z10 |
| | SIR 1820 P 16 | 18.5 | 20 | 27 | 21 | 13.85 | 18 | 9 | 170 | – | – | – | GI022 | Z12 |
| | SIR 2325 Q 16 | 23.5 | 25 | 29 | 26 | 16.55 | 23 | 11.5 | 180 | – | – | – | GI022 | Z12 |
| | SIR 2532 S 16 | 30 | 32 | 36 | 32 | 19.75 | 25 | 12.5 | 250 | – | – | – | GI022 | Z12 |
| | SIR 2532 S 22-2 | 30 | 32 | 25 | 25 | 16.65 | 25 | 12.5 | 250 | 80 | 2 | ✓ | GI076 | Z14 |
| | SIR 2532 S 22-A | 30 | 32 | 36 | 32 | 21.65 | 25 | 12.5 | 250 | – | – | – | GI076 | Z13 |
| | SIR 3240 T 22-A | 38 | 40 | 48 | 40 | 25.85 | 32 | 16 | 300 | – | – | – | GI076 | Z13 |
| L | SIL 0010 K 11-0 | 14.5 | 16 | 13 | 10 | 7.45 | 14 | 7 | 125 | 25 | 0 | – | GI085 | Z11 |
| | SIL 0010 K 11-1 | 14.5 | 16 | 13 | 10 | 7.55 | 14 | 7 | 125 | 25 | 1 | – | GI085 | Z11 |
| | SIL 0013 M 11-0 | 14.5 | 16 | 16 | 13 | 9 | 14 | 7 | 150 | 32 | 0 | – | GI085 | Z11 |
| | SIL 0013 M 11-1 | 14.5 | 16 | 16 | 13 | 9 | 14 | 7 | 150 | 32 | 1 | – | GI085 | Z11 |
| | SIL 1416 N 16-0 | 14 | 16 | 22 | 17 | 11.4 | 14.5 | 7.5 | 160 | – | 0 | – | GI022 | Z9 |
| | SIL 1416 N 16-1 | 14 | 16 | 22 | 17 | 11.4 | 14.5 | 7.5 | 160 | – | 1 | – | GI022 | Z9 |
| | SIL 1416 N 16-2 | 14 | 16 | 16.5 | 15.5 | 10.6 | 14.5 | 7.5 | 160 | 40 | 2 | ✓ | GI022 | Z10 |
| | SIL 1820 P 16 | 18.5 | 20 | 27 | 21 | 13.85 | 18 | 9 | 170 | – | – | – | GI022 | Z12 |
| | SIL 2325 Q 16 | 23.5 | 25 | 29 | 26 | 16.55 | 23 | 11.5 | 180 | – | – | – | GI022 | Z12 |
| | SIL 2532 S 16 | 30 | 32 | 36 | 32 | 19.75 | 25 | 12.5 | 250 | – | – | – | GI022 | Z12 |
| | SIL 2532 S 22-2 | 30 | 32 | 25 | 25 | 16.65 | 25 | 12.5 | 250 | 80 | 2 | ✓ | GI076 | Z14 |
| | SIL 2532 S 22-A | 30 | 32 | 36 | 32 | 21.65 | 25 | 12.5 | 250 | – | – | – | GI076 | Z13 |
| | SIL 3240 T 22-A | 38 | 40 | 48 | 40 | 25.85 | 32 | 16 | 300 | – | – | – | GI076 | Z13 |

| | | |
|---|---|---|
| GI022 | TN 16NR.. | TN 16NL.. |
| GI076 | TN 22NR.. | TN 22NL.. |
| GI085 | TN 11NR.. | TN 11NL.. |

| | | Nm | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| Z10 | US 3510A-T15P | 3.0 | M 3.5 | 10.6 | – | – | FLAG T15P | – | – |
| Z11 | US 2506-T07P | 0.9 | M 2.5 | 6.3 | – | – | FLAG T07P | – | – |
| Z12 | US 3512A-T15P | 3.0 | M 3.5 | 12.7 | – | HS 0304 | FLAG T15P | HXK 2.5 | 604 |
| Z13 | US 4514A-T20 | 5.0 | M 4.5 | 14 | SP 0405 | – | FLAG T20 | – | 604 |
| Z14 | US 4514A-T20 | 5.0 | M 4.5 | 14 | – | – | FLAG T20 | – | – |
| Z9 | US 3510A-T15P | 3.0 | M 3.5 | 10.6 | – | – | FLAG T15P | – | P-16 |

# SI(RL)-S

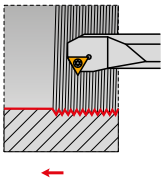
P M K N S H

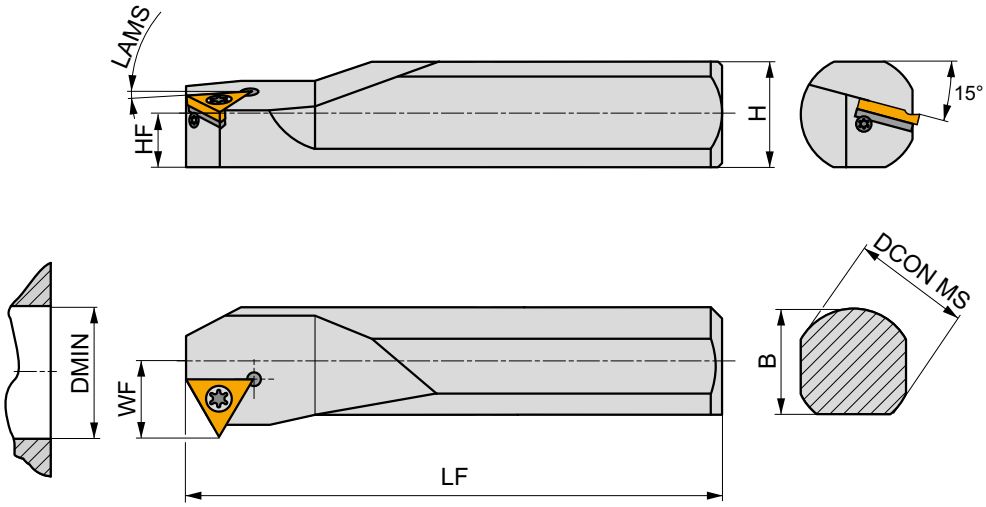
PRAMET

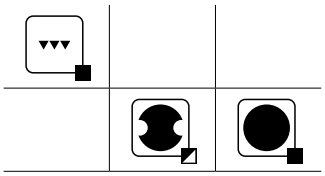
S

## Vnútorný závitový nôž s upínaním skrutkou pre neutrálne doštičky TN 22

Pravý/Ľavý nôž s upínaním skrutkou pre sústruženie veľkých vnútorných závitov s doštičkami TN22 NN. Vhodný pre výrobu závitov s metrickým alebo palcovým profilom. Minimálny priemer otvoru pre sústruženie Ø39mm. Dostupný s veľkosťou stopky Ø32 až Ø40mm. Teleso je povrchovo upravené pre predĺženie životnosti nástroja.





| | Produkt | B (mm) | DCON MS (mm) | DMIN (mm) | WF (mm) | H (mm) | HF (mm) | LF (mm) | LAMS (°) | | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| R | SIR-S 2532 S 22-A | 30 | 32 | 39 | 22.3 | 25 | 12.5 | 250 | – | GI107 | Z15 |
| | SIR-S 3240 T 22-A | 38 | 40 | 48 | 27 | 32 | 16 | 300 | – | GI107 | Z15 |
| L | SIL-S 2532 S 22-A | 30 | 32 | 39 | 22.3 | 25 | 12.5 | 250 | – | GI107 | Z15 |
| | SIL-S 3240 T 22-A | 38 | 40 | 48 | 27 | 32 | 16 | 300 | – | GI107 | Z15 |

| | |
|---|---|
| GI107 | TN 22NN.. |

| | | | | | | | |
|---|---|---|---|---|---|---|---|
| Z15 | US 4514A-T20 | 5.0 Nm | M 4.5 | 14 | SP 0405 | FLAG T20 | 604 |

DORMER PRAMET

# VŠETKY MATERIÁLY

V našej aplikácii kalkulačky nájdete informácie o obrábaní ocele, nehrdzavejúcej ocele, liatiny, superzliatin alebo neželezných materiálov. Stiahnite si ju z obchodu s aplikáciami. **Jednoducho Spoľahliví.**