

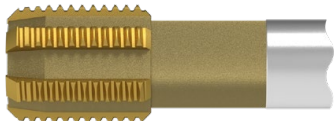
## Novi proizvodi za strojarske tehničare

**NEW** Uvaljiva HSS-E s trakama od tvrdog metala



M

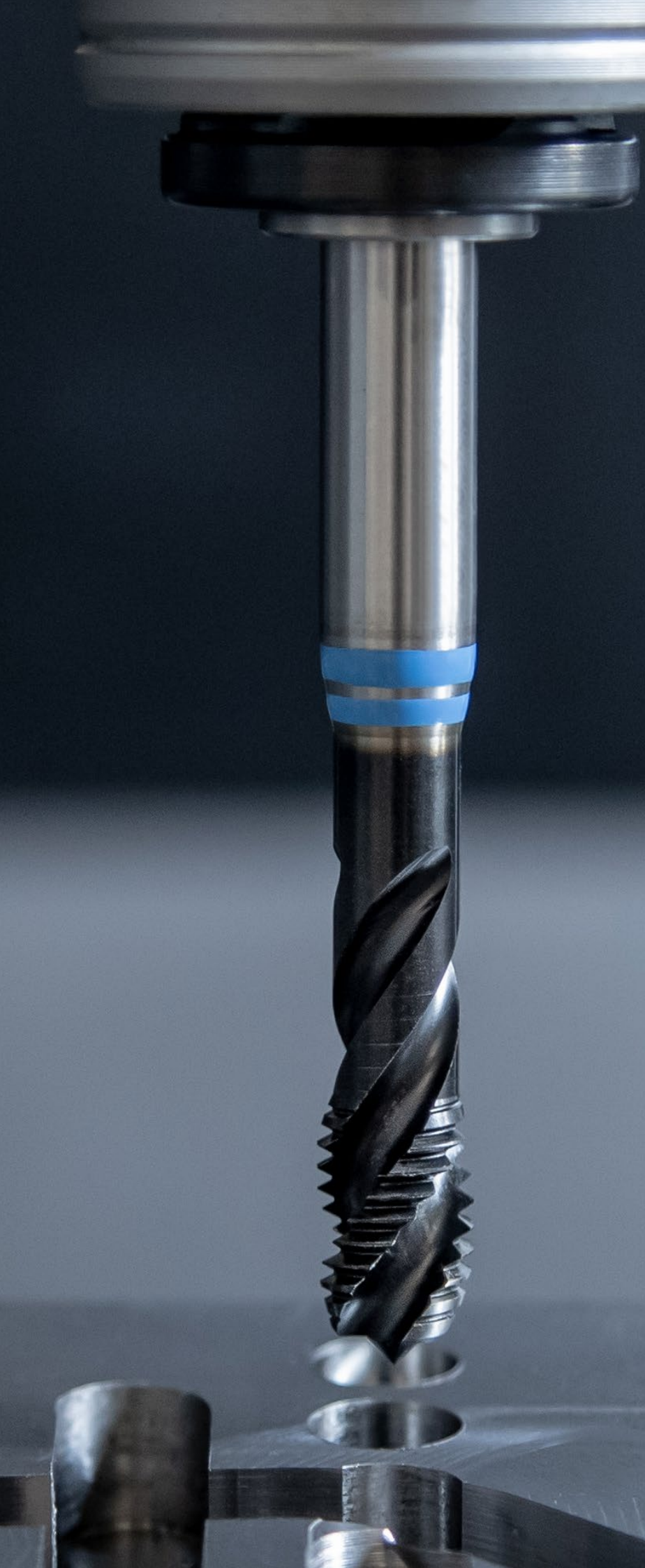
→ Stranica 52



MF

→ Stranica 73

- ▲ Dugi vijek trajanja, zahvaljujući inovativnoj kombinaciji fleksibilnog HSS osnovnog materijala nosača i otpornih na habanje, zalemljenih traka od tvrdog metala
- ▲ Univerzalna primjena u svim savitljivim materijalima
- ▲ Smanjenje troškova alata



Obrada provrta

- 1 HSS svrdla
- 2 VHM svrdla
- 3 Svrdla s okretnim ploščicama
- 4 Razvrtači i upuštači
- 5 Alati za istokarivanje

Obrada navoja

- 6 Navojna svrdla i alati za oblikovanje navoja
- 7 Cirkularna glodala i glodala za navoje
- 8 Alati za tokarenje navoja

Obrada tokarenjem

- 9 Tokarski alati s okretnim ploščicama
- 10 Multifunkcionalni alati – EcoCut i FreeTurn
- 11 Ubodni alati
- 12 Minijaturni tokarski alati

Obrada glodanjem

- 13 HSS glodala
- 14 VHM glodala
- 15 Alati za glodanje s okretnim ploščicama

Naprezanje alata

- 16 Prihvati alata i pribor
- 17 Stezanje obratka
- 18 Primjeri materijala

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## WNT \ Performance

Alati vrhunske kvalitete za vrhunske radne efekte.

Alati vrhunske kvalitete iz linije proizvoda **WNT Performance** koncipirani su za specijalne primjene i odlikuju se izvanrednim radnim karakteristikama. Ako u svojoj proizvodnji postavite najviše zahtjeve u smislu radnog učinka te očekujete najbolje moguće rezultate, preporučamo vrhunske alate iz ove linije proizvoda.

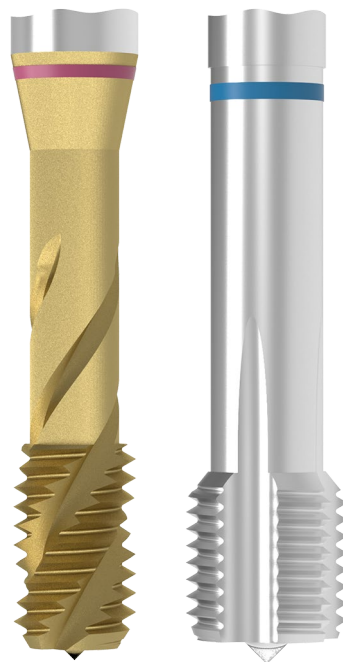
## WNT \ Standard

Kvalitetni alati za standardne primjene.

Alati iz linije proizvoda **WNT Standard** visoko su kvalitetni, snažni i pouzdani te uživaju veliko povjerenje naših kupaca diljem svijeta. Alati iz ove linije proizvoda prvi su izbor za mnoge standardne primjene i jamče vam optimalne rezultate.

## Objašnjenje simbola

|                                                                                     |                                                                                                                                |
|-------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------|
| <b>M</b>                                                                            | Vrsta navoja<br>Objašnjenje za vrste navoja pronađite na → <b>stranici 6.</b>                                                  |
| <b>UNI NCW</b>                                                                      | Područje primjene<br>Posebna svojstva<br>Objašnjenje područja primjene/posebna svojstva možete pronaći na → <b>stranici 7.</b> |
| <b>C</b><br>2-3                                                                     | Oblik zasjeka<br>Objašnjenje tolerancija oblika zasjeka pronađite na → <b>stranici 6.</b>                                      |
| <b>ISO 2 6H</b>                                                                     | Tolerancija<br>Objašnjenje tolerancija pronađite na → <b>stranici 105.</b>                                                     |
| <b>TiN</b>                                                                          | Prevlaka<br>Objašnjenje prevlaka možete pronaći na → <b>stranici 108.</b>                                                      |
|  | Dovod rashladnog sredstva                                                                                                      |

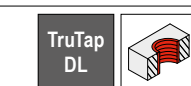
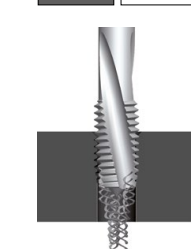
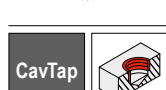
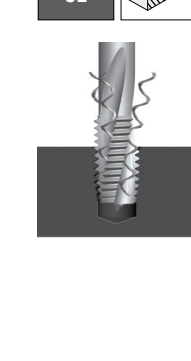
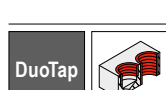


|                                                                                        |                                                                                                |
|----------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------|
| <b>Prsten u boji</b><br>Objašnjenje prstenova u boji pronađite na → <b>stranici 5.</b> |                                                                                                |
| <b>HSS-E</b>                                                                           | Rezni materijal<br>Objašnjenje tolerancija reznih materijala pronađite na → <b>stranici 6.</b> |
| <b>FHA 42°</b>                                                                         | Kut zakretanja                                                                                 |
| $\leq 1100 \text{ N/mm}^2$                                                             | Vlačna čvrstoća koja se obrađuje                                                               |
|   | Prolazni navoj                                                                                 |
|   | Slijepi navoj                                                                                  |
|   | Prolazni i slijepi navoj                                                                       |



Podaci o rezanju u velikoj mjeri ovise o vanjskim uvjetima, kao npr. stabilnosti naprezanja alata i radnog komada, materijalu i vrsti stroja! Navedene vrijednosti predstavljaju moguće podatke o rezanju, koji se moraju korigirati prema uvjetima primjene prema gore ili prema dolje!

## Vrste alata

|                                                                                                                                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|      | <b>Ureznik za prolazne provrte tip TruTap</b> <ul style="list-style-type: none"> <li>▲ Za prolazni navoj do 4xD</li> <li>▲ Oblik zasjeka B: 3,5–5 stupanjski zasjek, s zasjekom</li> <li>▲ S ravnim žljebovima</li> <li>▲ Među ostalim pogodan za sinkronu obradu, s Weldon površinama i s iznimno dugom izvedbom</li> <li>▲ Zahvaljujući specijalnoj geometriji utora za strugotine, strugotine se odvođe u smjeru rezanja</li> </ul>                                                                                                                                        |   <b>Ureznik za prolazne provrte tip TruTap DL</b> <ul style="list-style-type: none"> <li>▲ Za prolazni navoj do 4xD</li> <li>▲ Oblik zasjeka D: 3,5–5 stupanjski zasjek, bez zasjeka</li> <li>▲ 15° lijevih navoja</li> <li>▲ Pogodan za čelik, titanij i legure titanija te Inconel 718</li> <li>▲ Strugotine se odvođe u smjeru rezanja</li> </ul>                                                                                                                                                                                                                                     |
|      | <b>Ureznik za slijepe provrte tip CavTap</b> <ul style="list-style-type: none"> <li>▲ Za slijepe provrte do 3xD</li> <li>▲ Oblik zasjeka C: 2–3 stupanjski zasjek, bez oštrica za guljenje</li> <li>▲ Oblik zasjeka E: 1,5–2 stupanjski zasjek, bez oštrica za guljenje</li> <li>▲ (35°, 42°, 45°, 50°) s desnim navojima jako zakrenutim</li> <li>▲ Među ostalim pogodan za sinkronu obradu, s Weldon površinama, s iznimno dugom izvedbom i s unutarnjim hlađenjem</li> <li>▲ Kroz vrlo zakrivljene spiralne utore se strugotine sigurno odvođe u smjeru rezanja</li> </ul> |   <b>Ureznik za slijepe provrte tip CavTap SL</b> <ul style="list-style-type: none"> <li>▲ Za slijepe provrte do 2xD</li> <li>▲ Oblik zasjeka C: 2–3 stupanjski zasjek, bez zasjeka</li> <li>▲ Oblik zasjeka E: 1,5–2 stupanjski zasjek, bez zasjeka</li> <li>▲ (15°, 25°, 30°) s desnim navojima lagano zakrenuti</li> <li>▲ Pogodan za čelik, titanij i legure titanija te Inconel 718</li> <li>▲ Među ostalim pogodan za sinkronu obradu, u iznimno dugoj izvedbi i s unutarnjim hlađenjem</li> <li>▲ Također primjenjiv za teške uvjete primjene kao kod poprečnih provrta</li> </ul> |
|   | <b>Ureznik za proboje i slijepe prolazne tip DuoTap</b> <ul style="list-style-type: none"> <li>▲ Za navoje slijepih i prolaznih provrta do 2xD</li> <li>▲ Oblik zasjeka C: 2–3 stupanjski zasjek, bez zasjeka</li> <li>▲ Oblik zasjeka D: 3,5–5 stupanjski zasjek, bez zasjeka</li> <li>▲ Oblik zasjeka E: 1,5–2 stupanjski zasjek, bez zasjeka</li> <li>▲ S ravnim navojima</li> <li>▲ Za čelik, materijale s kratkim strugotinama i kaljene materijale do 55 (62) HRC</li> <li>▲ Među ostalim s iznimno dugim izvedbama i unutarnjim hlađenjem</li> </ul>                   |   <b>Uvaljivač za oblikovanje navoja tip DuoForm</b> <ul style="list-style-type: none"> <li>▲ Za navoje slijepih provrta i prolazne navoje do 3xD</li> <li>▲ Oblik zasjeka C: 2–3 stupanjski zasjek, bez zasjeka</li> <li>▲ Za materijale koji se mogu hladno oblikovati do 1400 N/mm<sup>2</sup></li> <li>▲ Među ostalim pogodan za sinkronu obradu, s utorima za podmazivanje i unutarnjim hlađenjem</li> </ul>                                                                                                                                                                      |

## Prstenovi u boji

|                                                                                                                                                                                                                                                                     |                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|  <b>Za čelike do 750 N/mm<sup>2</sup></b><br><b>ST</b><br>Područje primjene ST: neprevučeni ureznik navoja za čelike do 750 N/mm <sup>2</sup> vlačne čvrstoće                    |  <b>Za materijale otporne na hrđanje i kiseline</b><br><b>VA</b><br>Područje primjene VA: za nehrđajuće čelike                                                 |  <b>Za kaljene čelike</b><br><b>HT</b><br>Područje primjene HT: za tešku obradu                                                                                                                           |
|  <b>Za čelike do 1100 N/mm<sup>2</sup></b><br><b>ST</b><br><b>VG</b><br>Područje primjene ST i VG: prevučeni ureznik navoja za čelike do 1.100 N/mm <sup>2</sup> vlačne čvrstoće |  <b>Za legure visokootporne na toplinu</b><br><b>Ti</b><br><b>Ni</b><br>Područje primjene Ti i Ni: za čelike koji su visokootporni na toplinu, titan i Inconel |  <b>Za aluminij i neželjezne materijale</b><br><b>NW</b> <b>Ms</b><br><b>Soft</b> <b>AMPCO</b><br>Područje primjene NW, Soft, Ms i AMPCO: za aluminij, mesinge s kratkim strugotinama i mekane materijale |
|  <b>Za čelike visoke čvrstoće do 1400 N/mm<sup>2</sup></b><br><b>HR</b><br>Područje primjene HR: za čelike do 1.400 N/mm <sup>2</sup> vlačne čvrstoće                            |  <b>Za lijevano željezo</b><br><b>GG</b><br>Područje primjene GG: za lijevano željezo                                                                          |  <b>Za univerzalnu primjenu do 1100 N/mm<sup>2</sup></b><br><b>UNI</b><br>Područje primjene UNI: za univerzalnu primjenu                                                                                  |

## Vrste navoja

|               |                                                                        |
|---------------|------------------------------------------------------------------------|
| <b>M</b>      | Metrički ISO navoj DIN 13                                              |
| <b>MF</b>     | Metrički fini ISO navoj DIN 13                                         |
| <b>G</b>      | Whitworthov cijevni navoj DIN EN ISO 228                               |
| <b>UNC</b>    | Unificirani grubi navoj ASME B1.15 i ISO 3161                          |
| <b>UNF</b>    | Unificirani fini navoj ASME B1.1                                       |
| <b>EG M</b>   | Metrički navoj prema ISO-standardu za navojne žičane umetke DIN 8140-2 |
| <b>EG UNC</b> | EG unificirani grubi navoj za navojne žičane umetke ASME B18.29.1      |
| <b>EG UNF</b> | EG unificirani fini navoj za navojne žičane umetke ASME B18.29.1       |

|             |                                                                           |
|-------------|---------------------------------------------------------------------------|
| <b>UNJC</b> | Unificirani grubi navoj ASME B1.15 i ISO 3161                             |
| <b>UNJF</b> | Unificirani iznimno fini navoj ASME B1.15 i ISO 3161                      |
| <b>BSW</b>  | Whitworthov navoj BS84                                                    |
| <b>NPT</b>  | Američki kon. Cijevni navoj s brtvenim sredstvom (1:16) ANSI/ASME B1.20.1 |
| <b>NPTF</b> | Američki kon. cijevni navoj s brtvenim sredstvom (1:16) ANSI/ASME B1.20.3 |
| <b>Rc</b>   | Kon. Whitworthov cijevni navoj (1:16) DIN EN 10226-2 (ISO7-1)             |
| <b>Rp</b>   | Cil. Whitworthov cijevni navoj DIN EN 10226-1 (ISO7-1)                    |



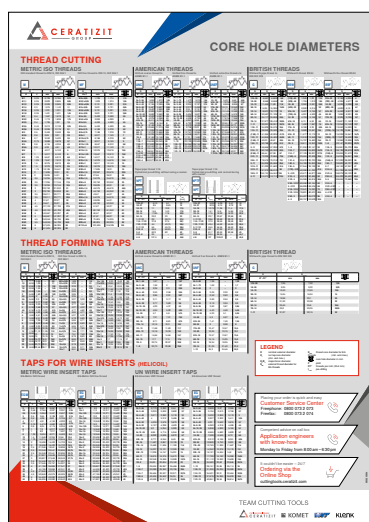
Ove vrste navoja, kao i ručni ureznik i nož za rezanje dostupne su u internetskoj trgovini.

## Oblik zasjeka

|                   |                                                |
|-------------------|------------------------------------------------|
| <b>B</b><br>4-5   | Oblik B<br>(sa zasjekom, 4-5 uvodnih navoja)   |
| <b>C</b><br>2-3   | Oblik C<br>(bez zasjeka, 2-3 uvodnih navoja)   |
| <b>D</b><br>4-5   | Oblik D<br>(bez zasjeka, 4-5 uvodnih navoja)   |
| <b>E</b><br>1,5-2 | Oblik E<br>(bez zasjeka, 1,5-2 uvodnih navoja) |

## Rezni materijali

|                   |                                                                      |
|-------------------|----------------------------------------------------------------------|
| <b>HSS</b>        | Brzorezni čelik                                                      |
| <b>HSS-E</b>      | Brzorezni čelik visoke kvalitete                                     |
| <b>HSS-E / HM</b> | Osnovni materijal HSS-E<br>medij za rezanje/oblikovanje: Tvrdi metal |
| <b>HSS-PM</b>     | Brzorezni čelik visoke kvalitete, praškasti metal                    |
| <b>VHM</b>        | Tvrdi metal                                                          |



## Obvezna oprema za Vašu proizvodnju!

Promjer navojnog jezgrenog otvora pogledajte zahvaljujući  
**CERATIZITOVOM** posteru za radionice!

Za kopiju na lokalnom jeziku obratite se prodajnom predstavniku.

## Područja primjene

| WNT \ Performance |                                                                         |                                                                                                                                                       |                                                                                                                                                                                |
|-------------------|-------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>UNI</b>        | Za univerzalnu primjenu do 1100 N/mm <sup>2</sup>                       | <b>EC</b>                                                                                                                                             | DuoForm ureznik za univerzalnu primjenu                                                                                                                                        |
| <b>ST</b>         | Za čelike s dobrim obradnim svojstvima                                  | <b>NEO</b>                                                                                                                                            | DuoForm ureznik za legure s visokom otpornošću na toplinu                                                                                                                      |
| <b>FE</b>         | Nož za rezanje navoja za čelik                                          | <b>ERGO</b>                                                                                                                                           | Ručni ureznik za nehrđajuće, na toplinu otporne i kaljene čelike do 1100 N/mm <sup>2</sup>  |
| <b>VG</b>         | Za kaljene čelike i čelike otporne na vrućinu < 1100 N/mm <sup>2</sup>  | <b>ERGO F.T</b>                                                                                                                                       | Ručni ureznik za čelike do 1400 N/mm <sup>2</sup> , volfram, ohlađeno lijevano željezo      |
| <b>HR</b>         | Za visokootporne čelike < 1400 N/mm <sup>2</sup>                        |  Alati za ova područja primjene dostupni su u internetskoj trgovini. |                                                                                                                                                                                |
| <b>VA</b>         | Za vrste čelika otporne na hrđanje i kiseline do 1100 N/mm <sup>2</sup> |                                                                                                                                                       |                                                                                                                                                                                |
| <b>GG</b>         | Za sivi lijev                                                           |                                                                                                                                                       |                                                                                                                                                                                |
| <b>NW</b>         | Za aluminij                                                             |                                                                                                                                                       |                                                                                                                                                                                |
| <b>Soft</b>       | Za mekane materijale                                                    |                                                                                                                                                       |                                                                                                                                                                                |
| <b>Ms</b>         | Za mjed s kratkim strugotinama                                          |                                                                                                                                                       |                                                                                                                                                                                |
| <b>AMPCO</b>      | Za Ampco legure                                                         |                                                                                                                                                       |                                                                                                                                                                                |
| <b>Ti</b>         | Za titanij i legure titanija                                            |                                                                                                                                                       |                                                                                                                                                                                |
| <b>Ni</b>         | Specijalno za Inconel 718                                               |                                                                                                                                                       |                                                                                                                                                                                |
| <b>HT</b>         | Za kaljene čelike i ohlađeno lijevano željezo do 55 HRC                 |                                                                                                                                                       |                                                                                                                                                                                |

| WNT \ Standard |                                                     |  |  |
|----------------|-----------------------------------------------------|--|--|
| <b>UNI</b>     | Za univerzalnu primjenu do 1000 N/mm <sup>2</sup>   |  |  |
| <b>FE</b>      | Za čelike do 850 N/mm <sup>2</sup>                  |  |  |
| <b>FE-HF</b>   | Za čelike visoke čvrstoće do 1100 N/mm <sup>2</sup> |  |  |
| <b>VA</b>      | Za materijale otporne na hrđanje i kiseline         |  |  |
| <b>GG</b>      | Za sivi lijev                                       |  |  |
| <b>AL</b>      | Za aluminij i legure aluminija                      |  |  |

6

## Specijalna svojstva

|            |                                                                   |                        |                                                                            |
|------------|-------------------------------------------------------------------|------------------------|----------------------------------------------------------------------------|
| <b>AUT</b> | Kratka izvedba za automatsku primjenu                             | <b>MMB</b>             | Ureznik za matice                                                          |
| <b>AZ</b>  | S isprekidanim zubima, smanjuje trenje                            | <b>NC</b>              | Za CNC sinkronu obradu s kompenzacijskom glavom minimalne duljine          |
| <b>CNC</b> | Za CNC sinkronu obradu s kompenzacijskom glavom minimalne duljine | <b>NCW</b>             | S Weldon steznom površinom za CNC sinkronu obradu bez kompenzacijske glave |
| <b>DRY</b> | Za suhu obradu ili podmazivanje minimalnim količinama (MMS)       | <b>R<sub>z</sub>=1</b> | Nareznica za rezanje navoja obrađen lepanjem                               |
| <b>EL</b>  | Iznimno dugački, s dvostrukom ukupnom duljinom                    | <b>S</b>               | S konusno položenim vodećim navojem, za duboke navoje                      |
| <b>ES</b>  | Iznimno kratka                                                    | <b>SN</b>              | Uvaljivač navoja s utorima za mazivo                                       |
| <b>HML</b> | Sa zalemljenim trakama od tvrdog metala za veće brzine rezanja    | <b>TS</b>              | Za obradu pri visokim brzinama, do 100 m/min                               |
| <b>LH</b>  | Za lijeve navoje                                                  |                        |                                                                            |

## Toolfinder

|            |                                                                                                          | Obrada                                                                              | Područje primjene | WNT \ Standard |       |    |     |                                                                                                               |
|------------|----------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------|----------------|-------|----|-----|---------------------------------------------------------------------------------------------------------------|
| Uvaljivači |                                                                                                          |                                                                                     |                   | M              | MF    | G  | UNC | UNF                                                                                                           |
| UNI        | Za materijale za hladno oblikovanje                                                                      |    | UNI               | 55             | 74    |    |     |                                                                                                               |
| Ureznik    |                                                                                                          |                                                                                     |                   |                |       |    |     |                                                                                                               |
| UNI        | Za univerzalnu primjenu<br>do 1.000 N/mm² <b>WNT Standard</b><br>do 1.100 N/mm² <b>WNT Performance</b>   |    | UNI               | 26+27          | 60+61 | 76 | 83  | 91                                                                                                            |
|            |                                                                                                          |    | UNI               | 43+44          | 67    | 79 | 85  | 94                                                                                                            |
| P          | Za čelike<br>do 850 N/mm² <b>WNT Standard</b><br>do 1100 N/mm² <b>WNT Performance</b>                    |    | FE                | 27             | 61    |    |     |                                                                                                               |
|            |                                                                                                          |    | FE                | 44             | 68    |    |     | 23 282...<br>23 283...<br> |
|            |                                                                                                          |    |                   |                |       |    |     |                                                                                                               |
| P          | Za čelike visoke čvrstoće<br>do 1.100 N/mm² <b>WNT Standard</b><br>do 1.400 N/mm² <b>WNT Performance</b> |    | FE-HF             | 27             |       |    | 83  |                                                                                                               |
|            |                                                                                                          |   | FE-HF             | 44             |       |    | 85  |                                                                                                               |
|            |                                                                                                          |  |                   |                |       |    |     |                                                                                                               |
| M          | Za materijale otporne na hrđanje i kiseline                                                              |  | VA                | 28             | 61    |    | 83  |                                                                                                               |
|            |                                                                                                          |  | VA                | 44+45          | 69    |    | 85  | 94                                                                                                            |
| K          | Za lijevano željezo                                                                                      |  | GG                | 51             |       |    |     |                                                                                                               |
| N          | Za aluminij i neželjezne materijale                                                                      |  | AL                | 28             |       |    |     |                                                                                                               |
|            |                                                                                                          |  | AL                | 45             |       |    |     |                                                                                                               |
|            |                                                                                                          |  |                   |                |       |    |     |                                                                                                               |
| S          | Za materijale visoke otpornosti na toplinu                                                               |  |                   |                |       |    |     |                                                                                                               |
|            |                                                                                                          |  |                   |                |       |    |     |                                                                                                               |
| H          | Tvrđi materijali                                                                                         |  |                   |                |       |    |     |                                                                                                               |

 Alate za ostale primjene pronađite u pregledu ureznika za navoje na → **Stranica 10–15.**

 Ovaj artikl možete pronaći u našem internetskom dućanu pod [cuttingtools.ceratizit.com](https://cuttingtools.ceratizit.com)

| WNT \ Performance |                   |       |      |       |       |                |        |      |     |        |                |                             |     |                             |                |                |
|-------------------|-------------------|-------|------|-------|-------|----------------|--------|------|-----|--------|----------------|-----------------------------|-----|-----------------------------|----------------|----------------|
| Vrsta alata       | Područje primjene | M     | EG M | MF    | G     | UNC            | EG UNC | UNJC | UNF | EG UNF | UNJF           | BSW                         | NPT | NPTF                        | Rp             | Rc             |
| DuoForm           | EC                | 52+53 |      | 73    | 81    | 86             |        |      | 95  |        |                |                             |     |                             |                |                |
| TruTap            | UNI               | 16–18 | 56   | 58+59 | 75    | 82             | 87     |      | 90  | 96     |                | 22 626...<br>22 627...<br>↓ |     |                             |                |                |
| CavTap            | UNI               | 29–32 | 57   | 62+63 | 77+78 | 84             | 88     |      | 92  | 97     |                | 22 628...<br>22 629...<br>↓ |     |                             |                |                |
| TruTap            | ST                | 19+20 |      | 59    | 75    |                |        |      |     |        |                |                             |     |                             |                |                |
| CavTap            | ST                | 34+35 |      | 64+65 | 78    |                |        |      |     |        |                |                             |     |                             |                |                |
| DuoTap            | ST                | 46+47 |      | 71+72 | 80    |                |        |      |     |        |                |                             | 100 | 22 367...<br>22 382...<br>↓ | 22 381...<br>↓ | 22 389...<br>↓ |
| TruTap            | HR                | 20    |      |       |       |                |        |      |     |        |                |                             |     |                             |                |                |
| CavTap            | HR                | 35    |      |       |       |                |        |      |     |        |                |                             |     |                             |                |                |
| DuoTap            | HR                | 46+47 |      | 70+71 | 80    |                |        |      |     |        |                |                             |     |                             |                |                |
| TruTap            | VA                | 21    |      |       | 75    | 82             |        |      |     |        |                |                             |     |                             |                |                |
| CavTap            | VA                | 36    |      | 66    | 78    | 84             |        |      | 92  |        |                |                             | 98  |                             |                |                |
| DuoTap            | GG                | 48    |      | 71    |       |                |        |      |     |        |                |                             |     |                             |                |                |
| TruTap            | NW                | 21    |      | 59    | 75    |                |        |      |     |        |                |                             |     |                             |                |                |
| CavTap            | NW                | 37    |      | 66    | 78    |                |        |      |     |        |                |                             |     |                             |                |                |
| DuoTap            | AMPCO             | 46+47 |      |       |       |                |        |      |     |        |                |                             |     |                             |                |                |
| TruTap            | Ti                | 22    |      |       |       | 82             |        |      |     |        | 22 167...<br>↓ |                             |     |                             |                |                |
| CavTap SL         | Ti                | 38    |      |       |       | 22 262...<br>↓ |        | 89   | 93  |        | 22 168...<br>↓ |                             |     |                             |                |                |
| DuoTap            | HT                | 49    |      | 70    |       |                |        |      |     |        |                |                             |     |                             |                |                |

 Produžetke za drške ureznika možete pronaći na → **stranici 101**.

 Ulja za narezivanje navoja mogu se pronaći u internetskoj trgovini na [cuttingtools.ceratzit.com](https://cuttingtools.ceratzit.com)

## Pregled ureznika

| Područje primjene /<br>specijalna svojstva                                          | Vrsta alata                               | Oblik zasjeka                                                                       | Tolerancija                     | Rezni materijal | ■ S prevlakom<br>□ Bez prevlake | Rashladno sredstvo | WNT \ Performance    | WNT \ Standard |
|-------------------------------------------------------------------------------------|-------------------------------------------|-------------------------------------------------------------------------------------|---------------------------------|-----------------|---------------------------------|--------------------|----------------------|----------------|
| <b>M</b>                                                                            | <b>Metrički navoj prema ISO standardu</b> |                                                                                     |                                 |                 |                                 |                    |                      |                |
|    | <b>UNI – Prolazni navoj</b>               |                                                                                     |                                 |                 |                                 |                    |                      |                |
| UNI                                                                                 | TruTap                                    |    | ISO 2 6H<br>ISO 3 6G<br>7G      | HSS-E           | ■                               |                    | 16+17                |                |
| UNI<br>CNC                                                                          | TruTap                                    |    | ISO 2X 6HX<br>ISO 3X 6GX<br>7GX | HSS-E           | ■                               |                    | 18                   |                |
| UNI<br>NCW                                                                          | TruTap                                    |    | ISO 2 6H                        | HSS-PM          | ■                               |                    | 18                   |                |
| UNI<br>EL                                                                           | TruTap                                    |    | ISO 2 6H                        | HSS-E           | ■                               |                    | 24                   |                |
| UNI                                                                                 |                                           |    | ISO 2 6H                        | HSS-E<br>HSS-PM | ■                               |                    | 26                   |                |
| UNI<br>NC                                                                           |                                           |    | ISO 2 6H                        | HSS-E           | ■                               |                    | 27                   |                |
| UNI<br>NCW                                                                          |                                           |    | ISO 2 6H                        | HSS-PM          | ■                               |                    | 27                   |                |
|  | <b>UNI – Slijepi navoj</b>                |                                                                                     |                                 |                 |                                 |                    |                      |                |
| UNI                                                                                 | CavTap                                    |  | ISO 2 6H<br>7G                  | HSS-E           | ■                               |                    | 29                   |                |
| UNI                                                                                 | CavTap                                    |  | ISO 2 6H                        | HSS-E           | ■                               | 💧                  | 30                   |                |
| UNI                                                                                 |                                           |  | ISO 2 6H                        | HSS-E<br>HSS-PM | ■                               |                    | 43                   |                |
| UNI<br>NC                                                                           |                                           |  | ISO 2 6H                        | HSS-E           | ■                               |                    | 43                   |                |
| UNI<br>NCW                                                                          | CavTap                                    |  | ISO 2 6H                        | HSS-PM          | ■                               |                    | 30                   |                |
| UNI<br>NCW                                                                          |                                           |  | ISO 2 6H                        | HSS-PM          | ■                               |                    | 44                   |                |
| UNI<br>CNC                                                                          | CavTap                                    |  | ISO 2X 6HX<br>ISO 2 6H<br>7G    | HSS-E           | ■                               |                    | 31                   |                |
| UNI<br>CNC                                                                          | CavTap                                    |  | ISO 2 6H                        | HSS-E           | ■                               | 💧                  | 31                   |                |
| UNI<br>CNC                                                                          | CavTap                                    |  | ISO 3 6G                        | HSS-E           | ■                               |                    | 22 588..., 22 589... |                |
| UNI<br>DRY                                                                          | CavTap                                    |  | ISO 2 6H                        | HSS-E           | ■                               | 💧                  | 32                   |                |
| UNI                                                                                 | CavTap                                    |  | ISO 1 4H                        | HSS-E           | ■                               |                    | 22 528...            |                |
| UNI                                                                                 | CavTap                                    |  | ISO 3 6G                        | HSS-E           | ■                               |                    | 22 530...            |                |
| UNI<br>S                                                                            | CavTap                                    |  | ISO 2 6H                        | HSS-E           | ■                               |                    | 22 536..., 22 537... |                |
| UNI<br>ES                                                                           | CavTap                                    |  | ISO 2 6H                        | HSS-E           | ■                               |                    | 39                   |                |
| UNI<br>EL                                                                           | CavTap                                    |  | ISO 2 6H                        | HSS-E           | ■                               |                    | 41                   |                |
| UNI                                                                                 | CavTap SL                                 |  | ISO 2 6H                        | HSS-E           | □                               |                    | 22 516...            |                |

| Područje primjene /<br>specijalna svojstva                                          | Vrsta alata                               | Oblik zasjeka                                                                        | Tolerancija | Rezni materijal | ■ S prevlakom<br>□ Bez prevlake | Rashladno sredstvo | WNT \ Performance    | WNT \ Standard |
|-------------------------------------------------------------------------------------|-------------------------------------------|--------------------------------------------------------------------------------------|-------------|-----------------|---------------------------------|--------------------|----------------------|----------------|
| <b>M</b>                                                                            | <b>Metrički navoj prema ISO standardu</b> |                                                                                      |             |                 |                                 |                    |                      |                |
|    | <b>P – Prolazni navoj</b>                 |                                                                                      |             |                 |                                 |                    |                      |                |
| ST                                                                                  | TruTap                                    |    | ISO 2 6H    | HSS-E           | □                               |                    | 19                   |                |
| ST<br>LH                                                                            | TruTap                                    |    | ISO 2 6H    | HSS-E           | □                               |                    | 19                   |                |
| ST                                                                                  | TruTap                                    |    | ISO 1 4H    | HSS-E           | □                               |                    | 22 002..., 22 003... |                |
| ST                                                                                  | TruTap                                    |    | ISO 3 6G    | HSS-E           | □                               |                    | 22 004...            |                |
| ST<br>TS                                                                            | TruTap                                    |    | ISO 2X 6HX  | HSS-E           | ■                               |                    | 20                   |                |
| HR                                                                                  | TruTap                                    |    | ISO 2X 6HX  | HSS-PM          | ■                               |                    | 20                   |                |
| VG                                                                                  | TruTap                                    |    | ISO 2X 6HX  | HSS-E           | ■                               |                    | 20                   |                |
| ST<br>EL                                                                            | TruTap                                    |  | ISO 2 6H    | HSS-E           | □                               |                    | 24                   |                |
| ST<br>MMB                                                                           |                                           |  | ISO 2 6H    | HSS-E           | □                               |                    | 25                   |                |
| FE                                                                                  |                                           |  | ISO 2 6H    | HSS-E           | □                               |                    | 27                   |                |
| FE-HF                                                                               |                                           |  | ISO 2 6H    | HSS-E           | ■                               |                    | 27                   |                |
|  | <b>P – Slijepi navoj</b>                  |                                                                                      |             |                 |                                 |                    |                      |                |
| ST                                                                                  | CavTap                                    |  | ISO 2 6H    | HSS-E           | ■□                              |                    | 34                   |                |
| ST                                                                                  | CavTap                                    |  | ISO 3 6G    | HSS-E           | □                               |                    | 22 134..., 22 135... |                |
| ST<br>CNC                                                                           | CavTap SL                                 |  | ISO 2X 6HX  | HSS-E           | ■                               | 💧                  | 33                   |                |
| ST<br>TS                                                                            | CavTap SL                                 |  | ISO 2X 6HX  | HSS-E           | ■                               |                    | 33                   |                |
| ST<br>ES                                                                            | CavTap SL                                 |  | ISO 2 6H    | HSS-E           | □                               |                    | 40                   |                |
| ST<br>EL                                                                            | CavTap                                    |  | ISO 2 6H    | HSS-E           | □                               |                    | 41                   |                |
| ST<br>EL                                                                            | CavTap SL                                 |  | ISO 2 6H    | HSS-E           | □                               |                    | 42                   |                |
| ST<br>LH                                                                            | CavTap                                    |  | ISO 2 6H    | HSS-E           | □                               |                    | 34                   |                |
| ST<br>TS                                                                            | CavTap                                    |  | ISO 2 6H    | HSS-E           | ■                               | 💧                  | 35                   |                |
| HR                                                                                  | CavTap SL                                 |  | ISO 2 6H    | HSS-PM          | ■                               |                    | 33                   |                |
| HR                                                                                  | CavTap                                    |  | ISO 2 6H    | HSS-PM          | ■□                              |                    | 35                   |                |



Ovaj artikl možete pronaći u našem internetskom dućanu pod  
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## Pregled ureznika

| Područje primjene /<br>specijalna svojstva | Vrsta alata                                       | Oblik zasjeka | Tolerancija | Rezni materijal | ■ S prevlakom<br>□ Bez prevlake<br>Rashladno sredstvo | WNT / Performance<br>WNT / Standard |
|--------------------------------------------|---------------------------------------------------|---------------|-------------|-----------------|-------------------------------------------------------|-------------------------------------|
| <b>M</b>                                   | <b>Metrički navoj prema ISO standardu</b>         |               |             |                 |                                                       |                                     |
| FE                                         |                                                   |               | ISO 2 6H    | HSS-E           | □                                                     | 44                                  |
| FE-HF                                      |                                                   |               | ISO 2 6H    | HSS-E           | ■                                                     | 44                                  |
|                                            | <b>P – Slijepi navoj</b>                          |               |             |                 |                                                       |                                     |
| ST                                         | DuoTap                                            |               | ISO 2X 6HX  | HSS-E           | □                                                     | 46+47                               |
| ST<br>AZ                                   | DuoTap                                            |               | ISO 2X 6HX  | HSS-E           | □                                                     | 22 111..., 22 113...<br>            |
| HR                                         | DuoTap                                            |               | ISO 2X 6HX  | HSS-E           | ■                                                     | 46+47                               |
| HR<br>EL                                   | DuoTap                                            |               | ISO 2X 6HX  | HSS-E           | ■                                                     | 50                                  |
|                                            | <b>M – Prolazni navoj</b>                         |               |             |                 |                                                       |                                     |
| VA                                         | TruTap                                            |               | ISO 2 6H    | HSS-E           | ■                                                     | 21                                  |
| VA                                         |                                                   |               | ISO 2 6H    | HSS-PM<br>HSS-E | ■                                                     | 28                                  |
|                                            | <b>M – Slijepi navoj</b>                          |               |             |                 |                                                       |                                     |
| VA                                         | CavTap                                            |               | ISO 2 6H    | HSS-E           | ■                                                     | 36                                  |
| VA                                         | CavTap                                            |               | ISO 2 6H    | HSS-E           | ■                                                     | 36                                  |
| VA                                         |                                                   |               | ISO 2 6H    | HSS-E<br>HSS-PM | ■ □                                                   | 44+45                               |
|                                            | <b>K – Prolazni navoji i navoji slijepih rupa</b> |               |             |                 |                                                       |                                     |
| GG                                         | DuoTap                                            |               | ISO 2X 6HX  | HSS-E           | ■                                                     | 48                                  |
| GG                                         |                                                   |               | ISO 2X 6HX  | HSS-E           | ■                                                     | 51                                  |
|                                            | <b>N – Prolazni navoj</b>                         |               |             |                 |                                                       |                                     |
| NW                                         | TruTap                                            |               | ISO 2 6H    | HSS-E           | ■                                                     | 21                                  |
| Soft                                       | TruTap                                            |               | ISO 2 6H    | HSS-E           | ■                                                     | 22 305...<br>                       |
| AL                                         |                                                   |               | ISO 2 6H    | HSS-E           | ■ □                                                   | 28                                  |
|                                            | <b>N – Slijepi navoj</b>                          |               |             |                 |                                                       |                                     |
| Soft                                       | CavTap                                            |               | ISO 2 6H    | HSS-E           | ■ □                                                   | 37                                  |
| NW                                         | CavTap                                            |               | ISO 2 6H    | HSS-E           | ■                                                     | 37                                  |
| AL                                         |                                                   |               | ISO 2 6H    | HSS-E           | ■ □                                                   | 45                                  |

| Područje primjene /<br>specijalna svojstva | Vrsta alata                                       | Oblik zasjeka | Tolerancija              | Rezni materijal | ■ S prevlakom<br>□ Bez prevlake<br>Rashladno sredstvo | WNT / Performance<br>WNT / Standard |
|--------------------------------------------|---------------------------------------------------|---------------|--------------------------|-----------------|-------------------------------------------------------|-------------------------------------|
| <b>M</b>                                   | <b>Metrički navoj prema ISO standardu</b>         |               |                          |                 |                                                       |                                     |
|                                            | <b>N – Prolazni navoji i navoji slijepih rupa</b> |               |                          |                 |                                                       |                                     |
| AMPCO                                      | DuoTap                                            |               | ISO 2X 6HX               | HSS-PM          | □                                                     | 46+47                               |
| Ms                                         | DuoTap                                            |               | ISO 2X 6HX               | HSS-E           | □                                                     | 22 119...<br>                       |
|                                            | <b>S – Prolazni navoj</b>                         |               |                          |                 |                                                       |                                     |
| Ti                                         | TruTap                                            |               | ISO 1X 4HX<br>ISO 2X 6HX | HSS-PM          | ■                                                     | 22                                  |
| Ti                                         | TruTap<br>DL                                      |               | ISO 2X 6HX               | HSS-E           | ■                                                     | 23                                  |
| Ni                                         | TruTap<br>DL                                      |               | ISO 2X 6HX               | HSS-E           | ■                                                     | 23                                  |
|                                            | <b>S – Slijepi navoj</b>                          |               |                          |                 |                                                       |                                     |
| Ti                                         | CavTap<br>SL                                      |               | ISO 2X 6HX               | HSS-PM          | ■                                                     | 38                                  |
| Ni                                         | CavTap<br>SL                                      |               | ISO 2X 6HX               | HSS-PM          | ■                                                     | 38                                  |
|                                            | <b>H – Prolazni navoji i navoji slijepih rupa</b> |               |                          |                 |                                                       |                                     |
| HT                                         | DuoTap                                            |               | ISO 2X 6HX               | VHM             | ■                                                     | 49                                  |
| HT                                         | DuoTap                                            |               | ISO 2X 6HX               | HSS-PM          | ■                                                     | 49                                  |
|                                            | <b>Uvaljivači</b>                                 |               |                          |                 |                                                       |                                     |
| EC                                         | DuoForm                                           |               | ISO 2X 6HX               | HSS-E           | ■                                                     | 52                                  |
| EC<br>SN                                   | DuoForm                                           |               | ISO 2X 6HX<br>ISO 3X 6GX | HSS-E           | ■                                                     | 53                                  |
| NW<br>HML                                  | DuoForm                                           |               | ISO 2X 6HX               | HSS-E           | □                                                     | 52                                  |
| NEO<br>SN                                  | DuoForm                                           |               | ISO 2X 6HX               | HSS-PM          | ■                                                     | 54                                  |
| UNI                                        |                                                   |               | ISO 2X 6HX               | HSS-E           | ■                                                     | 55                                  |
| UNI<br>SN                                  |                                                   |               | ISO 2X 6HX               | HSS-E           | ■                                                     | 55                                  |
|                                            | <b>Ručni ureznik</b>                              |               |                          |                 |                                                       |                                     |
| ST                                         |                                                   |               | ISO 2X 6HX               | VHM             | □                                                     | 22 800...<br>                       |
| ST                                         |                                                   |               | ISO 2X 6HX               | HSS-E           | □                                                     | 22 010...<br>                       |
| ERGO                                       |                                                   |               | ISO 2X 6HX               | HSS-E           | □                                                     | 22 012...<br>                       |
| ERGO<br>F.T.                               |                                                   |               | ISO 2X 6HX               | HSS-E           | ■                                                     | 22 013...<br>                       |

## Pregled ureznika

| Područje primjene /<br>specijalna svojstva                                        | Vrsta alata                               | Oblik zasjeka                                                                     | Tolerancija      | Rezni materijal | ■ S prevlakom<br>□ Bez prevlake | Rashladno sredstvo | WNT / Performance    | WNT / Standard                                                                    |
|-----------------------------------------------------------------------------------|-------------------------------------------|-----------------------------------------------------------------------------------|------------------|-----------------|---------------------------------|--------------------|----------------------|-----------------------------------------------------------------------------------|
| <b>M</b>                                                                          | <b>Metrički navoj prema ISO standardu</b> |                                                                                   |                  |                 |                                 |                    |                      |                                                                                   |
|  | <b>Nareznice</b>                          |                                                                                   |                  |                 |                                 |                    |                      |                                                                                   |
| FE                                                                                |                                           |  | ISO 6g<br>ISO 6e | HSS             | □                               |                    | 22 700..., 22 701... |  |
| FE                                                                                |                                           |  | ISO 6g           | HSS             | □                               |                    | 23 910...            |  |
| FE<br>LH                                                                          |                                           |  | ISO 6g           | HSS             | □                               |                    | 22 702...            |  |
| VA                                                                                |                                           |  | ISO 6g           | HSS-E           | □                               |                    | 22 704...            |  |
| VA<br>R <sub>z</sub> =1                                                           |                                           |  | ISO 6g           | HSS-E           | □                               |                    | 22 705...            |  |

|                                                                                     |                                                            |                                                                                     |        |       |   |  |    |  |
|-------------------------------------------------------------------------------------|------------------------------------------------------------|-------------------------------------------------------------------------------------|--------|-------|---|--|----|--|
| <b>EG M</b>                                                                         | <b>Metrički navoj prema ISO-standardu za žičane umetke</b> |                                                                                     |        |       |   |  |    |  |
|  | <b>UNI – Prolazni navoj</b>                                |                                                                                     |        |       |   |  |    |  |
| UNI                                                                                 | TruTap                                                     |  | 6H mod | HSS-E | ■ |  | 56 |  |
|  | <b>UNI – Slijepi navoj</b>                                 |                                                                                     |        |       |   |  |    |  |
| UNI                                                                                 | CavTap                                                     |  | 6H mod | HSS-E | ■ |  | 57 |  |
|  | <b>N – Slijepi navoj</b>                                   |                                                                                     |        |       |   |  |    |  |
| Soft                                                                                | CavTap                                                     |  | 6H mod | HSS-E | ■ |  | 57 |  |

|                                                                                     |                                |                                                                                     |                      |                 |   |  |           |                                                                                     |
|-------------------------------------------------------------------------------------|--------------------------------|-------------------------------------------------------------------------------------|----------------------|-----------------|---|--|-----------|-------------------------------------------------------------------------------------|
| <b>MF</b>                                                                           | <b>Metrički ISO fini navoj</b> |                                                                                     |                      |                 |   |  |           |                                                                                     |
|  | <b>UNI – Prolazni navoj</b>    |                                                                                     |                      |                 |   |  |           |                                                                                     |
| UNI                                                                                 | TruTap                         |  | ISO 2 6H             | HSS-E           | ■ |  | 58+59     |                                                                                     |
| UNI                                                                                 | TruTap                         |  | ISO 3 6G             | HSS-E           | ■ |  | 22 599... |  |
| UNI                                                                                 |                                |  | ISO 2 6H             | HSS-PM<br>HSS-E | ■ |  | 60+61     |                                                                                     |
|  | <b>UNI – Slijepi navoj</b>     |                                                                                     |                      |                 |   |  |           |                                                                                     |
| UNI                                                                                 | CavTap                         |  | ISO 2 6H<br>ISO 3 6G | HSS-E           | ■ |  | 62        |                                                                                     |
| UNI                                                                                 | CavTap                         |  | ISO 2 6H             | HSS-E           | ■ |  | 63        |                                                                                     |
| UNI                                                                                 |                                |  | ISO 2 6H             | HSS-PM<br>HSS-E | ■ |  | 67+68     |                                                                                     |

| Područje primjene /<br>specijalna svojstva                                          | Vrsta alata                                       | Oblik zasjeka                                                                        | Tolerancija    | Rezni materijal | ■ S prevlakom<br>□ Bez prevlake | Rashladno sredstvo | WNT / Performance | WNT / Standard                                                                        |
|-------------------------------------------------------------------------------------|---------------------------------------------------|--------------------------------------------------------------------------------------|----------------|-----------------|---------------------------------|--------------------|-------------------|---------------------------------------------------------------------------------------|
| <b>MF</b>                                                                           | <b>Metrički ISO fini navoj</b>                    |                                                                                      |                |                 |                                 |                    |                   |                                                                                       |
| UNI<br>CNC                                                                          | CavTap                                            |    | ISO 3 6G       | HSS-E           | ■                               |                    | 22 561...         |    |
| UNI<br>CNC                                                                          | CavTap                                            |    | ISO 2 6H<br>7G | HSS-E           | ■                               |                    | 63                |                                                                                       |
| UNI<br>NC                                                                           |                                                   |    | ISO 2 6H       | HSS-E           | ■                               |                    | 68                |                                                                                       |
|    | <b>P – Prolazni navoj</b>                         |                                                                                      |                |                 |                                 |                    |                   |                                                                                       |
| ST<br>TS                                                                            | TruTap                                            |    | ISO 2X 6HX     | HSS-E           | ■                               |                    | 59                |                                                                                       |
| ST<br>LH                                                                            | TruTap                                            |    | ISO 2 6H       | HSS-E           | □                               |                    | 59                |                                                                                       |
| FE                                                                                  |                                                   |    | ISO 2 6H       | HSS-E           | □                               |                    | 61                |                                                                                       |
|   | <b>P – Slijepi navoj</b>                          |                                                                                      |                |                 |                                 |                    |                   |                                                                                       |
| ST<br>TS                                                                            | CavTap                                            |  | ISO 2 6H       | HSS-E           | ■                               |                    | 22 216...         |  |
| ST<br>LH                                                                            | CavTap                                            |  | ISO 2 6H       | HSS-E           | □                               |                    | 64                |                                                                                       |
| ST                                                                                  | CavTap<br>SL                                      |  | ISO 2 6H       | HSS-E           | □                               |                    | 65                |                                                                                       |
| FE                                                                                  |                                                   |  | ISO 2 6H       | HSS-E           | □                               |                    | 68                |                                                                                       |
|  | <b>P – Prolazni navoji i navoji slijepih rupa</b> |                                                                                      |                |                 |                                 |                    |                   |                                                                                       |
| ST                                                                                  | DuoTap                                            |  | ISO 2X 6HX     | HSS-E           | □                               |                    | 70+71             |                                                                                       |
| ST<br>ES                                                                            | DuoTap                                            |  | ISO 2X 6HX     | HSS-E           | □                               |                    | 72                |                                                                                       |
| ST<br>LH/ES                                                                         | DuoTap                                            |  | ISO 2X 6HX     | HSS-E           | □                               |                    | 72                |                                                                                       |
| HR                                                                                  | DuoTap                                            |  | ISO 2X 6HX     | HSS-E           | ■                               |                    | 70+71             |                                                                                       |
|  | <b>M – Prolazni navoj</b>                         |                                                                                      |                |                 |                                 |                    |                   |                                                                                       |
| VA                                                                                  |                                                   |  | ISO 2 6H       | HSS-E           | ■                               |                    | 61                |                                                                                       |
|  | <b>M – Slijepi navoj</b>                          |                                                                                      |                |                 |                                 |                    |                   |                                                                                       |
| VA                                                                                  | CavTap                                            |  | ISO 2 6H       | HSS-E           | ■                               |                    | 66                |                                                                                       |
| VA                                                                                  |                                                   |  | ISO 2 6H       | HSS-E           | ■                               |                    | 69                |                                                                                       |
|  | <b>K – Prolazni navoji i navoji slijepih rupa</b> |                                                                                      |                |                 |                                 |                    |                   |                                                                                       |
| GG                                                                                  | DuoTap                                            |  | ISO 2X 6HX     | HSS-E           | ■                               |                    | 71                |                                                                                       |

 Ovaj artikl možete pronaći u našem internetskom dućanu pod [cuttingtools.ceratitis.com](http://cuttingtools.ceratitis.com)

## Pregled ureznika

| Područje primjene /<br>specijalna svojstva                                          | Vrsta alata                                       | Oblik zasjeka                                                                       | Tolerancija | Rezni materijal | ■ S prevlakom<br>□ Bez prevlake | Rashladno sredstvo | WNT \ Performance | WNT \ Standard                                                                      |
|-------------------------------------------------------------------------------------|---------------------------------------------------|-------------------------------------------------------------------------------------|-------------|-----------------|---------------------------------|--------------------|-------------------|-------------------------------------------------------------------------------------|
| <b>MF</b>                                                                           | <b>Metrički ISO fini navoj</b>                    |                                                                                     |             |                 |                                 |                    |                   |                                                                                     |
|    | <b>N – Prolazni navoj</b>                         |                                                                                     |             |                 |                                 |                    |                   |                                                                                     |
| NW                                                                                  | TruTap                                            |    | ISO 2 6H    | HSS-E           | ■                               |                    | 59                |                                                                                     |
|    | <b>N – Slijepi navoj</b>                          |                                                                                     |             |                 |                                 |                    |                   |                                                                                     |
| NW                                                                                  | CavTap                                            |    | ISO 2 6H    | HSS-E           | ■                               |                    | 66                |                                                                                     |
|    | <b>H – Prolazni navoji i navoji slijepih rupa</b> |                                                                                     |             |                 |                                 |                    |                   |                                                                                     |
| HT                                                                                  | DuoTap                                            |    | ISO 2X 6HX  | VHM             | ■                               |                    | 70                |                                                                                     |
|    | <b>Uvaljivači</b>                                 |                                                                                     |             |                 |                                 |                    |                   |                                                                                     |
| EC SN                                                                               | DuoForm                                           |   | ISO 2X 6HX  | HSS-E           | ■                               |                    | 73                |                                                                                     |
| EC HML                                                                              | DuoForm                                           |  | ISO 2X 6HX  | HSS-E           | ■                               | 💧                  | 73                |                                                                                     |
| UNI SN                                                                              |                                                   |  | ISO 2X 6HX  | HSS-E           | ■                               |                    | 74                |                                                                                     |
|  | <b>Nareznice</b>                                  |                                                                                     |             |                 |                                 |                    |                   |                                                                                     |
| FE                                                                                  |                                                   |  | ISO 6g      | HSS             | □                               |                    | 22 711...         |  |
| VA                                                                                  |                                                   |  | ISO 6g      | HSS-E           | □                               |                    | 22 714...         |  |

|                                                                                     |                                |                                                                                     |                              |       |   |  |    |  |
|-------------------------------------------------------------------------------------|--------------------------------|-------------------------------------------------------------------------------------|------------------------------|-------|---|--|----|--|
| <b>G</b>                                                                            | <b>Whitworth cijevni navoj</b> |                                                                                     |                              |       |   |  |    |  |
|  | <b>UNI – Prolazni navoj</b>    |                                                                                     |                              |       |   |  |    |  |
| UNI                                                                                 | TruTap                         |  | ISO 228                      | HSS-E | ■ |  | 75 |  |
| UNI                                                                                 |                                |  | ISO 228                      | HSS-E | ■ |  | 76 |  |
|  | <b>UNI – Slijepi navoj</b>     |                                                                                     |                              |       |   |  |    |  |
| UNI                                                                                 | CavTap                         |  | ISO 228                      | HSS-E | ■ |  | 77 |  |
| UNI                                                                                 | CavTap                         |  | ISO 228,<br>ISO 228<br>+0,05 | HSS-E | ■ |  | 77 |  |
| UNI CNC                                                                             | CavTap                         |  | ISO 228                      | HSS-E | ■ |  | 78 |  |
| UNI                                                                                 |                                |  | ISO 228                      | HSS-E | ■ |  | 79 |  |

|                                                                                     |                                                   |                                                                                      |          |       |   |  |           |                                                                                       |
|-------------------------------------------------------------------------------------|---------------------------------------------------|--------------------------------------------------------------------------------------|----------|-------|---|--|-----------|---------------------------------------------------------------------------------------|
|                                                                                     |                                                   |                                                                                      |          |       |   |  |           |                                                                                       |
| <b>G</b>                                                                            | <b>Whitworth cijevni navoj</b>                    |                                                                                      |          |       |   |  |           |                                                                                       |
|    | <b>P – Prolazni navoj</b>                         |                                                                                      |          |       |   |  |           |                                                                                       |
| ST                                                                                  | TruTap                                            |    | ISO 228  | HSS-E | □ |  | 75        |                                                                                       |
| FE                                                                                  |                                                   |    | ISO 228  | HSS-E | □ |  | 23 260... |    |
|    | <b>P – Slijepi navoj</b>                          |                                                                                      |          |       |   |  |           |                                                                                       |
| ST                                                                                  | CavTap                                            |    | ISO 228  | HSS-E | □ |  | 78        |                                                                                       |
| ST                                                                                  | CavTap SL                                         |    | ISO 228  | HSS-E | □ |  | 22 353... |    |
| FE                                                                                  |                                                   |    | ISO 228  | HSS-E | □ |  | 23 261... |    |
|   | <b>P – Prolazni navoji i navoji slijepih rupa</b> |                                                                                      |          |       |   |  |           |                                                                                       |
| ST                                                                                  | DuoTap                                            |  | ISO 228X | HSS-E | □ |  | 80        |                                                                                       |
| HR                                                                                  | DuoTap                                            |  | ISO 228X | HSS-E | ■ |  | 80        |                                                                                       |
|  | <b>M – Prolazni navoj</b>                         |                                                                                      |          |       |   |  |           |                                                                                       |
| VA                                                                                  | TruTap                                            |  | ISO 228  | HSS-E | ■ |  | 75        |                                                                                       |
|  | <b>M – Slijepi navoj</b>                          |                                                                                      |          |       |   |  |           |                                                                                       |
| VA                                                                                  | CavTap                                            |  | ISO 228  | HSS-E | ■ |  | 78        |                                                                                       |
|  | <b>K – Prolazni navoji i navoji slijepih rupa</b> |                                                                                      |          |       |   |  |           |                                                                                       |
| GG                                                                                  | DuoTap                                            |  | ISO 228X | HSS-E | ■ |  | 22 348... |  |
|  | <b>N – Prolazni navoj</b>                         |                                                                                      |          |       |   |  |           |                                                                                       |
| NW                                                                                  | TruTap                                            |  | ISO 228  | HSS-E | ■ |  | 75        |                                                                                       |
|  | <b>N – Slijepi navoj</b>                          |                                                                                      |          |       |   |  |           |                                                                                       |
| NW                                                                                  | CavTap                                            |  | ISO 228  | HSS-E | ■ |  | 78        |                                                                                       |
|  | <b>Uvaljivači</b>                                 |                                                                                      |          |       |   |  |           |                                                                                       |
| EC                                                                                  | DuoForm                                           |  | ISO 228  | HSS-E | ■ |  | 81        |                                                                                       |
| EC SN                                                                               | DuoForm                                           |  | ISO 228  | HSS-E | ■ |  | 81        |                                                                                       |
|  | <b>Nareznice</b>                                  |                                                                                      |          |       |   |  |           |                                                                                       |
| FE                                                                                  |                                                   |  | ISO 228A | HSS   | □ |  | 22 741... |  |

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## Pregled ureznika

| Područje primjene /<br>specijalna svojstva                                          | Vrsta alata             | Oblik zasjeka                                                                       | Tolerancija | Rezni materijal | ■ S prevlakom<br>□ Bez prevlake<br>Rashladno sredstvo | WNT / Performance<br>WNT / Standard                                                              |
|-------------------------------------------------------------------------------------|-------------------------|-------------------------------------------------------------------------------------|-------------|-----------------|-------------------------------------------------------|--------------------------------------------------------------------------------------------------|
| <b>UNC</b>                                                                          | Unificirani grubi navoj |                                                                                     |             |                 |                                                       |                                                                                                  |
|    | UNI – Prolazni navoj    |                                                                                     |             |                 |                                                       |                                                                                                  |
| UNI                                                                                 | TruTap                  |    | 2B          | HSS-E           | ■                                                     | 82                                                                                               |
| UNI                                                                                 |                         |    | 2B          | HSS-E           | ■                                                     | 83                                                                                               |
|    | UNI – Slijepi navoj     |                                                                                     |             |                 |                                                       |                                                                                                  |
| UNI                                                                                 | CavTap                  |    | 2B          | HSS-E           | ■                                                     | 84                                                                                               |
| UNI                                                                                 |                         |    | 2B          | HSS-E           | ■                                                     | 85                                                                                               |
|    | P – Prolazni navoj      |                                                                                     |             |                 |                                                       |                                                                                                  |
| FE-HF                                                                               |                         |    | 2B          | HSS-E           | ■                                                     | 83                                                                                               |
|  | P – Slijepi navoj       |                                                                                     |             |                 |                                                       |                                                                                                  |
| ST                                                                                  | CavTap                  |  | 2B          | HSS-E           | □                                                     | 22 264...<br> |
| FE-HF                                                                               |                         |  | 2B          | HSS-E           | ■                                                     | 85                                                                                               |
|  | M – Prolazni navoj      |                                                                                     |             |                 |                                                       |                                                                                                  |
| VA                                                                                  | TruTap                  |  | 2B          | HSS-E           | ■                                                     | 82                                                                                               |
| VA                                                                                  |                         |  | 2B          | HSS-E           | ■                                                     | 83                                                                                               |
|  | M – Slijepi navoj       |                                                                                     |             |                 |                                                       |                                                                                                  |
| VA                                                                                  | CavTap                  |  | 2B          | HSS-E           | ■                                                     | 84                                                                                               |
| VA                                                                                  |                         |  | 2B          | HSS-E           | □                                                     | 85                                                                                               |
|  | S – Prolazni navoj      |                                                                                     |             |                 |                                                       |                                                                                                  |
| Ti                                                                                  | TruTap                  |  | 2BX         | HSS-PM          | ■                                                     | 82                                                                                               |
|  | S – Slijepi navoj       |                                                                                     |             |                 |                                                       |                                                                                                  |
| TI                                                                                  | CavTap SL               |  | 2BX         | HSS-PM          | ■                                                     | 22 262...<br> |
|  | Uvaljivači              |                                                                                     |             |                 |                                                       |                                                                                                  |
| EC                                                                                  | DuoForm                 |  | 2BX         | HSS-E           | ■                                                     | 86                                                                                               |
| EC SN                                                                               | DuoForm                 |  | 2BX         | HSS-E           | ■                                                     | 86                                                                                               |

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| Područje primjene /<br>specijalna svojstva                                        | Vrsta alata             | Oblik zasjeka                                                                      | Tolerancija | Rezni materijal | ■ S prevlakom<br>□ Bez prevlake<br>Rashladno sredstvo | WNT / Performance<br>WNT / Standard                                                              |
|-----------------------------------------------------------------------------------|-------------------------|------------------------------------------------------------------------------------|-------------|-----------------|-------------------------------------------------------|--------------------------------------------------------------------------------------------------|
| <b>UNC</b>                                                                        | Unificirani grubi navoj |                                                                                    |             |                 |                                                       |                                                                                                  |
|  | Nareznice               |                                                                                    |             |                 |                                                       |                                                                                                  |
| FE                                                                                |                         |  | 2A          | HSS             | □                                                     | 22 721...<br> |

|                                                                                   |                                          |                                                                                    |        |       |   |    |
|-----------------------------------------------------------------------------------|------------------------------------------|------------------------------------------------------------------------------------|--------|-------|---|----|
| <b>EG UNC</b>                                                                     | Unificirani grubi navoj za žičane umetke |                                                                                    |        |       |   |    |
|  | UNI – Prolazni navoj                     |                                                                                    |        |       |   |    |
| UNI                                                                               | TruTap                                   |  | 2B mod | HSS-E | ■ | 87 |
|  | UNI – Slijepi navoj                      |                                                                                    |        |       |   |    |
| UNI                                                                               | CavTap                                   |  | 2B mod | HSS-E | ■ | 88 |

|                                                                                     |                         |                                                                                      |     |       |   |    |
|-------------------------------------------------------------------------------------|-------------------------|--------------------------------------------------------------------------------------|-----|-------|---|----|
| <b>UNJC</b>                                                                         | Unificirani grubi navoj |                                                                                      |     |       |   |    |
|  | S – Slijepi navoj       |                                                                                      |     |       |   |    |
| Ti                                                                                  | CavTap SL               |  | 3BX | HSS-E | ■ | 89 |

|                                                                                     |                                 |                                                                                      |          |       |   |    |
|-------------------------------------------------------------------------------------|---------------------------------|--------------------------------------------------------------------------------------|----------|-------|---|----|
| <b>UNF</b>                                                                          | Američki unificirani fini navoj |                                                                                      |          |       |   |    |
|  | UNI – Prolazni navoj            |                                                                                      |          |       |   |    |
| UNI                                                                                 | TruTap                          |  | 2B       | HSS-E | ■ | 90 |
| UNI                                                                                 |                                 |  | 2B       | HSS-E | ■ | 91 |
|  | UNI – Slijepi navoj             |                                                                                      |          |       |   |    |
| UNI                                                                                 | CavTap                          |  | 2B       | HSS-E | ■ | 92 |
| UNI                                                                                 | CavTap                          |  | 2B +0,05 | HSS-E | ■ | 92 |
| UNI                                                                                 |                                 |  | 2B       | HSS-E | ■ | 94 |
|  | M – Slijepi navoj               |                                                                                      |          |       |   |    |
| VA                                                                                  | CavTap                          |  | 2B       | HSS-E | ■ | 92 |
| VA                                                                                  |                                 |  | 2B       | HSS-E | □ | 94 |

## Pregled ureznika

| Područje primjene /<br>specijalna svojstva                                        | Vrsta alata                     | Oblik zasjeka                                                                              | Tolerancija | Rezni materijal | ■ S prevlakom<br>□ Bez prevlake<br>Rashladno sredstvo | WNT / Performance<br>WNT / Standard |
|-----------------------------------------------------------------------------------|---------------------------------|--------------------------------------------------------------------------------------------|-------------|-----------------|-------------------------------------------------------|-------------------------------------|
| <b>UNF</b>                                                                        | Američki unificirani fini navoj |                                                                                            |             |                 |                                                       |                                     |
|  | <b>S – Slijepi navoj</b>        |                                                                                            |             |                 |                                                       |                                     |
| <b>Ti</b>                                                                         | CavTap<br>SL                    |  C<br>2-3 | 2BX<br>3BX  | HSS-PM          | ■                                                     | 93                                  |
|  | <b>Uvaljivači</b>               |                                                                                            |             |                 |                                                       |                                     |
| <b>EC<br/>SN</b>                                                                  | DuoForm                         |  C<br>2-3 | 2BX         | HSS-E           | ■                                                     | 95                                  |

|                                                                                     |                                         |                                                                                                |    |       |   |    |
|-------------------------------------------------------------------------------------|-----------------------------------------|------------------------------------------------------------------------------------------------|----|-------|---|----|
| <b>EG<br/>UNF</b>                                                                   | Unificirani fini navoj za žičane umetke |                                                                                                |    |       |   |    |
|    | <b>UNI – Prolazni navoj</b>             |                                                                                                |    |       |   |    |
| <b>UNI</b>                                                                          | TruTap                                  |  B<br>4-5    | 2B | HSS-E | ■ | 96 |
|  | <b>UNI – Slijepi navoj</b>              |                                                                                                |    |       |   |    |
| <b>UNI</b>                                                                          | CavTap                                  |  E<br>1,5-2 | 2B | HSS-E | ■ | 97 |

|                                                                                     |                               |                                                                                              |     |       |   |                                                                                                  |
|-------------------------------------------------------------------------------------|-------------------------------|----------------------------------------------------------------------------------------------|-----|-------|---|--------------------------------------------------------------------------------------------------|
| <b>UNJF</b>                                                                         | Unificirani ekstra fini navoj |                                                                                              |     |       |   |                                                                                                  |
|  | <b>S – Prolazni navoj</b>     |                                                                                              |     |       |   |                                                                                                  |
| <b>Ti</b>                                                                           | TruTap<br>DL                  |  D<br>4-5 | 3BX | HSS-E | ■ | 22 167...<br> |
|  | <b>S – Slijepi navoj</b>      |                                                                                              |     |       |   |                                                                                                  |
| <b>Ti</b>                                                                           | CavTap<br>SL                  |  C<br>2-3 | 3BX | HSS-E | ■ | 22 168...<br> |

|                                                                                     |                             |                                                                                              |      |       |   |                                                                                                             |
|-------------------------------------------------------------------------------------|-----------------------------|----------------------------------------------------------------------------------------------|------|-------|---|-------------------------------------------------------------------------------------------------------------|
| <b>BSW</b>                                                                          | Whitworthov navoj           |                                                                                              |      |       |   |                                                                                                             |
|  | <b>UNI – Prolazni navoj</b> |                                                                                              |      |       |   |                                                                                                             |
| <b>UNI</b>                                                                          | TruTap                      |  B<br>4-5 | med. | HSS-E | ■ | 22 626..., 22 627...<br> |
|  | <b>UNI – Slijepi navoj</b>  |                                                                                              |      |       |   |                                                                                                             |
| <b>UNI</b>                                                                          | CavTap                      |  C<br>2-3 | med. | HSS-E | ■ | 22 628..., 22 629...<br> |

|                                                                                   |                                                   |                                                                                             |             |                 |                                                       |                                                                                                             |
|-----------------------------------------------------------------------------------|---------------------------------------------------|---------------------------------------------------------------------------------------------|-------------|-----------------|-------------------------------------------------------|-------------------------------------------------------------------------------------------------------------|
| Područje primjene /<br>specijalna svojstva                                        | Vrsta alata                                       | Oblik zasjeka                                                                               | Tolerancija | Rezni materijal | ■ S prevlakom<br>□ Bez prevlake<br>Rashladno sredstvo | WNT / Performance<br>WNT / Standard                                                                         |
| <b>NPT</b>                                                                        | Američki konusni cijevni navoj                    |                                                                                             |             |                 |                                                       |                                                                                                             |
|  | <b>P – Prolazni navoji i navoji slijepih rupa</b> |                                                                                             |             |                 |                                                       |                                                                                                             |
| <b>ST<br/>ES</b>                                                                  | DuoTap                                            |  C<br>2-3 |             | HSS-E           | □                                                     | 100                                                                                                         |
| <b>VG</b>                                                                         | DuoTap                                            |  C<br>2-3 |             | HSS-E           | □                                                     | 99                                                                                                          |
| <b>VG<br/>AZ</b>                                                                  | DuoTap                                            |  C<br>2-3 |             | HSS-E           | □                                                     | 22 377..., 22 378...<br> |
|  | <b>M – Slijepi navoj</b>                          |                                                                                             |             |                 |                                                       |                                                                                                             |
| <b>VA</b>                                                                         | CavTap                                            |  C<br>2-3 |             | HSS-E           | ■                                                     | 98                                                                                                          |

|                                                                                     |                                                   |                                                                                               |  |       |   |                                                                                                    |
|-------------------------------------------------------------------------------------|---------------------------------------------------|-----------------------------------------------------------------------------------------------|--|-------|---|----------------------------------------------------------------------------------------------------|
| <b>NPTF</b>                                                                         | Američki konusni cijevni navoj                    |                                                                                               |  |       |   |                                                                                                    |
|  | <b>P – Prolazni navoji i navoji slijepih rupa</b> |                                                                                               |  |       |   |                                                                                                    |
| <b>ST</b>                                                                           | DuoTap                                            |  C<br>2-3 |  | HSS-E | □ | 22 382...<br> |
| <b>VG</b>                                                                           | DuoTap                                            |  C<br>2-3 |  | HSS-E | □ | 22 380...<br> |
| <b>ST<br/>ES</b>                                                                    | DuoTap                                            |  C<br>2-3 |  | HSS-E | □ | 22 367...<br> |

|                                                                                     |                                                   |                                                                                               |   |       |   |                                                                                                    |
|-------------------------------------------------------------------------------------|---------------------------------------------------|-----------------------------------------------------------------------------------------------|---|-------|---|----------------------------------------------------------------------------------------------------|
| <b>Rp</b>                                                                           | Cilindrični Whitworth navoj                       |                                                                                               |   |       |   |                                                                                                    |
|  | <b>P – Prolazni navoji i navoji slijepih rupa</b> |                                                                                               |   |       |   |                                                                                                    |
| <b>ST</b>                                                                           | DuoTap                                            |  C<br>2-3 | X | HSS-E | □ | 22 381...<br> |

|                                                                                     |                                                   |                                                                                               |  |       |   |                                                                                                    |
|-------------------------------------------------------------------------------------|---------------------------------------------------|-----------------------------------------------------------------------------------------------|--|-------|---|----------------------------------------------------------------------------------------------------|
| <b>Rc</b>                                                                           | Konusni Whitworth navoj                           |                                                                                               |  |       |   |                                                                                                    |
|  | <b>P – Prolazni navoji i navoji slijepih rupa</b> |                                                                                               |  |       |   |                                                                                                    |
| <b>ST</b>                                                                           | DuoTap                                            |  C<br>2-3 |  | HSS-E | □ | 22 389...<br> |

## Pribor

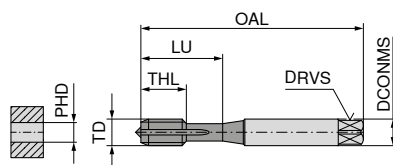
Produžetak drška ureznika 101

Ulje za narezivanje navoja, bez klora 22 950...  

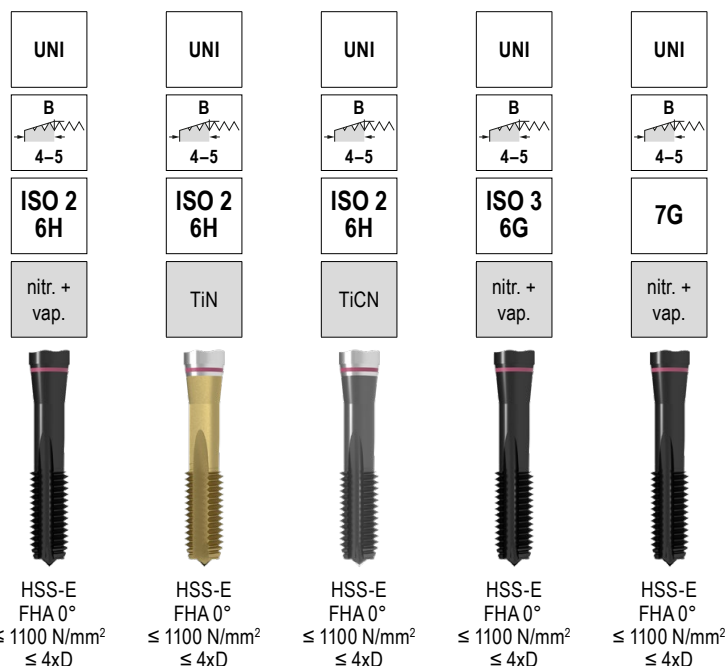

Pasta za narezivanje navoja, bez klora

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cuttingtools.ceratizit.com

## Strojni ureznik za prolazni provrt, desni



DIN 371 s ojačanim drškom



| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori | 22 501 ... |                   | 22 503 ... |     | 22 505 ... |       | 22 508 ... |     | 22 510 ... |     |
|----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|------------|-------------------|------------|-----|------------|-------|------------|-----|------------|-----|
|          |          |           |              |            |           |           |          |       | EUR<br>U0  |                   | EUR<br>U0  |     | EUR<br>U0  |       | EUR<br>U0  |     | EUR<br>U0  |     |
| M1       | 0,25     | 40        | 2,5          | 2,1        | 0,75      | 5         | 5        | 2     | 122,55     | 010 <sup>1)</sup> |            |     |            |       |            |     |            |     |
| M1,2     | 0,25     | 40        | 2,5          | 2,1        | 0,95      | 5         | 5        | 2     | 116,33     | 012 <sup>1)</sup> |            |     |            |       |            |     |            |     |
| M1,4     | 0,30     | 40        | 2,5          | 2,1        | 1,10      | 7         | 7        | 3     | 105,28     | 014 <sup>1)</sup> |            |     |            |       |            |     |            |     |
| M1,6     | 0,35     | 40        | 2,5          | 2,1        | 1,25      | 8         | 11       | 3     | 73,92      | 016               |            |     |            |       |            |     |            |     |
| M1,7     | 0,35     | 40        | 2,5          | 2,1        | 1,35      | 6         | 11       | 2     | 113,73     | 017               |            |     |            |       |            |     |            |     |
| M1,8     | 0,35     | 40        | 2,5          | 2,1        | 1,45      | 6         | 11       | 2     | 156,17     | 018               |            |     |            |       |            |     |            |     |
| M2       | 0,40     | 45        | 2,8          | 2,1        | 1,60      | 7         | 12       | 2     |            |                   | 50,86      | 020 |            |       |            |     | 62,47      | 020 |
| M2       | 0,40     | 45        | 2,8          | 2,1        | 1,60      | 7         | 12       | 3     | 53,74      | 020               |            |     |            |       |            |     |            |     |
| M2,2     | 0,45     | 45        | 2,8          | 2,1        | 1,75      | 7         | 12       | 2     | 57,26      | 022               |            |     |            |       |            |     |            |     |
| M2,5     | 0,45     | 50        | 2,8          | 2,1        | 2,05      | 9         | 14       | 2     | 52,82      | 025               |            |     |            | 52,82 | 025        |     | 61,16      | 025 |
| M3       | 0,50     | 56        | 3,5          | 2,7        | 2,50      | 11        | 18       | 3     | 39,56      | 030               | 42,95      | 030 | 42,95      | 030   | 42,95      | 030 | 49,44      | 030 |
| M3,5     | 0,60     | 56        | 4,0          | 3,0        | 2,90      | 12        | 20       | 3     | 43,46      | 035               |            |     |            |       |            |     |            |     |
| M4       | 0,70     | 63        | 4,5          | 3,4        | 3,30      | 13        | 21       | 3     | 35,90      | 040               | 44,74      | 040 | 44,74      | 040   | 43,46      | 040 | 49,71      | 040 |
| M5       | 0,80     | 70        | 6,0          | 4,9        | 4,20      | 15        | 25       | 3     | 36,83      | 050               | 45,40      | 050 | 45,40      | 050   | 43,72      | 050 | 50,86      | 050 |
| M6       | 1,00     | 80        | 6,0          | 4,9        | 5,00      | 17        | 30       | 3     | 37,35      | 060               | 51,28      | 060 | 51,28      | 060   | 44,74      | 060 | 52,17      | 060 |
| M7       | 1,00     | 80        | 7,0          | 5,5        | 6,00      | 17        | 30       | 3     | 52,17      | 070               |            |     |            |       |            |     |            |     |
| M8       | 1,25     | 90        | 8,0          | 6,2        | 6,80      | 20        | 35       | 3     | 42,28      | 080               | 57,52      | 080 | 57,52      | 080   | 50,63      | 080 | 57,26      | 080 |
| M10      | 1,50     | 100       | 10,0         | 8,0        | 8,50      | 22        | 39       | 3     | 50,75      | 100               | 80,15      | 100 | 80,15      | 100   | 61,16      | 100 | 69,88      | 100 |
| M12      | 1,75     | 110       | 12,0         | 9,0        | 10,20     | 24        | 44       | 3     | 74,69      | 120               |            |     |            |       |            |     |            |     |
| P        |          |           |              |            |           |           |          |       | 12         |                   | 15         |     | 15         |       | 12         |     | 12         |     |
| M        |          |           |              |            |           |           |          |       | 7          |                   | 9          |     | 9          |       | 7          |     | 7          |     |
| K        |          |           |              |            |           |           |          |       | 12         |                   | 18         |     | 18         |       | 12         |     | 12         |     |
| N        |          |           |              |            |           |           |          |       |            |                   | 12         |     | 12         |       |            |     |            |     |
| S        |          |           |              |            |           |           |          |       |            |                   |            |     |            |       |            |     |            |     |
| H        |          |           |              |            |           |           |          |       |            |                   |            |     |            |       |            |     |            |     |
| O        |          |           |              |            |           |           |          |       |            |                   |            |     |            |       |            |     |            |     |

1) Tol. ISO 14H ≤ M1,4

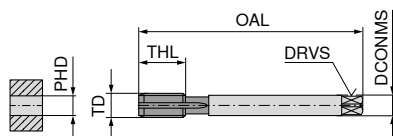
Brzina rezanja v<sub>c</sub> (m/min)

DIN 376 možete pronaći na sljedećoj stranici.

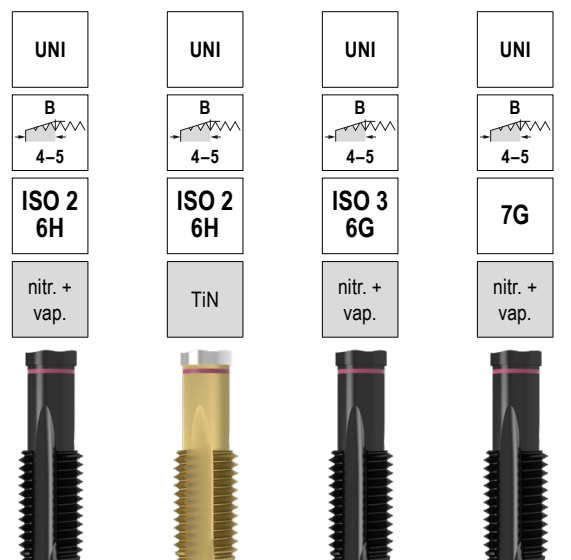
## Strojni ureznik za prolazni provrt, desni

TruTap

M



DIN 376 sa zašiljenim drškom

HSS-E  
FHA 0°  
≤ 1100 N/mm²  
≤ 4xDHSS-E  
FHA 0°  
≤ 1100 N/mm²  
≤ 4xDHSS-E  
FHA 0°  
≤ 1100 N/mm²  
≤ 4xDHSS-E  
FHA 0°  
≤ 1100 N/mm²  
≤ 4xD

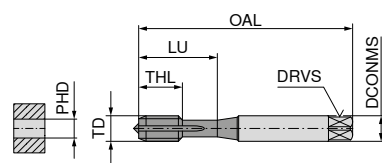
| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori | 22 502 ...<br>EUR<br>U0 | 22 504 ...<br>EUR<br>U0 | 22 509 ...<br>EUR<br>U0 | 22 511 ...<br>EUR<br>U0 |
|----------|----------|-----------|--------------|------------|-----------|-----------|-------|-------------------------|-------------------------|-------------------------|-------------------------|
| M3       | 0,50     | 56        | 2,2          |            | 2,5       | 11        | 3     | 73,26                   |                         |                         |                         |
| M4       | 0,70     | 63        | 2,8          | 2,1        | 3,3       | 13        | 3     | 48,80                   |                         |                         |                         |
| M5       | 0,80     | 70        | 3,5          | 2,7        | 4,2       | 15        | 3     | 46,59                   |                         |                         |                         |
| M6       | 1,00     | 80        | 4,5          | 3,4        | 5,0       | 17        | 3     | 45,68                   |                         |                         |                         |
| M8       | 1,25     | 90        | 6,0          | 4,9        | 6,8       | 20        | 3     | 50,09                   |                         |                         |                         |
| M10      | 1,50     | 100       | 7,0          | 5,5        | 8,5       | 22        | 3     | 58,04                   |                         |                         |                         |
| M12      | 1,75     | 110       | 9,0          | 7,0        | 10,2      | 24        | 3     | 56,74                   | 92,25                   | 120                     |                         |
| M14      | 2,00     | 110       | 11,0         | 9,0        | 12,0      | 26        | 3     | 81,84                   | 136,61                  | 140                     |                         |
| M16      | 2,00     | 110       | 12,0         | 9,0        | 14,0      | 27        | 3     | 82,76                   | 118,79                  | 160                     |                         |
| M18      | 2,50     | 125       | 14,0         | 11,0       | 15,5      | 30        | 3     | 162,72                  | 214,58                  | 180                     |                         |
| M20      | 2,50     | 140       | 16,0         | 12,0       | 17,5      | 32        | 3     | 126,61                  | 221,14                  | 200                     |                         |
| M22      | 2,50     | 140       | 18,0         | 14,5       | 19,5      | 32        | 3     | 203,13                  | 327,95                  | 220                     |                         |
| M24      | 3,00     | 160       | 18,0         | 14,5       | 21,0      | 34        | 3     | 165,23                  | 279,78                  | 240                     |                         |
| M27      | 3,00     | 160       | 20,0         | 16,0       | 24,0      | 36        | 3     | 230,32                  |                         |                         |                         |
| M30      | 3,50     | 180       | 22,0         | 18,0       | 26,5      | 40        | 4     | 270,73                  |                         |                         |                         |
| M33      | 3,50     | 180       | 25,0         | 20,0       | 29,5      | 40        | 4     | 624,66                  |                         |                         |                         |
| M36      | 4,00     | 200       | 28,0         | 22,0       | 32,0      | 50        | 4     | 744,36                  |                         |                         |                         |
| M42      | 4,50     | 200       | 32,0         | 24,0       | 37,5      | 56        | 4     | 1.417,43                |                         |                         |                         |
| M48      | 5,00     | 250       | 36,0         | 29,0       | 43,0      | 65        | 4     | 1.430,54                |                         |                         |                         |
| P        |          |           |              |            |           |           |       | 12                      | 15                      | 12                      | 12                      |
| M        |          |           |              |            |           |           |       | 7                       | 9                       | 7                       | 7                       |
| K        |          |           |              |            |           |           |       | 12                      | 18                      | 12                      | 12                      |
| N        |          |           |              |            |           |           |       |                         | 12                      |                         |                         |
| S        |          |           |              |            |           |           |       |                         |                         |                         |                         |
| H        |          |           |              |            |           |           |       |                         |                         |                         |                         |
| O        |          |           |              |            |           |           |       |                         |                         |                         |                         |

Brzina rezanja v<sub>c</sub> (m/min)

## Strojni ureznik za prolazni provrt, desni

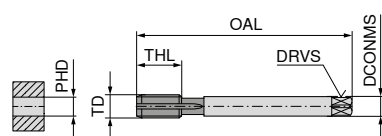
▲ CNC = za CNC sinkronu obradu s kompenzacijskom glavom minimalne duljine

▲ NCW = s Weldon steznom površinom za CNC sinkronu obradu bez kompenzacijske glave



DIN 371 s ojačanim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| M3       | 0,50     | 56        | 3,5          | 2,7        | 2,5       | 6         | 18       | 3     |
| M3       | 0,50     | 70        | 6,0          | 4,9        | 2,5       | 6         | 18       | 3     |
| M4       | 0,70     | 63        | 4,5          | 3,4        | 3,3       | 7         | 21       | 3     |
| M4       | 0,70     | 70        | 6,0          | 4,9        | 3,3       | 7         | 21       | 3     |
| M5       | 0,80     | 70        | 6,0          | 4,9        | 4,2       | 8         | 25       | 3     |
| M6       | 1,00     | 80        | 6,0          | 4,9        | 5,0       | 10        | 30       | 3     |
| M8       | 1,25     | 90        | 8,0          | 6,2        | 6,8       | 14        | 35       | 3     |
| M8       | 1,25     | 90        | 8,0          | 6,2        | 6,8       | 14        | 35       | 4     |
| M10      | 1,50     | 100       | 10,0         | 8,0        | 8,5       | 16        | 39       | 3     |
| M10      | 1,50     | 100       | 10,0         | 8,0        | 8,5       | 16        | 39       | 4     |
| M12      | 1,75     | 110       | 10,0         | 8,0        | 10,2      | 18        | 41       | 3     |
| M16      | 2,00     | 110       | 12,0         | 9,0        | 14,0      | 22        | 44       | 3     |



DIN 376 sa zašiljenim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|-------|
| M12      | 1,75     | 110       | 9            | 7          | 10,2      | 18        | 4     |
| M14      | 2,00     | 110       | 11           | 9          | 12,0      | 20        | 4     |
| M16      | 2,00     | 110       | 12           | 9          | 14,0      | 22        | 4     |
| M20      | 2,50     | 140       | 16           | 12         | 17,5      | 25        | 4     |

|   |    |    |    |    |
|---|----|----|----|----|
| P | 15 | 15 | 15 | 15 |
| M | 8  | 9  | 9  | 9  |
| K | 15 | 18 | 18 | 18 |
| N | 22 | 12 | 12 | 12 |
| S |    |    |    |    |
| H |    |    |    |    |
| O |    |    |    |    |

Brzina rezanja  $v_c$  (m/min)

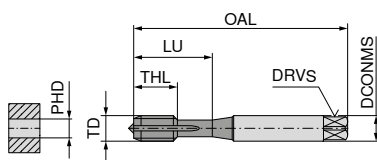
| UNI<br>NCW                                | UNI<br>CNC                               | UNI<br>CNC                               | UNI<br>CNC                               |
|-------------------------------------------|------------------------------------------|------------------------------------------|------------------------------------------|
| B<br>4-5                                  | B<br>4-5                                 | B<br>4-5                                 | B<br>4-5                                 |
| ISO 2<br>6H                               | ISO 2X<br>6HX                            | ISO 3X<br>6GX                            | 7GX                                      |
| TiN                                       | TiN GS                                   | TiN GS                                   | TiN GS                                   |
|                                           |                                          |                                          |                                          |
| HSS-PM<br>FHA 0°<br>≤ 1100 N/mm²<br>≤ 4xD | HSS-E<br>FHA 0°<br>≤ 1100 N/mm²<br>≤ 4xD | HSS-E<br>FHA 0°<br>≤ 1100 N/mm²<br>≤ 4xD | HSS-E<br>FHA 0°<br>≤ 1100 N/mm²<br>≤ 4xD |

| 22 148 ... | 22 542 ... | 22 596 ... | 22 592 ... |
|------------|------------|------------|------------|
| EUR<br>U0  | EUR<br>U0  | EUR<br>U0  | EUR<br>U0  |
| 61,41 030  | 46,59 030  |            |            |
| 63,89 040  | 49,44 040  | 59,61 040  | 59,61 040  |
| 64,54 050  | 50,09 050  | 61,41 050  | 61,41 050  |
| 81,19 060  | 63,63 060  | 67,27 060  | 75,07 060  |
| 90,69 080  | 70,27 080  | 72,74 080  | 81,99 080  |
| 111,39 100 | 87,46 100  | 90,69 100  | 98,51 100  |
| 135,31 120 |            |            |            |
| 188,71 160 |            |            |            |

| 22 543 ... | 22 593 ... |
|------------|------------|
| EUR<br>U0  | EUR<br>U0  |
| 101,77 120 | 119,33 120 |
| 286,35 140 |            |
| 145,79 160 |            |
| 247,13 200 |            |

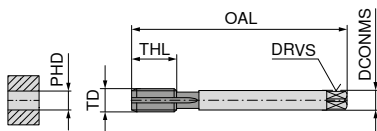
## Strojni ureznik za prolazni provrt

▲ LH = za lijeve navoje



DIN 371 s ojačanim drškom

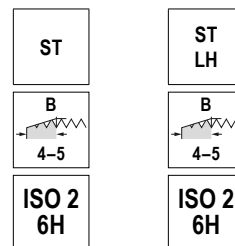
| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| M2       | 0,40     | 45        | 2,8          | 2,1        | 1,60      | 7         | 12       | 2     |
| M2,3     | 0,40     | 45        | 2,8          | 2,1        | 1,90      | 7         | 12       | 2     |
| M2,5     | 0,45     | 50        | 2,8          | 2,1        | 2,05      | 9         | 14       | 2     |
| M2,6     | 0,45     | 50        | 2,8          | 2,1        | 2,15      | 9         | 14       | 2     |
| M3       | 0,50     | 56        | 3,5          | 2,7        | 2,50      | 11        | 18       | 3     |
| M3,5     | 0,60     | 56        | 4,0          | 3,0        | 2,90      | 12        | 20       | 3     |
| M4       | 0,70     | 63        | 4,5          | 3,4        | 3,30      | 13        | 21       | 3     |
| M5       | 0,80     | 70        | 6,0          | 4,9        | 4,20      | 15        | 25       | 3     |
| M6       | 1,00     | 80        | 6,0          | 4,9        | 5,00      | 17        | 30       | 3     |
| M8       | 1,25     | 90        | 8,0          | 6,2        | 6,80      | 20        | 35       | 3     |
| M10      | 1,50     | 100       | 10,0         | 8,0        | 8,50      | 22        | 39       | 3     |



DIN 376 sa zašiljenim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|-------|
| M5       | 0,80     | 70        | 3,5          | 2,7        | 4,2       | 15        | 3     |
| M6       | 1,00     | 80        | 4,5          | 3,4        | 5,0       | 17        | 3     |
| M8       | 1,25     | 90        | 6,0          | 4,9        | 6,8       | 20        | 3     |
| M10      | 1,50     | 100       | 7,0          | 5,5        | 8,5       | 22        | 3     |
| M12      | 1,75     | 110       | 9,0          | 7,0        | 10,2      | 24        | 3     |
| M14      | 2,00     | 110       | 11,0         | 9,0        | 12,0      | 26        | 3     |
| M16      | 2,00     | 110       | 12,0         | 9,0        | 14,0      | 27        | 3     |
| M18      | 2,50     | 125       | 14,0         | 11,0       | 15,5      | 30        | 3     |
| M20      | 2,50     | 140       | 16,0         | 12,0       | 17,5      | 32        | 3     |

|   |    |    |
|---|----|----|
| P | 12 | 12 |
| M |    |    |
| K | 12 | 12 |
| N | 12 | 22 |
| S |    |    |
| H |    |    |
| O |    |    |

HSS-E  
FHA 0°  
≤ 750 N/mm²  
≤ 4xDHSS-E  
FHA 0°  
≤ 750 N/mm²  
≤ 4xD

22 020 ...

EUR  
U0

020

023

025

026

030

035

040

050

060

080

100

22 127 ...

EUR  
U0

020

023

025

026

030

035

040

050

060

080

100

22 021 ...

EUR  
U0

050

060

080

100

120

140

160

180

200

22 147 ...

EUR  
U0

050

060

080

100

120

140

160

180

200

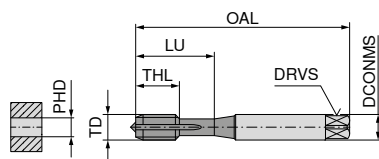
Brzina rezanja v<sub>c</sub> (m/min)

## Strojni ureznik za prolazni provrt, desni

▲ TS = za obradu pri visokim brzinama, do 100 m/min

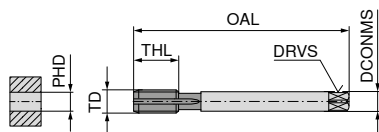
TruTap

M



DIN 371 s ojačanim drškom

| TD   | TP   | OAL | DCONMS | DRVS | PHD  | THL | LU | Utori |
|------|------|-----|--------|------|------|-----|----|-------|
| mm   | mm   | mm  | mm     | mm   | mm   | mm  | mm |       |
| M2   | 0,40 | 45  | 2,8    | 2,1  | 1,60 | 7   | 12 | 2     |
| M2   | 0,40 | 45  | 2,8    | 2,1  | 1,60 | 4   | 12 | 2     |
| M2,5 | 0,45 | 50  | 2,8    | 2,1  | 2,05 | 9   | 14 | 2     |
| M2,5 | 0,45 | 50  | 2,8    | 2,1  | 2,05 | 5   | 15 | 2     |
| M3   | 0,50 | 56  | 3,5    | 2,7  | 2,50 | 11  | 18 | 2     |
| M3   | 0,50 | 56  | 3,5    | 2,7  | 2,50 | 6   | 18 | 3     |
| M4   | 0,70 | 63  | 4,5    | 3,4  | 3,30 | 13  | 21 | 2     |
| M4   | 0,70 | 63  | 4,5    | 3,4  | 3,30 | 7   | 21 | 3     |
| M5   | 0,80 | 70  | 6,0    | 4,9  | 4,20 | 15  | 25 | 2     |
| M5   | 0,80 | 70  | 6,0    | 4,9  | 4,20 | 8   | 25 | 3     |
| M6   | 1,00 | 80  | 6,0    | 4,9  | 5,00 | 17  | 30 | 3     |
| M6   | 1,00 | 80  | 6,0    | 4,9  | 5,00 | 10  | 30 | 3     |
| M8   | 1,25 | 90  | 8,0    | 6,2  | 6,80 | 20  | 35 | 3     |
| M8   | 1,25 | 90  | 8,0    | 6,2  | 6,80 | 14  | 35 | 4     |
| M10  | 1,50 | 100 | 10,0   | 8,0  | 8,50 | 22  | 39 | 3     |
| M10  | 1,50 | 100 | 10,0   | 8,0  | 8,50 | 16  | 39 | 4     |



DIN 376 sa zašiljenim drškom

| TD  | TP   | OAL | DCONMS | DRVS | PHD  | THL | Utori |
|-----|------|-----|--------|------|------|-----|-------|
| mm  | mm   | mm  | mm     | mm   | mm   | mm  |       |
| M12 | 1,75 | 110 | 9      | 7    | 10,2 | 18  | 4     |
| M16 | 2,00 | 110 | 12     | 9    | 14,0 | 22  | 4     |
| M20 | 2,50 | 140 | 16     | 12   | 17,5 | 25  | 4     |

|   |    |    |    |
|---|----|----|----|
| P | 65 | 8  | 10 |
| M |    | 8  | 8  |
| K | 65 |    |    |
| N | 75 | 10 | 22 |
| S |    | 4  |    |
| H |    |    |    |
| O |    |    |    |

Brzina rezanja  $v_c$  (m/min)

| ST<br>TS                                 | HR                                        | VG                                       |
|------------------------------------------|-------------------------------------------|------------------------------------------|
| B<br>4-5                                 | B<br>4-5                                  | B<br>4-5                                 |
| ISO 2X<br>6HX                            | ISO 2X<br>6HX                             | ISO 2X<br>6HX                            |
| TiN                                      | AlTiNHD                                   | TiN                                      |
|                                          |                                           |                                          |
| HSS-E<br>FHA 0°<br>≤ 1100 N/mm²<br>≤ 4xD | HSS-PM<br>FHA 0°<br>≤ 1400 N/mm²<br>≤ 4xD | HSS-E<br>FHA 0°<br>≤ 1100 N/mm²<br>≤ 4xD |
| 22 092 ...                               | 22 468 ...                                | 22 120 ...                               |
| EUR<br>U0                                | EUR<br>U0                                 | EUR<br>U0                                |
| 60,38 020                                | 89,77 02000                               | 52,82 020                                |
| 60,38 025                                | 89,77 02500                               | 52,82 025                                |
| 47,36 030                                | 58,37 03000                               | 38,91 030                                |
| 51,66 040                                | 60,91 04000                               | 41,78 040                                |
| 56,47 050                                | 62,86 05000                               | 44,50 050                                |
| 68,70 060                                | 71,22 06000                               | 54,13 060                                |
| 86,67 080                                | 78,25 08000                               | 57,26 080                                |
| 93,96 100                                | 110,22 10000                              | 81,99 100                                |

22 093 ...

EUR  
U0126,37 120  
163,91 160  
244,74 200

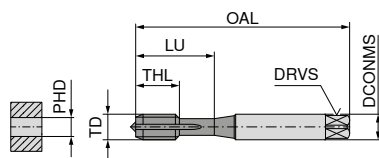
22 121 ...

EUR  
U097,07 120  
135,31 160  
227,70 200

## Strojni ureznik za prolazni provrt, desni

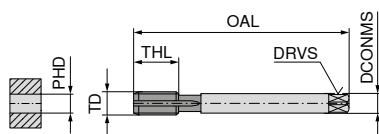
TruTap

M



DIN 371 s ojačanim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| M1,6     | 0,35     | 40        | 2,5          | 2,1        | 1,25      | 6         | 11       | 2     |
| M2       | 0,40     | 45        | 2,8          | 2,1        | 1,60      | 7         | 12       | 2     |
| M2,5     | 0,45     | 50        | 2,8          | 2,1        | 2,05      | 9         | 14       | 2     |
| M3       | 0,50     | 56        | 3,5          | 2,7        | 2,50      | 11        | 18       | 3     |
| M3,5     | 0,60     | 56        | 4,0          | 3,0        | 2,90      | 12        | 20       | 3     |
| M4       | 0,70     | 63        | 4,5          | 3,4        | 3,30      | 13        | 21       | 3     |
| M5       | 0,80     | 70        | 6,0          | 4,9        | 4,20      | 15        | 25       | 3     |
| M6       | 1,00     | 80        | 6,0          | 4,9        | 5,00      | 17        | 30       | 3     |
| M8       | 1,25     | 90        | 8,0          | 6,2        | 6,80      | 20        | 35       | 3     |
| M8       | 1,25     | 100       | 8,0          | 6,2        | 6,80      | 20        | 35       | 3     |
| M10      | 1,50     | 100       | 10,0         | 8,0        | 8,50      | 22        | 39       | 3     |
| M10      | 1,50     | 110       | 10,0         | 8,0        | 8,50      | 22        | 39       | 3     |



DIN 376 sa zašiljenim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|-------|
| M12      | 1,75     | 110       | 9            | 7          | 10,2      | 24        | 3     |
| M14      | 2,00     | 110       | 11           | 9          | 12,0      | 26        | 3     |
| M16      | 2,00     | 110       | 12           | 9          | 14,0      | 27        | 3     |
| M18      | 2,50     | 125       | 14           | 11         | 15,5      | 30        | 3     |
| M20      | 2,50     | 140       | 16           | 12         | 17,5      | 32        | 3     |

|   |   |    |
|---|---|----|
| P | 8 | 10 |
| M | 6 | 8  |
| K |   |    |
| N |   | 15 |
| S |   |    |
| H |   |    |
| O |   |    |

Brzina rezanja  $v_c$  (m/min)

|                                         |                                         |                                         |
|-----------------------------------------|-----------------------------------------|-----------------------------------------|
| VA                                      | VA                                      | NW                                      |
| B<br>4-5                                | B<br>4-5                                | B<br>4-5                                |
| ISO 2<br>6H                             | ISO 2<br>6H                             | ISO 2<br>6H                             |
| nitr.                                   | TiN GS                                  | DLC                                     |
|                                         |                                         |                                         |
| HSS-E<br>FHA 0°<br>≤ 900 N/mm²<br>≤ 4xD | HSS-E<br>FHA 0°<br>≤ 900 N/mm²<br>≤ 4xD | HSS-E<br>FHA 0°<br>≤ 880 N/mm²<br>≤ 4xD |

22 056 ...

EUR  
U0020  
025  
030  
035  
040  
050  
060  
080  
100

22 038 ...

EUR  
U0016  
020  
025  
030  
040  
050  
060  
080  
100

22 464 ...

EUR  
U002000  
02500  
03000  
04000  
05000  
06000  
08000  
10000

22 057 ...

EUR  
U0120  
140  
160  
180  
200

22 039 ...

EUR  
U0120  
140  
160  
200

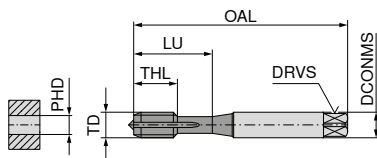
22 465 ...

EUR  
U012000  
16000  
20000

## Strojni ureznik za prolazni provrt, desni

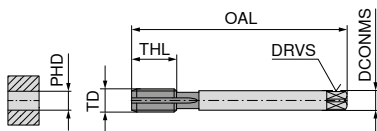
TruTap

M



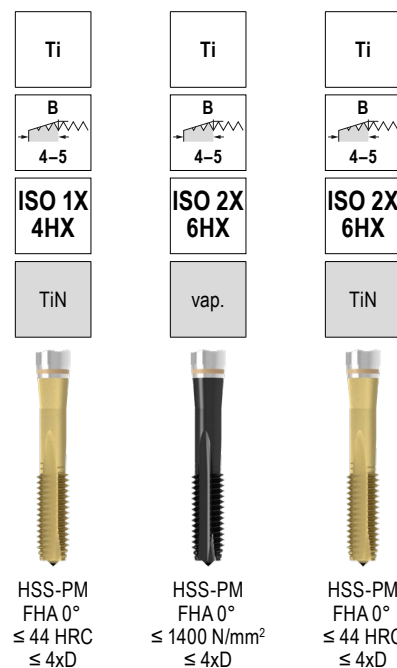
DIN 371 s ojačanim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| M1,6     | 0,35     | 40        | 2,5          | 2,1        | 1,25      | 8         | 9,5      | 3     |
| M2       | 0,40     | 45        | 2,8          | 2,1        | 1,60      | 8         | 9,5      | 3     |
| M2,5     | 0,45     | 50        | 2,8          | 2,1        | 2,05      | 9         | 14,0     | 3     |
| M3       | 0,50     | 56        | 3,5          | 2,7        | 2,50      | 11        | 18,0     | 3     |
| M3,5     | 0,60     | 56        | 4,0          | 3,0        | 2,90      | 12        | 20,0     | 3     |
| M4       | 0,70     | 63        | 4,5          | 3,4        | 3,30      | 13        | 21,0     | 3     |
| M5       | 0,80     | 70        | 6,0          | 4,9        | 4,20      | 15        | 25,0     | 3     |
| M6       | 1,00     | 80        | 6,0          | 4,9        | 5,00      | 17        | 30,0     | 3     |
| M8       | 1,25     | 90        | 8,0          | 6,2        | 6,80      | 20        | 35,0     | 3     |
| M10      | 1,50     | 100       | 10,0         | 8,0        | 8,50      | 22        | 39,0     | 3     |



DIN 376 sa zašiljenim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|-------|
| M12      | 1,75     | 110       | 9            | 7          | 10,2      | 24        | 3     |
| P        |          |           |              |            |           |           |       |
| M        |          |           |              |            |           |           |       |
| K        |          |           |              |            |           |           |       |
| N        |          |           |              |            |           |           |       |
| S        |          |           |              |            |           |           |       |
| H        |          |           |              |            |           |           |       |
| O        |          |           |              |            |           |           |       |



22 081 ...

EUR  
U0

020

030

65,73

67,67

75,47

90,69

22 075 ...

EUR  
U0

128,99

103,19

101,11

70,79

80,94

74,30

74,30

76,39

87,46

101,77

016

020

025

030

035

040

050

060

080

100

22 077 ...

EUR  
U0

67,67

70,79

72,48

83,54

100,32

030

040

050

060

080

100

22 140 ...

EUR  
U0

123,26

120

22 142 ...

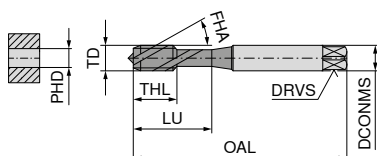
EUR  
U0

109,81

120

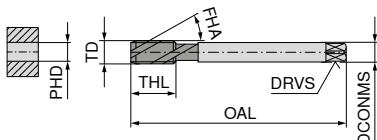
Brzina rezanja  $v_c$  (m/min)

## Strojni ureznik za prolazni provrt, desni



DIN 371 s ojačanim drškom

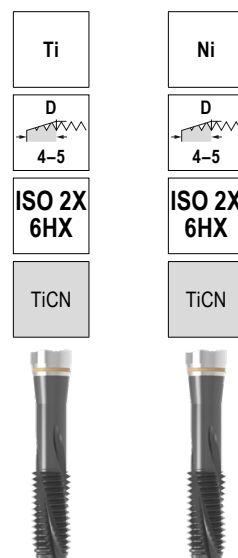
| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| M3       | 0,50     | 56        | 3,5          | 2,7        | 2,5       | 11        | 18       | 2     |
| M4       | 0,70     | 63        | 4,5          | 3,4        | 3,3       | 13        | 21       | 3     |
| M5       | 0,80     | 70        | 6,0          | 4,9        | 4,2       | 15        | 25       | 3     |
| M6       | 1,00     | 80        | 6,0          | 4,9        | 5,0       | 17        | 30       | 3     |
| M8       | 1,25     | 90        | 8,0          | 6,2        | 6,8       | 20        | 35       | 3     |
| M10      | 1,50     | 100       | 10,0         | 8,0        | 8,5       | 22        | 39       | 3     |



DIN 376 sa zašiljenim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|-------|
| M12      | 1,75     | 110       | 9            | 7,0        | 10,2      | 24        | 3     |
| M16      | 2,00     | 110       | 12           | 9,0        | 14,0      | 27        | 3     |
| M20      | 2,50     | 140       | 16           | 12,0       | 17,5      | 32        | 3     |
| M24      | 3,00     | 160       | 18           | 14,5       | 21,0      | 34        | 3     |

|   |    |    |
|---|----|----|
| P | 7  |    |
| M | 7  |    |
| K |    |    |
| N | 22 | 22 |
| S | 5  | 2  |
| H |    |    |
| O |    |    |

Brzina rezanja  $v_c$  (m/min)HSS-E  
FHA 15°  
≤ 1200 N/mm<sup>2</sup>  
≤ 4xDHSS-E  
FHA 15°  
≤ 1600 N/mm<sup>2</sup>  
≤ 4xD

22 159 ...

EUR  
U056,60 030  
61,93 040  
62,32 050  
83,28 060  
91,50 080  
112,56 100

22 297 ...

EUR  
U067,67 030  
70,66 040  
72,36 050  
91,50 060  
101,50 080  
127,08 100

22 160 ...

EUR  
U0129,95 120  
183,59 160  
317,46 200  
372,18 240

22 298 ...

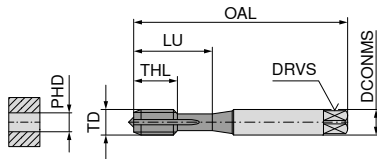
EUR  
U0147,11 120  
205,51 160  
351,32 200

## Strojni ureznik za prolazni provrt, desni

▲ EL = iznimno dugački, s dvostrukom ukupnom duljinom

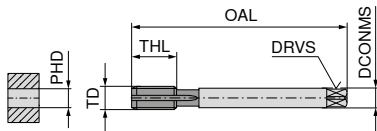
TruTap

M



DIN 371 s ojačanim drškom

| TD | TP   | OAL | DCONMS | DRVS | PHD | THL | LU | Utori |
|----|------|-----|--------|------|-----|-----|----|-------|
| mm | mm   | mm  | mm     | mm   | mm  | mm  | mm |       |
| M3 | 0,50 | 100 | 3,5    | 2,7  | 2,5 | 11  | 18 | 3     |
| M4 | 0,70 | 125 | 4,5    | 3,4  | 3,3 | 13  | 21 | 3     |
| M5 | 0,80 | 140 | 6,0    | 4,9  | 4,2 | 15  | 25 | 3     |
| M6 | 1,00 | 160 | 6,0    | 4,9  | 5,0 | 17  | 30 | 3     |
| M8 | 1,25 | 180 | 8,0    | 6,2  | 6,8 | 20  | 35 | 3     |



DIN 376 sa zašiljenim drškom

| TD  | TP   | OAL | DCONMS | DRVS | PHD  | THL | Utori |
|-----|------|-----|--------|------|------|-----|-------|
| mm  | mm   | mm  | mm     | mm   | mm   | mm  |       |
| M6  | 1,00 | 160 | 4,5    | 3,4  | 5,0  | 17  | 3     |
| M8  | 1,25 | 180 | 6,0    | 4,9  | 6,8  | 20  | 3     |
| M10 | 1,50 | 200 | 7,0    | 5,5  | 8,5  | 22  | 3     |
| M12 | 1,75 | 224 | 9,0    | 7,0  | 10,2 | 24  | 3     |
| M14 | 2,00 | 224 | 11,0   | 9,0  | 12,0 | 26  | 3     |
| M16 | 2,00 | 224 | 12,0   | 9,0  | 14,0 | 27  | 3     |
| M18 | 2,50 | 250 | 14,0   | 11,0 | 15,5 | 30  | 3     |
| M20 | 2,50 | 280 | 16,0   | 12,0 | 17,5 | 32  | 3     |

|   |    |    |
|---|----|----|
| P | 12 | 12 |
| M | 7  |    |
| K | 12 | 12 |
| N |    | 22 |
| S |    |    |
| H |    |    |
| O |    |    |

Brzina rezanja  $v_c$  (m/min)UNI  
ELISO 2  
6Hnitr. +  
vap.HSS-E  
FHA 0°  
≤ 1100 N/mm²  
≤ 4xDST  
ELISO 2  
6HHSS-E  
FHA 0°  
≤ 950 N/mm²  
≤ 4xD

22 514 ...

EUR  
U0

75,47

030

75,47

040

83,54

050

92,14

060

98,51

080

22 233 ...

EUR  
U0

73,65

030

70,66

040

77,18

050

80,55

060

96,04

080

22 515 ...

EUR  
U0

76,77

060

94,88

080

104,10

100

128,99

120

195,27

140

249,87

160

298,03

180

261,55

200

22 234 ...

EUR  
U0

80,55

060

96,04

080

106,96

100

128,99

120

208,14

140

200,40

160

301,97

180

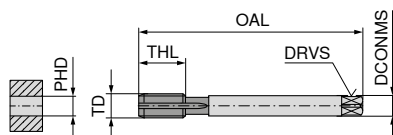
272,04

200

## Strojni ureznik za prolazni provrt, desni

▲ MMB = ureznik za matice

M

ST  
MMBISO 2  
6H

DIN 357 sa zašiljenim drškom

HSS-E  
FHA 0°  
≤ 850 N/mm²  
≤ 1xD

22 098 ...

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori |    |
|----------|----------|-----------|--------------|------------|-----------|-----------|-------|----|
| M3       | 0,50     | 70        | 2,2          |            | 2,5       | 16        | 3     |    |
| M4       | 0,70     | 90        | 2,8          | 2,1        | 3,3       | 22        | 3     |    |
| M5       | 0,80     | 100       | 3,5          | 2,7        | 4,2       | 24        | 3     |    |
| M6       | 1,00     | 110       | 4,5          | 3,4        | 5,0       | 30        | 3     |    |
| M8       | 1,25     | 125       | 6,0          | 4,9        | 6,8       | 38        | 3     |    |
| M10      | 1,50     | 140       | 7,0          | 5,5        | 8,5       | 45        | 3     |    |
| M12      | 1,75     | 180       | 9,0          | 7,0        | 10,2      | 50        | 3     |    |
| M16      | 2,00     | 200       | 12,0         | 9,0        | 14,0      | 63        | 3     |    |
| P        |          |           |              |            |           |           |       | 15 |
| M        |          |           |              |            |           |           |       |    |
| K        |          |           |              |            |           |           |       |    |
| N        |          |           |              |            |           |           |       |    |
| S        |          |           |              |            |           |           |       |    |
| H        |          |           |              |            |           |           |       |    |
| O        |          |           |              |            |           |           |       |    |

EUR  
U0

030

55,56

040

55,56

050

58,16

060

58,16

080

71,84

100

81,99

120

109,81

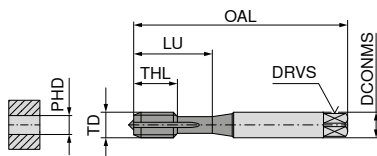
160

156,17

Brzina rezanja v<sub>c</sub> (m/min)

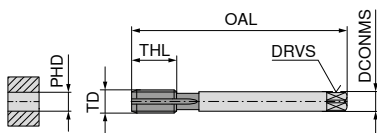
## Strojni ureznik za prolazni provrt, desni

M



DIN 371 s ojačanim drškom

| TD   | TP   | OAL | DCONMS | DRVS | PHD  | THL | LU   | Utori |
|------|------|-----|--------|------|------|-----|------|-------|
| mm   | mm   | mm  | mm     | mm   | mm   | mm  | mm   |       |
| M2   | 0,40 | 45  | 2,8    | 2,1  | 1,60 | 4   | 13,5 | 2     |
| M2   | 0,40 | 45  | 2,8    | 2,1  | 1,60 | 7   | 12,0 | 2     |
| M2,5 | 0,45 | 50  | 2,8    | 2,1  | 2,05 | 9   | 14,0 | 2     |
| M3   | 0,50 | 56  | 3,5    | 2,7  | 2,50 | 11  | 18,0 | 3     |
| M4   | 0,70 | 63  | 4,5    | 3,4  | 3,30 | 13  | 21,0 | 3     |
| M5   | 0,80 | 70  | 6,0    | 4,9  | 4,20 | 15  | 25,0 | 3     |
| M6   | 1,00 | 80  | 6,0    | 4,9  | 5,00 | 17  | 30,0 | 3     |
| M8   | 1,25 | 90  | 8,0    | 6,2  | 6,80 | 20  | 35,0 | 3     |
| M10  | 1,50 | 100 | 10,0   | 8,0  | 8,50 | 22  | 39,0 | 3     |



DIN 376 sa zašiljenim drškom

| TD  | TP   | OAL | DCONMS | DRVS | PHD  | THL | Utori |
|-----|------|-----|--------|------|------|-----|-------|
| mm  | mm   | mm  | mm     | mm   | mm   | mm  |       |
| M3  | 0,50 | 56  | 2,2    |      | 2,5  | 11  | 3     |
| M4  | 0,70 | 63  | 2,8    | 2,1  | 3,3  | 13  | 3     |
| M5  | 0,80 | 70  | 3,5    | 2,7  | 4,2  | 15  | 3     |
| M6  | 1,00 | 80  | 4,5    | 3,4  | 5,0  | 17  | 3     |
| M8  | 1,25 | 90  | 6,0    | 4,9  | 6,8  | 20  | 3     |
| M10 | 1,50 | 100 | 7,0    | 5,5  | 8,5  | 22  | 3     |
| M12 | 1,75 | 110 | 9,0    | 7,0  | 10,2 | 24  | 3     |
| M14 | 2,00 | 110 | 11,0   | 9,0  | 12,0 | 20  | 4     |
| M14 | 2,00 | 110 | 11,0   | 9,0  | 12,0 | 26  | 3     |
| M16 | 2,00 | 110 | 12,0   | 9,0  | 14,0 | 27  | 3     |
| M18 | 2,50 | 125 | 14,0   | 11,0 | 15,5 | 25  | 4     |
| M18 | 2,50 | 125 | 14,0   | 11,0 | 15,5 | 30  | 3     |
| M20 | 2,50 | 140 | 16,0   | 12,0 | 17,5 | 32  | 3     |
| M22 | 2,50 | 140 | 18,0   | 14,5 | 19,5 | 32  | 3     |
| M24 | 3,00 | 160 | 18,0   | 14,5 | 21,0 | 34  | 3     |
| M27 | 3,00 | 160 | 20,0   | 16,0 | 24,0 | 36  | 3     |
| M30 | 3,50 | 180 | 22,0   | 18,0 | 26,5 | 40  | 4     |
| M33 | 3,50 | 180 | 25,0   | 20,0 | 29,5 | 40  | 4     |
| M36 | 4,00 | 200 | 28,0   | 22,0 | 32,0 | 50  | 4     |

|   |    |    |    |
|---|----|----|----|
| P | 12 | 15 | 15 |
| M | 7  | 9  | 9  |
| K | 12 | 18 | 18 |
| N |    | 12 | 12 |
| S |    |    |    |
| H |    |    |    |
| O |    |    |    |

Brzina rezanja  $v_c$  (m/min)

| UNI                                                         | UNI                                                         | UNI                                                          |
|-------------------------------------------------------------|-------------------------------------------------------------|--------------------------------------------------------------|
| B<br>4-5                                                    | B<br>4-5                                                    | B<br>4-5                                                     |
| ISO 2<br>6H                                                 | ISO 2<br>6H                                                 | ISO 2<br>6H                                                  |
| nitr. +<br>vap.                                             | TiN                                                         | TiN                                                          |
|                                                             |                                                             |                                                              |
| HSS-E<br>FHA 0°<br>$\leq 1000 \text{ N/mm}^2$<br>$\leq 3xD$ | HSS-E<br>FHA 0°<br>$\leq 1000 \text{ N/mm}^2$<br>$\leq 3xD$ | HSS-PM<br>FHA 0°<br>$\leq 1000 \text{ N/mm}^2$<br>$\leq 3xD$ |
| 23 110 ...                                                  | 23 112 ...                                                  | 23 010 ...                                                   |
| EUR<br>T9                                                   | EUR<br>T9                                                   | EUR<br>T9                                                    |
| 14,67 020                                                   | 17,26 020                                                   | 11,96 020                                                    |
| 14,42 025                                                   | 19,24 025                                                   |                                                              |
| 9,78 030                                                    | 12,45 030                                                   | 14,91 030                                                    |
| 9,96 040                                                    | 13,57 040                                                   | 13,68 040                                                    |
| 9,96 050                                                    | 13,68 050                                                   | 15,30 050                                                    |
| 10,16 060                                                   | 17,39 060                                                   | 18,26 060                                                    |
| 11,77 080                                                   | 18,85 080                                                   | 20,35 080                                                    |
| 14,05 100                                                   | 23,30 100                                                   | 26,87 100                                                    |

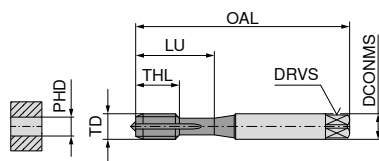
| 23 111 ... | 23 113 ...   | 23 021 ... |
|------------|--------------|------------|
| EUR<br>T9  | EUR<br>T9    | EUR<br>T9  |
| 10,58 030  |              |            |
| 10,42 040  |              |            |
| 10,42 050  |              |            |
| 10,95 060  |              |            |
| 12,84 080  |              |            |
| 14,79 100  |              |            |
| 17,75 120  | 27,63 120    | 32,05 120  |
|            |              | 48,59 140  |
| 25,65 140  | 48,06 14000  |            |
| 26,26 160  | 39,08 160    | 45,14 160  |
|            |              | 79,03 180  |
|            | 76,26 18000  |            |
| 41,80 200  | 67,20 200    | 81,63 200  |
|            | 112,93 22000 |            |
|            | 101,22 240   |            |
|            | 141,27 27000 |            |
|            | 158,43 30000 |            |
|            | 207,79 33000 |            |
|            | 254,52 36000 |            |

## Strojni ureznik za prolazni provrt, desni

▲ NCW = s Weldon steznom površinom za CNC sinkronu obradu bez kompenzacijske glave

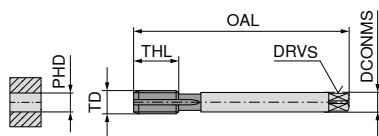
▲ NC = za CNC sinkronu obradu s kompenzacijskom glavom minimalne duljine

M



DIN 371 s ojačanim drškom

| TD   | TP   | OAL | DCONMS | DRVS | PHD  | THL | LU | Utori |
|------|------|-----|--------|------|------|-----|----|-------|
| mm   | mm   | mm  | mm     | mm   | mm   | mm  | mm |       |
| M1,6 | 0,35 | 40  | 2,5    | 2,1  | 1,25 | 6   | 11 | 2     |
| M2   | 0,40 | 45  | 2,8    | 2,1  | 1,60 | 7   | 12 | 2     |
| M2,5 | 0,45 | 50  | 2,8    | 2,1  | 2,05 | 9   | 14 | 2     |
| M3   | 0,50 | 56  | 3,5    | 2,7  | 2,50 | 11  | 18 | 3     |
| M3   | 0,50 | 70  | 6,0    | 4,9  | 2,50 | 6   | 18 | 3     |
| M3,5 | 0,60 | 56  | 4,0    | 3,0  | 2,90 | 12  | 20 | 3     |
| M4   | 0,70 | 63  | 4,5    | 3,4  | 3,30 | 13  | 21 | 3     |
| M4   | 0,70 | 70  | 6,0    | 4,9  | 3,30 | 7   | 21 | 3     |
| M5   | 0,80 | 70  | 6,0    | 4,9  | 4,20 | 8   | 25 | 3     |
| M5   | 0,80 | 70  | 6,0    | 4,9  | 4,20 | 15  | 25 | 3     |
| M6   | 1,00 | 80  | 6,0    | 4,9  | 5,00 | 10  | 30 | 3     |
| M6   | 1,00 | 80  | 6,0    | 4,9  | 5,00 | 17  | 30 | 3     |
| M8   | 1,25 | 90  | 8,0    | 6,2  | 6,80 | 14  | 35 | 3     |
| M8   | 1,25 | 90  | 8,0    | 6,2  | 6,80 | 20  | 35 | 3     |
| M10  | 1,50 | 100 | 10,0   | 8,0  | 8,50 | 16  | 39 | 3     |
| M10  | 1,50 | 100 | 10,0   | 8,0  | 8,50 | 22  | 39 | 3     |



DIN 376 sa zašiljenim drškom

| TD  | TP   | OAL | DCONMS | DRVS | PHD  | THL | Utori |
|-----|------|-----|--------|------|------|-----|-------|
| mm  | mm   | mm  | mm     | mm   | mm   | mm  |       |
| M12 | 1,75 | 110 | 9      | 7    | 10,2 | 24  | 3     |
| M12 | 1,75 | 110 | 10     | 8    | 10,2 | 18  | 3     |
| M14 | 2,00 | 110 | 11     | 9    | 12,0 | 26  | 3     |
| M16 | 2,00 | 110 | 12     | 9    | 14,0 | 22  | 3     |
| M16 | 2,00 | 110 | 12     | 9    | 14,0 | 27  | 3     |
| M20 | 2,50 | 140 | 16     | 12   | 17,5 | 32  | 3     |

|   |    |    |    |    |
|---|----|----|----|----|
| P | 15 | 15 | 12 | 15 |
| M | 9  | 8  |    |    |
| K | 18 | 15 | 12 | 15 |
| N | 12 | 22 | 12 | 15 |
| S |    |    |    |    |
| H |    |    |    |    |
| O |    |    |    |    |

Brzina rezanja  $v_c$  (m/min)

| UNI NC                                   | UNI NCW                                   | FE                                      | FE-HF                                    |
|------------------------------------------|-------------------------------------------|-----------------------------------------|------------------------------------------|
| B<br>4-5                                 | B<br>4-5                                  | B<br>4-5                                | B<br>4-5                                 |
| ISO 2<br>6H                              | ISO 2<br>6H                               | ISO 2<br>6H                             | ISO 2<br>6H                              |
| TiN GS                                   | TiCN                                      |                                         | TiCN                                     |
|                                          |                                           |                                         |                                          |
| HSS-E<br>FHA 0°<br>≤ 1000 N/mm²<br>≤ 3xD | HSS-PM<br>FHA 0°<br>≤ 1000 N/mm²<br>≤ 3xD | HSS-E<br>FHA 0°<br>≤ 850 N/mm²<br>≤ 3xD | HSS-E<br>FHA 0°<br>≤ 1100 N/mm²<br>≤ 3xD |

23 114 ...

EUR  
T9

21,08

030

23 116 ...

EUR  
T9

25,28

030

23 212 ...

EUR  
T9

30,46

016

20,60

020

17,26

025

13,68

030

23 310 ...

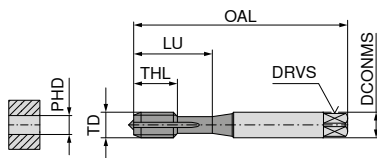
EUR  
T9

19,98

030

## Strojni ureznik za prolazni provrt, desni

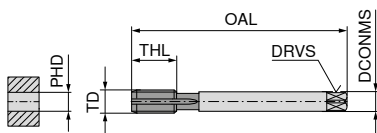
M



DIN 371 s ojačanim drškom

|                                          |                                           |                                          |                                         |                                         |
|------------------------------------------|-------------------------------------------|------------------------------------------|-----------------------------------------|-----------------------------------------|
| VA                                       | VA                                        | VA                                       | AL                                      | AL                                      |
|                                          |                                           |                                          |                                         |                                         |
| ISO 2 6H                                 | ISO 2 6H                                  | ISO 2 6H                                 | ISO 2 6H                                | ISO 2 6H                                |
| TiN                                      | nitr.                                     | nitr.                                    |                                         | CrN                                     |
|                                          |                                           |                                          |                                         |                                         |
| HSS-E<br>FHA 0°<br>≤ 1200 N/mm²<br>≤ 3xD | HSS-PM<br>FHA 0°<br>≤ 1200 N/mm²<br>≤ 3xD | HSS-E<br>FHA 0°<br>≤ 1200 N/mm²<br>≤ 3xD | HSS-E<br>FHA 0°<br>≤ 500 N/mm²<br>≤ 3xD | HSS-E<br>FHA 0°<br>≤ 500 N/mm²<br>≤ 3xD |

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori | 23 412 ... |     | 23 450 ... |     | 23 410 ... |     | 23 610 ... |     | 23 612 ... |     |
|----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|------------|-----|------------|-----|------------|-----|------------|-----|------------|-----|
|          |          |           |              |            |           |           |          |       | EUR<br>T9  |     | EUR<br>T9  |     | EUR<br>T9  |     | EUR<br>T9  |     | EUR<br>T9  |     |
| M2       | 0,40     | 45        | 2,8          | 2,1        | 1,60      | 7         | 12       | 2     | 27,88      | 020 |            |     | 15,17      | 020 |            |     |            |     |
| M2,5     | 0,45     | 50        | 2,8          | 2,1        | 2,05      | 9         | 14       | 2     | 23,43      | 025 |            |     | 17,50      | 025 |            |     |            |     |
| M3       | 0,50     | 56        | 3,5          | 2,7        | 2,50      | 11        | 18       | 3     | 18,50      | 030 | 13,92      | 030 | 9,96       | 030 | 13,68      | 030 | 15,54      | 030 |
| M4       | 0,70     | 63        | 4,5          | 3,4        | 3,30      | 13        | 21       | 3     | 20,60      | 040 | 14,05      | 040 | 9,96       | 040 | 13,68      | 040 | 16,03      | 040 |
| M5       | 0,80     | 70        | 6,0          | 4,9        | 4,20      | 15        | 25       | 3     | 21,08      | 050 | 15,17      | 050 | 10,38      | 050 | 14,19      | 050 | 16,50      | 050 |
| M6       | 1,00     | 80        | 6,0          | 4,9        | 5,00      | 17        | 30       | 3     | 27,63      | 060 | 15,42      | 060 | 10,38      | 060 | 14,19      | 060 | 16,50      | 060 |
| M8       | 1,25     | 90        | 8,0          | 6,2        | 6,80      | 20        | 35       | 3     | 29,47      | 080 | 17,26      | 080 | 13,33      | 080 | 18,37      | 080 | 18,85      | 080 |
| M10      | 1,50     | 100       | 10,0         | 8,0        | 8,50      | 22        | 39       | 3     | 40,57      | 100 | 19,60      | 100 | 16,15      | 100 | 21,94      | 100 | 23,19      | 100 |



DIN 376 sa zašiljenim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori | 23 413 ... |     | 23 451 ... |     | 23 411 ... |     |
|----------|----------|-----------|--------------|------------|-----------|-----------|-------|------------|-----|------------|-----|------------|-----|
|          |          |           |              |            |           |           |       | EUR<br>T9  |     | EUR<br>T9  |     | EUR<br>T9  |     |
| M12      | 1,75     | 110       | 9            | 7,0        | 10,2      | 24        | 3     | 44,74      | 120 | 34,88      | 120 | 21,45      | 120 |
| M14      | 2,00     | 110       | 11           | 9,0        | 12,0      | 26        | 3     |            |     | 46,24      | 140 |            |     |
| M16      | 2,00     | 110       | 12           | 9,0        | 14,0      | 27        | 3     | 55,86      | 160 | 48,95      | 160 | 33,05      | 160 |
| M20      | 2,50     | 140       | 16           | 12,0       | 17,5      | 32        | 3     | 97,65      | 200 | 73,13      | 200 | 50,55      | 200 |
| M24      | 3,00     | 160       | 18           | 14,5       | 21,0      | 34        | 3     |            |     |            |     | 66,82      | 240 |

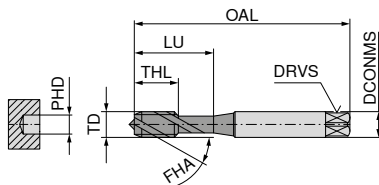
|   |    |    |    |    |    |
|---|----|----|----|----|----|
| P | 10 | 8  | 8  |    |    |
| M | 8  | 6  | 6  |    |    |
| K |    |    |    |    |    |
| N | 24 | 22 | 22 | 15 | 20 |
| S |    |    |    |    |    |
| H |    |    |    |    |    |
| O |    |    |    |    |    |

Brzina rezanja v<sub>c</sub> (m/min)

## Strojni ureznik za prolazni provrt, desni

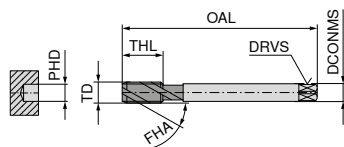
CavTap

M



DIN 371 s ojačanim drškom

| TD   | TP   | OAL | DCONMS | DRVS | PHD   | THL  | LU | Utori |
|------|------|-----|--------|------|-------|------|----|-------|
| mm   | mm   | mm  | mm     | mm   | mm    | mm   | mm |       |
| M2   | 0,40 | 45  | 2,8    | 2,1  | 1,60  | 4,0  | 12 | 2     |
| M2,2 | 0,45 | 45  | 2,8    | 2,1  | 1,75  | 4,5  | 12 | 2     |
| M2,3 | 0,40 | 45  | 2,8    | 2,1  | 1,90  | 4,5  | 12 | 2     |
| M2,5 | 0,45 | 50  | 2,8    | 2,1  | 2,05  | 5,0  | 15 | 2     |
| M2,6 | 0,45 | 50  | 2,8    | 2,1  | 2,15  | 5,0  | 15 | 2     |
| M3   | 0,50 | 56  | 3,5    | 2,7  | 2,50  | 6,0  | 18 | 3     |
| M3,5 | 0,60 | 56  | 4,0    | 3,0  | 2,90  | 7,0  | 20 | 3     |
| M4   | 0,70 | 63  | 4,5    | 3,4  | 3,30  | 7,0  | 21 | 3     |
| M5   | 0,80 | 70  | 6,0    | 4,9  | 4,20  | 8,0  | 25 | 3     |
| M6   | 1,00 | 80  | 6,0    | 4,9  | 5,00  | 10,0 | 30 | 3     |
| M7   | 1,00 | 80  | 7,0    | 5,5  | 6,00  | 10,0 | 30 | 3     |
| M8   | 1,25 | 90  | 8,0    | 6,2  | 6,80  | 14,0 | 35 | 3     |
| M10  | 1,50 | 100 | 10,0   | 8,0  | 8,50  | 16,0 | 39 | 3     |
| M12  | 1,75 | 110 | 12,0   | 9,0  | 10,20 | 18,0 | 44 | 3     |



DIN 376 sa zašiljenim drškom

| TD  | TP   | OAL | DCONMS | DRVS | PHD | THL | Utori |
|-----|------|-----|--------|------|-----|-----|-------|
| mm  | mm   | mm  | mm     | mm   | mm  | mm  |       |
| M3  | 0,50 | 56  | 2,2    | 2,5  | 6   | 3   |       |
| M4  | 0,70 | 63  | 2,8    | 3,3  | 7   | 3   |       |
| M5  | 0,80 | 70  | 3,5    | 4,2  | 8   | 3   |       |
| M6  | 1,00 | 80  | 4,5    | 5,0  | 10  | 3   |       |
| M8  | 1,25 | 90  | 6,0    | 6,8  | 14  | 3   |       |
| M10 | 1,50 | 100 | 7,0    | 8,5  | 16  | 3   |       |
| M12 | 1,75 | 110 | 9,0    | 10,2 | 18  | 3   |       |
| M14 | 2,00 | 110 | 11,0   | 12,0 | 20  | 3   |       |
| M16 | 2,00 | 110 | 12,0   | 14,0 | 22  | 3   |       |
| M18 | 2,50 | 125 | 14,0   | 15,5 | 25  | 3   |       |
| M20 | 2,50 | 140 | 16,0   | 17,5 | 25  | 3   |       |
| M22 | 2,50 | 140 | 18,0   | 19,5 | 27  | 4   |       |
| M24 | 3,00 | 160 | 18,0   | 21,0 | 30  | 4   |       |
| M27 | 3,00 | 160 | 20,0   | 24,0 | 30  | 4   |       |
| M30 | 3,50 | 180 | 22,0   | 26,5 | 35  | 4   |       |
| M33 | 3,50 | 180 | 25,0   | 29,5 | 35  | 4   |       |
| M36 | 4,00 | 200 | 28,0   | 32,0 | 40  | 4   |       |

|   |    |    |    |    |
|---|----|----|----|----|
| P | 12 | 15 | 12 | 15 |
| M | 7  | 9  | 7  | 9  |
| K | 12 | 18 | 12 | 18 |
| N |    | 12 |    | 12 |
| S |    |    |    |    |
| H |    |    |    |    |
| O |    |    |    |    |

Brzina rezanja  $v_c$  (m/min)

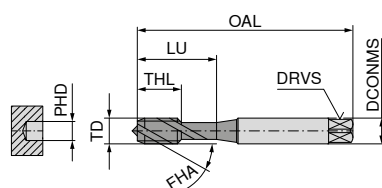
| UNI                                                                                                                                                                                | UNI                                                                                                                          | UNI                                                                                                 | UNI                                                                                                             |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------|
| C<br>2-3                                                                                                                                                                           | C<br>2-3                                                                                                                     | C<br>2-3                                                                                            | C<br>2-3                                                                                                        |
| ISO 2<br>6H                                                                                                                                                                        | ISO 2<br>6H                                                                                                                  | 7G                                                                                                  | ISO 2<br>6H                                                                                                     |
| vap.                                                                                                                                                                               | TiN                                                                                                                          | vap.                                                                                                | TiCN                                                                                                            |
|                                                                                                                                                                                    |                                                                                                                              |                                                                                                     |                                                                                                                 |
| HSS-E<br>FHA 42°<br>≤ 1100 N/mm²<br>≤ 3xD                                                                                                                                          | HSS-E<br>FHA 42°<br>≤ 1100 N/mm²<br>≤ 3xD                                                                                    | HSS-E<br>FHA 42°<br>≤ 1100 N/mm²<br>≤ 3xD                                                           | HSS-E<br>FHA 42°<br>≤ 1100 N/mm²<br>≤ 3xD                                                                       |
| 22 518 ...                                                                                                                                                                         | 22 520 ...                                                                                                                   | 22 532 ...                                                                                          | 22 522 ...                                                                                                      |
| EUR<br>U0                                                                                                                                                                          | EUR<br>U0                                                                                                                    | EUR<br>U0                                                                                           | EUR<br>U0                                                                                                       |
| 41,52 020<br>46,98 022<br>49,71 023<br>39,81 025<br>47,36 026<br>35,40 030<br>38,25 035<br>37,35 040<br>37,74 050<br>38,91 060<br>57,26 070<br>45,80 080<br>54,91 100<br>60,38 120 | 59,61 020<br><br><br><br>44,74 030<br><br><br>47,89 040<br>48,27 050<br>56,87 060<br><br>62,72 080<br>74,69 100<br>91,50 120 | <br><br><br>41,52 030<br><br><br>41,52 040<br>44,50 050<br>59,61 060<br><br>69,61 080<br>103,19 100 | <br><br><br>44,74 030<br><br><br>47,89 040<br>48,27 050<br>56,87 060<br><br>63,24 080<br>74,69 100<br>95,12 120 |

## Strojni ureznik za prolazni provrt, desni

▲ NCW = s Weldon steznom površinom za CNC sinkronu obradu bez kompenzacijske glave

CavTap

M



DIN 371 s ojačanim drškom

UNI  
NCWISO 2  
6H

TiN

HSS-PM  
FHA 42°  
≤ 1100 N/mm²  
≤ 3xD22 149 ...  
EUR  
U0

UNI

ISO 2  
6H

vap.

HSS-E  
FHA 42°  
≤ 1100 N/mm²  
≤ 3xD22 524 ...  
EUR  
U0

UNI

ISO 2  
6H

vap.

HSS-E  
FHA 42°  
≤ 1100 N/mm²  
≤ 3xD22 534 ...  
EUR  
U0

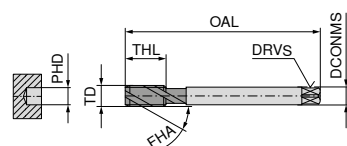
UNI

ISO 2  
6H

TiN

HSS-E  
FHA 42°  
≤ 1100 N/mm²  
≤ 3xD22 526 ...  
EUR  
U0

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| M3       | 0,50     | 56        | 3,5          | 2,7        | 2,5       | 6         | 18       | 3     |
| M3       | 0,50     | 70        | 6,0          | 4,9        | 2,5       | 6         | 18       | 3     |
| M4       | 0,70     | 63        | 4,5          | 3,4        | 3,3       | 7         | 21       | 3     |
| M4       | 0,70     | 70        | 6,0          | 4,9        | 3,3       | 7         | 21       | 3     |
| M5       | 0,80     | 70        | 6,0          | 4,9        | 4,2       | 8         | 25       | 3     |
| M6       | 1,00     | 80        | 6,0          | 4,9        | 5,0       | 10        | 30       | 3     |
| M8       | 1,25     | 90        | 8,0          | 6,2        | 6,8       | 14        | 35       | 3     |
| M10      | 1,50     | 100       | 10,0         | 8,0        | 8,5       | 16        | 39       | 3     |



DIN 376 sa zašiljenim drškom

|          |          |           |              |            |           |           |       | 22 149 ... | 22 525 ... | 22 535 ... | 22 527 ... |     |        |     |
|----------|----------|-----------|--------------|------------|-----------|-----------|-------|------------|------------|------------|------------|-----|--------|-----|
| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori | EUR<br>U0  | EUR<br>U0  | EUR<br>U0  | EUR<br>U0  |     |        |     |
| M12      | 1,75     | 110       | 9            | 7,0        | 10,2      | 18        | 4     | 144,37     | 68,33      | 120        | 88,36      | 120 | 87,46  | 120 |
| M12      | 1,75     | 110       | 10           | 8,0        | 10,2      | 18        | 3     |            | 111,39     | 140        | 128,99     | 140 |        |     |
| M14      | 2,00     | 110       | 11           | 9,0        | 12,0      | 20        | 4     | 193,84     |            |            |            |     |        |     |
| M16      | 2,00     | 110       | 12           | 9,0        | 14,0      | 22        | 3     |            | 95,49      | 160        | 127,43     | 160 | 125,76 | 160 |
| M16      | 2,00     | 110       | 12           | 9,0        | 14,0      | 22        | 4     |            | 174,52     | 180        |            |     |        |     |
| M18      | 2,50     | 125       | 14           | 11,0       | 15,5      | 25        | 4     |            | 148,42     | 200        | 190,02     | 200 | 213,40 | 200 |
| M20      | 2,50     | 140       | 16           | 12,0       | 17,5      | 25        | 4     |            | 238,18     | 220        |            |     |        |     |
| M22      | 2,50     | 140       | 18           | 14,5       | 19,5      | 27        | 5     |            | 208,14     | 240        |            |     |        |     |
| M24      | 3,00     | 160       | 18           | 14,5       | 21,0      | 30        | 5     |            |            |            |            |     |        |     |
| P        |          |           |              |            |           |           |       | 15         | 12         | 12         | 15         |     |        |     |
| M        |          |           |              |            |           |           |       | 8          | 7          | 7          | 9          |     |        |     |
| K        |          |           |              |            |           |           |       | 15         | 12         | 12         | 18         |     |        |     |
| N        |          |           |              |            |           |           |       | 22         |            |            | 12         |     |        |     |
| S        |          |           |              |            |           |           |       |            |            |            |            |     |        |     |
| H        |          |           |              |            |           |           |       |            |            |            |            |     |        |     |
| O        |          |           |              |            |           |           |       |            |            |            |            |     |        |     |

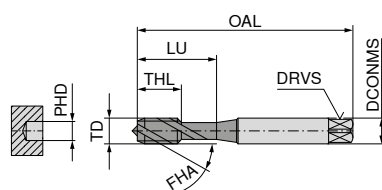
Brzina rezanja v<sub>c</sub> (m/min)

## Strojni ureznik za prolazni provrt, desni

▲ CNC = za CNC sinkronu obradu s kompenzacijskom glavom minimalne duljine

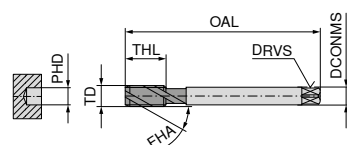
CavTap

M



DIN 371 s ojačanim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| M3       | 0,50     | 56        | 3,5          | 2,7        | 2,5       | 6         | 18       | 3     |
| M4       | 0,70     | 63        | 4,5          | 3,4        | 3,3       | 7         | 21       | 3     |
| M5       | 0,80     | 70        | 6,0          | 4,9        | 4,2       | 8         | 25       | 3     |
| M6       | 1,00     | 80        | 6,0          | 4,9        | 5,0       | 10        | 30       | 3     |
| M8       | 1,25     | 90        | 8,0          | 6,2        | 6,8       | 14        | 35       | 3     |
| M10      | 1,50     | 100       | 10,0         | 8,0        | 8,5       | 16        | 39       | 3     |



DIN 376 sa zašiljenim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori | 22 417 ...<br>EUR<br>U0 | 22 545 ...<br>EUR<br>U0 | 22 595 ...<br>EUR<br>U0 |
|----------|----------|-----------|--------------|------------|-----------|-----------|-------|-------------------------|-------------------------|-------------------------|
| M12      | 1,75     | 110       | 9            | 7          | 10,2      | 18        | 3     | 128,15                  | 120                     | 128,99                  |
| M12      | 1,75     | 110       | 9            | 7          | 10,2      | 18        | 4     |                         | 113,73                  | 120                     |
| M14      | 2,00     | 110       | 11           | 9          | 12,0      | 20        | 3     | 183,59                  | 140                     | 153,54                  |
| M14      | 2,00     | 110       | 11           | 9          | 12,0      | 20        | 4     |                         | 139,24                  | 140                     |
| M16      | 2,00     | 110       | 12           | 9          | 14,0      | 22        | 3     | 178,35                  | 160                     | 166,53                  |
| M16      | 2,00     | 110       | 12           | 9          | 14,0      | 22        | 4     |                         | 152,24                  | 160                     |
| M20      | 2,50     | 140       | 16           | 12         | 17,5      | 25        | 3     | 305,89                  | 200                     | 243,44                  |
| M20      | 2,50     | 140       | 16           | 12         | 17,5      | 25        | 4     |                         | 221,14                  | 200                     |
| P        |          |           |              |            |           |           |       | 15                      | 15                      | 15                      |
| M        |          |           |              |            |           |           |       | 9                       | 9                       | 9                       |
| K        |          |           |              |            |           |           |       | 18                      | 18                      | 18                      |
| N        |          |           |              |            |           |           |       | 22                      | 12                      | 12                      |
| S        |          |           |              |            |           |           |       |                         |                         |                         |
| H        |          |           |              |            |           |           |       |                         |                         |                         |
| O        |          |           |              |            |           |           |       |                         |                         |                         |

Brzina rezanja v<sub>c</sub> (m/min)

| UNI<br>CNC                                | UNI<br>CNC                                | UNI<br>CNC                                | UNI<br>CNC                                |
|-------------------------------------------|-------------------------------------------|-------------------------------------------|-------------------------------------------|
| C<br>2-3                                  | C<br>2-3                                  | E<br>1,5-2                                | C<br>2-3                                  |
| ISO 2X<br>6HX                             | ISO 2<br>6H                               | ISO 2<br>6H                               | 7G                                        |
| TiN                                       | TiN GS                                    | TiN GS                                    | TiN GS                                    |
|                                           |                                           |                                           |                                           |
| HSS-E<br>FHA 50°<br>≤ 1100 N/mm²<br>≤ 3xD | HSS-E<br>FHA 45°<br>≤ 1100 N/mm²<br>≤ 3xD | HSS-E<br>FHA 45°<br>≤ 1100 N/mm²<br>≤ 3xD | HSS-E<br>FHA 45°<br>≤ 1100 N/mm²<br>≤ 3xD |
| 22 416 ...                                | 22 544 ...                                | 22 546 ...                                | 22 594 ...                                |
| EUR<br>U0                                 | EUR<br>U0                                 | EUR<br>U0                                 | EUR<br>U0                                 |
| 60,75 030                                 | 53,74 030                                 |                                           | 61,81 030                                 |
| 63,63 040                                 | 54,91 040                                 |                                           | 62,47 040                                 |
| 65,33 050                                 | 56,87 050                                 | 81,19 050                                 | 64,28 050                                 |
| 78,98 060                                 | 58,82 060                                 | 81,99 060                                 | 70,27 060                                 |
| 87,84 080                                 | 73,52 080                                 | 105,28 080                                | 86,67 080                                 |
| 108,79 100                                | 83,54 100                                 | 121,00 100                                | 96,15 100                                 |

## Strojni ureznik za prolazni provrt, desni

▲ DRY = za suhu obradu ili podmazivanje minimalnim količinama (MMS)

CavTap

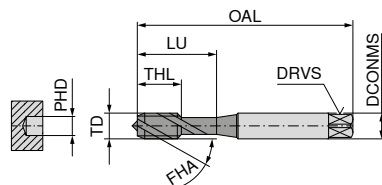
M

UNI  
DRYC  
2-3ISO 2  
6H

TiN

HSS-E  
FHA 42°  
≤ 1100 N/mm²  
≤ 3xD

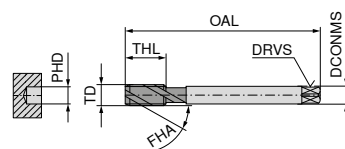
22 449 ...

EUR  
U0

DIN 371 s ojačanim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| M5       | 0,80     | 70        | 6            | 4,9        | 4,2       | 8         | 25       | 3     |
| M6       | 1,00     | 80        | 6            | 4,9        | 5,0       | 10        | 30       | 3     |
| M8       | 1,25     | 90        | 8            | 6,2        | 6,8       | 14        | 35       | 3     |
| M10      | 1,50     | 100       | 10           | 8,0        | 8,5       | 16        | 39       | 3     |

|        |     |
|--------|-----|
| 83,28  | 050 |
| 96,95  | 060 |
| 106,96 | 080 |
| 129,95 | 100 |



DIN 376 sa zašiljenim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|-------|
| M12      | 1,75     | 110       | 9            | 7          | 10,2      | 18        | 4     |
| M16      | 2,00     | 110       | 12           | 9          | 14,0      | 22        | 4     |
| M20      | 2,50     | 140       | 16           | 12         | 17,5      | 25        | 4     |

22 450 ...

EUR  
U0

|        |     |
|--------|-----|
| 141,87 | 120 |
| 200,40 | 160 |
| 327,95 | 200 |

|   |    |
|---|----|
| P | 12 |
| M |    |
| K | 12 |
| N | 22 |
| S |    |
| H |    |
| O |    |

Brzina rezanja v<sub>c</sub> (m/min)

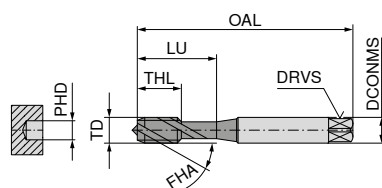
## Strojni ureznik za prolazni provrt, desni

▲ CNC = za CNC sinkronu obradu s kompenzacijskom glavom minimalne duljine

▲ TS = za obradu pri visokim brzinama, do 100 m/min

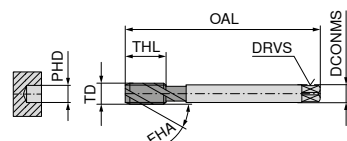
CavTap  
SL

M



DIN 371 s ojačanim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| M3       | 0,50     | 56        | 3,5          | 2,7        | 2,5       | 6         | 18       | 2     |
| M3       | 0,50     | 56        | 3,5          | 2,7        | 2,5       | 11        | 18       | 3     |
| M4       | 0,70     | 63        | 4,5          | 3,4        | 3,3       | 7         | 21       | 3     |
| M4       | 0,70     | 63        | 4,5          | 3,4        | 3,3       | 13        | 21       | 3     |
| M5       | 0,80     | 70        | 6,0          | 4,9        | 4,2       | 8         | 25       | 3     |
| M5       | 0,80     | 70        | 6,0          | 4,9        | 4,2       | 15        | 25       | 3     |
| M6       | 1,00     | 80        | 6,0          | 4,9        | 5,0       | 10        | 30       | 3     |
| M6       | 1,00     | 80        | 6,0          | 4,9        | 5,0       | 17        | 30       | 3     |
| M8       | 1,25     | 90        | 8,0          | 6,2        | 6,8       | 14        | 35       | 3     |
| M8       | 1,25     | 90        | 8,0          | 6,2        | 6,8       | 20        | 35       | 3     |
| M10      | 1,50     | 100       | 10,0         | 8,0        | 8,5       | 16        | 39       | 3     |
| M10      | 1,50     | 100       | 10,0         | 8,0        | 8,5       | 22        | 39       | 3     |
| M12      | 1,75     | 110       | 12,0         | 9,0        | 10,2      | 24        | 44       | 3     |



DIN 376 sa zašiljenim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|-------|
| M12      | 1,75     | 110       | 9            | 7          | 10,2      | 18        | 3     |
| M16      | 2,00     | 110       | 12           | 9          | 14,0      | 22        | 3     |
| M20      | 2,50     | 140       | 16           | 12         | 17,5      | 25        | 3     |

|   |    |    |    |    |
|---|----|----|----|----|
| P | 65 | 12 | 8  | 12 |
| M |    | 8  | 8  | 8  |
| K | 65 | 20 |    | 20 |
| N | 22 | 22 | 10 | 22 |
| S |    |    | 4  |    |
| H |    |    |    |    |
| O |    |    |    |    |

Brzina rezanja  $v_c$  (m/min)ST  
TSISO 2X  
6HX

TiN

HSS-E  
FHA 15°  
≤ 1050 N/mm²  
≤ 2xD

22 406 ...

EUR  
U0

57,26

030

ST  
CNCISO 2X  
6HX

TiN

HSS-E  
FHA 15°  
≤ 1100 N/mm²  
≤ 2xD

22 328 ...

EUR  
U0

52,17

030

HR

ISO 2  
6H

AlTiNHD

HSS-PM  
FHA 25°  
≤ 1400 N/mm²  
≤ 2xD

22 469 ...

EUR  
U0

46,36

03000

ST  
CNCISO 2X  
6HX

TiN

HSS-E  
FHA 15°  
≤ 1100 N/mm²  
≤ 2xD

22 443 ...

EUR  
U0

83,28

050

96,95

060

106,19

080

128,99

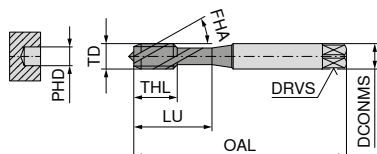
100

## Strojni ureznik za slijepi provrt

▲ LH = za lijeve navoje

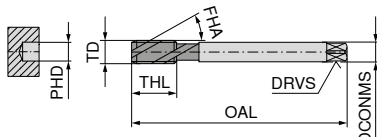
CavTap

M



DIN 371 s ojačanim drškom

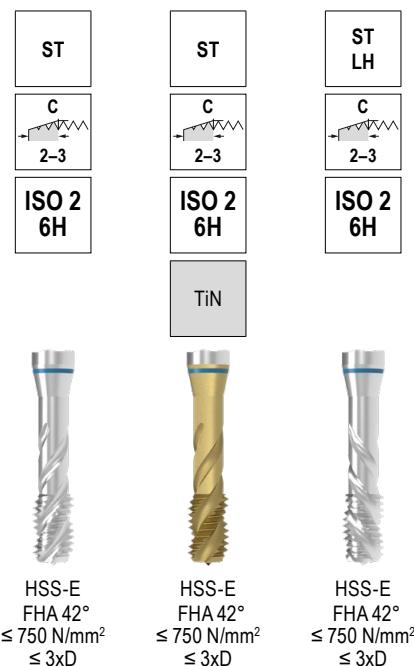
| TD   | TP   | OAL | DCONMS | DRVS | PHD  | THL  | LU | Utori |
|------|------|-----|--------|------|------|------|----|-------|
| mm   | mm   | mm  | mm     | mm   | mm   | mm   | mm |       |
| M2   | 0,40 | 45  | 2,8    | 2,1  | 1,60 | 4,0  | 12 | 2     |
| M2,3 | 0,40 | 45  | 2,8    | 2,1  | 1,90 | 4,5  | 12 | 2     |
| M2,5 | 0,45 | 50  | 2,8    | 2,1  | 2,05 | 5,0  | 15 | 2     |
| M3   | 0,50 | 56  | 3,5    | 2,7  | 2,50 | 6,0  | 18 | 3     |
| M3,5 | 0,60 | 56  | 4,0    | 3,0  | 2,90 | 7,0  | 20 | 3     |
| M4   | 0,70 | 63  | 4,5    | 3,4  | 3,30 | 7,0  | 21 | 3     |
| M5   | 0,80 | 70  | 6,0    | 4,9  | 4,20 | 8,0  | 25 | 3     |
| M6   | 1,00 | 80  | 6,0    | 4,9  | 5,00 | 10,0 | 30 | 3     |
| M8   | 1,25 | 90  | 8,0    | 6,2  | 6,80 | 14,0 | 35 | 3     |
| M10  | 1,50 | 100 | 10,0   | 8,0  | 8,50 | 16,0 | 39 | 3     |



DIN 376 sa zašiljenim drškom

| TD  | TP   | OAL | DCONMS | DRVS | PHD  | THL | Utori |
|-----|------|-----|--------|------|------|-----|-------|
| mm  | mm   | mm  | mm     | mm   | mm   | mm  |       |
| M3  | 0,50 | 56  | 2,2    |      | 2,5  | 6   | 3     |
| M4  | 0,70 | 63  | 2,8    | 2,1  | 3,3  | 7   | 3     |
| M5  | 0,80 | 70  | 3,5    | 2,7  | 4,2  | 8   | 3     |
| M6  | 1,00 | 80  | 4,5    | 3,4  | 5,0  | 10  | 3     |
| M8  | 1,25 | 90  | 6,0    | 4,9  | 6,8  | 14  | 3     |
| M10 | 1,50 | 100 | 7,0    | 5,5  | 8,5  | 16  | 3     |
| M12 | 1,75 | 110 | 9,0    | 7,0  | 10,2 | 18  | 3     |
| M14 | 2,00 | 110 | 11,0   | 9,0  | 12,0 | 20  | 3     |
| M16 | 2,00 | 110 | 12,0   | 9,0  | 14,0 | 22  | 3     |
| M18 | 2,50 | 125 | 14,0   | 11,0 | 15,5 | 25  | 3     |
| M20 | 2,50 | 140 | 16,0   | 12,0 | 17,5 | 25  | 3     |

|   |    |    |    |
|---|----|----|----|
| P | 12 | 15 | 12 |
| M |    |    |    |
| K | 12 | 15 | 12 |
| N | 12 | 15 | 22 |
| S |    |    |    |
| H |    |    |    |
| O |    |    |    |

Brzina rezanja  $v_c$  (m/min)

| 22 082 ... | 22 084 ... | 22 138 ... |
|------------|------------|------------|
| EUR        | EUR        | EUR        |
| U0         | U0         | U0         |
| 38,63 020  | 49,71 020  |            |
| 42,95 023  |            |            |
| 37,47 025  |            |            |
| 32,67 030  | 40,59 030  | 56,47 030  |
| 36,05 035  |            |            |
| 32,54 040  | 41,52 040  | 50,86 040  |
| 33,06 050  | 41,78 050  | 54,91 050  |
| 33,83 060  | 52,44 060  | 52,82 060  |
| 40,59 080  | 58,82 080  | 63,63 080  |
| 47,89 100  | 79,39 100  | 73,26 100  |

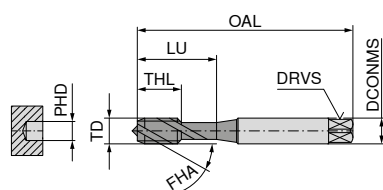
| 22 083 ... | 22 085 ... | 22 139 ... |
|------------|------------|------------|
| EUR        | EUR        | EUR        |
| U0         | U0         | U0         |
| 38,00 030  |            |            |
| 38,25 040  |            |            |
| 38,63 050  |            |            |
| 46,32 060  |            |            |
| 42,95 080  |            |            |
|            | 89,14 100  |            |
| 61,93 120  | 93,96 120  | 104,10 120 |
| 78,59 140  |            |            |
| 85,87 160  | 121,00 160 | 149,73 160 |
| 125,53 180 |            |            |
| 127,68 200 | 203,13 200 | 221,14 200 |

## Strojni ureznik za prolazni provrt, desni

▲ TS = za obradu pri visokim brzinama, do 100 m/min

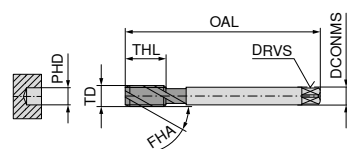
CavTap

M



DIN 371 s ojačanim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| M3       | 0,50     | 56        | 3,5          | 2,7        | 2,5       | 6         | 18       | 3     |
| M4       | 0,70     | 63        | 4,5          | 3,4        | 3,3       | 7         | 21       | 3     |
| M5       | 0,80     | 70        | 6,0          | 4,9        | 4,2       | 8         | 25       | 3     |
| M6       | 1,00     | 80        | 6,0          | 4,9        | 5,0       | 10        | 30       | 3     |
| M8       | 1,25     | 90        | 8,0          | 6,2        | 6,8       | 14        | 35       | 3     |
| M10      | 1,50     | 100       | 10,0         | 8,0        | 8,5       | 16        | 39       | 3     |



DIN 376 sa zašiljenim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|-------|
| M12      | 1,75     | 110       | 9            | 7          | 10,2      | 18        | 4     |
| M16      | 2,00     | 110       | 12           | 9          | 14,0      | 22        | 4     |

|   |   |    |    |    |
|---|---|----|----|----|
| P | 6 | 8  | 65 | 65 |
| M | 6 | 8  |    |    |
| K |   |    | 65 | 65 |
| N | 8 | 12 | 75 | 75 |
| S |   |    |    |    |
| H |   |    |    |    |
| O |   |    |    |    |

Brzina rezanja  $v_c$  (m/min)

|             |             |             |             |
|-------------|-------------|-------------|-------------|
| HR          | HR          | ST<br>TS    | ST<br>TS    |
| C<br>2-3    | C<br>2-3    | C<br>2-3    | C<br>2-3    |
| ISO 2<br>6H | ISO 2<br>6H | ISO 2<br>6H | ISO 2<br>6H |
|             | OSM         | TiN         | TiN         |

HSS-PM  
FHA 42°  
≤ 1400 N/mm<sup>2</sup>  
≤ 3xDHSS-PM  
FHA 42°  
≤ 1400 N/mm<sup>2</sup>  
≤ 3xDHSS-E  
FHA 40°  
≤ 1100 N/mm<sup>2</sup>  
≤ 2xDHSS-E  
FHA 40°  
≤ 1100 N/mm<sup>2</sup>  
≤ 2xD

22 498 ...

EUR  
U0

030

38,25

040

36,05

050

38,00

060

37,47

080

45,40

100

54,91

22 499 ...

EUR  
U0

030

48,55

040

48,55

050

51,66

060

53,35

080

67,67

100

76,39

22 046 ...

EUR  
U0

050

100,32

060

130,18

080

135,31

100

183,59

22 044 ...

EUR  
U0

040

59,20

050

63,63

060

67,67

080

76,39

100

94,88

22 045 ...

EUR  
U0

120

113,73

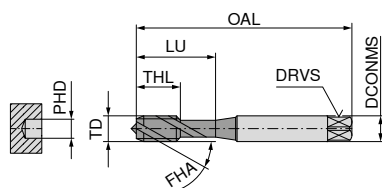
160

163,91

## Strojni ureznik za prolazni provrt, desni

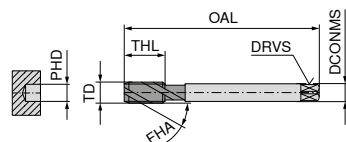
CavTap

M



DIN 371 s ojačanim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| M1,6     | 0,35     | 40        | 2,5          | 2,1        | 1,25      | 4         | 11       | 2     |
| M2       | 0,40     | 45        | 2,8          | 2,1        | 1,60      | 4         | 12       | 2     |
| M2,5     | 0,45     | 50        | 2,8          | 2,1        | 2,05      | 5         | 15       | 2     |
| M2,5     | 0,45     | 50        | 2,8          | 2,1        | 2,05      | 5         | 15       | 3     |
| M3       | 0,50     | 56        | 3,5          | 2,7        | 2,50      | 6         | 18       | 3     |
| M4       | 0,70     | 63        | 4,5          | 3,4        | 3,30      | 7         | 21       | 3     |
| M5       | 0,80     | 70        | 6,0          | 4,9        | 4,20      | 8         | 25       | 3     |
| M6       | 1,00     | 80        | 6,0          | 4,9        | 5,00      | 10        | 30       | 3     |
| M8       | 1,25     | 90        | 8,0          | 6,2        | 6,80      | 14        | 35       | 3     |
| M10      | 1,50     | 100       | 10,0         | 8,0        | 8,50      | 16        | 39       | 3     |



DIN 376 sa zašiljenim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|-------|
| M12      | 1,75     | 110       | 9            | 7,0        | 10,2      | 18        | 4     |
| M14      | 2,00     | 110       | 11           | 9,0        | 12,0      | 20        | 4     |
| M16      | 2,00     | 110       | 12           | 9,0        | 14,0      | 22        | 4     |
| M20      | 2,50     | 140       | 16           | 12,0       | 17,5      | 25        | 4     |
| M22      | 2,50     | 140       | 18           | 14,5       | 19,5      | 27        | 5     |
| M24      | 3,00     | 160       | 18           | 14,5       | 21,0      | 30        | 5     |
| M30      | 3,50     | 180       | 22           | 18,0       | 26,5      | 35        | 5     |

|   |   |    |    |
|---|---|----|----|
| P | 8 | 10 | 10 |
| M | 6 | 8  | 8  |
| K |   |    |    |
| N |   |    |    |
| S |   |    |    |
| H |   |    |    |
| O |   |    |    |

Brzina rezanja  $v_c$  (m/min)

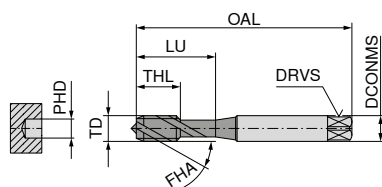
| VA                                       | VA                                       | VA                                       |
|------------------------------------------|------------------------------------------|------------------------------------------|
| C<br>2-3                                 | E<br>1,5-2                               | C<br>2-3                                 |
| ISO 2<br>6H                              | ISO 2<br>6H                              | ISO 2<br>6H                              |
| vap.                                     | TiN GS                                   | TiN GS                                   |
|                                          |                                          |                                          |
| HSS-E<br>FHA 42°<br>≤ 900 N/mm²<br>≤ 3xD | HSS-E<br>FHA 45°<br>≤ 900 N/mm²<br>≤ 3xD | HSS-E<br>FHA 45°<br>≤ 900 N/mm²<br>≤ 3xD |
| 22 090 ...                               | 22 042 ...                               | 22 040 ...                               |
| EUR<br>U0                                | EUR<br>U0                                | EUR<br>U0                                |
| 62,47 020                                |                                          | 99,53 016                                |
| 49,44 025                                |                                          | 56,10 020                                |
|                                          |                                          | 53,35 025                                |
| 36,96 030                                |                                          | 54,91 030                                |
| 38,00 040                                |                                          | 55,56 040                                |
| 38,63 050                                | 81,99 050                                | 58,16 050                                |
| 38,91 060                                | 82,90 060                                | 59,61 060                                |
| 45,40 080                                | 105,94 080                               | 74,69 080                                |
| 54,91 100                                | 121,83 100                               | 86,67 100                                |

|            |            |
|------------|------------|
| 22 091 ... | 22 041 ... |
| EUR<br>U0  | EUR<br>U0  |
| 68,33 120  | 116,33 120 |
| 100,32 140 | 140,55 140 |
| 96,15 160  | 153,54 160 |
| 148,42 200 | 223,87 200 |
| 248,55 220 |            |
| 188,71 240 |            |
| 387,91 300 |            |

## Strojni ureznik za prolazni provrt, desni

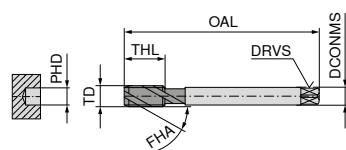
CavTap

M



DIN 371 s ojačanim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| M2       | 0,40     | 45        | 2,8          | 2,1        | 1,60      | 4         | 12       | 2     |
| M2,5     | 0,45     | 50        | 2,8          | 2,1        | 2,05      | 5         | 15       | 2     |
| M2,5     | 0,45     | 50        | 2,8          | 2,1        | 2,05      | 5         | 14       | 2     |
| M3       | 0,50     | 56        | 3,5          | 2,7        | 2,50      | 6         | 18       | 2     |
| M3       | 0,50     | 56        | 3,5          | 2,7        | 2,50      | 6         | 18       | 3     |
| M4       | 0,70     | 63        | 4,5          | 3,4        | 3,30      | 7         | 21       | 2     |
| M4       | 0,70     | 63        | 4,5          | 3,4        | 3,30      | 7         | 21       | 3     |
| M5       | 0,80     | 70        | 6,0          | 4,9        | 4,20      | 8         | 25       | 2     |
| M5       | 0,80     | 70        | 6,0          | 4,9        | 4,20      | 8         | 25       | 3     |
| M6       | 1,00     | 80        | 6,0          | 4,9        | 5,00      | 10        | 30       | 2     |
| M6       | 1,00     | 80        | 6,0          | 4,9        | 5,00      | 10        | 30       | 3     |
| M8       | 1,25     | 90        | 8,0          | 6,2        | 6,80      | 14        | 35       | 2     |
| M8       | 1,25     | 90        | 8,0          | 6,2        | 6,80      | 14        | 35       | 3     |
| M10      | 1,50     | 100       | 10,0         | 8,0        | 8,50      | 16        | 39       | 2     |
| M10      | 1,50     | 100       | 10,0         | 8,0        | 8,50      | 16        | 39       | 3     |



DIN 376 sa zašiljenim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|-------|
| M12      | 1,75     | 110       | 9            | 7          | 10,2      | 18        | 3     |
| M14      | 2,00     | 110       | 11           | 9          | 12,0      | 20        | 3     |
| M16      | 2,00     | 110       | 12           | 9          | 14,0      | 22        | 3     |
| M20      | 2,50     | 140       | 16           | 12         | 17,5      | 25        | 3     |

22 461 ...

EUR  
U0

|     |        |       |
|-----|--------|-------|
| M12 | 79,07  | 12000 |
| M14 | 113,56 | 14000 |
| M16 | 110,29 | 16000 |
| M20 | 158,19 | 20000 |

|   |    |    |
|---|----|----|
| P | 15 | 15 |
| M |    |    |
| K |    |    |
| N | 22 | 22 |
| S |    | 15 |
| H |    |    |
| O |    |    |

Brzina rezanja  $v_c$  (m/min)

|                                          |                                          |                                          |                                          |
|------------------------------------------|------------------------------------------|------------------------------------------|------------------------------------------|
| Soft                                     | Soft                                     | NW                                       | NW                                       |
|                                          |                                          |                                          |                                          |
| ISO 2 6H                                 | ISO 2 6H                                 | ISO 2 6H                                 | ISO 2 6H                                 |
|                                          | CH                                       | vap.                                     | DLC                                      |
|                                          |                                          |                                          |                                          |
| HSS-E<br>FHA 42°<br>≤ 500 N/mm²<br>≤ 3xD | HSS-E<br>FHA 42°<br>≤ 500 N/mm²<br>≤ 3xD | HSS-E<br>FHA 38°<br>≤ 500 N/mm²<br>≤ 3xD | HSS-E<br>FHA 38°<br>≤ 880 N/mm²<br>≤ 3xD |

22 326 ...

EUR  
U0

50,75 020

47,49 025

38,91 030

38,91 040

40,21 050

40,21 060

48,15 080

56,60 100

22 324 ...

EUR  
U0

68,58 020

66,63 025

57,78 030

62,32 040

64,28 050

89,27 060

96,95 080

121,83 100

22 086 ...

EUR  
U0

43,72 020

40,59 025

34,09 030

34,09 040

35,40 050

35,40 060

40,87 080

50,09 100

22 460 ...

EUR  
U0

56,55 02000

56,55 02500

45,92 03000

47,25 04000

47,25 05000

48,61 06000

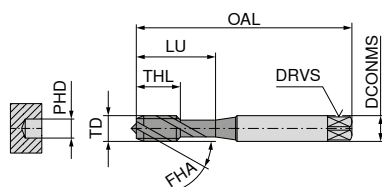
54,86 08000

62,56 10000

## Strojni ureznik za prolazni provrt, desni

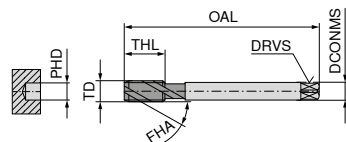
CavTap  
SL

M



DIN 371 s ojačanim drškom

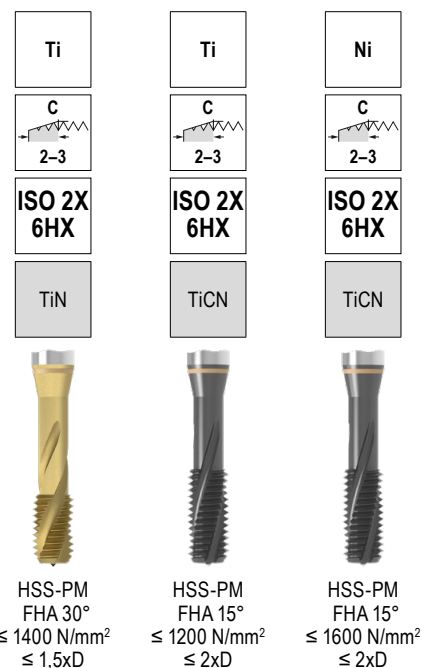
| TD   | TP   | OAL | DCONMS | DRVS | PHD  | THL | LU | Utori |
|------|------|-----|--------|------|------|-----|----|-------|
| mm   | mm   | mm  | mm     | mm   | mm   | mm  | mm |       |
| M3   | 0,50 | 56  | 3,5    | 2,7  | 2,5  | 11  | 18 | 2     |
| M3   | 0,50 | 56  | 3,5    | 2,7  | 2,5  | 6   | 18 | 3     |
| M3,5 | 0,60 | 56  | 4,0    | 3,0  | 2,9  | 12  | 20 | 3     |
| M4   | 0,70 | 63  | 4,5    | 3,4  | 3,3  | 7   | 21 | 3     |
| M4   | 0,70 | 63  | 4,5    | 3,4  | 3,3  | 13  | 21 | 3     |
| M5   | 0,80 | 70  | 6,0    | 4,9  | 4,2  | 8   | 25 | 3     |
| M5   | 0,80 | 70  | 6,0    | 4,9  | 4,2  | 15  | 25 | 3     |
| M6   | 1,00 | 80  | 6,0    | 4,9  | 5,0  | 10  | 30 | 3     |
| M6   | 1,00 | 80  | 6,0    | 4,9  | 5,0  | 17  | 30 | 3     |
| M8   | 1,25 | 90  | 8,0    | 6,2  | 6,8  | 14  | 35 | 3     |
| M8   | 1,25 | 90  | 8,0    | 6,2  | 6,8  | 20  | 35 | 3     |
| M10  | 1,50 | 100 | 10,0   | 8,0  | 8,5  | 16  | 39 | 3     |
| M10  | 1,50 | 100 | 10,0   | 8,0  | 8,5  | 22  | 39 | 3     |
| M12  | 1,75 | 110 | 12,0   | 9,0  | 10,2 | 18  | 44 | 3     |



DIN 376 sa zašiljenim drškom

| TD  | TP   | OAL | DCONMS | DRVS | PHD  | THL | Utori |
|-----|------|-----|--------|------|------|-----|-------|
| mm  | mm   | mm  | mm     | mm   | mm   | mm  |       |
| M12 | 1,75 | 110 | 9      | 7,0  | 10,2 | 24  | 3     |
| M14 | 2,00 | 110 | 11     | 9,0  | 12,0 | 26  | 3     |
| M16 | 2,00 | 110 | 12     | 9,0  | 14,0 | 27  | 3     |
| M20 | 2,50 | 140 | 16     | 12,0 | 17,5 | 32  | 3     |
| M24 | 3,00 | 160 | 18     | 14,5 | 21,0 | 34  | 3     |

|   |    |    |
|---|----|----|
| P | 7  | 7  |
| M | 7  | 7  |
| K |    |    |
| N | 22 | 22 |
| S | 5  | 5  |
| H |    |    |
| O |    |    |

Brzina rezanja  $v_c$  (m/min)

22 076 ...

EUR

U0

53,35

030

22 163 ...

EUR

U0

55,30

030

22 424 ...

EUR

U0

70,66

030

54,91

040

59,47

035

60,75

040

55,19

050

60,38

060

63,63

080

92,14

100

109,81

100

105,28

120

124,34

120

174,52

160

301,97

200

344,76

240

73,65

040

76,39

050

96,04

060

105,40

080

131,38

100

153,54

120

225,19

140

210,88

160

365,61

200

## Strojni ureznik za prolazni provrt, desni

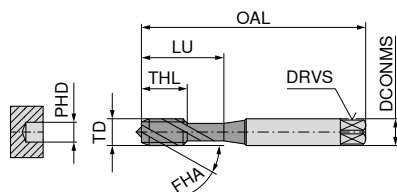
▲ ES = iznimno kratki

CavTap

M

UNI  
ESE  
1,5-2ISO 2  
6H

vap.



DIN 352 s ojačanim drškom

HSS-E  
FHA 42°  
≤ 1100 N/mm<sup>2</sup>  
≤ 3xD

22 500 ...

EUR  
U0

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| M3       | 0,50     | 40        | 3,5          | 2,7        | 2,5       | 6         | 18       | 3     |
| M4       | 0,70     | 45        | 4,5          | 3,4        | 3,3       | 7         | 22       | 3     |
| M5       | 0,80     | 50        | 6,0          | 4,9        | 4,2       | 9         | 25       | 3     |
| M6       | 1,00     | 56        | 6,0          | 4,9        | 5,0       | 10        | 28       | 3     |
| M8       | 1,25     | 63        | 6,0          | 4,9        | 6,8       | 14        |          | 3     |
| M10      | 1,50     | 70        | 7,0          | 5,5        | 8,5       | 16        |          | 3     |
| M12      | 1,75     | 75        | 9,0          | 7,0        | 10,2      | 18        |          | 4     |
| M16      | 2,00     | 80        | 12,0         | 9,0        | 14,0      | 22        |          | 4     |

|       |     |
|-------|-----|
| 30,97 | 030 |
| 31,90 | 040 |
| 32,67 | 050 |
| 33,83 | 060 |
| 38,91 | 080 |
| 46,32 | 100 |
| 60,38 | 120 |
| 95,49 | 160 |

|   |    |
|---|----|
| P | 12 |
| M | 7  |
| K | 12 |
| N |    |
| S |    |
| H |    |
| O |    |

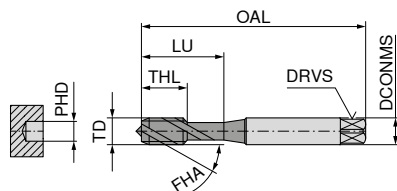
Brzina rezanja v<sub>c</sub> (m/min)

## Strojni ureznik za prolazni provrt, desni

▲ ES = iznimno kratki

CavTap  
SL

M

ST  
ESC  
2-3ISO 2  
6H

DIN 352 s ojačanim drškom

HSS-E  
FHA 15°  
≤ 750 N/mm²  
≤ 2xD

22 016 ...

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| M3       | 0,50     | 40        | 3,5          | 2,7        | 2,5       | 10        | 18       | 2     |
| M4       | 0,70     | 45        | 4,5          | 3,4        | 3,3       | 12        | 22       | 3     |
| M5       | 0,80     | 50        | 6,0          | 4,9        | 4,2       | 14        | 25       | 3     |
| M6       | 1,00     | 56        | 6,0          | 4,9        | 5,0       | 16        | 28       | 3     |
| M8       | 1,25     | 63        | 6,0          | 4,9        | 6,8       | 20        |          | 3     |
| M10      | 1,50     | 70        | 7,0          | 5,5        | 8,5       | 22        |          | 3     |
| M12      | 1,75     | 75        | 9,0          | 7,0        | 10,2      | 24        |          | 3     |

EUR

U0

030

040

050

060

080

100

120

|   |    |
|---|----|
| P | 12 |
| M |    |
| K | 12 |
| N | 12 |
| S |    |
| H |    |
| O |    |

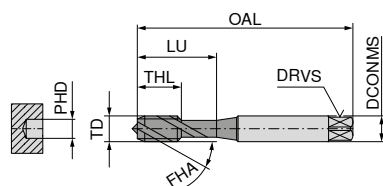
Brzina rezanja  $v_c$  (m/min)

## Strojni ureznik za prolazni provrt, desni

▲ EL = iznimno dugački, s dvostrukom ukupnom duljinom

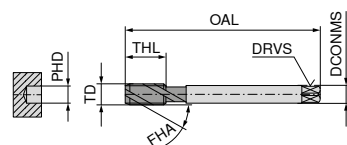
CavTap

M



DIN 371 s ojačanim drškom

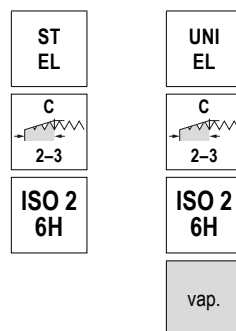
| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| M3       | 0,50     | 100       | 3,5          | 2,7        | 2,5       | 6         | 18       | 3     |
| M4       | 0,70     | 125       | 4,5          | 3,4        | 3,3       | 7         | 21       | 3     |
| M5       | 0,80     | 140       | 6,0          | 4,9        | 4,2       | 8         | 25       | 3     |
| M6       | 1,00     | 160       | 6,0          | 4,9        | 5,0       | 10        | 30       | 3     |
| M8       | 1,25     | 180       | 8,0          | 6,2        | 6,8       | 14        | 35       | 3     |



DIN 376 sa zašiljenim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|-------|
| M6       | 1,00     | 160       | 4,5          | 3,4        | 5,0       | 10        | 3     |
| M8       | 1,25     | 180       | 6,0          | 4,9        | 6,8       | 14        | 3     |
| M10      | 1,50     | 200       | 7,0          | 5,5        | 8,5       | 16        | 3     |
| M12      | 1,75     | 224       | 9,0          | 7,0        | 10,2      | 18        | 3     |
| M14      | 2,00     | 224       | 11,0         | 9,0        | 12,0      | 20        | 3     |
| M16      | 2,00     | 224       | 12,0         | 9,0        | 14,0      | 22        | 3     |
| M18      | 2,50     | 250       | 14,0         | 11,0       | 15,5      | 25        | 3     |
| M20      | 2,50     | 280       | 16,0         | 12,0       | 17,5      | 25        | 3     |

|   |    |    |
|---|----|----|
| P | 12 | 12 |
| M |    | 7  |
| K | 12 | 12 |
| N | 22 |    |
| S |    |    |
| H |    |    |
| O |    |    |

Brzina rezanja v<sub>c</sub> (m/min)HSS-E  
FHA 42°  
≤ 750 N/mm²  
≤ 3xDHSS-E  
FHA 42°  
≤ 1100 N/mm²  
≤ 3xD

22 422 ...

EUR  
U0

74,82

030

73,26

040

81,84

050

85,23

060

102,54

080

22 538 ...

EUR  
U0

64,28

030

64,28

040

72,09

050

75,87

060

90,69

080

22 539 ...

EUR  
U0

81,99

060

99,53

080

100,32

100

128,15

120

188,71

140

180,84

160

290,16

180

248,55

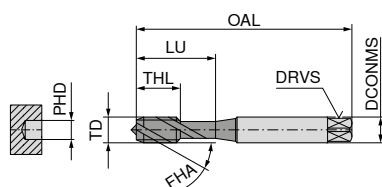
200

## Strojni ureznik za prolazni provrt, desni

▲ EL = iznimno dugački, s dvostrukom ukupnom duljinom

CavTap  
SL

M

ST  
ELE  
1,5-2ISO 2  
6H

DIN 371 s ojačanim drškom

HSS-E  
FHA 15°  
≤ 750 N/mm²  
≤ 2xD

22 078 ...

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| M3       | 0,50     | 100       | 3,5          | 2,7        | 2,5       | 11        | 18       | 2     |
| M4       | 0,70     | 125       | 4,5          | 3,4        | 3,3       | 13        | 21       | 3     |
| M5       | 0,80     | 140       | 6,0          | 4,9        | 4,2       | 15        | 25       | 3     |
| M6       | 1,00     | 160       | 6,0          | 4,9        | 5,0       | 17        | 30       | 3     |
| M8       | 1,25     | 180       | 8,0          | 6,2        | 6,8       | 20        | 35       | 3     |

EUR

U0

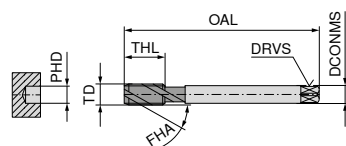
61,81 030

61,41 040

69,61 050

72,48 060

87,46 080



DIN 376 sa zašiljenim drškom

22 080 ...

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|-------|
| M6       | 1,00     | 160       | 4,5          | 3,4        | 5,0       | 17        | 3     |
| M8       | 1,25     | 180       | 6,0          | 4,9        | 6,8       | 20        | 3     |
| M10      | 1,50     | 200       | 7,0          | 5,5        | 8,5       | 22        | 3     |
| M12      | 1,75     | 224       | 9,0          | 7,0        | 10,2      | 24        | 3     |
| M14      | 2,00     | 224       | 11,0         | 9,0        | 12,0      | 26        | 3     |
| M16      | 2,00     | 224       | 12,0         | 9,0        | 14,0      | 27        | 3     |
| M20      | 2,50     | 280       | 16,0         | 12,0       | 17,5      | 32        | 3     |

EUR

U0

75,47 060

89,78 080

95,49 100

121,83 120

178,35 140

175,72 160

243,44 200

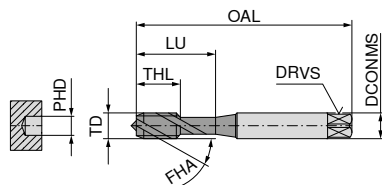
|   |    |
|---|----|
| P | 12 |
| M |    |
| K | 12 |
| N | 12 |
| S |    |
| H |    |
| O |    |

Brzina rezanja v<sub>c</sub> (m/min)

## Strojni ureznik za prolazni provrt, desni

▲ NC = za CNC sinkronu obradu s kompenzacijskom glavom minimalne duljine

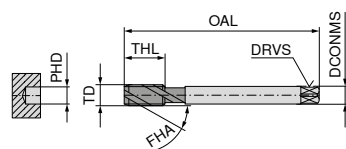
M



DIN 371 s ojačanim drškom

| UNI                                         | UNI                                         | UNI                                          | UNI                                       | UNI NC                                    |
|---------------------------------------------|---------------------------------------------|----------------------------------------------|-------------------------------------------|-------------------------------------------|
| C<br>2-3                                    | C<br>2-3                                    | C<br>2-3                                     | C<br>2-3                                  | C<br>2-3                                  |
| ISO 2<br>6H                                 | ISO 2<br>6H                                 | ISO 2<br>6H                                  | ISO 2<br>6H                               | ISO 2<br>6H                               |
| vap.                                        | TiN                                         | TiN                                          | TiCN                                      | TiN GS                                    |
|                                             |                                             |                                              |                                           |                                           |
| HSS-E<br>FHA 35°<br>≤ 1000 N/mm²<br>≤ 2,5xD | HSS-E<br>FHA 35°<br>≤ 1000 N/mm²<br>≤ 2,5xD | HSS-PM<br>FHA 50°<br>≤ 1000 N/mm²<br>≤ 2,5xD | HSS-E<br>FHA 45°<br>≤ 1000 N/mm²<br>≤ 3xD | HSS-E<br>FHA 45°<br>≤ 1000 N/mm²<br>≤ 3xD |

|      |      |     |        |      |      |     |    |       | 23 118 ... | 23 120 ... | 23 026 ... | 23 122 ... | 23 124 ... |
|------|------|-----|--------|------|------|-----|----|-------|------------|------------|------------|------------|------------|
| TD   | TP   | OAL | DCONMS | DRVS | PHD  | THL | LU | Utori | EUR<br>T9  | EUR<br>T9  | EUR<br>T9  | EUR<br>T9  | EUR<br>T9  |
| M2   | 0,40 | 45  | 2,8    | 2,1  | 1,60 | 4   | 12 | 2     | 15,30      | 13,33      |            |            |            |
| M2,5 | 0,45 | 50  | 2,8    | 2,1  | 2,05 | 5   | 14 | 2     | 15,04      | 20,10      |            |            |            |
| M3   | 0,50 | 56  | 3,5    | 2,7  | 2,50 | 6   | 18 | 3     | 10,33      | 15,30      | 17,01      | 22,32      | 23,54      |
| M4   | 0,70 | 63  | 4,5    | 3,4  | 3,30 | 7   | 21 | 3     | 10,33      | 16,39      | 17,01      | 23,54      | 24,90      |
| M5   | 0,80 | 70  | 6,0    | 4,9  | 4,20 | 8   | 25 | 3     | 10,85      | 16,66      | 18,26      | 24,53      | 26,26      |
| M6   | 1,00 | 80  | 6,0    | 4,9  | 5,00 | 10  | 30 | 3     | 11,22      | 20,72      | 21,20      | 31,69      | 35,51      |
| M8   | 1,25 | 90  | 8,0    | 6,2  | 6,80 | 14  | 35 | 3     | 13,19      | 22,32      | 25,16      | 34,03      | 38,10      |
| M10  | 1,50 | 100 | 10,0   | 8,0  | 8,50 | 16  | 39 | 3     | 15,17      | 28,60      | 31,69      | 43,02      | 48,45      |



DIN 376 sa zašiljenim drškom

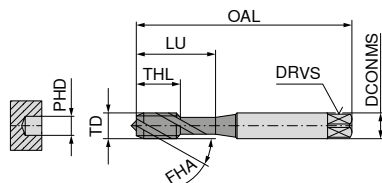
|     |      |     |        |      |      |     |       |  | 23 119 ... | 23 121 ... | 23 027 ... | 23 123 ... | 23 125 ... |
|-----|------|-----|--------|------|------|-----|-------|--|------------|------------|------------|------------|------------|
| TD  | TP   | OAL | DCONMS | DRVS | PHD  | THL | Utori |  | EUR<br>T9  | EUR<br>T9  | EUR<br>T9  | EUR<br>T9  | EUR<br>T9  |
| M3  | 0,50 | 56  | 2,2    | 2,1  | 2,5  | 6   | 3     |  | 12,32      |            |            |            |            |
| M4  | 0,70 | 63  | 2,8    | 2,1  | 3,3  | 7   | 3     |  | 11,11      |            |            |            |            |
| M5  | 0,80 | 70  | 3,5    | 2,7  | 4,2  | 8   | 3     |  | 10,95      |            |            |            |            |
| M6  | 1,00 | 80  | 4,5    | 3,4  | 5,0  | 10  | 3     |  | 10,77      |            |            |            |            |
| M8  | 1,25 | 90  | 6,0    | 4,9  | 6,8  | 14  | 3     |  | 11,28      |            |            |            |            |
| M10 | 1,50 | 100 | 7,0    | 5,5  | 8,5  | 16  | 3     |  | 15,30      |            |            |            |            |
| M12 | 1,75 | 110 | 9,0    | 7,0  | 10,2 | 18  | 3     |  | 17,26      | 34,28      |            |            |            |
| M12 | 1,75 | 110 | 9,0    | 7,0  | 10,2 | 18  | 4     |  |            |            | 37,36      | 51,05      | 56,23      |
| M14 | 2,00 | 110 | 11,0   | 9,0  | 12,0 | 20  | 3     |  |            | 52,12      |            |            |            |
| M14 | 2,00 | 110 | 11,0   | 9,0  | 12,0 | 20  | 4     |  |            |            | 53,88      |            |            |
| M16 | 2,00 | 110 | 12,0   | 9,0  | 14,0 | 22  | 3     |  | 25,40      | 47,72      |            |            |            |
| M16 | 2,00 | 110 | 12,0   | 9,0  | 14,0 | 22  | 4     |  |            |            | 53,88      | 68,07      | 74,97      |
| M18 | 2,50 | 125 | 14,0   | 11,0 | 15,5 | 25  | 3     |  |            | 82,44      |            |            |            |
| M20 | 2,50 | 140 | 16,0   | 12,0 | 17,5 | 25  | 3     |  | 38,22      | 70,66      |            |            |            |
| M20 | 2,50 | 140 | 16,0   | 12,0 | 17,5 | 25  | 4     |  |            |            | 61,64      |            |            |
| M22 | 2,50 | 140 | 18,0   | 14,5 | 19,5 | 27  | 4     |  |            | 120,88     |            |            |            |
| M24 | 3,00 | 160 | 18,0   | 14,5 | 21,0 | 34  | 4     |  |            | 99,64      |            |            |            |
| M27 | 3,00 | 160 | 20,0   | 16,0 | 24,0 | 30  | 4     |  |            | 151,16     |            |            |            |
| M30 | 3,50 | 180 | 22,0   | 18,0 | 26,5 | 35  | 4     |  |            | 167,85     |            |            |            |
| M33 | 3,50 | 180 | 25,0   | 20,0 | 29,5 | 35  | 4     |  |            | 242,01     |            |            |            |
| M36 | 4,00 | 200 | 28,0   | 22,0 | 32,0 | 40  | 4     |  |            | 262,98     |            |            |            |
| P   |      |     |        |      |      |     |       |  | 12         | 15         | 15         | 15         | 15         |
| M   |      |     |        |      |      |     |       |  | 7          | 9          | 9          | 9          | 9          |
| K   |      |     |        |      |      |     |       |  | 12         | 18         | 18         | 18         | 18         |
| N   |      |     |        |      |      |     |       |  |            | 12         | 12         | 12         | 12         |
| S   |      |     |        |      |      |     |       |  |            |            |            |            |            |
| H   |      |     |        |      |      |     |       |  |            |            |            |            |            |
| O   |      |     |        |      |      |     |       |  |            |            |            |            |            |

Brzina rezanja v<sub>c</sub> (m/min)

## Strojni ureznik za prolazni provrt, desni

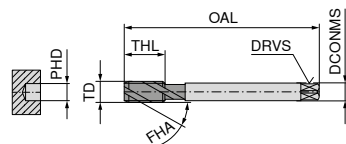
▲ NCW = s Weldon steznom površinom za CNC sinkronu obradu bez kompenzacijske glave

M



DIN 371 s ojačanim drškom

| TD   | TP   | OAL | DCONMS | DRVS | PHD  | THL | LU | Utori |
|------|------|-----|--------|------|------|-----|----|-------|
| mm   | mm   | mm  | mm     | mm   | mm   | mm  | mm |       |
| M2   | 0,40 | 45  | 2,8    | 2,1  | 1,60 | 4   | 12 | 2     |
| M2,5 | 0,45 | 50  | 2,8    | 2,1  | 2,05 | 5   | 14 | 2     |
| M3   | 0,50 | 56  | 3,5    | 2,7  | 2,50 | 6   | 18 | 3     |
| M3   | 0,50 | 70  | 6,0    | 4,9  | 2,50 | 6   | 18 | 3     |
| M4   | 0,70 | 63  | 4,5    | 3,4  | 3,30 | 7   | 21 | 3     |
| M4   | 0,70 | 70  | 6,0    | 4,9  | 3,30 | 7   | 21 | 3     |
| M5   | 0,80 | 70  | 6,0    | 4,9  | 4,20 | 8   | 25 | 3     |
| M6   | 1,00 | 80  | 6,0    | 4,9  | 5,00 | 10  | 30 | 3     |
| M8   | 1,25 | 90  | 8,0    | 6,2  | 6,80 | 14  | 35 | 3     |
| M10  | 1,50 | 100 | 10,0   | 8,0  | 8,50 | 16  | 39 | 3     |



DIN 376 sa zašiljenim drškom

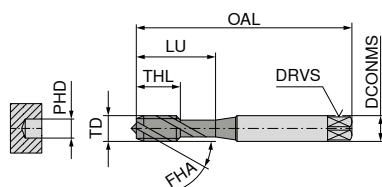
| TD  | TP   | OAL | DCONMS | DRVS | PHD  | THL | Utori | 23 127 ... | 23 217 ... | 23 313 ... | 23 415 ... |
|-----|------|-----|--------|------|------|-----|-------|------------|------------|------------|------------|
| mm  | mm   | mm  | mm     | mm   | mm   | mm  |       | EUR T9     | EUR T9     | EUR T9     | EUR T9     |
| M12 | 1,75 | 110 | 10     | 8,0  | 10,2 | 18  | 3     | 55,97      | 120        | 49,08      | 120        |
| M12 | 1,75 | 110 | 9      | 7,0  | 10,2 | 18  | 3     |            | 29,60      | 120        | 33,16      |
| M14 | 2,00 | 110 | 11     | 9,0  | 12,0 | 20  | 3     |            | 35,64      | 140        |            |
| M16 | 2,00 | 110 | 12     | 9,0  | 14,0 | 22  | 3     | 75,32      | 160        | 66,33      | 160        |
| M20 | 2,50 | 140 | 16     | 12,0 | 17,5 | 25  | 3     |            | 44,89      | 160        | 51,05      |
| M24 | 3,00 | 160 | 18     | 14,5 | 21,0 | 30  | 4     |            | 70,78      | 200        | 78,05      |
|     |      |     |        |      |      |     |       |            |            | 118,86     | 200        |
|     |      |     |        |      |      |     |       |            |            |            | 107,02     |
| P   |      |     |        |      |      |     |       | 15         | 12         | 15         | 8          |
| M   |      |     |        |      |      |     |       | 8          |            |            | 6          |
| K   |      |     |        |      |      |     |       | 15         | 12         | 15         |            |
| N   |      |     |        |      |      |     |       | 22         | 22         | 24         | 22         |
| S   |      |     |        |      |      |     |       |            |            |            |            |
| H   |      |     |        |      |      |     |       |            |            |            |            |
| O   |      |     |        |      |      |     |       |            |            |            |            |

Brzina rezanja  $v_c$  (m/min)

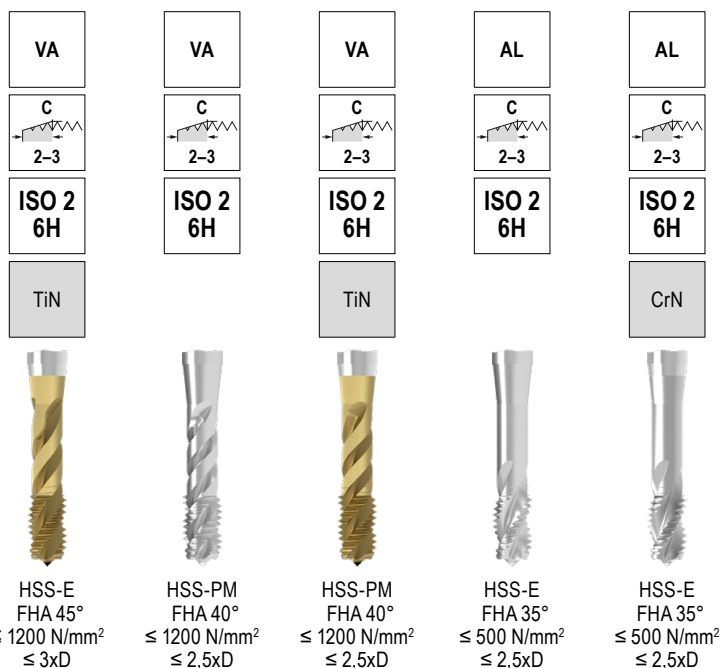
| UNI NCW                                      | FE                                         | FE-HF                                       | VA                                          |
|----------------------------------------------|--------------------------------------------|---------------------------------------------|---------------------------------------------|
| C<br>2-3                                     | C<br>2-3                                   | C<br>2-3                                    | C<br>2-3                                    |
| ISO 2 6H                                     | ISO 2 6H                                   | ISO 2 6H                                    | ISO 2 6H                                    |
| TiCN                                         |                                            | TiCN                                        |                                             |
|                                              |                                            |                                             |                                             |
| HSS-PM<br>FHA 35°<br>≤ 1000 N/mm²<br>≤ 2,5xD | HSS-E<br>FHA 35°<br>≤ 850 N/mm²<br>≤ 2,5xD | HSS-E<br>FHA 35°<br>≤ 1100 N/mm²<br>≤ 2,5xD | HSS-E<br>FHA 35°<br>≤ 1200 N/mm²<br>≤ 2,5xD |
| 23 126 ...                                   | 23 216 ...                                 | 23 312 ...                                  | 23 414 ...                                  |
| EUR T9                                       | EUR T9                                     | EUR T9                                      | EUR T9                                      |
|                                              | 13,92 020                                  |                                             | 23,80 020                                   |
|                                              | 25,53 025                                  |                                             | 28,24 025                                   |
|                                              | 13,68 030                                  | 20,47 030                                   | 15,42 030                                   |
| 25,28 030                                    | 13,68 040                                  | 22,32 040                                   | 15,42 040                                   |
| 28,86 040                                    | 14,19 050                                  | 22,56 050                                   | 15,92 050                                   |
| 29,34 050                                    | 14,19 060                                  | 31,21 060                                   | 15,92 060                                   |
| 29,34 060                                    | 18,37 080                                  | 34,03 080                                   | 20,60 080                                   |
| 37,11 080                                    | 21,94 100                                  | 42,42 100                                   | 25,05 100                                   |
| 44,74 100                                    |                                            |                                             |                                             |

## Strojni ureznik za prolazni provrt, desni

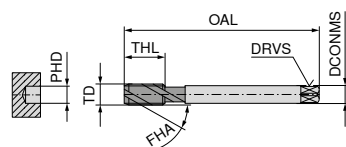
M



DIN 371 s ojačanim drškom



|      |      |     |        |      |      |     |    |       |  | 23 416 ... | 23 426 ... | 23 456 ... | 23 616 ... | 23 614 ... |
|------|------|-----|--------|------|------|-----|----|-------|--|------------|------------|------------|------------|------------|
| TD   | TP   | OAL | DCONMS | DRVS | PHD  | THL | LU | Utori |  | EUR<br>T9  | EUR<br>T9  | EUR<br>T9  | EUR<br>T9  | EUR<br>T9  |
| M2   | 0,40 | 45  | 2,8    | 2,1  | 1,60 | 4   | 12 | 2     |  | 25,65      |            |            |            |            |
| M2,5 | 0,45 | 50  | 2,8    | 2,1  | 2,05 | 5   | 14 | 2     |  | 24,53      |            |            |            |            |
| M3   | 0,50 | 56  | 3,5    | 2,7  | 2,50 | 6   | 18 | 3     |  | 20,84      | 15,17      | 17,01      | 13,68      | 18,01      |
| M4   | 0,70 | 63  | 4,5    | 3,4  | 3,30 | 7   | 21 | 3     |  | 21,83      | 15,42      | 18,50      | 13,68      | 18,01      |
| M5   | 0,80 | 70  | 6,0    | 4,9  | 4,20 | 8   | 25 | 3     |  | 22,32      | 15,78      | 18,85      | 14,19      | 18,62      |
| M6   | 1,00 | 80  | 6,0    | 4,9  | 5,00 | 10  | 30 | 3     |  | 27,99      | 16,03      | 24,28      | 14,19      | 18,62      |
| M8   | 1,25 | 90  | 8,0    | 6,2  | 6,80 | 14  | 35 | 3     |  | 30,83      | 18,85      | 26,01      | 18,37      | 21,58      |
| M10  | 1,50 | 100 | 10,0   | 8,0  | 8,50 | 16  | 39 | 3     |  | 38,96      | 22,70      | 35,87      | 21,94      | 26,38      |



DIN 376 sa zašiljenim drškom

|     |      |     |        |      |      |     |       | 23 417 ... | 23 427 ... | 23 457 ... | 23 615 ... |
|-----|------|-----|--------|------|------|-----|-------|------------|------------|------------|------------|
| TD  | TP   | OAL | DCONMS | DRVS | PHD  | THL | Utori | EUR<br>T9  | EUR<br>T9  | EUR<br>T9  | EUR<br>T9  |
| M12 | 1,75 | 110 | 9      | 7,0  | 10,2 | 18  | 3     |            | 37,47      | 51,30      | 32,68      |
| M12 | 1,75 | 110 | 9      | 7,0  | 10,2 | 18  | 4     | 46,11      |            |            |            |
| M14 | 2,00 | 110 | 11     | 9,0  | 12,0 | 20  | 4     |            | 49,32      |            |            |
| M16 | 2,00 | 110 | 12     | 9,0  | 14,0 | 22  | 3     |            | 53,63      | 64,62      |            |
| M16 | 2,00 | 110 | 12     | 9,0  | 14,0 | 22  | 4     | 62,89      |            |            |            |
| M20 | 2,50 | 140 | 16     | 12,0 | 17,5 | 25  | 3     |            | 79,90      | 128,28     |            |
| M20 | 2,50 | 140 | 16     | 12,0 | 17,5 | 25  | 4     | 108,37     |            |            |            |
| M24 | 3,00 | 160 | 18     | 14,5 | 21,0 | 30  | 4     |            | 101,10     |            |            |

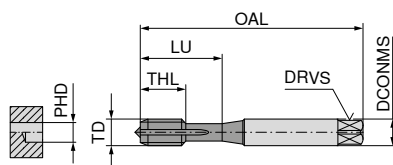
|   |    |    |    |    |    |
|---|----|----|----|----|----|
| P | 10 | 8  | 10 |    |    |
| M | 8  | 6  | 8  |    |    |
| K |    |    |    |    |    |
| N | 24 | 22 | 24 | 15 | 20 |
| S |    |    |    |    |    |
| H |    |    |    |    |    |
| O |    |    |    |    |    |

Brzina rezanja  $v_c$  (m/min)

## Strojni ureznik za proboj i sljepi provrt, desni

DuoTap

M



DIN 371 s ojačanim drškom

HSS-E  
FHA 0°  
≤ 750 N/mm²  
≤ 2xDHSS-E  
FHA 0°  
≤ 1400 N/mm²  
≤ 2xDHSS-PM  
FHA 0°  
≤ 800 N/mm²  
≤ 2xD

| TD   | TP   | OAL | DCONMS | DRVS | PHD  | THL | LU | Utori | 22 028 ... | 22 006 ...        | 22 030 ... |
|------|------|-----|--------|------|------|-----|----|-------|------------|-------------------|------------|
| mm   | mm   | mm  | mm     | mm   | mm   | mm  | mm |       | EUR U0     | EUR U0            | EUR U0     |
| M1,2 | 0,25 | 40  | 2,5    | 2,1  | 0,95 | 5   | 5  | 2     | 54,13      | 012 <sup>1)</sup> |            |
| M1,4 | 0,30 | 40  | 2,5    | 2,1  | 1,10 | 6   | 6  | 2     | 43,72      | 014 <sup>1)</sup> |            |
| M1,6 | 0,35 | 40  | 2,5    | 2,1  | 1,25 | 6   | 11 | 2     | 39,29      | 016               |            |
| M1,7 | 0,35 | 40  | 2,5    | 2,1  | 1,35 | 6   | 11 | 2     | 42,95      | 017               |            |
| M1,8 | 0,35 | 40  | 2,5    | 2,1  | 1,45 | 6   | 11 | 2     | 39,81      | 018               |            |
| M2   | 0,40 | 45  | 2,8    | 2,1  | 1,60 | 7   | 12 | 3     | 33,45      | 020               |            |
| M2,2 | 0,45 | 45  | 2,8    | 2,1  | 1,75 | 7   | 12 | 3     | 35,40      | 022               |            |
| M2,3 | 0,40 | 45  | 2,8    | 2,1  | 1,90 | 7   | 12 | 3     | 38,25      | 023               |            |
| M2,5 | 0,45 | 50  | 2,8    | 2,1  | 2,05 | 9   | 14 | 3     | 32,67      | 025               |            |
| M2,6 | 0,45 | 50  | 2,8    | 2,1  | 2,15 | 9   | 14 | 3     | 35,13      | 026               |            |
| M3   | 0,50 | 56  | 3,5    | 2,7  | 2,50 | 11  | 18 | 3     | 27,20      | 030               | 36,96 030  |
| M3,5 | 0,60 | 56  | 4,0    | 3,0  | 2,90 | 12  | 20 | 3     | 27,85      | 035               |            |
| M4   | 0,70 | 63  | 4,5    | 3,4  | 3,30 | 13  | 21 | 3     | 27,57      | 040               | 38,25 040  |
| M5   | 0,80 | 70  | 6,0    | 4,9  | 4,20 | 15  | 25 | 3     | 27,85      | 050               | 39,81 050  |
| M6   | 1,00 | 80  | 6,0    | 4,9  | 5,00 | 17  | 30 | 3     | 27,98      | 060               | 40,10 060  |
| M7   | 1,00 | 80  | 7,0    | 5,5  | 6,00 | 17  | 30 | 3     | 39,81      | 070               |            |
| M8   | 1,25 | 90  | 8,0    | 6,2  | 6,80 | 20  | 35 | 3     | 31,90      | 080               | 44,50 080  |
| M10  | 1,50 | 100 | 10,0   | 8,0  | 8,50 | 22  | 39 | 3     | 40,10      | 100               | 55,19 100  |
| P    |      |     |        |      |      |     |    |       | 12         | 6                 |            |
| M    |      |     |        |      |      |     |    |       |            |                   |            |
| K    |      |     |        |      |      |     |    |       | 12         | 16                |            |
| N    |      |     |        |      |      |     |    |       |            | 12                | 8          |
| S    |      |     |        |      |      |     |    |       |            |                   |            |
| H    |      |     |        |      |      |     |    |       |            |                   |            |
| O    |      |     |        |      |      |     |    |       |            |                   |            |

1) Tol. 4H/5H ≤ M1,4

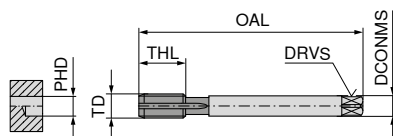
Brzina rezanja v<sub>c</sub> (m/min)

DIN 376 možete pronaći na sljedećoj stranici.

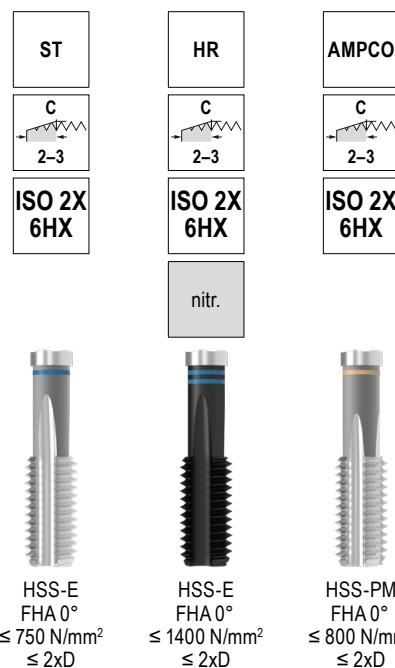
## Strojni ureznik za proboj i sljepi provrt, desni

DuoTap

M



DIN 376 sa zašiljenim drškom



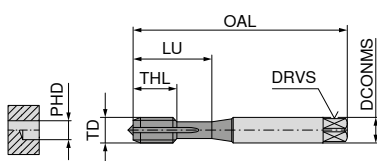
| 22 029 ... | 22 007 ... | 22 031 ... |
|------------|------------|------------|
| EUR U0     | EUR U0     | EUR U0     |
| 34,62 040  |            |            |
| 35,40 050  |            |            |
| 35,40 060  |            |            |
| 44,74 080  |            |            |
| 50,09 100  |            |            |
| 51,66 120  | 70,27 120  | 100,32 120 |
| 71,18 140  |            |            |
| 75,87 160  | 99,53 160  | 150,92 160 |
| 112,82 180 |            |            |
| 114,64 200 |            | 191,34 200 |
| 162,72 220 |            |            |
| 154,97 240 |            | 234,13 240 |
| 305,89 330 |            |            |
| 12         | 6          |            |
|            |            |            |
| 12         | 16         |            |
|            | 12         | 8          |
|            |            |            |
|            |            |            |
|            |            |            |

Brzina rezanja  $v_c$  (m/min)

## Strojni ureznik za proboj i sljepi provrt, desni

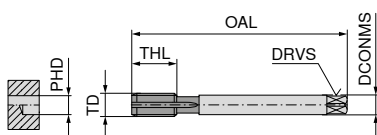
DuoTap

M



DIN 371 s ojačanim drškom

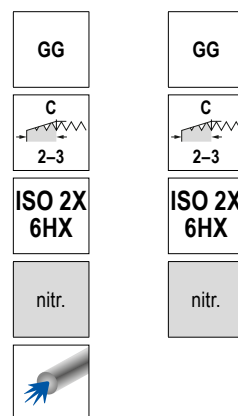
| TD   | TP   | OAL | DCONMS | DRVS | PHD  | THL | LU | Utori |
|------|------|-----|--------|------|------|-----|----|-------|
| mm   | mm   | mm  | mm     | mm   | mm   | mm  | mm |       |
| M2   | 0,40 | 45  | 2,8    | 2,1  | 1,60 | 7   | 12 | 3     |
| M2,5 | 0,45 | 50  | 2,8    | 2,1  | 2,05 | 9   | 14 | 3     |
| M3   | 0,50 | 56  | 3,5    | 2,7  | 2,50 | 11  | 18 | 3     |
| M3,5 | 0,60 | 56  | 4,0    | 3,0  | 2,90 | 12  | 20 | 3     |
| M4   | 0,70 | 63  | 4,5    | 3,4  | 3,30 | 13  | 21 | 3     |
| M5   | 0,80 | 70  | 6,0    | 4,9  | 4,20 | 15  | 25 | 3     |
| M6   | 1,00 | 80  | 6,0    | 4,9  | 5,00 | 17  | 30 | 3     |
| M8   | 1,25 | 90  | 8,0    | 6,2  | 6,80 | 20  | 35 | 3     |
| M10  | 1,50 | 100 | 10,0   | 8,0  | 8,50 | 22  | 39 | 3     |



DIN 376 sa zašiljenim drškom

| TD  | TP   | OAL | DCONMS | DRVS | PHD  | THL | Utori |
|-----|------|-----|--------|------|------|-----|-------|
| mm  | mm   | mm  | mm     | mm   | mm   | mm  |       |
| M6  | 1,00 | 80  | 4,5    | 3,4  | 5,0  | 17  | 3     |
| M8  | 1,25 | 90  | 6,0    | 4,9  | 6,8  | 20  | 3     |
| M10 | 1,50 | 100 | 7,0    | 5,5  | 8,5  | 22  | 3     |
| M12 | 1,75 | 110 | 9,0    | 7,0  | 10,2 | 24  | 3     |
| M14 | 2,00 | 110 | 11,0   | 9,0  | 12,0 | 26  | 3     |
| M16 | 2,00 | 110 | 12,0   | 9,0  | 14,0 | 27  | 3     |
| M18 | 2,50 | 125 | 14,0   | 11,0 | 15,5 | 30  | 4     |
| M20 | 2,50 | 140 | 16,0   | 12,0 | 17,5 | 32  | 4     |
| M22 | 2,50 | 140 | 18,0   | 14,5 | 19,5 | 32  | 4     |
| M24 | 3,00 | 160 | 18,0   | 14,5 | 21,0 | 34  | 4     |

|   |    |    |
|---|----|----|
| P |    |    |
| M |    |    |
| K | 16 | 16 |
| N | 12 | 12 |
| S |    |    |
| H |    |    |
| O |    |    |

Brzina rezanja  $v_c$  (m/min)22 036 ...  
EUR  
U022 032 ...  
EUR  
U0

|       |     |       |     |
|-------|-----|-------|-----|
| 47,63 | 050 | 35,40 | 020 |
| 48,80 | 060 | 35,40 | 025 |
| 53,74 | 080 | 29,81 | 030 |
| 63,63 | 100 | 32,67 | 035 |
|       |     | 30,59 | 040 |
|       |     | 32,54 | 050 |
|       |     | 32,54 | 060 |
|       |     | 38,12 | 080 |
|       |     | 44,74 | 100 |

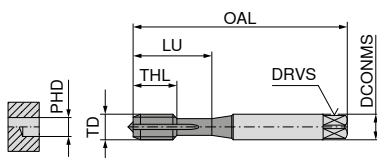
22 033 ...

|        |     |
|--------|-----|
| EUR    |     |
| U0     |     |
| 38,91  | 060 |
| 41,52  | 080 |
| 47,63  | 100 |
| 56,74  | 120 |
| 75,07  | 140 |
| 81,84  | 160 |
| 121,12 | 180 |
| 121,12 | 200 |
| 183,59 | 220 |
| 159,99 | 240 |

## Strojni ureznik za proboj i sljepi provrt, desni

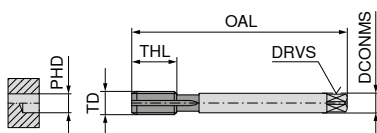
DuoTap

M



DIN 371 s ojačanim drškom

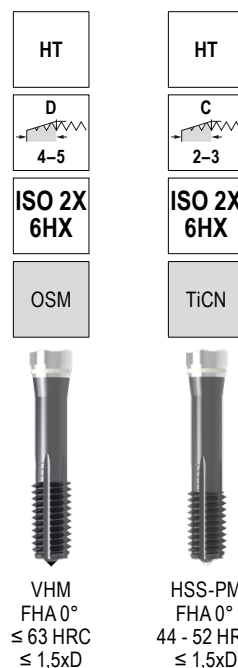
| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| M3       | 0,50     | 63        | 4,5          | 3,4        | 2,55      | 6         | 18       | 4     |
| M4       | 0,70     | 63        | 4,5          | 3,4        | 3,40      | 8         | 20       | 4     |
| M5       | 0,80     | 70        | 6,0          | 4,9        | 4,30      | 10        | 26       | 4     |
| M6       | 1,00     | 80        | 6,0          | 4,9        | 5,00      | 10        | 30       | 4     |
| M6       | 1,00     | 80        | 6,0          | 4,9        | 5,10      | 12        | 28       | 4     |
| M8       | 1,25     | 90        | 8,0          | 6,2        | 6,80      | 14        | 35       | 5     |
| M8       | 1,25     | 90        | 8,0          | 6,2        | 6,90      | 15        | 35       | 5     |
| M10      | 1,50     | 100       | 10,0         | 8,0        | 8,50      | 18        | 38       | 5     |
| M10      | 1,50     | 100       | 10,0         | 8,0        | 8,50      | 16        | 39       | 5     |
| M12      | 1,75     | 110       | 12,0         | 9,0        | 10,40     | 21        | 41       | 5     |
| M16      | 2,00     | 110       | 16,0         | 12,0       | 14,20     | 24        | 44       | 6     |



DIN 376 sa zašiljenim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|-------|
| M12      | 1,75     | 110       | 9            | 7          | 10,4      | 18        | 5     |
| M16      | 2,00     | 110       | 12           | 9          | 14,2      | 22        | 6     |

|   |   |    |
|---|---|----|
| P |   |    |
| M |   |    |
| K |   |    |
| N |   | 22 |
| S |   |    |
| H | 2 | 2  |
| O |   |    |

Brzina rezanja  $v_c$  (m/min)VHM  
FHA 0°  
≤ 63 HRC  
≤ 1,5xDHSS-PM  
FHA 0°  
44 - 52 HRC  
≤ 1,5xD

22 806 ...

EUR

U0

242,83

242,83

274,54

287,06

320,09

396,03

608,45

858,21

030

040

050

060

080

100

120

160

22 227 ...

EUR

U0

158,79

170,48

213,40

060

080

100

22 228 ...

EUR

U0

266,79

365,61

120

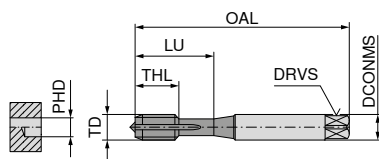
160

## Strojni ureznik za proboj i sljepi provrt, desni

▲ EL = iznimno dugački, s dvostrukom ukupnom duljinom

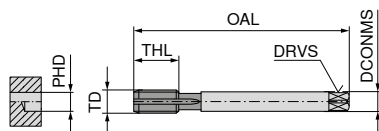
DuoTap

M



DIN 371 s ojačanim drškom

| TD | TP   | OAL | DCONMS | DRVS | PHD | THL | LU | Utori |
|----|------|-----|--------|------|-----|-----|----|-------|
| mm | mm   | mm  | mm     | mm   | mm  | mm  | mm |       |
| M3 | 0,50 | 100 | 3,5    | 2,7  | 2,5 | 11  | 18 | 3     |
| M4 | 0,70 | 125 | 4,5    | 3,4  | 3,3 | 13  | 21 | 3     |
| M5 | 0,80 | 140 | 6,0    | 4,9  | 4,2 | 15  | 25 | 3     |
| M6 | 1,00 | 160 | 6,0    | 4,9  | 5,0 | 17  | 30 | 3     |
| M8 | 1,25 | 180 | 8,0    | 6,2  | 6,8 | 20  | 35 | 3     |



DIN 376 sa zašiljenim drškom

| TD  | TP   | OAL | DCONMS | DRVS | PHD  | THL | Utori |
|-----|------|-----|--------|------|------|-----|-------|
| mm  | mm   | mm  | mm     | mm   | mm   | mm  |       |
| M10 | 1,50 | 200 | 7      | 5,5  | 8,5  | 22  | 3     |
| M12 | 1,75 | 224 | 9      | 7,0  | 10,2 | 24  | 3     |
| M16 | 2,00 | 224 | 12     | 9,0  | 14,0 | 27  | 3     |
| M20 | 2,50 | 280 | 16     | 12,0 | 17,5 | 32  | 4     |

|   |    |
|---|----|
| P | 6  |
| M |    |
| K | 16 |
| N | 22 |
| S |    |
| H |    |
| O |    |

Brzina rezanja  $v_c$  (m/min)HR  
ELC  
2-3ISO 2X  
6HX

nitr.

HSS-E  
FHA 0°  
≤ 1400 N/mm²  
≤ 2xD

22 122 ...

EUR  
U0

|       |     |
|-------|-----|
| 67,92 | 030 |
| 67,92 | 040 |
| 71,84 | 050 |
| 75,07 | 060 |
| 89,14 | 080 |

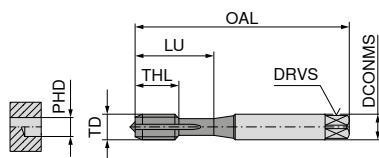
22 123 ...

EUR  
U0

|        |     |
|--------|-----|
| 99,53  | 100 |
| 119,33 | 120 |
| 187,40 | 160 |
| 255,00 | 200 |

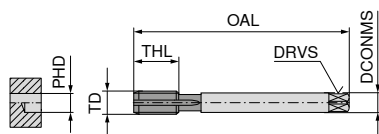
## Strojni ureznik za proboj i sljepi provrt, desni

M



DIN 371 s ojačanim drškom

| TD  | TP   | OAL | DCONMS | DRVS | PHD | THL | LU | Utori |
|-----|------|-----|--------|------|-----|-----|----|-------|
| mm  | mm   | mm  | mm     | mm   | mm  | mm  | mm |       |
| M5  | 0,80 | 70  | 6      | 4,9  | 4,2 | 15  | 25 | 3     |
| M6  | 1,00 | 80  | 6      | 4,9  | 5,0 | 17  | 30 | 3     |
| M8  | 1,25 | 90  | 8      | 6,2  | 6,8 | 20  | 35 | 3     |
| M10 | 1,50 | 100 | 10     | 8,0  | 8,5 | 22  | 39 | 3     |



DIN 376 sa zašiljenim drškom

| TD  | TP   | OAL | DCONMS | DRVS | PHD  | THL | Utori |
|-----|------|-----|--------|------|------|-----|-------|
| mm  | mm   | mm  | mm     | mm   | mm   | mm  |       |
| M12 | 1,75 | 110 | 9      | 7    | 10,2 | 24  | 3     |

|   |    |
|---|----|
| P |    |
| M |    |
| K | 20 |
| N | 24 |
| S |    |
| H |    |
| O |    |

Brzina rezanja  $v_c$  (m/min)

GG

ISO 2X  
6HX

TiCN

HSS-E  
FHA 0°  
≤ 900 N/mm²  
≤ 2xD

23 512 ...

EUR  
T9

|       |     |
|-------|-----|
| 20,60 | 050 |
| 28,48 | 060 |
| 29,95 | 080 |
| 38,10 | 100 |

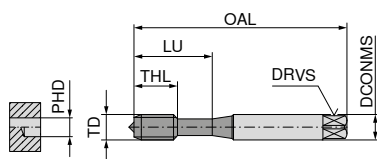
23 513 ...

EUR  
T9

|       |     |
|-------|-----|
| 44,15 | 120 |
|-------|-----|

## Strojni uvaljivač navoja za prolazni i slijepi provrt, desni

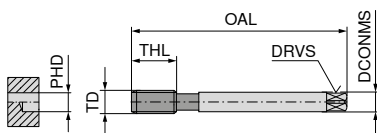
▲ HML = sa zalemljenim trakama od tvrdog metala za veće brzine rezanja



DIN 2174 s ojačanim drškom

| TD   | TP   | OAL | DCONMS | DRVS | PHD  | THL | LU   |
|------|------|-----|--------|------|------|-----|------|
| mm   | mm   | mm  | mm     | mm   | mm   | mm  | mm   |
| M1   | 0,25 | 40  | 2,5    | 2,1  | 0,90 | 5   | 6,5  |
| M1,2 | 0,25 | 40  | 2,5    | 2,1  | 1,10 | 5   | 6,5  |
| M1,4 | 0,30 | 40  | 2,5    | 2,1  | 1,28 | 6   | 9,0  |
| M1,6 | 0,35 | 40  | 2,5    | 2,1  | 1,47 | 6   | 9,0  |
| M1,7 | 0,35 | 40  | 2,5    | 2,1  | 1,57 | 6   | 9,0  |
| M2   | 0,40 | 45  | 2,8    | 2,1  | 1,85 | 7   | 10,0 |
| M2,5 | 0,45 | 50  | 2,8    | 2,1  | 2,33 | 9   | 14,0 |
| M2,6 | 0,45 | 50  | 2,8    | 2,1  | 2,43 | 9   | 14,0 |
| M3   | 0,50 | 56  | 3,5    | 2,7  | 2,80 | 11  | 18,0 |
| M3,5 | 0,60 | 56  | 4,0    | 3,0  | 3,25 | 12  | 20,0 |
| M4   | 0,70 | 63  | 4,5    | 3,4  | 3,70 | 13  | 21,0 |
| M5   | 0,80 | 70  | 6,0    | 4,9  | 4,65 | 15  | 25,0 |
| M6   | 1,00 | 80  | 6,0    | 4,9  | 5,60 | 17  | 30,0 |
| M6   | 1,00 | 80  | 6,0    | 5,0  | 5,60 | 18  | 30,0 |
| M8   | 1,25 | 90  | 8,0    | 6,2  | 7,40 | 20  | 35,0 |
| M8   | 1,25 | 90  | 8,0    | 6,0  | 7,45 | 18  | 35,0 |
| M8   | 1,25 | 90  | 8,0    | 6,2  | 7,45 | 20  | 35,0 |
| M10  | 1,50 | 100 | 10,0   | 8,0  | 9,35 | 22  | 39,0 |

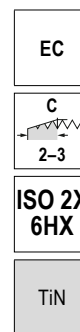
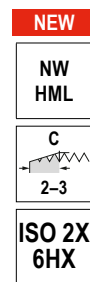
1) Tol. ISO 1X 4HX ≤ M1,4



DIN 2174 sa zašiljenim drškom

| TD  | TP   | OAL | DCONMS | DRVS | PHD   | THL |
|-----|------|-----|--------|------|-------|-----|
| mm  | mm   | mm  | mm     | mm   | mm    | mm  |
| M12 | 1,75 | 110 | 9      | 7    | 11,25 | 24  |
| M16 | 2,00 | 110 | 12     | 9    | 15,10 | 27  |

|   |    |    |
|---|----|----|
| P | 18 | 18 |
| M | 10 | 10 |
| K | 10 | 10 |
| N | 30 | 18 |
| S |    | 22 |
| H |    |    |
| O |    |    |

Brzina rezanja  $v_c$  (m/min)HSS-E / HM  
≤ 880 N/mm<sup>2</sup>  
≤ 3xDHSS-E  
≤ 1100 N/mm<sup>2</sup>  
≤ 1,5xDHSS-E  
≤ 1100 N/mm<sup>2</sup>  
≤ 1,5xD22 473 ...  
EUR  
U022 128 ...  
EUR  
U022 100 ...  
EUR  
U0

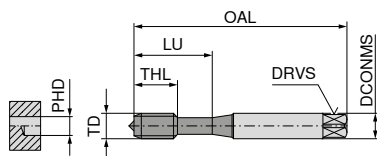
|       |     |               |
|-------|-----|---------------|
| 95,77 | 010 | <sup>1)</sup> |
| 90,69 | 012 | <sup>1)</sup> |
| 81,07 | 014 | <sup>1)</sup> |
| 78,21 | 016 |               |
| 85,87 | 017 |               |
| 56,10 | 020 |               |
| 54,38 | 025 |               |
| 60,51 | 026 |               |
| 52,05 | 030 |               |
| 45,80 | 035 |               |
| 53,22 | 040 |               |
| 55,56 | 050 |               |
| 63,50 | 060 |               |
| 69,74 | 080 |               |
| 60,13 | 080 |               |
| 78,59 | 100 |               |
| 88,48 | 100 |               |

22 101 ...  
EUR  
U0

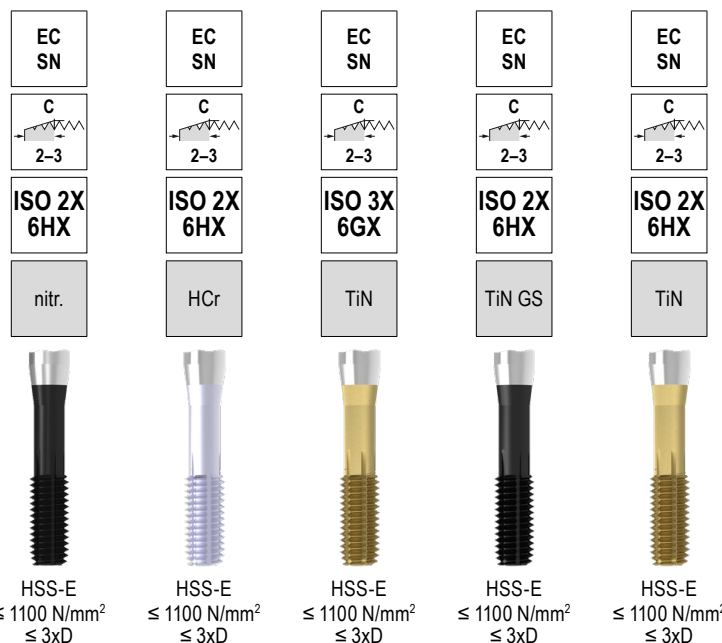
|        |     |
|--------|-----|
| 97,18  | 120 |
| 163,91 | 160 |

## Strojni uvaljivač navoja za prolazni i slijepi provrt, desni

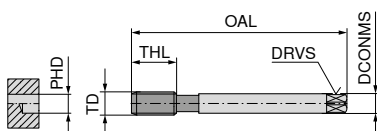
▲ SN = ureznik s utorima za mazivo



DIN 2174 s ojačanim drškom

HSS-E  
≤ 1100 N/mm<sup>2</sup>  
≤ 3xDHSS-E  
≤ 1100 N/mm<sup>2</sup>  
≤ 3xDHSS-E  
≤ 1100 N/mm<sup>2</sup>  
≤ 3xDHSS-E  
≤ 1100 N/mm<sup>2</sup>  
≤ 3xDHSS-E  
≤ 1100 N/mm<sup>2</sup>  
≤ 3xD

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori | 22 104 ... |     | 22 107 ... |     | 22 108 ... |     | 22 154 ... |     | 22 105 ... |     |
|----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|------------|-----|------------|-----|------------|-----|------------|-----|------------|-----|
|          |          |           |              |            |           |           |          |       | EUR<br>U0  |     | EUR<br>U0  |     | EUR<br>U0  |     | EUR<br>U0  |     | EUR<br>U0  |     |
| M2       | 0,40     | 45        | 2,8          | 2,1        | 1,85      | 7         | 10       | 3     |            |     |            |     |            |     |            |     | 64,41      | 020 |
| M2,5     | 0,45     | 50        | 2,8          | 2,1        | 2,33      | 9         | 14       | 3     |            |     |            |     |            |     |            |     | 58,82      | 025 |
| M3       | 0,50     | 56        | 3,5          | 2,7        | 2,80      | 11        | 18       | 3     | 40,10      | 030 | 55,56      | 030 | 54,01      | 030 | 74,44      | 030 | 56,74      | 030 |
| M3,5     | 0,60     | 56        | 4,0          | 3,0        | 3,25      | 12        | 20       | 3     |            |     |            |     |            |     |            |     | 56,10      | 035 |
| M4       | 0,70     | 63        | 4,5          | 3,4        | 3,70      | 13        | 21       | 4     | 41,52      | 040 | 56,74      | 040 | 56,10      | 040 | 76,53      | 040 | 58,82      | 040 |
| M5       | 0,80     | 70        | 6,0          | 4,9        | 4,65      | 15        | 25       | 4     | 43,85      | 050 | 59,61      | 050 | 58,82      | 050 | 79,25      | 050 |            |     |
| M5       | 0,80     | 70        | 6,0          | 4,9        | 4,65      | 15        | 25       | 5     |            |     |            |     |            |     |            |     | 61,16      | 050 |
| M6       | 1,00     | 80        | 6,0          | 4,9        | 5,60      | 17        | 30       | 4     | 44,50      | 060 | 59,61      | 060 | 68,70      | 060 | 87,58      | 060 | 69,35      | 060 |
| M8       | 1,25     | 90        | 8,0          | 6,2        | 7,45      | 20        | 35       | 5     | 53,60      | 080 | 68,33      | 080 | 78,21      | 080 | 95,25      | 080 | 76,53      | 080 |
| M10      | 1,50     | 100       | 10,0         | 8,0        | 9,35      | 22        | 39       | 6     | 68,70      | 100 | 90,04      | 100 | 99,03      | 100 | 115,82     | 100 | 95,77      | 100 |



DIN 2174 sa zašiljenim drškom

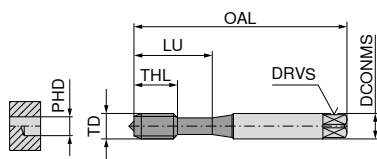
| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori | 22 106 ... |     |
|----------|----------|-----------|--------------|------------|-----------|-----------|-------|------------|-----|
|          |          |           |              |            |           |           |       | EUR<br>U0  |     |
| M12      | 1,75     | 110       | 9            | 7          | 11,25     | 24        | 6     | 119,45     | 120 |
| M14      | 2,00     | 110       | 11           | 9          | 13,10     | 26        | 5     | 230,32     | 140 |
| M16      | 2,00     | 110       | 12           | 9          | 15,10     | 27        | 7     | 184,78     | 160 |

|   |    |    |    |    |    |
|---|----|----|----|----|----|
| P | 12 | 18 | 18 | 18 | 18 |
| M |    | 10 | 10 | 10 | 10 |
| K | 8  | 10 | 10 | 10 | 10 |
| N | 12 | 18 | 22 | 22 | 22 |
| S |    |    |    |    |    |
| H |    |    |    |    |    |
| O |    |    |    |    |    |

Brzina rezanja v<sub>c</sub> (m/min)

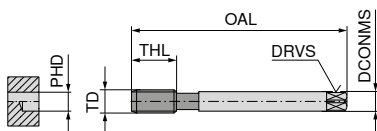
## Strojni uvaljivač navoja za prolazni i slijepi provrt, desni

▲ SN = ureznik s utorima za mazivo



DIN 2174 s ojačanim drškom

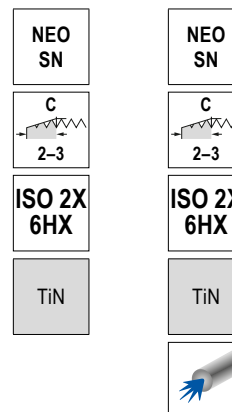
| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| M3       | 0,50     | 56        | 3,5          | 2,7        | 2,80      | 11        | 18       | 4     |
| M4       | 0,70     | 63        | 4,5          | 3,4        | 3,70      | 13        | 21       | 4     |
| M5       | 0,80     | 70        | 6,0          | 4,9        | 4,65      | 15        | 25       | 4     |
| M6       | 1,00     | 80        | 6,0          | 4,9        | 5,60      | 17        | 30       | 5     |
| M8       | 1,25     | 90        | 8,0          | 6,2        | 7,45      | 20        | 35       | 5     |
| M10      | 1,50     | 100       | 10,0         | 8,0        | 9,35      | 22        | 39       | 5     |



DIN 2174 sa zašiljenim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|-------|
| M12      | 1,75     | 110       | 9            | 7          | 11,25     | 24        | 6     |
| M16      | 2,00     | 110       | 12           | 9          | 15,10     | 27        | 6     |

|   |    |    |
|---|----|----|
| P | 18 | 18 |
| M | 10 | 10 |
| K | 10 | 10 |
| N | 22 | 22 |
| S |    |    |
| H |    |    |
| O |    |    |

Brzina rezanja  $v_c$  (m/min)

HSS-PM  
 $\leq 1100 \text{ N/mm}^2$   
 $\leq 3xD$

HSS-PM  
 $\leq 1100 \text{ N/mm}^2$   
 $\leq 3xD$

22 452 ...

EUR  
U0

74,44

030

76,53

040

81,46

050

102,67

060

115,03

080

149,73

100

22 453 ...

EUR  
U0

101,77

050

124,10

060

140,55

080

178,35

100

22 452 ...

EUR  
U0

172,98

120

281,10

160

22 454 ...

EUR  
U0

208,14

120

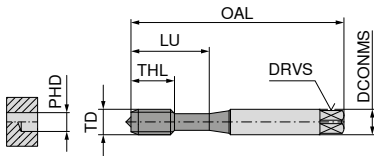
318,89

160

## Strojni uvaljivač navoja za prolazni i slijepi provrt, desni

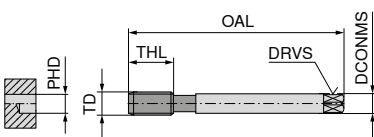
▲ SN = ureznik s utorima za mazivo

M



DIN 2174 s ojačanim drškom

| TD   | TP   | OAL | DCONMS | DRVS | PHD  | THL | LU | Utori |
|------|------|-----|--------|------|------|-----|----|-------|
| mm   | mm   | mm  | mm     | mm   | mm   | mm  | mm |       |
| M2   | 0,40 | 45  | 2,8    | 2,1  | 1,85 | 7   | 12 |       |
| M2   | 0,40 | 45  | 2,8    | 2,1  | 1,85 | 7   | 12 | 3     |
| M2,5 | 0,45 | 50  | 2,8    | 2,1  | 2,33 | 9   | 14 |       |
| M2,5 | 0,45 | 50  | 2,8    | 2,1  | 2,33 | 9   | 14 | 3     |
| M3   | 0,50 | 56  | 3,5    | 2,7  | 2,80 | 11  | 18 |       |
| M3   | 0,50 | 56  | 3,5    | 2,7  | 2,80 | 11  | 18 | 3     |
| M4   | 0,70 | 63  | 4,5    | 3,4  | 3,70 | 13  | 21 |       |
| M4   | 0,70 | 63  | 4,5    | 3,4  | 3,70 | 13  | 21 | 4     |
| M5   | 0,80 | 70  | 6,0    | 4,9  | 4,65 | 15  | 25 |       |
| M5   | 0,80 | 70  | 6,0    | 4,9  | 4,65 | 15  | 25 | 4     |
| M6   | 1,00 | 80  | 6,0    | 4,9  | 5,60 | 17  | 30 |       |
| M6   | 1,00 | 80  | 6,0    | 4,9  | 5,60 | 17  | 30 | 4     |
| M8   | 1,25 | 90  | 8,0    | 6,2  | 7,45 | 20  | 35 |       |
| M8   | 1,25 | 90  | 8,0    | 6,2  | 7,45 | 20  | 35 | 5     |
| M10  | 1,50 | 100 | 10,0   | 8,0  | 9,35 | 22  | 39 |       |
| M10  | 1,50 | 100 | 10,0   | 8,0  | 9,35 | 22  | 39 | 5     |



DIN 2174 sa zašiljenim drškom

| TD  | TP   | OAL | DCONMS | DRVS | PHD   | THL | Utori | 23 811 ... | 23 813 ... | 23 815 ...   | 23 817 ... |
|-----|------|-----|--------|------|-------|-----|-------|------------|------------|--------------|------------|
| mm  | mm   | mm  | mm     | mm   | mm    | mm  |       | EUR T9     | EUR T9     | EUR T9       | EUR T9     |
| M12 | 1,75 | 110 | 9      | 7,0  | 11,25 | 24  |       | 43,52 120  | 36,38 120  | 48,70 120    | 41,80 120  |
| M12 | 1,75 | 110 | 9      | 7,0  | 11,25 | 24  | 5     |            |            |              |            |
| M16 | 2,00 | 110 | 12     | 9,0  | 15,10 | 27  |       | 82,00 160  | 72,74 160  | 91,12 160    | 83,60 160  |
| M16 | 2,00 | 110 | 12     | 9,0  | 15,10 | 27  | 6     |            |            |              |            |
| M18 | 2,50 | 125 | 14     | 11,0 | 16,80 | 30  | 6     |            |            | 168,09 18000 |            |
| M20 | 2,50 | 140 | 16     | 12,0 | 18,80 | 32  | 6     |            |            | 156,29 20000 |            |
| M24 | 3,00 | 160 | 18     | 14,5 | 22,60 | 34  | 6     |            |            | 208,86 24000 |            |
| P   |      |     |        |      |       |     |       | 18         | 18         | 18           | 18         |
| M   |      |     |        |      |       |     |       | 10         | 10         | 10           | 10         |
| K   |      |     |        |      |       |     |       | 10         |            | 10           |            |
| N   |      |     |        |      |       |     |       | 22         | 18         | 22           | 18         |
| S   |      |     |        |      |       |     |       |            |            |              |            |
| H   |      |     |        |      |       |     |       |            |            |              |            |
| O   |      |     |        |      |       |     |       |            |            |              |            |

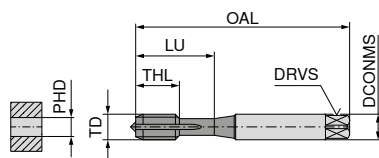
Brzina rezanja  $v_c$  (m/min)

## Strojni ureznik za prolazni provrt, za žičane umetke, desni

TruTap

EG M

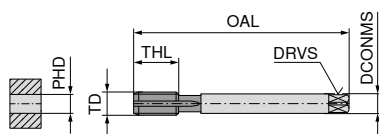
UNI

B  
4-56H  
modnitr. +  
vap.HSS-E  
FHA 0°  
≤ 1100 N/mm²  
≤ 4xD

DIN 40435 s ojačanim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| EG-M2,5  | 0,45     | 56        | 3,5          | 2,7        | 2,65      | 11        | 18       | 3     |
| EG-M3    | 0,50     | 63        | 4,5          | 3,4        | 3,15      | 10        | 21       | 3     |
| EG-M4    | 0,70     | 70        | 6,0          | 4,9        | 4,20      | 12        | 25       | 3     |
| EG-M5    | 0,80     | 80        | 6,0          | 4,9        | 5,25      | 13        | 30       | 3     |
| EG-M6    | 1,00     | 90        | 8,0          | 6,2        | 6,30      | 17        | 35       | 3     |
| EG-M8    | 1,25     | 100       | 10,0         | 8,0        | 8,40      | 18        | 39       | 3     |

22 662 ...

EUR  
U059,85 025  
49,71 030  
51,66 040  
50,09 050  
50,63 060  
60,38 080

DIN 40435 sa zašiljenim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|-------|
| EG-M10   | 1,50     | 100       | 9            | 7,0        | 10,50     | 22        | 3     |
| EG-M12   | 1,75     | 110       | 11           | 9,0        | 12,50     | 26        | 3     |
| EG-M16   | 2,00     | 125       | 14           | 11,0       | 16,50     | 27        | 3     |
| EG-M20   | 2,50     | 160       | 18           | 14,5       | 20,75     | 34        | 3     |

22 663 ...

EUR  
U081,19 100  
92,91 120  
135,31 160  
190,02 200

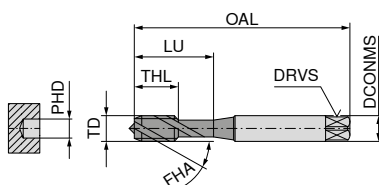
|   |    |
|---|----|
| P | 12 |
| M | 7  |
| K | 12 |
| N |    |
| S |    |
| H |    |
| O |    |

Brzina rezanja  $v_c$  (m/min)

## Strojni ureznik za slijepi provrt, za žičane umetke, desni

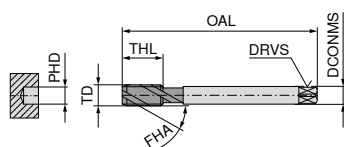
CavTap

EG M



DIN 40435 s ojačanim drškom

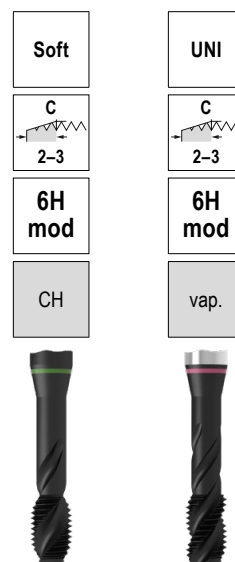
| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| EG-M2,5  | 0,45     | 56        | 3,5          | 2,7        | 2,65      | 5         | 18       | 2     |
| EG-M2,5  | 0,45     | 56        | 3,5          | 2,7        | 2,65      | 5         | 18       | 3     |
| EG-M3    | 0,50     | 63        | 4,5          | 3,4        | 3,15      | 5         | 21       | 2     |
| EG-M3    | 0,50     | 63        | 4,5          | 3,4        | 3,15      | 5         | 21       | 3     |
| EG-M4    | 0,70     | 70        | 6,0          | 4,9        | 4,20      | 8         | 25       | 2     |
| EG-M4    | 0,70     | 70        | 6,0          | 4,9        | 4,20      | 8         | 25       | 3     |
| EG-M5    | 0,80     | 80        | 6,0          | 4,9        | 5,25      | 8         | 30       | 2     |
| EG-M5    | 0,80     | 80        | 6,0          | 4,9        | 5,25      | 8         | 30       | 3     |
| EG-M6    | 1,00     | 90        | 8,0          | 6,2        | 6,30      | 10        | 35       | 2     |
| EG-M6    | 1,00     | 90        | 8,0          | 6,2        | 6,30      | 10        | 35       | 3     |
| EG-M8    | 1,25     | 100       | 10,0         | 8,0        | 8,40      | 16        | 39       | 2     |
| EG-M8    | 1,25     | 100       | 10,0         | 8,0        | 8,40      | 16        | 39       | 3     |



DIN 40435 sa zašiljenim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|-------|
| EG-M10   | 1,50     | 100       | 9            | 7,0        | 10,50     | 15        | 5     |
| EG-M12   | 1,75     | 110       | 11           | 9,0        | 12,50     | 20        | 4     |
| EG-M16   | 2,00     | 125       | 14           | 11,0       | 16,50     | 20        | 5     |
| EG-M20   | 2,50     | 160       | 18           | 14,5       | 20,75     | 30        | 4     |

|   |    |
|---|----|
| P | 12 |
| M | 7  |
| K | 12 |
| N | 22 |
| S |    |
| H |    |
| O |    |

Brzina rezanja  $v_c$  (m/min)HSS-E  
FHA 42°  
≤ 500 N/mm²  
≤ 3xDHSS-E  
FHA 42°  
≤ 1100 N/mm²  
≤ 3xD

22 280 ...

EUR

U0

72,36

025

22 664 ...

EUR

U0

57,26

025

69,88

030

52,17

030

69,88

040

52,17

040

95,25

050

48,15

050

96,95

060

52,17

060

121,83

080

58,44

080

22 665 ...

EUR

U0

74,69

100

91,50

120

137,93

160

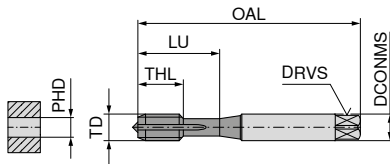
187,40

200

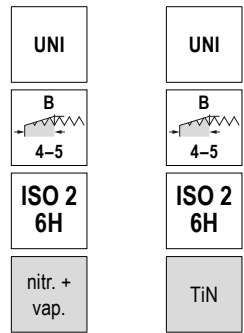
## Strojni ureznik za prolazni provrt, desni

TruTap

MF



DIN 371 s ojačanim drškom

HSS-E  
FHA 0°  
≤ 1100 N/mm²  
≤ 4xDHSS-E  
FHA 0°  
≤ 1100 N/mm²  
≤ 4xD

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| M5x0,5   | 0,50     | 70        | 6            | 4,9        | 4,5       | 11        | 25       | 3     |
| M6x0,5   | 0,50     | 80        | 6            | 4,9        | 5,5       | 13        | 30       | 3     |
| M6x0,75  | 0,75     | 80        | 6            | 4,9        | 5,2       | 13        | 30       | 3     |
| M8x1     | 1,00     | 90        | 8            | 6,2        | 7,0       | 17        | 35       | 3     |
| M10x1    | 1,00     | 90        | 10           | 8,0        | 9,0       | 18        | 35       | 4     |

22 590 ...

EUR  
U0

60,38

050

63,63

060

63,63

062

62,07

084

63,63

102

22 550 ...

EUR  
U0

69,88

050

87,46

060

87,46

062

83,54

080

94,88

100

|   |    |    |
|---|----|----|
| P | 12 | 15 |
| M | 7  | 9  |
| K | 12 | 18 |
| N |    | 12 |
| S |    |    |
| H |    |    |
| O |    |    |

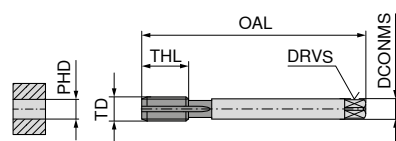
Brzina rezanja v<sub>c</sub> (m/min)

DIN 374 možete pronaći na sljedećoj stranici.

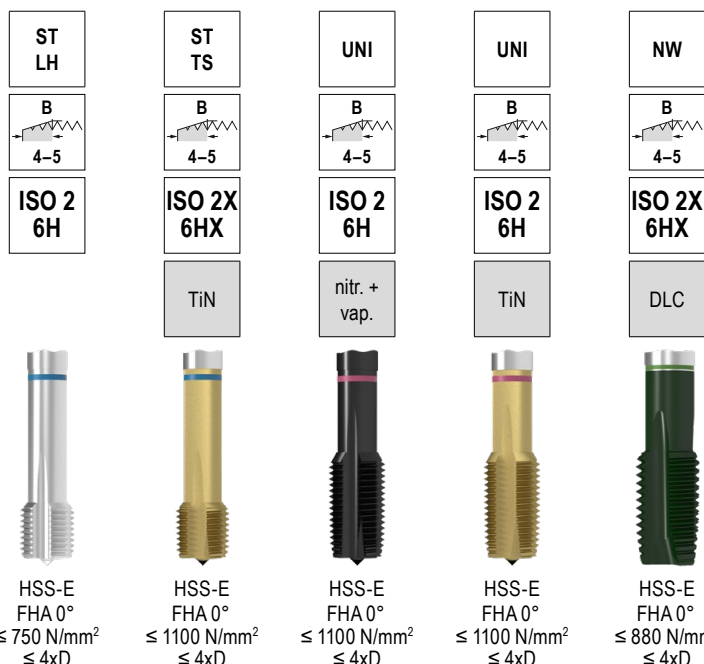
## Strojni ureznik za prolazni provrt, desni

▲ TS = za obradu pri visokim brzinama, do 100 m/min

▲ LH = za lijeve navoje



DIN 374 sa zašiljenim drškom

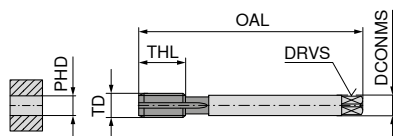


| TD       | TP   | OAL | DCONMS | DRVS | PHD  | THL | Utori | 22 210 ... | 22 193 ... | 22 551 ... | 22 552 ... | 22 466 ... |
|----------|------|-----|--------|------|------|-----|-------|------------|------------|------------|------------|------------|
| mm       | mm   | mm  | mm     | mm   | mm   | mm  |       | EUR U0     | EUR U0     | EUR U0     | EUR U0     | EUR U0     |
| M8x0,75  | 0,75 | 80  | 6      | 4,9  | 7,2  | 14  | 3     |            |            |            |            |            |
| M8x1     | 1,00 | 90  | 6      | 4,9  | 7,0  | 10  | 4     |            | 94,88      | 080        |            |            |
| M8x1     | 1,00 | 90  | 6      | 4,9  | 7,0  | 17  | 3     | 78,98      |            | 54,13      | 084        | 83,54      |
| M10x0,75 | 0,75 | 90  | 7      | 5,5  | 9,2  | 18  | 4     |            |            | 79,39      | 100        | 66,66      |
| M10x1    | 1,00 | 90  | 7      | 5,5  | 9,0  | 10  | 4     |            | 101,77     |            |            |            |
| M10x1    | 1,00 | 90  | 7      | 5,5  | 9,0  | 18  | 4     | 81,99      |            | 55,19      | 102        | 91,50      |
| M10x1,25 | 1,25 | 100 | 7      | 5,5  | 8,8  | 22  | 3     |            |            | 118,42     | 104        | 69,24      |
| M12x1    | 1,00 | 100 | 9      | 7,0  | 11,0 | 18  | 4     | 105,94     |            | 64,54      | 120        | 87,24      |
| M12x1,25 | 1,25 | 100 | 9      | 7,0  | 10,8 | 22  | 3     |            |            | 89,78      | 121        | 79,85      |
| M12x1,5  | 1,50 | 100 | 9      | 7,0  | 10,5 | 15  | 4     |            | 97,73      |            |            | 89,71      |
| M12x1,5  | 1,50 | 100 | 9      | 7,0  | 10,5 | 22  | 3     | 112,82     |            | 61,16      | 124        | 77,24      |
| M14x1    | 1,00 | 100 | 11     | 9,0  | 13,0 | 18  | 4     |            |            | 166,53     | 140        | 107,74     |
| M14x1,25 | 1,25 | 100 | 11     | 9,0  | 12,8 | 22  | 3     |            |            |            |            | 102,22     |
| M14x1,5  | 1,50 | 100 | 11     | 9,0  | 12,5 | 15  | 4     |            | 123,26     |            |            |            |
| M14x1,5  | 1,50 | 100 | 11     | 9,0  | 12,5 | 22  | 3     | 144,37     |            | 81,99      | 144        | 124,10     |
| M16x1    | 1,00 | 100 | 12     | 9,0  | 15,0 | 18  | 4     |            |            |            |            | 117,17     |
| M16x1,5  | 1,50 | 100 | 12     | 9,0  | 14,5 | 15  | 4     |            | 163,91     |            |            |            |
| M16x1,5  | 1,50 | 100 | 12     | 9,0  | 14,5 | 22  | 3     | 144,37     |            | 97,73      | 162        | 128,15     |
| M18x1    | 1,00 | 110 | 14     | 11,0 | 17,0 | 20  | 5     |            |            | 272,04     | 180        |            |
| M18x1,5  | 1,50 | 110 | 14     | 11,0 | 16,5 | 17  | 4     |            | 203,13     |            |            |            |
| M18x1,5  | 1,50 | 110 | 14     | 11,0 | 16,5 | 25  | 4     | 163,91     |            | 113,73     | 182        |            |
| M18x2    | 2,00 | 125 | 14     | 11,0 | 16,0 | 26  | 3     |            |            | 223,87     | 184        |            |
| M20x1    | 1,00 | 125 | 16     | 12,0 | 19,0 | 20  | 5     |            |            | 294,09     | 200        |            |
| M20x1,5  | 1,50 | 125 | 16     | 12,0 | 18,5 | 17  | 4     |            | 255,00     |            |            |            |
| M20x1,5  | 1,50 | 125 | 16     | 12,0 | 18,5 | 25  | 4     | 190,02     |            | 128,15     | 202        | 201,70     |
| M22x1,5  | 1,50 | 125 | 18     | 14,5 | 20,5 | 25  | 4     |            |            | 140,55     | 222        | 244,74     |
| M24x1,5  | 1,50 | 140 | 18     | 14,5 | 22,5 | 27  | 4     |            |            | 158,79     | 242        |            |
| M24x2    | 2,00 | 140 | 18     | 14,5 | 22,0 | 27  | 4     |            |            | 287,53     | 244        |            |
| M25x1,5  | 1,50 | 140 | 18     | 14,5 | 23,5 | 28  | 4     |            |            | 473,63     | 250        |            |
| M26x1,5  | 1,50 | 140 | 18     | 14,5 | 24,5 | 28  | 4     |            |            | 196,57     | 260        |            |
| M27x2    | 2,00 | 140 | 20     | 16,0 | 25,0 | 28  | 4     |            |            | 499,73     | 272        |            |
| M28x1,5  | 1,50 | 140 | 20     | 16,0 | 26,5 | 28  | 5     |            |            | 230,32     | 280        |            |
| M30x1,5  | 1,50 | 150 | 22     | 18,0 | 28,5 | 28  | 5     |            |            | 247,13     | 302        |            |
| P        |      |     |        |      |      |     |       | 12         | 65         | 12         | 15         |            |
| M        |      |     |        |      |      |     |       |            |            | 7          | 9          |            |
| K        |      |     |        |      |      |     |       | 12         | 65         | 12         | 18         |            |
| N        |      |     |        |      |      |     |       | 22         | 22         |            | 12         | 15         |
| S        |      |     |        |      |      |     |       |            |            |            |            |            |
| H        |      |     |        |      |      |     |       |            |            |            |            |            |
| O        |      |     |        |      |      |     |       |            |            |            |            |            |

Brzina rezanja  $v_c$  (m/min)

## Strojni ureznik za prolazni provrt, desni

MF



DIN 374 sa zašiljenim drškom

UNI

ISO 2  
6H

TiN

HSS-PM  
FHA 0°  
≤ 1000 N/mm²  
≤ 3xD

23 041 ...

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|-------|
| M8x1     | 1,00     | 90        | 6            | 4,9        | 7,0       | 17        | 3     |
| M10x1    | 1,00     | 90        | 7            | 5,5        | 9,0       | 18        | 4     |
| M10x1,25 | 1,25     | 100       | 7            | 5,5        | 8,8       | 22        | 3     |
| M12x1    | 1,00     | 100       | 9            | 7,0        | 11,0      | 18        | 4     |
| M12x1,25 | 1,25     | 100       | 9            | 7,0        | 10,8      | 22        | 3     |
| M12x1,5  | 1,50     | 100       | 9            | 7,0        | 10,5      | 22        | 3     |
| M14x1,25 | 1,25     | 100       | 11           | 9,0        | 12,8      | 22        | 3     |
| M14x1,5  | 1,50     | 100       | 11           | 9,0        | 12,5      | 22        | 3     |
| M16x1,5  | 1,50     | 100       | 12           | 9,0        | 14,5      | 22        | 3     |
| M18x1,5  | 1,50     | 110       | 14           | 11,0       | 16,5      | 17        | 4     |
| M20x1,5  | 1,50     | 125       | 16           | 12,0       | 18,5      | 17        | 4     |
| M22x1,5  | 1,50     | 125       | 18           | 14,5       | 20,5      | 25        | 4     |
| M24x1,5  | 1,50     | 140       | 18           | 14,5       | 22,5      | 27        | 4     |
| M24x2    | 2,00     | 140       | 18           | 14,5       | 22,0      | 27        | 4     |

EUR

T9

26,52

081

30,34

102

32,54

104

37,36

120

39,08

122

34,77

121

45,14

142

42,91

144

48,59

162

64,24

182

86,81

202

81,63

222

93,70

242

106,77

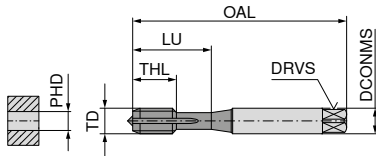
244

|   |    |
|---|----|
| P | 15 |
| M | 9  |
| K | 18 |
| N | 12 |
| S |    |
| H |    |
| O |    |

Brzina rezanja  $v_c$  (m/min)

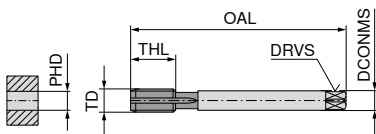
## Strojni ureznik za prolazni provrt, desni

MF



DIN 371 s ojačanim drškom

| TD      | TP   | OAL | DCONMS | DRVS | PHD | THL | LU | Utori |
|---------|------|-----|--------|------|-----|-----|----|-------|
| mm      | mm   | mm  | mm     | mm   | mm  | mm  | mm |       |
| M4x0,5  | 0,50 | 63  | 4,5    | 3,4  | 3,5 | 10  | 21 | 3     |
| M5x0,5  | 0,50 | 70  | 6,0    | 4,9  | 4,5 | 11  | 25 | 3     |
| M6x0,75 | 0,75 | 80  | 6,0    | 4,9  | 5,2 | 13  | 30 | 3     |
| M6x0,5  | 0,50 | 80  | 6,0    | 4,9  | 5,5 | 13  | 30 | 3     |



DIN 374 sa zašiljenim drškom

| TD       | TP   | OAL | DCONMS | DRVS | PHD  | THL | Utori |
|----------|------|-----|--------|------|------|-----|-------|
| mm       | mm   | mm  | mm     | mm   | mm   | mm  |       |
| M8x0,5   | 0,50 | 80  | 6      | 4,9  | 7,5  | 14  | 3     |
| M8x0,75  | 0,75 | 80  | 6      | 4,9  | 7,2  | 14  | 3     |
| M8x1     | 1,00 | 90  | 6      | 4,9  | 7,0  | 17  | 3     |
| M8x1     | 1,00 | 90  | 6      | 4,9  | 7,0  | 17  | 4     |
| M10x0,75 | 0,75 | 90  | 7      | 5,5  | 9,2  | 18  | 4     |
| M10x1    | 1,00 | 90  | 7      | 5,5  | 9,0  | 18  | 4     |
| M10x1,25 | 1,25 | 100 | 7      | 5,5  | 8,8  | 22  | 3     |
| M12x1    | 1,00 | 100 | 9      | 7,0  | 11,0 | 18  | 4     |
| M12x1,25 | 1,25 | 100 | 9      | 7,0  | 10,8 | 22  | 3     |
| M12x1,5  | 1,50 | 100 | 9      | 7,0  | 10,5 | 22  | 3     |
| M14x1    | 1,00 | 100 | 11     | 9,0  | 13,0 | 18  | 4     |
| M14x1,5  | 1,50 | 100 | 11     | 9,0  | 12,5 | 22  | 3     |
| M16x1    | 1,00 | 100 | 12     | 9,0  | 15,0 | 18  | 4     |
| M16x1,5  | 1,50 | 100 | 12     | 9,0  | 14,5 | 22  | 3     |
| M18x1    | 1,00 | 110 | 14     | 11,0 | 17,0 | 20  | 5     |
| M18x1,5  | 1,50 | 110 | 14     | 11,0 | 16,5 | 25  | 4     |
| M20x1    | 1,00 | 125 | 16     | 12,0 | 19,0 | 20  | 5     |
| M20x1,5  | 1,50 | 125 | 16     | 12,0 | 18,5 | 25  | 4     |
| M22x1,5  | 1,50 | 125 | 18     | 14,5 | 20,5 | 25  | 4     |
| M24x1,5  | 1,50 | 140 | 18     | 14,5 | 22,5 | 27  | 4     |
| M26x1,5  | 1,50 | 140 | 18     | 14,5 | 24,5 | 28  | 4     |
| M28x1,5  | 1,50 | 140 | 20     | 16,0 | 26,5 | 28  | 5     |
| M30x1,5  | 1,50 | 150 | 22     | 18,0 | 28,5 | 28  | 5     |

|   |    |    |    |    |
|---|----|----|----|----|
| P | 12 | 15 | 12 | 10 |
| M | 7  | 9  |    | 8  |
| K | 12 | 18 | 12 |    |
| N |    | 12 | 12 | 24 |
| S |    |    |    |    |
| H |    |    |    |    |
| O |    |    |    |    |

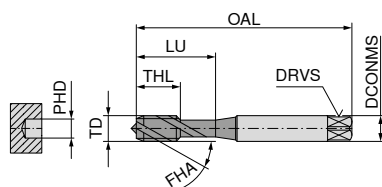
Brzina rezanja  $v_c$  (m/min)

| UNI                                              | UNI                                              | FE                                      | VA                                       |
|--------------------------------------------------|--------------------------------------------------|-----------------------------------------|------------------------------------------|
| B<br>4-5                                         | B<br>4-5                                         | B<br>4-5                                | B<br>4-5                                 |
| ISO 2<br>6H                                      | ISO 2<br>6H                                      | ISO 2<br>6H                             | ISO 2<br>6H                              |
| nitr. +<br>vap.                                  | TiN                                              |                                         | TiN                                      |
|                                                  |                                                  |                                         |                                          |
| HSS-E<br>FHA 0°<br>≤ 1000 N/mm²<br>≤ 3xD         | HSS-E<br>FHA 0°<br>≤ 1000 N/mm²<br>≤ 3xD         | HSS-E<br>FHA 0°<br>≤ 850 N/mm²<br>≤ 3xD | HSS-E<br>FHA 0°<br>≤ 1200 N/mm²<br>≤ 4xD |
| 23 140 ...                                       | 23 142 ...                                       |                                         | 23 440 ...                               |
| EUR<br>T9                                        | EUR<br>T9                                        |                                         | EUR<br>T9                                |
| 18,74 040<br>18,74 050<br>18,74 062<br>19,98 060 | 25,28 040<br>25,53 050<br>31,44 062<br>31,44 060 |                                         | 31,07 050<br>37,99 062                   |

## Strojni ureznik za prolazni provrt, desni

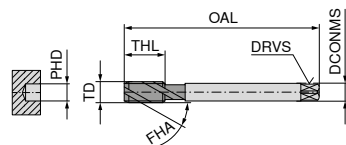
CavTap

MF



DIN 371 s ojačanim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| M4x0,5   | 0,50     | 63        | 4,5          | 3,4        | 3,50      | 5         | 21       | 3     |
| M6x0,75  | 0,75     | 80        | 6,0          | 4,9        | 5,25      | 8         | 30       | 3     |
| M5x0,5   | 0,50     | 70        | 6,0          | 4,9        | 4,50      | 5         | 25       | 3     |



DIN 374 sa zašiljenim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|-------|
| M8x1     | 1,0      | 90        | 6            | 4,9        | 7,0       | 10        | 3     |
| M10x1    | 1,0      | 90        | 7            | 5,5        | 9,0       | 10        | 4     |
| M12x1,5  | 1,5      | 100       | 9            | 7,0        | 10,5      | 15        | 5     |
| M14x1,5  | 1,5      | 100       | 11           | 9,0        | 12,5      | 15        | 5     |
| M16x1,5  | 1,5      | 100       | 12           | 9,0        | 14,5      | 15        | 5     |
| M18x1,5  | 1,5      | 110       | 14           | 11,0       | 16,5      | 17        | 5     |
| M20x1,5  | 1,5      | 125       | 16           | 12,0       | 18,5      | 17        | 5     |

|   |    |    |    |
|---|----|----|----|
| P | 12 | 15 | 12 |
| M | 7  | 9  | 7  |
| K | 12 | 18 | 12 |
| N |    | 12 |    |
| S |    |    |    |
| H |    |    |    |
| O |    |    |    |

Brzina rezanja  $v_c$  (m/min)

|                                           |                                           |                                           |
|-------------------------------------------|-------------------------------------------|-------------------------------------------|
| UNI                                       | UNI                                       | UNI                                       |
| E<br>1,5-2                                | E<br>1,5-2                                | E<br>1,5-2                                |
| ISO 2<br>6H                               | ISO 2<br>6H                               | ISO 3<br>6G                               |
| vap.                                      | TiN                                       | vap.                                      |
|                                           |                                           |                                           |
| HSS-E<br>FHA 42°<br>≤ 1100 N/mm²<br>≤ 3xD | HSS-E<br>FHA 42°<br>≤ 1100 N/mm²<br>≤ 3xD | HSS-E<br>FHA 42°<br>≤ 1100 N/mm²<br>≤ 3xD |

22 441 ...

EUR  
U0

|       |     |
|-------|-----|
| 65,18 | 040 |
| 65,18 | 062 |
| 65,18 | 050 |

22 555 ...

EUR  
U0

|        |     |
|--------|-----|
| 59,61  | 080 |
| 64,28  | 100 |
| 73,52  | 120 |
| 94,88  | 140 |
| 112,82 | 160 |

22 556 ...

EUR  
U0

|        |     |
|--------|-----|
| 76,39  | 080 |
| 97,73  | 100 |
| 112,05 | 120 |
| 143,17 | 140 |
| 150,92 | 160 |

22 490 ...

EUR  
U0

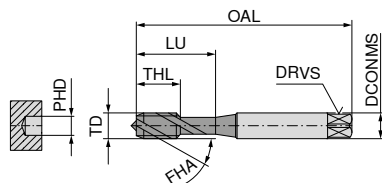
|        |     |
|--------|-----|
| 65,18  | 080 |
| 71,84  | 100 |
| 78,98  | 120 |
| 104,10 | 140 |
| 124,10 | 160 |
| 143,17 | 180 |
| 163,91 | 200 |

## Strojni ureznik za prolazni provrt, desni

▲ CNC = za CNC sinkronu obradu s kompenzacijskom glavom minimalne duljine

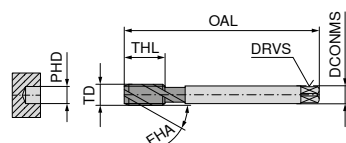
CavTap

MF



DIN 371 s ojačanim drškom

| TD      | TP   | OAL | DCONMS | DRVS | PHD | THL | LU | Utori |
|---------|------|-----|--------|------|-----|-----|----|-------|
| mm      | mm   | mm  | mm     | mm   | mm  | mm  | mm |       |
| M4x0,5  | 0,50 | 63  | 4,5    | 3,4  | 3,5 | 5   | 21 | 3     |
| M5x0,5  | 0,50 | 70  | 6,0    | 4,9  | 4,5 | 5   | 25 | 3     |
| M6x0,5  | 0,50 | 80  | 6,0    | 4,9  | 5,5 | 5   | 30 | 3     |
| M6x0,75 | 0,75 | 80  | 6,0    | 4,9  | 5,2 | 8   | 30 | 3     |



DIN 374 sa zašiljenim drškom

| TD       | TP   | OAL | DCONMS | DRVS | PHD  | THL | Utori |
|----------|------|-----|--------|------|------|-----|-------|
| mm       | mm   | mm  | mm     | mm   | mm   | mm  |       |
| M6x0,75  | 0,75 | 80  | 4,5    | 3,4  | 5,2  | 8   | 3     |
| M8x0,75  | 0,75 | 80  | 6,0    | 4,9  | 7,2  | 8   | 3     |
| M8x1     | 1,00 | 90  | 6,0    | 4,9  | 7,0  | 10  | 3     |
| M10x0,75 | 0,75 | 90  | 7,0    | 5,5  | 9,2  | 10  | 4     |
| M10x1    | 1,00 | 90  | 7,0    | 5,5  | 9,0  | 10  | 3     |
| M10x1    | 1,00 | 90  | 7,0    | 5,5  | 9,0  | 10  | 4     |
| M10x1,25 | 1,25 | 100 | 7,0    | 5,5  | 8,8  | 16  | 3     |
| M12x1    | 1,00 | 100 | 9,0    | 7,0  | 11,0 | 11  | 4     |
| M12x1,25 | 1,25 | 100 | 9,0    | 7,0  | 10,8 | 15  | 4     |
| M12x1,5  | 1,50 | 100 | 9,0    | 7,0  | 10,5 | 15  | 4     |
| M12x1,5  | 1,50 | 100 | 9,0    | 7,0  | 10,5 | 15  | 5     |
| M14x1,5  | 1,50 | 100 | 11,0   | 9,0  | 12,5 | 15  | 4     |
| M14x1,5  | 1,50 | 100 | 11,0   | 9,0  | 12,5 | 15  | 5     |
| M16x1,5  | 1,50 | 100 | 12,0   | 9,0  | 14,5 | 15  | 4     |
| M16x1,5  | 1,50 | 100 | 12,0   | 9,0  | 14,5 | 15  | 5     |
| M18x1,5  | 1,50 | 110 | 14,0   | 11,0 | 16,5 | 17  | 4     |
| M18x1,5  | 1,50 | 110 | 14,0   | 11,0 | 16,5 | 17  | 5     |
| M20x1,5  | 1,50 | 125 | 16,0   | 12,0 | 18,5 | 17  | 4     |
| M20x1,5  | 1,50 | 125 | 16,0   | 12,0 | 18,5 | 17  | 5     |
| M22x1,5  | 1,50 | 125 | 18,0   | 14,5 | 20,5 | 17  | 4     |
| M24x1,5  | 1,50 | 140 | 18,0   | 14,5 | 22,5 | 20  | 5     |
| M26x1,5  | 1,50 | 140 | 18,0   | 14,5 | 24,5 | 20  | 5     |
| M28x1,5  | 1,50 | 140 | 20,0   | 16,0 | 26,5 | 20  | 5     |
| M30x1,5  | 1,50 | 150 | 22,0   | 18,0 | 28,5 | 22  | 6     |

|   |    |    |    |    |
|---|----|----|----|----|
| P | 12 | 15 | 15 | 15 |
| M | 7  | 9  | 9  | 9  |
| K | 12 | 18 | 18 | 18 |
| N |    | 12 | 12 | 12 |
| S |    |    |    |    |
| H |    |    |    |    |
| O |    |    |    |    |

Brzina rezanja  $v_c$  (m/min)

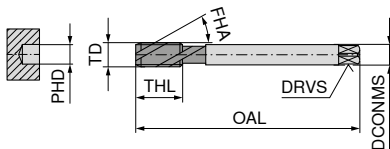
| UNI                                       | UNI                                       | UNI CNC                                   | UNI CNC                                   |
|-------------------------------------------|-------------------------------------------|-------------------------------------------|-------------------------------------------|
| C<br>2-3                                  | C<br>2-3                                  | E<br>1,5-2                                | E<br>1,5-2                                |
| ISO 2 6H                                  | ISO 2 6H                                  | 7G                                        | ISO 2 6H                                  |
| vap.                                      | TiN                                       | TiN GS                                    | TiN GS                                    |
|                                           |                                           |                                           |                                           |
| HSS-E<br>FHA 42°<br>≤ 1100 N/mm²<br>≤ 3xD | HSS-E<br>FHA 42°<br>≤ 1100 N/mm²<br>≤ 3xD | HSS-E<br>FHA 45°<br>≤ 1100 N/mm²<br>≤ 3xD | HSS-E<br>FHA 45°<br>≤ 1100 N/mm²<br>≤ 3xD |
| 22 202 ...                                |                                           |                                           | 22 548 ...                                |
| EUR<br>U0                                 |                                           |                                           | EUR<br>U0                                 |
| 65,18 040                                 |                                           |                                           | 75,47 050                                 |
| 59,61 050                                 |                                           |                                           | 75,47 060                                 |
| 65,18 060                                 |                                           |                                           | 75,47 062                                 |
| 65,18 062                                 |                                           |                                           |                                           |

## Strojni ureznik za slijepi provrt

▲ LH = za lijeve navoje

CavTap

MF

ST  
LHISO 2  
6H

DIN 374 sa zašiljenim drškom

HSS-E  
FHA 42°  
≤ 750 N/mm²  
≤ 3xD

22 601 ...

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|-------|
| M8x1     | 1,0      | 90        | 6            | 4,9        | 7,0       | 10        | 3     |
| M10x1    | 1,0      | 90        | 7            | 5,5        | 9,0       | 10        | 3     |
| M12x1    | 1,0      | 100       | 9            | 7,0        | 11,0      | 11        | 4     |
| M14x1,5  | 1,5      | 100       | 11           | 9,0        | 12,5      | 15        | 4     |
| M16x1,5  | 1,5      | 100       | 12           | 9,0        | 14,5      | 15        | 4     |
| M18x1,5  | 1,5      | 110       | 14           | 11,0       | 16,5      | 17        | 4     |
| M20x1,5  | 1,5      | 125       | 16           | 12,0       | 18,5      | 17        | 4     |

EUR

U0

082

94,88

100

97,73

120

119,33

140

128,99

160

153,54

180

178,35

200

208,14

|   |    |
|---|----|
| P | 12 |
| M |    |
| K | 12 |
| N | 12 |
| S |    |
| H |    |
| O |    |

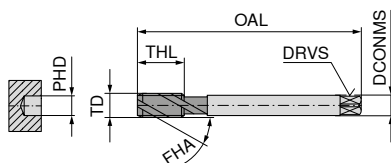
Brzina rezanja  $v_c$  (m/min)

## Strojni ureznik za prolazni provrt, desni

CavTap  
SL

MF

ST

ISO 2  
6H

DIN 374 sa zašiljenim drškom

HSS-E  
FHA 15°  
≤ 750 N/mm²  
≤ 2xD

22 182 ...

| TD       | TP   | OAL | DCONMS | DRVS | PHD  | THL | Utori | EUR    |     |
|----------|------|-----|--------|------|------|-----|-------|--------|-----|
| mm       | mm   | mm  | mm     | mm   | mm   | mm  |       | U0     |     |
| M6x0,75  | 0,75 | 80  | 4,5    | 3,4  | 5,2  | 13  | 3     | 59,85  | 062 |
| M8x0,75  | 0,75 | 80  | 6,0    | 4,9  | 7,2  | 14  | 3     | 60,38  | 082 |
| M8x1     | 1,00 | 90  | 6,0    | 4,9  | 7,0  | 17  | 3     | 55,19  | 084 |
| M9x1     | 1,00 | 90  | 7,0    | 5,5  | 8,0  | 17  | 3     | 81,99  | 090 |
| M10x0,75 | 0,75 | 90  | 7,0    | 5,5  | 9,2  | 18  | 3     | 96,15  | 100 |
| M10x1    | 1,00 | 90  | 7,0    | 5,5  | 9,0  | 18  | 3     | 58,16  | 102 |
| M10x1,25 | 1,25 | 100 | 7,0    | 5,5  | 8,8  | 22  | 3     | 82,90  | 104 |
| M11x1    | 1,00 | 90  | 8,0    | 6,2  | 10,0 | 18  | 3     | 92,14  | 110 |
| M12x1    | 1,00 | 100 | 9,0    | 7,0  | 11,0 | 18  | 3     | 71,18  | 120 |
| M12x1,25 | 1,25 | 100 | 9,0    | 7,0  | 10,8 | 22  | 3     | 92,14  | 122 |
| M12x1,5  | 1,50 | 100 | 9,0    | 7,0  | 10,5 | 22  | 3     | 67,92  | 124 |
| M14x1    | 1,00 | 100 | 11,0   | 9,0  | 13,0 | 18  | 4     | 93,96  | 140 |
| M14x1,5  | 1,50 | 100 | 11,0   | 9,0  | 12,5 | 22  | 3     | 91,50  | 144 |
| M15x1    | 1,00 | 100 | 12,0   | 9,0  | 14,0 | 18  | 4     | 123,26 | 150 |
| M16x1    | 1,00 | 100 | 12,0   | 9,0  | 15,0 | 18  | 4     | 110,74 | 160 |
| M16x1,5  | 1,50 | 100 | 12,0   | 9,0  | 14,5 | 22  | 3     | 108,00 | 162 |
| M18x1    | 1,00 | 110 | 14,0   | 11,0 | 17,0 | 20  | 4     | 152,24 | 180 |
| M18x1,5  | 1,50 | 110 | 14,0   | 11,0 | 16,5 | 25  | 4     | 140,55 | 182 |
| M18x2    | 2,00 | 125 | 14,0   | 11,0 | 16,0 | 26  | 3     | 222,56 | 184 |
| M20x1    | 1,00 | 125 | 16,0   | 12,0 | 19,0 | 20  | 4     | 154,97 | 200 |
| M20x1,5  | 1,50 | 125 | 16,0   | 12,0 | 18,5 | 25  | 4     | 139,24 | 202 |
| M20x2    | 2,00 | 140 | 16,0   | 12,0 | 18,0 | 27  | 3     | 190,02 | 204 |
| M22x1    | 1,00 | 125 | 18,0   | 14,5 | 21,0 | 20  | 4     | 203,13 | 220 |
| M22x1,5  | 1,50 | 125 | 18,0   | 14,5 | 20,5 | 25  | 4     | 157,48 | 222 |
| M22x2    | 2,00 | 140 | 18,0   | 14,5 | 20,0 | 27  | 4     | 193,84 | 224 |
| M24x1    | 1,00 | 140 | 18,0   | 14,5 | 23,0 | 20  | 5     | 212,08 | 240 |
| M24x1,5  | 1,50 | 140 | 18,0   | 14,5 | 22,5 | 27  | 4     | 171,78 | 242 |
| M24x2    | 2,00 | 140 | 18,0   | 14,5 | 22,0 | 27  | 4     | 200,40 | 244 |
| M25x1,5  | 1,50 | 140 | 18,0   | 14,5 | 23,5 | 28  | 4     | 286,35 | 252 |
| M27x1,5  | 1,50 | 140 | 20,0   | 16,0 | 25,5 | 28  | 4     | 248,55 | 270 |
| M27x2    | 2,00 | 140 | 20,0   | 16,0 | 25,0 | 28  | 4     | 281,10 | 272 |
| M28x2    | 2,00 | 140 | 20,0   | 16,0 | 26,0 | 28  | 4     | 327,95 | 282 |
| M30x1,5  | 1,50 | 150 | 22,0   | 18,0 | 28,5 | 28  | 5     | 285,04 | 302 |
| M30x2    | 2,00 | 150 | 22,0   | 18,0 | 28,0 | 28  | 4     | 301,97 | 304 |
| M32x1,5  | 1,50 | 150 | 22,0   | 18,0 | 30,5 | 28  | 6     | 327,95 | 320 |
| M33x2    | 2,00 | 160 | 25,0   | 20,0 | 31,0 | 30  | 4     | 396,85 | 332 |
| M34x1,5  | 1,50 | 170 | 28,0   | 22,0 | 32,5 | 30  | 6     | 400,91 | 340 |
| M36x2    | 2,00 | 170 | 28,0   | 22,0 | 34,0 | 30  | 5     | 504,86 | 362 |
| M36x3    | 3,00 | 200 | 28,0   | 22,0 | 33,0 | 42  | 4     | 473,63 | 364 |
| M40x1,5  | 1,50 | 170 | 32,0   | 24,0 | 38,5 | 30  | 6     | 497,23 | 400 |
| M42x2    | 2,00 | 170 | 32,0   | 24,0 | 40,0 | 30  | 6     | 601,19 | 422 |
| M42x3    | 3,00 | 200 | 32,0   | 24,0 | 39,0 | 45  | 4     | 636,35 | 424 |
| M45x1,5  | 1,50 | 180 | 36,0   | 29,0 | 43,5 | 32  | 6     | 588,19 | 450 |
| M48x2    | 2,00 | 190 | 36,0   | 29,0 | 46,0 | 32  | 6     | 829,00 | 482 |
| M48x3    | 3,00 | 225 | 36,0   | 29,0 | 45,0 | 50  | 5     | 841,99 | 484 |

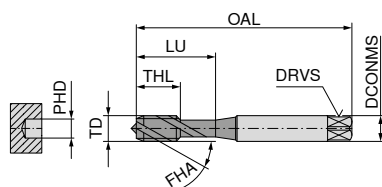
|   |    |
|---|----|
| P | 12 |
| M |    |
| K | 12 |
| N | 22 |
| S |    |
| H |    |
| O |    |

Brzina rezanja v<sub>c</sub> (m/min)

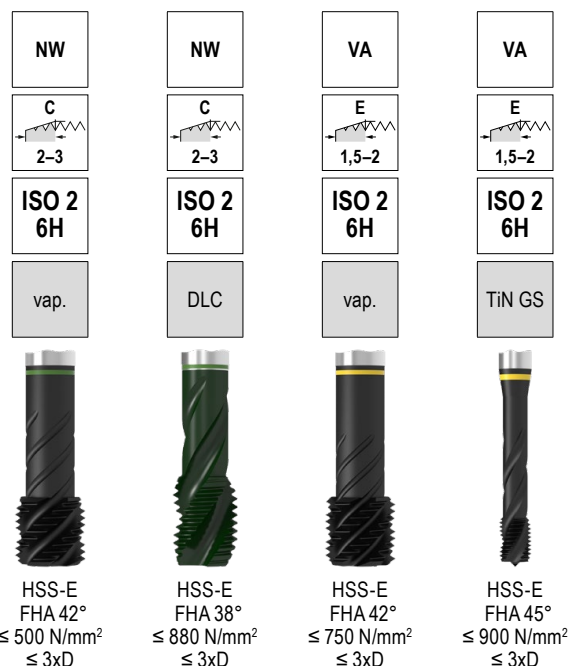
## Strojni ureznik za prolazni provrt, desni

CavTap

MF



DIN 371 s ojačanim drškom

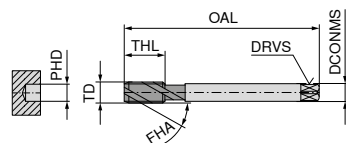


| TD      | TP   | OAL | DCONMS | DRVS | PHD | THL | LU | Utori |
|---------|------|-----|--------|------|-----|-----|----|-------|
| mm      | mm   | mm  | mm     | mm   | mm  | mm  | mm |       |
| M4x0,5  | 0,50 | 63  | 4,5    | 3,4  | 3,5 | 5   | 21 | 3     |
| M5x0,5  | 0,50 | 70  | 6,0    | 4,9  | 4,5 | 5   | 25 | 3     |
| M6x0,5  | 0,50 | 80  | 6,0    | 4,9  | 5,5 | 5   | 30 | 3     |
| M6x0,75 | 0,75 | 80  | 6,0    | 4,9  | 5,2 | 8   | 30 | 3     |

22 176 ...

EUR  
U0

|       |     |
|-------|-----|
| 99,53 | 040 |
| 76,39 | 050 |
| 76,39 | 060 |
| 76,39 | 062 |



DIN 374 sa zašiljenim drškom

| TD       | TP   | OAL | DCONMS | DRVS | PHD  | THL | Utori |
|----------|------|-----|--------|------|------|-----|-------|
| mm       | mm   | mm  | mm     | mm   | mm   | mm  |       |
| M8x0,75  | 0,75 | 80  | 6      | 4,9  | 7,2  | 8   | 3     |
| M8x1     | 1,00 | 90  | 6      | 4,9  | 7,0  | 10  | 3     |
| M10x1    | 1,00 | 90  | 7      | 5,5  | 9,0  | 10  | 3     |
| M10x1    | 1,00 | 90  | 7      | 5,5  | 9,0  | 10  | 4     |
| M10x1,25 | 1,25 | 100 | 7      | 5,5  | 8,8  | 16  | 3     |
| M12x1    | 1,00 | 100 | 9      | 7,0  | 11,0 | 11  | 4     |
| M12x1,25 | 1,25 | 100 | 9      | 7,0  | 10,8 | 15  | 4     |
| M12x1,5  | 1,50 | 100 | 9      | 7,0  | 10,5 | 15  | 4     |
| M12x1,5  | 1,50 | 100 | 9      | 7,0  | 10,5 | 15  | 5     |
| M14x1    | 1,00 | 100 | 11     | 9,0  | 13,0 | 11  | 4     |
| M14x1,25 | 1,25 | 100 | 11     | 9,0  | 12,8 | 15  | 4     |
| M14x1,5  | 1,50 | 100 | 11     | 9,0  | 12,5 | 15  | 4     |
| M14x1,5  | 1,50 | 100 | 11     | 9,0  | 12,5 | 15  | 5     |
| M16x1    | 1,00 | 100 | 12     | 9,0  | 15,0 | 12  | 4     |
| M16x1,5  | 1,50 | 100 | 12     | 9,0  | 14,5 | 15  | 4     |
| M16x1,5  | 1,50 | 100 | 12     | 9,0  | 14,5 | 15  | 5     |
| M18x1,5  | 1,50 | 110 | 14     | 11,0 | 16,5 | 17  | 4     |
| M18x1,5  | 1,50 | 110 | 14     | 11,0 | 16,5 | 17  | 5     |
| M20x1,5  | 1,50 | 125 | 16     | 12,0 | 18,5 | 17  | 4     |
| M20x1,5  | 1,50 | 125 | 16     | 12,0 | 18,5 | 17  | 5     |
| M26x1,5  | 1,50 | 140 | 18     | 14,5 | 24,5 | 20  | 6     |
| M28x1,5  | 1,50 | 140 | 20     | 16,0 | 26,5 | 20  | 6     |
| M30x1,5  | 1,50 | 150 | 22     | 18,0 | 28,5 | 22  | 6     |

22 188 ...

EUR  
U0

|        |     |
|--------|-----|
| 59,61  | 081 |
| 62,07  | 100 |
| 75,87  | 120 |
| 68,33  | 122 |
| 97,73  | 140 |
| 107,23 | 160 |
| 150,92 | 180 |
| 140,55 | 200 |

22 462 ...

EUR  
U0

|        |       |
|--------|-------|
| 70,89  | 08000 |
| 76,55  | 10000 |
| 101,99 | 10200 |
| 91,86  | 12000 |
| 113,56 | 12200 |
| 90,64  | 12400 |
| 117,43 | 14000 |
| 118,63 | 14200 |
| 116,10 | 14400 |
| 135,31 | 16000 |
| 133,99 | 16200 |

22 189 ...

EUR  
U0

|        |     |
|--------|-----|
| 59,61  | 082 |
| 69,22  | 100 |
| 78,32  | 121 |
| 76,39  | 120 |
| 94,88  | 140 |
| 114,64 | 160 |
| 158,79 | 200 |
| 308,40 | 260 |
| 360,50 | 280 |
| 356,56 | 300 |

22 177 ...

EUR  
U0

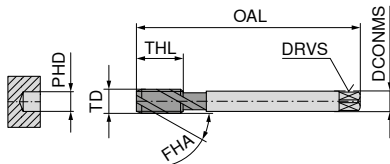
|        |     |
|--------|-----|
| 80,29  | 082 |
| 97,07  | 084 |
| 110,74 | 102 |
| 128,15 | 120 |
| 123,26 | 124 |
| 157,48 | 144 |
| 183,59 | 162 |
| 223,87 | 182 |
| 277,29 | 202 |

|   |    |    |    |
|---|----|----|----|
| P | 15 | 8  | 10 |
| M |    | 6  | 8  |
| K |    |    |    |
| N | 22 | 15 | 22 |
| S |    |    |    |
| H |    |    |    |
| O |    |    |    |

Brzina rezanja v<sub>c</sub> (m/min)

## Strojni ureznik za slijepi provrt, desni

MF



DIN 374 sa zašiljenim drškom

UNI

ISO 2  
6H

TiN

HSS-PM  
FHA 40°  
≤ 1000 N/mm²  
≤ 2,5xD

23 047 ...

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| M8x1     | 1,00     | 90        | 6            | 4,9        | 7,0       | 10        | 35       | 3     |
| M10x1    | 1,00     | 90        | 7            | 5,5        | 9,0       | 10        | 35       | 4     |
| M10x1,25 | 1,25     | 100       | 7            | 5,5        | 8,8       | 16        | 39       | 4     |
| M12x1    | 1,00     | 100       | 9            | 7,0        | 11,0      | 11        | 40       | 4     |
| M12x1,25 | 1,25     | 100       | 9            | 7,0        | 10,8      | 15        | 40       | 5     |
| M12x1,5  | 1,50     | 100       | 9            | 7,0        | 10,5      | 15        | 40       | 5     |
| M14x1    | 1,00     | 100       | 11           | 9,0        | 12,8      | 11        | 40       | 4     |
| M14x1,5  | 1,50     | 100       | 11           | 9,0        | 12,5      | 15        | 40       | 5     |
| M16x1,5  | 1,50     | 100       | 12           | 9,0        | 14,5      | 15        | 44       | 5     |
| M18x1,5  | 1,50     | 110       | 14           | 11,0       | 16,5      | 17        | 44       | 5     |
| M20x1,5  | 1,50     | 125       | 16           | 12,0       | 18,5      | 17        | 44       | 5     |
| M22x1,5  | 1,50     | 125       | 18           | 14,5       | 20,5      | 17        | 44       | 5     |
| M24x1,5  | 1,50     | 140       | 18           | 14,5       | 22,5      | 20        | 48       | 5     |
| M24x2    | 2,00     | 140       | 18           | 14,5       | 22,0      | 20        | 48       | 5     |

EUR

T9

26,01

081

33,91

102

33,05

104

38,58

120

42,04

122

37,36

121

45,14

140

44,26

144

57,33

162

74,59

182

85,07

202

93,70

222

95,43

242

111,10

244

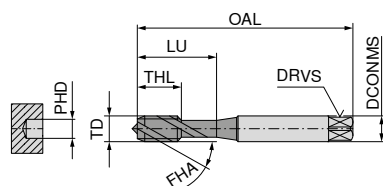
|   |    |
|---|----|
| P | 15 |
| M | 9  |
| K | 18 |
| N | 12 |
| S |    |
| H |    |
| O |    |

Brzina rezanja  $v_c$  (m/min)

## Strojni ureznik za prolazni provrt, desni

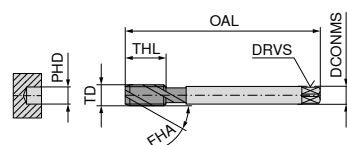
▲ NC = za CNC sinkronu obradu s kompenzacijskom glavom minimalne duljine

MF



DIN 371 s ojačanim drškom

| TD      | TP   | OAL | DCONMS | DRVS | PHD | THL | LU | Utori |
|---------|------|-----|--------|------|-----|-----|----|-------|
| mm      | mm   | mm  | mm     | mm   | mm  | mm  | mm |       |
| M4x0,5  | 0,50 | 63  | 4,5    | 3,4  | 3,5 | 5   | 21 | 3     |
| M5x0,5  | 0,50 | 70  | 6,0    | 4,9  | 4,5 | 5   | 25 | 3     |
| M6x0,5  | 0,50 | 80  | 6,0    | 4,9  | 5,5 | 5   | 30 | 3     |
| M6x0,75 | 0,75 | 80  | 6,0    | 4,9  | 5,2 | 8   | 30 | 3     |



DIN 374 sa zašiljenim drškom

| TD       | TP   | OAL | DCONMS | DRVS | PHD  | THL | Utori |
|----------|------|-----|--------|------|------|-----|-------|
| mm       | mm   | mm  | mm     | mm   | mm   | mm  |       |
| M4x0,5   | 0,50 | 63  | 2,8    | 2,1  | 3,5  | 5   | 3     |
| M5x0,5   | 0,50 | 70  | 3,5    | 2,7  | 4,5  | 5   | 3     |
| M6x0,75  | 0,75 | 80  | 4,5    | 3,4  | 5,2  | 8   | 3     |
| M8x0,5   | 0,50 | 80  | 6,0    | 8,0  | 7,5  | 6   | 3     |
| M8x0,75  | 0,75 | 80  | 6,0    | 4,9  | 7,2  | 8   | 3     |
| M8x1     | 1,00 | 90  | 6,0    | 4,9  | 7,0  | 10  | 3     |
| M10x0,75 | 0,75 | 90  | 7,0    | 5,5  | 9,2  | 10  | 4     |
| M10x1    | 1,00 | 90  | 7,0    | 5,5  | 9,0  | 10  | 3     |
| M10x1    | 1,00 | 90  | 7,0    | 5,5  | 9,0  | 10  | 4     |
| M10x1,25 | 1,25 | 100 | 7,0    | 5,5  | 8,8  | 16  | 3     |
| M12x1    | 1,00 | 100 | 9,0    | 7,0  | 11,0 | 11  | 4     |
| M12x1,25 | 1,25 | 100 | 9,0    | 7,0  | 10,8 | 15  | 4     |
| M12x1,5  | 1,50 | 100 | 9,0    | 7,0  | 10,5 | 15  | 4     |
| M12x1,5  | 1,50 | 100 | 9,0    | 7,0  | 10,5 | 15  | 5     |
| M14x1    | 1,00 | 100 | 11,0   | 9,0  | 13,0 | 11  | 4     |
| M14x1,5  | 1,50 | 100 | 11,0   | 9,0  | 12,5 | 15  | 4     |
| M14x1,5  | 1,50 | 100 | 11,0   | 9,0  | 12,5 | 15  | 5     |
| M16x1    | 1,00 | 100 | 12,0   | 9,0  | 15,0 | 12  | 4     |
| M16x1,5  | 1,50 | 100 | 12,0   | 9,0  | 14,5 | 15  | 4     |
| M16x1,5  | 1,50 | 100 | 12,0   | 9,0  | 14,5 | 15  | 5     |
| M18x1,5  | 1,50 | 110 | 14,0   | 11,0 | 16,5 | 17  | 4     |
| M18x1,5  | 1,50 | 110 | 14,0   | 11,0 | 16,5 | 17  | 5     |
| M20x1,5  | 1,50 | 125 | 16,0   | 12,0 | 18,5 | 17  | 4     |
| M20x1,5  | 1,50 | 125 | 16,0   | 12,0 | 18,5 | 17  | 5     |
| M22x1,5  | 1,50 | 125 | 18,0   | 14,5 | 20,5 | 17  | 4     |
| M24x1,5  | 1,50 | 140 | 18,0   | 14,5 | 22,5 | 20  | 5     |

|   |    |    |    |    |
|---|----|----|----|----|
| P | 12 | 15 | 12 | 15 |
| M |    | 9  | 7  | 9  |
| K | 12 | 18 | 12 | 18 |
| N | 22 | 12 |    | 12 |
| S |    |    |    |    |
| H |    |    |    |    |
| O |    |    |    |    |

Brzina rezanja v<sub>c</sub> (m/min)

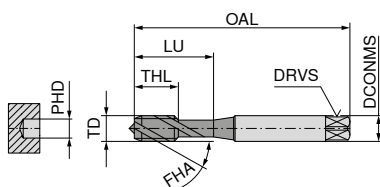
|                                            |                                           |                                             |                                             |
|--------------------------------------------|-------------------------------------------|---------------------------------------------|---------------------------------------------|
| FE                                         | UNI NC                                    | UNI                                         | UNI                                         |
| C<br>2-3                                   | E<br>1,5-2                                | C<br>2-3                                    | C<br>2-3                                    |
| ISO 2<br>6H                                | ISO 2<br>6H                               | ISO 2<br>6H                                 | ISO 2<br>6H                                 |
|                                            | TiN GS                                    | vap.                                        | TiN                                         |
|                                            |                                           |                                             |                                             |
| HSS-E<br>FHA 35°<br>≤ 850 N/mm²<br>≤ 2,5xD | HSS-E<br>FHA 45°<br>≤ 1000 N/mm²<br>≤ 3xD | HSS-E<br>FHA 35°<br>≤ 1000 N/mm²<br>≤ 2,5xD | HSS-E<br>FHA 35°<br>≤ 1000 N/mm²<br>≤ 2,5xD |

| 23 144 ... | 23 146 ... |
|------------|------------|
| EUR<br>T9  | EUR<br>T9  |
| 18,74 040  | 27,25 040  |
| 18,74 050  | 27,25 050  |
| 20,47 060  | 31,69 060  |
| 19,98 062  | 31,69 062  |

| 23 243 ... | 23 149 ... | 23 145 ... | 23 147 ... |
|------------|------------|------------|------------|
| EUR<br>T9  | EUR<br>T9  | EUR<br>T9  | EUR<br>T9  |
| 28,12 082  |            | 18,26 040  |            |
|            |            | 18,26 050  |            |
|            |            | 19,48 062  |            |
| 54,01 080  |            |            |            |
| 28,12 082  | 49,43 082  | 22,07 082  | 33,79 082  |
| 26,38 084  | 46,35 084  | 16,15 084  | 31,69 084  |
| 59,18 100  |            | 35,51 100  | 51,53 100  |
| 30,95 102  |            | 16,90 102  | 35,51 102  |
|            | 54,50 102  |            |            |
| 51,17 104  |            | 18,74 104  | 44,89 104  |
| 35,64 120  | 62,03 120  | 22,70 120  | 41,67 120  |
| 57,46 122  |            | 26,76 122  | 50,55 122  |
| 34,28 124  |            | 19,98 124  | 40,20 124  |
|            | 58,82 124  |            |            |
| 57,46 140  |            | 29,84 140  | 54,37 140  |
| 42,16 144  |            | 27,13 144  | 50,55 144  |
|            | 75,59 144  |            |            |
| 67,56 160  |            | 32,05 160  | 59,68 160  |
| 53,77 162  |            | 31,07 162  | 59,68 162  |
|            | 84,21 162  |            |            |
|            | 106,77 182 | 43,02 182  | 69,54 182  |
|            |            | 39,57 202  | 88,53 202  |
| 77,67 202  |            |            |            |
|            | 139,36 202 |            |            |
| 89,88 222  |            | 58,82 222  | 98,40 222  |
| 104,82 242 |            | 64,11 242  | 105,05 242 |

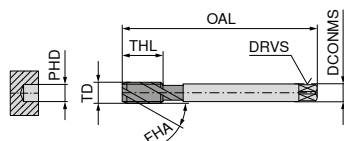
## Strojni ureznik za prolazni provrt, desni

MF



DIN 371 s ojačanim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| M5x0,5   | 0,50     | 70        | 6            | 4,9        | 4,5       | 5         | 25       | 3     |
| M6x0,75  | 0,75     | 80        | 6            | 4,9        | 5,2       | 8         | 30       | 3     |



DIN 374 sa zašiljenim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|-------|
| M8x0,75  | 0,75     | 80        | 6            | 4,9        | 7,2       | 8         | 3     |
| M8x1     | 1,00     | 90        | 6            | 4,9        | 7,0       | 10        | 3     |
| M10x1    | 1,00     | 90        | 7            | 5,5        | 9,0       | 10        | 4     |
| M12x1    | 1,00     | 100       | 9            | 7,0        | 11,0      | 11        | 4     |
| M12x1,5  | 1,50     | 100       | 9            | 7,0        | 10,5      | 15        | 5     |
| M14x1,5  | 1,50     | 100       | 11           | 9,0        | 12,5      | 15        | 5     |
| M16x1,5  | 1,50     | 100       | 12           | 9,0        | 14,5      | 15        | 5     |

|   |    |
|---|----|
| P | 10 |
| M | 8  |
| K |    |
| N | 24 |
| S |    |
| H |    |
| O |    |

Brzina rezanja  $v_c$  (m/min)

VA

E  
1,5-2ISO 2  
6H

TiN

HSS-E  
FHA 45°  
≤ 1200 N/mm²  
≤ 3xD

23 442 ...

EUR  
T932,93 050  
38,73 062

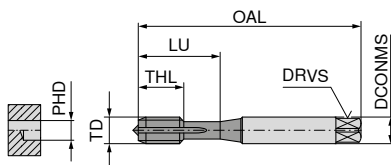
23 443 ...

EUR  
T941,31 082  
38,73 084  
43,52 102  
51,05 120  
49,08 124  
62,27 144  
71,51 162

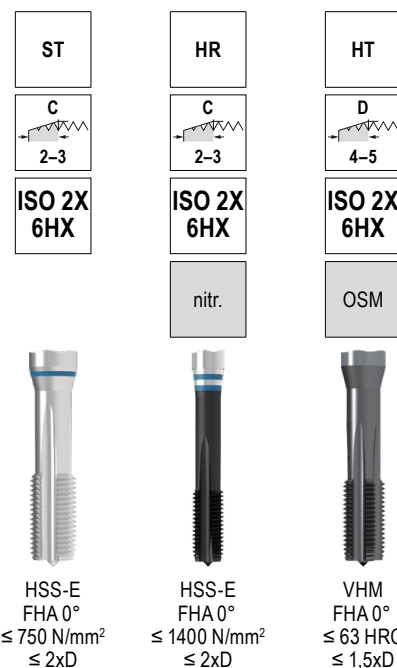
## Strojni ureznik za proboj i sljepi provrt, desni

DuoTap

MF



DIN 371 s ojačanim drškom



| 22 144 ... | 22 146 ... | 22 817 ... |
|------------|------------|------------|
| EUR<br>U0  | EUR<br>U0  | EUR<br>U0  |
| 50,86 040  | 56,47 040  |            |
| 50,86 050  | 56,47 050  |            |
| 50,86 060  | 56,47 060  |            |
| 50,86 062  | 56,47 062  |            |
| 50,86 084  |            |            |
|            |            | 429,04 080 |
| 50,86 104  |            |            |
|            |            | 547,66 100 |
|            |            | 634,68 120 |
|            |            | 745,08 140 |
|            |            | 847,00 160 |
| P          | 12         | 6          |
| M          |            |            |
| K          | 12         | 16         |
| N          | 22         | 22         |
| S          |            |            |
| H          |            |            |
| O          |            | 2          |

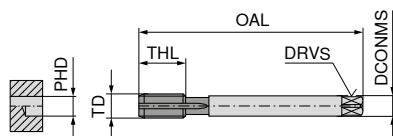
Brzina rezanja  $v_c$  (m/min)

DIN 374 možete pronaći na sljedećoj stranici.

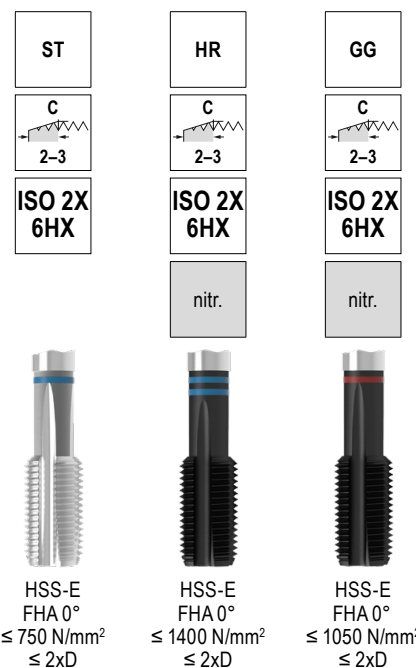
## Strojni ureznik za proboj i sljepi provrt, desni

DuoTap

MF



DIN 374 sa zašiljenim drškom



| 22 171 ... | 22 209 ... | 22 173 ... |
|------------|------------|------------|
| EUR U0     | EUR U0     | EUR U0     |
| 46,32 042  |            |            |
| 55,56 050  |            | 51,66 050  |
| 51,66 060  |            | 63,89 060  |
| 50,09 062  |            | 56,47 062  |
| 56,87 082  |            | 99,53 080  |
| 45,68 084  | 56,47 082  | 99,53 082  |
| 73,52 102  |            |            |
| 47,36 104  | 56,47 100  | 55,56 100  |
| 56,47 106  |            |            |
| 83,54 110  |            |            |
| 55,19 122  |            | 63,89 120  |
| 67,92 124  |            |            |
| 55,19 126  | 67,92 120  | 61,41 124  |
| 83,54 140  |            | 94,88 140  |
| 76,39 142  |            |            |
| 78,98 144  | 87,46 140  | 86,67 142  |
| 86,67 160  |            |            |
| 77,67 162  | 94,88 160  | 89,78 160  |
| 112,05 180 |            |            |
| 104,10 182 | 112,82 180 | 120,29 180 |
| 124,94 184 |            |            |
| 124,94 200 |            |            |
| 113,73 202 | 143,17 200 | 125,76 200 |
| 156,17 204 |            |            |
| 175,72 220 |            |            |
| 121,83 222 |            | 135,31 220 |
| 172,98 224 |            |            |
| 192,52 240 |            |            |
| 136,61 242 |            | 153,54 240 |
| 153,54 244 |            |            |
| 248,55 250 |            |            |
| 193,84 260 |            | 190,02 260 |
| 225,19 272 |            |            |
| 212,08 274 |            |            |
| 217,33 300 |            | 225,19 280 |
| 260,36 302 |            | 244,74 300 |

|   |    |    |    |
|---|----|----|----|
| P | 12 | 6  |    |
| M |    |    |    |
| K | 12 | 16 | 16 |
| N | 22 | 22 | 22 |
| S |    |    |    |
| H |    |    |    |
| O |    |    |    |

Brzina rezanja  $v_c$  (m/min)

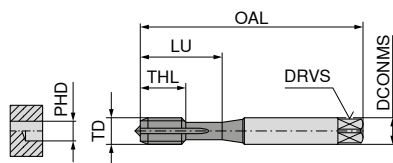
## Strojni ureznik za prolazni i slijepi provrt

▲ ES = iznimno kratki

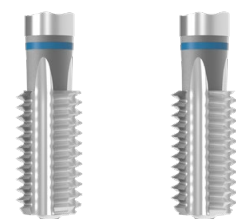
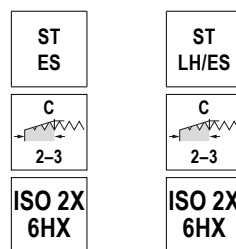
▲ LH = za lijeve navoje; ES = iznimno kratki

DuoTap

MF



DIN 2181 s ojačanim drškom

HSS-E  
FHA 0°  
≤ 750 N/mm²  
≤ 2xDHSS-E  
FHA 0°  
≤ 750 N/mm²  
≤ 2xD

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| M3x0,35  | 0,35     | 40        | 3,5          | 2,7        | 2,65      | 8         | 18       | 3     |
| M4x0,35  | 0,35     | 45        | 4,5          | 3,4        | 3,65      | 9         | 22       | 3     |
| M4x0,5   | 0,50     | 45        | 4,5          | 3,4        | 3,50      | 9         | 22       | 3     |
| M4,5x0,5 | 0,50     | 50        | 6,0          | 4,9        | 4,00      | 10        | 24       | 3     |
| M5x0,5   | 0,50     | 50        | 6,0          | 4,9        | 4,50      | 11        | 25       | 3     |
| M6x0,5   | 0,50     | 56        | 6,0          | 4,9        | 5,50      | 12        | 27       | 3     |
| M6x0,75  | 0,75     | 56        | 6,0          | 4,9        | 5,20      | 12        | 27       | 3     |
| M7x0,75  | 0,75     | 56        | 6,0          | 4,9        | 6,20      | 14        |          | 3     |
| M8x0,5   | 0,50     | 56        | 6,0          | 4,9        | 7,50      | 14        |          | 4     |
| M8x0,75  | 0,75     | 56        | 6,0          | 4,9        | 7,20      | 14        |          | 3     |
| M8x1     | 1,00     | 63        | 6,0          | 4,9        | 7,00      | 17        |          | 3     |
| M9x1     | 1,00     | 63        | 7,0          | 5,5        | 8,00      | 17        |          | 4     |
| M10x0,75 | 0,75     | 63        | 7,0          | 5,5        | 9,20      | 18        |          | 4     |
| M10x1    | 1,00     | 63        | 7,0          | 5,5        | 9,00      | 18        |          | 4     |
| M10x1,25 | 1,25     | 70        | 7,0          | 5,5        | 8,80      | 22        |          | 3     |
| M11x1    | 1,00     | 63        | 8,0          | 6,2        | 10,00     | 18        |          | 4     |
| M12x1    | 1,00     | 70        | 9,0          | 7,0        | 11,00     | 18        |          | 4     |
| M12x1,25 | 1,25     | 70        | 9,0          | 7,0        | 10,80     | 20        |          | 4     |
| M12x1,5  | 1,50     | 70        | 9,0          | 7,0        | 10,50     | 20        |          | 4     |
| M13x1    | 1,00     | 70        | 11,0         | 9,0        | 12,00     | 18        |          | 4     |
| M14x1    | 1,00     | 70        | 11,0         | 9,0        | 13,00     | 18        |          | 4     |
| M14x1,25 | 1,25     | 70        | 11,0         | 9,0        | 12,80     | 20        |          | 4     |
| M14x1,5  | 1,50     | 70        | 11,0         | 9,0        | 12,50     | 20        |          | 4     |
| M15x1    | 1,00     | 70        | 12,0         | 9,0        | 14,00     | 18        |          | 5     |
| M16x1    | 1,00     | 70        | 12,0         | 9,0        | 15,00     | 18        |          | 5     |
| M16x1,5  | 1,50     | 70        | 12,0         | 9,0        | 14,50     | 20        |          | 4     |
| M18x1    | 1,00     | 80        | 14,0         | 11,0       | 17,00     | 18        |          | 5     |
| M18x1,5  | 1,50     | 80        | 14,0         | 11,0       | 16,50     | 22        |          | 4     |
| M18x2    | 2,00     | 80        | 14,0         | 11,0       | 16,00     | 22        |          | 4     |
| M20x1,5  | 1,50     | 80        | 16,0         | 12,0       | 18,50     | 22        |          | 4     |
| M20x2    | 2,00     | 80        | 16,0         | 12,0       | 18,00     | 22        |          | 4     |

|   |    |    |
|---|----|----|
| P | 12 | 12 |
| M |    |    |
| K | 12 | 12 |
| N | 22 | 22 |
| S |    |    |
| H |    |    |
| O |    |    |

Brzina rezanja v<sub>c</sub> (m/min)

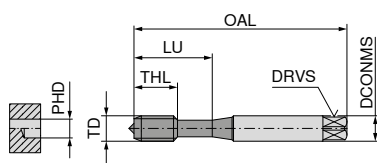
## Strojni uvaljivač navoja za prolazni i slijepi provrt, desni

▲ SN = ureznik s utorima za mazivo

▲ HML = sa zalemljenim trakama od tvrdog metala za veće brzine rezanja

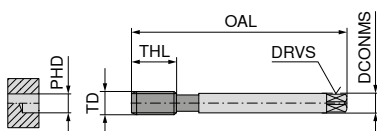
DuoForm

MF



DIN 2174 s ojačanim drškom

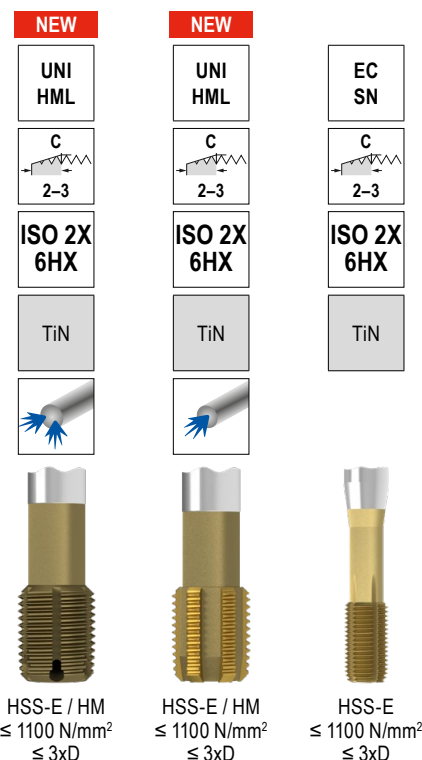
| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| M4x0,5   | 0,50     | 63        | 4,5          | 3,4        | 3,8       | 10        | 21       | 4     |
| M5x0,5   | 0,50     | 70        | 6,0          | 4,9        | 4,8       | 11        | 25       | 4     |
| M6x0,5   | 0,50     | 80        | 6,0          | 4,9        | 5,8       | 13        | 30       | 5     |
| M6x0,75  | 0,75     | 80        | 6,0          | 4,9        | 5,7       | 13        | 30       | 4     |
| M8x0,75  | 0,75     | 80        | 8,0          | 6,2        | 7,7       | 14        | 30       | 5     |
| M8x1     | 1,00     | 90        | 8,0          | 6,2        | 7,6       | 17        | 35       | 5     |
| M10x1    | 1,00     | 90        | 10,0         | 8,0        | 9,6       | 18        | 35       | 5     |



DIN 2174 sa zašiljenim drškom

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|-------|
| M12x1    | 1,0      | 100       | 9            | 7          | 11,60     | 18        | 6     |
| M12x1,5  | 1,5      | 100       | 9            | 7          | 11,35     | 13        |       |
| M12x1,5  | 1,5      | 100       | 9            | 7          | 11,35     | 22        | 6     |
| M14x1,5  | 1,5      | 100       | 11           | 9          | 13,35     | 22        | 6     |
| M16x1,5  | 1,5      | 100       | 12           | 9          | 15,35     | 18        |       |
| M16x1,5  | 1,5      | 100       | 12           | 9          | 15,35     | 22        | 6     |
| M20x1,5  | 1,5      | 125       | 16           | 12         | 19,35     | 25        | 6     |

| P | 30 | 30 | 18 |
|---|----|----|----|
| M | 20 | 20 | 10 |
| K | 30 | 30 | 10 |
| N | 40 | 40 | 22 |
| S |    |    |    |
| H |    |    |    |
| O |    |    |    |

Brzina rezanja v<sub>c</sub> (m/min)

22 205 ...

EUR  
U0040  
050  
060  
062  
080  
082  
100

22 474 ...

EUR  
U0

646,13

16100

22 474 ...

EUR  
U0

452,18

12000

515,95

16000

22 197 ...

EUR  
U0

122,67

120

124,34

124

158,79

140

179,53

160

251,18

200

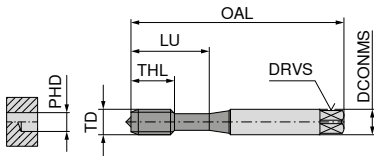
## Strojni uvaljivač navoja za prolazni i slijepi provrt, desni

▲ SN = ureznik s utorima za mazivo

MF

UNI  
SNC  
2-3ISO 2X  
6HX

TiN



DIN 2174 s ojačanim drškom

HSS-E  
≤ 850 N/mm<sup>2</sup>  
≤ 3xD

23 842 ...

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| M4x0,5   | 0,50     | 63        | 4,5          | 3,4        | 3,80      | 10        | 21       | 4     |
| M5x0,5   | 0,50     | 70        | 6,0          | 4,9        | 4,80      | 11        | 25       | 4     |
| M6x0,5   | 0,50     | 80        | 6,0          | 4,9        | 5,80      | 13        | 30       | 5     |
| M8x1     | 1,00     | 90        | 8,0          | 6,2        | 7,60      | 17        | 35       | 5     |
| M10x1    | 1,00     | 90        | 10,0         | 8,0        | 9,60      | 18        | 35       | 5     |
| M10x1,25 | 1,25     | 100       | 10,0         | 8,0        | 9,45      | 18        | 39       | 5     |

EUR

T9

040

53,14

050

47,83

060

53,38

084

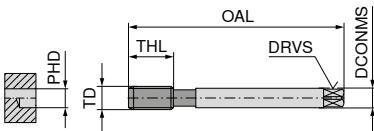
50,79

102

56,23

104

68,68



DIN 2174 sa zašiljenim drškom

23 843 ...

| TD<br>mm | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|-------|
| M12x1,25 | 1,25     | 100       | 9            | 7          | 11,45     | 22        | 6     |
| M12x1,5  | 1,50     | 100       | 9            | 7          | 11,35     | 22        | 6     |
| M14x1,5  | 1,50     | 100       | 11           | 9          | 13,35     | 22        | 6     |
| M16x1,5  | 1,50     | 100       | 12           | 9          | 15,35     | 22        | 6     |

EUR

T9

122

74,97

124

66,96

144

83,11

162

96,91

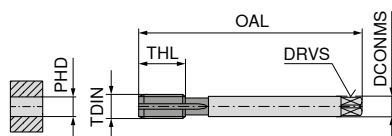
|   |    |
|---|----|
| P | 18 |
| M | 10 |
| K | 10 |
| N | 22 |
| S |    |
| H |    |
| O |    |

Brzina rezanja v<sub>c</sub> (m/min)

## Strojni ureznik za prolazni provrt, desni

TruTap

G



DIN 5156 sa zašiljenim drškom

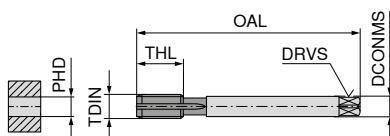
| UNI                                      | UNI                                      | ST                                      | NW                                      | VA                                      |
|------------------------------------------|------------------------------------------|-----------------------------------------|-----------------------------------------|-----------------------------------------|
|                                          |                                          |                                         |                                         |                                         |
| ISO 228                                  | ISO 228                                  | ISO 228                                 | ISO 228                                 | ISO 228                                 |
| nitr. + vap.                             | TiN                                      |                                         | DLC                                     | nitr.                                   |
|                                          |                                          |                                         |                                         |                                         |
| HSS-E<br>FHA 0°<br>≤ 1100 N/mm²<br>≤ 4xD | HSS-E<br>FHA 0°<br>≤ 1100 N/mm²<br>≤ 4xD | HSS-E<br>FHA 0°<br>≤ 750 N/mm²<br>≤ 4xD | HSS-E<br>FHA 0°<br>≤ 880 N/mm²<br>≤ 4xD | HSS-E<br>FHA 0°<br>≤ 900 N/mm²<br>≤ 4xD |

| TDIN   | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori | 22 632 ... |     | 22 630 ... |     | 22 346 ... |     | 22 467 ... |       | 22 352 ... |     |
|--------|----------|-----------|--------------|------------|-----------|-----------|-------|------------|-----|------------|-----|------------|-----|------------|-------|------------|-----|
|        |          |           |              |            |           |           |       | EUR<br>U0  |     | EUR<br>U0  |     | EUR<br>U0  |     | EUR<br>U0  |       | EUR<br>U0  |     |
| 1/8-28 | 0,907    | 90        | 7            | 5,5        | 8,80      | 18        | 3     | 72,48      | 012 | 97,73      | 012 | 54,91      | 012 | 72,26      | 01200 | 69,88      | 012 |
| 1/4-19 | 1,337    | 100       | 11           | 9,0        | 11,80     | 22        | 3     | 97,07      | 025 | 128,99     | 025 | 74,30      | 025 | 96,61      | 02500 | 91,50      | 025 |
| 3/8-19 | 1,337    | 100       | 12           | 9,0        | 15,25     | 22        | 3     | 121,00     | 037 | 150,92     | 037 | 89,14      | 037 | 123,98     | 03700 | 113,73     | 037 |
| 1/2-14 | 1,814    | 125       | 16           | 12,0       | 19,00     | 25        | 4     | 156,17     | 050 | 231,74     | 050 | 121,83     | 050 | 164,99     | 05000 | 150,92     | 050 |
| 3/4-14 | 1,814    | 140       | 20           | 16,0       | 24,50     | 28        | 4     | 248,55     | 075 |            |     | 195,27     | 075 | 261,43     | 07500 | 223,87     | 075 |
| 1-11   | 2,309    | 160       | 25           | 20,0       | 30,75     | 30        | 4     | 385,18     | 100 |            |     | 279,78     | 100 | 384,82     | 10000 | 342,26     | 100 |
| P      |          |           |              |            |           |           |       | 12         |     | 15         |     | 12         |     |            |       | 8          |     |
| M      |          |           |              |            |           |           |       | 7          |     | 9          |     |            |     |            |       | 6          |     |
| K      |          |           |              |            |           |           |       | 12         |     | 18         |     | 12         |     |            |       |            |     |
| N      |          |           |              |            |           |           |       |            |     | 12         |     | 22         |     | 15         |       | 22         |     |
| S      |          |           |              |            |           |           |       |            |     |            |     |            |     |            |       |            |     |
| H      |          |           |              |            |           |           |       |            |     |            |     |            |     |            |       |            |     |
| O      |          |           |              |            |           |           |       |            |     |            |     |            |     |            |       |            |     |

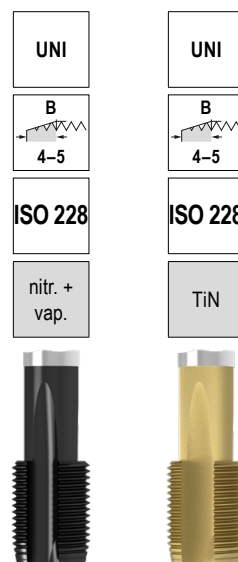
Brzina rezanja v<sub>c</sub> (m/min)

## Strojni ureznik za prolazni provrt, desni

G



DIN 5156 sa zašiljenim drškom

HSS-E  
FHA 0°  
≤ 1100 N/mm²  
≤ 3xDHSS-E  
FHA 0°  
≤ 1100 N/mm²  
≤ 3xD

| TDIN   | TP    | OAL | DCONMS | DRVS | PHD   | THL | Utori |
|--------|-------|-----|--------|------|-------|-----|-------|
| mm     | mm    | mm  | mm     | mm   | mm    | mm  |       |
| 1/8-28 | 0,907 | 90  | 7      | 5,5  | 8,80  | 18  | 3     |
| 1/4-19 | 1,337 | 100 | 11     | 9,0  | 11,80 | 22  | 3     |
| 3/8-19 | 1,337 | 100 | 12     | 9,0  | 15,25 | 22  | 3     |
| 1/2-14 | 1,814 | 125 | 16     | 12,0 | 19,00 | 25  | 4     |
| 3/4-14 | 1,814 | 140 | 20     | 16,0 | 24,50 | 28  | 4     |
| 1-11   | 2,309 | 160 | 25     | 20,0 | 30,75 | 30  | 4     |

23 161 ...

EUR  
T919,11 012  
25,78 025  
31,57 037  
43,65 050  
85,46 075  
94,32 100

23 160 ...

EUR  
T935,27 012  
46,61 025  
54,87 037  
84,21 050  
110,24 075  
203,37 100

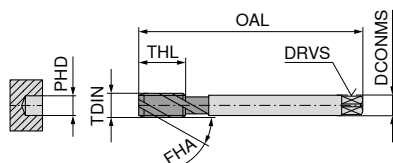
|   |    |    |
|---|----|----|
| P | 12 | 15 |
| M | 7  | 9  |
| K | 12 | 18 |
| N |    | 12 |
| S |    |    |
| H |    |    |
| O |    |    |

Brzina rezanja v<sub>c</sub> (m/min)

## Strojni ureznik za prolazni provrt, desni

CavTap

G



DIN 5156 sa zašiljenim drškom

| UNI                                       | UNI                                       | UNI                                       | UNI                                       | UNI                                       |
|-------------------------------------------|-------------------------------------------|-------------------------------------------|-------------------------------------------|-------------------------------------------|
|                                           |                                           |                                           |                                           |                                           |
| ISO 228                                   | ISO 228                                   | ISO 228                                   | ISO 228                                   | ISO 228 +0,05                             |
| vap.                                      | TiN                                       | vap.                                      | TiN                                       | vap.                                      |
|                                           |                                           |                                           |                                           |                                           |
| HSS-E<br>FHA 42°<br>≤ 1100 N/mm²<br>≤ 3xD | HSS-E<br>FHA 42°<br>≤ 1100 N/mm²<br>≤ 3xD | HSS-E<br>FHA 42°<br>≤ 1100 N/mm²<br>≤ 3xD | HSS-E<br>FHA 42°<br>≤ 1100 N/mm²<br>≤ 3xD | HSS-E<br>FHA 42°<br>≤ 1100 N/mm²<br>≤ 3xD |

| TDIN     | TP    | OAL | DCONMS | DRVS | PHD   | THL | Utori | 22 633 ... | 22 634 ... | 22 635 ... | 22 636 ... | 22 639 ... |
|----------|-------|-----|--------|------|-------|-----|-------|------------|------------|------------|------------|------------|
|          |       |     |        |      |       |     |       | EUR<br>U0  | EUR<br>U0  | EUR<br>U0  | EUR<br>U0  | EUR<br>U0  |
| 1/8-28   | 0,907 | 90  | 7      | 5,5  | 8,80  | 10  | 3     | 72,48      | 101,77     | 74,30      | 101,77     | 97,73      |
| 1/8-28   | 0,907 | 90  | 7      | 5,5  | 8,80  | 10  | 4     |            |            |            |            |            |
| 1/4-19   | 1,337 | 100 | 11     | 9,0  | 11,80 | 15  | 4     | 101,77     | 127,43     | 98,51      | 127,43     | 128,99     |
| 1/4-19   | 1,337 | 100 | 11     | 9,0  | 11,80 | 15  | 5     |            |            |            |            |            |
| 3/8-19   | 1,337 | 100 | 12     | 9,0  | 15,25 | 15  | 4     | 124,94     | 179,53     | 121,83     | 179,53     | 159,99     |
| 3/8-19   | 1,337 | 100 | 12     | 9,0  | 15,25 | 15  | 5     |            |            |            |            |            |
| 1/2-14   | 1,814 | 125 | 16     | 12,0 | 19,00 | 17  | 4     | 165,23     | 257,73     | 158,79     | 249,87     | 205,51     |
| 1/2-14   | 1,814 | 125 | 16     | 12,0 | 19,00 | 17  | 5     |            |            |            |            |            |
| 5/8-14   | 1,814 | 125 | 18     | 14,5 | 21,00 | 17  | 4     | 203,13     |            |            |            |            |
| 3/4-14   | 1,814 | 140 | 20     | 16,0 | 24,50 | 20  | 4     | 255,00     |            |            |            | 312,34     |
| 3/4-14   | 1,814 | 140 | 20     | 16,0 | 24,50 | 20  | 5     |            |            |            |            |            |
| 7/8-14   | 1,814 | 150 | 22     | 18,0 | 28,25 | 22  | 5     | 351,32     |            |            |            |            |
| 1-11     | 2,309 | 160 | 25     | 20,0 | 30,75 | 24  | 5     | 387,91     |            |            |            |            |
| 1-11     | 2,309 | 160 | 25     | 20,0 | 30,75 | 24  | 6     |            |            |            |            | 476,25     |
| 1 1/4-11 | 2,309 | 170 | 32     | 24,0 | 39,50 | 25  | 6     | 624,66     |            |            |            |            |
| 1 1/2-11 | 2,309 | 190 | 36     | 29,0 | 45,25 | 27  | 6     | 891,35     |            |            |            |            |
| P        |       |     |        |      |       |     |       | 12         | 15         | 12         | 15         | 12         |
| M        |       |     |        |      |       |     |       | 7          | 9          | 7          | 9          | 7          |
| K        |       |     |        |      |       |     |       | 12         | 18         | 12         | 18         | 12         |
| N        |       |     |        |      |       |     |       |            | 12         |            | 12         |            |
| S        |       |     |        |      |       |     |       |            |            |            |            |            |
| H        |       |     |        |      |       |     |       |            |            |            |            |            |
| O        |       |     |        |      |       |     |       |            |            |            |            |            |

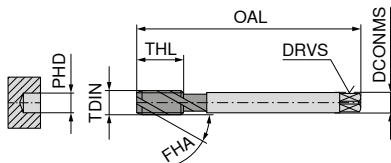
Brzina rezanja v<sub>c</sub> (m/min)

## Strojni ureznik za prolazni provrt, desni

▲ CNC = za CNC sinkronu obradu s kompenzacijskom glavom minimalne duljine

CavTap

G



DIN 5156 sa zašiljenim drškom

UNI  
CNC

ISO 228

TiN GS

HSS-E  
FHA 45°  
≤ 1100 N/mm<sup>2</sup>  
≤ 3xD

ST



ISO 228

HSS-E  
FHA 42°  
≤ 750 N/mm<sup>2</sup>  
≤ 3xD

NW



ISO 228

DLC

HSS-E  
FHA 36°  
≤ 880 N/mm<sup>2</sup>  
≤ 2,5xD

VA



ISO 228

vap.

HSS-E  
FHA 42°  
≤ 900 N/mm<sup>2</sup>  
≤ 3xD

VA



ISO 228

TiN GS

HSS-E  
FHA 45°  
≤ 900 N/mm<sup>2</sup>  
≤ 3xD

22 624 ...

EUR  
U0

22 354 ...

EUR  
U0

22 463 ...

EUR  
U0

22 355 ...

EUR  
U0

22 358 ...

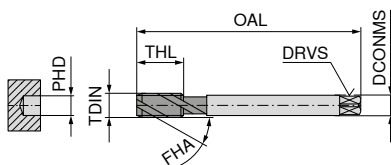
EUR  
U0

| TDIN   | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori |        |     |    |        |     |  |        |       |        |     |
|--------|----------|-----------|--------------|------------|-----------|-----------|-------|--------|-----|----|--------|-----|--|--------|-------|--------|-----|
| 1/8-28 | 0,907    | 90        | 7            | 5,5        | 8,80      | 10        | 3     |        |     |    |        |     |  |        |       |        |     |
| 1/8-28 | 0,907    | 90        | 7            | 5,5        | 8,80      | 10        | 4     | 116,33 | 012 |    | 62,07  | 012 |  | 80,40  | 01200 | 74,30  | 012 |
| 1/4-19 | 1,337    | 100       | 11           | 9,0        | 11,80     | 15        | 4     |        |     |    | 86,67  | 025 |  | 116,10 | 02500 | 98,51  | 025 |
| 1/4-19 | 1,337    | 100       | 11           | 9,0        | 11,80     | 15        | 5     | 152,24 | 025 |    | 105,94 | 037 |  | 138,40 | 03700 | 121,83 | 037 |
| 3/8-19 | 1,337    | 100       | 12           | 9,0        | 15,25     | 15        | 4     |        |     |    |        |     |  |        |       |        |     |
| 3/8-19 | 1,337    | 100       | 12           | 9,0        | 15,25     | 15        | 5     | 180,84 | 037 |    | 136,61 | 050 |  | 176,79 | 05000 | 154,97 | 050 |
| 1/2-14 | 1,814    | 125       | 16           | 12,0       | 19,00     | 17        | 4     |        |     |    |        |     |  |        |       | 203,13 | 062 |
| 1/2-14 | 1,814    | 125       | 16           | 12,0       | 19,00     | 17        | 5     | 273,36 | 050 |    |        |     |  |        |       |        |     |
| 5/8-14 | 1,814    | 125       | 18           | 14,5       | 21,00     | 17        | 5     |        |     |    | 217,33 | 075 |  | 281,81 | 07500 | 260,36 | 075 |
| 3/4-14 | 1,814    | 140       | 20           | 16,0       | 24,50     | 20        | 4     |        |     |    |        |     |  |        |       |        |     |
| 3/4-14 | 1,814    | 140       | 20           | 16,0       | 24,50     | 20        | 5     |        |     |    |        |     |  |        |       |        |     |
| 1-11   | 2,309    | 160       | 25           | 20,0       | 30,75     | 24        | 5     |        |     |    | 330,57 | 100 |  | 451,45 | 10000 | 382,67 | 100 |
| 1-11   | 2,309    | 160       | 25           | 20,0       | 30,75     | 24        | 6     |        |     |    |        |     |  |        |       |        |     |
| P      |          |           |              |            |           |           |       | 15     |     | 12 |        |     |  | 8      |       | 10     |     |
| M      |          |           |              |            |           |           |       | 9      |     |    |        |     |  | 6      |       | 8      |     |
| K      |          |           |              |            |           |           |       | 18     |     | 12 |        |     |  |        |       |        |     |
| N      |          |           |              |            |           |           |       | 12     |     | 22 |        | 15  |  | 22     |       | 22     |     |
| S      |          |           |              |            |           |           |       |        |     |    |        |     |  |        |       |        |     |
| H      |          |           |              |            |           |           |       |        |     |    |        |     |  |        |       |        |     |
| O      |          |           |              |            |           |           |       |        |     |    |        |     |  |        |       |        |     |

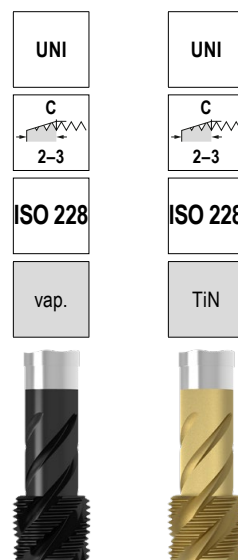
Brzina rezanja v<sub>c</sub> (m/min)

## Strojni ureznik za prolazni provrt, desni

G



DIN 5156 sa zašiljenim drškom

HSS-E  
FHA 35°  
≤ 1100 N/mm²  
≤ 2,5xDHSS-E  
FHA 35°  
≤ 1100 N/mm²  
≤ 2,5xD

| TDIN   | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori |
|--------|----------|-----------|--------------|------------|-----------|-----------|-------|
| 1/8-28 | 0,907    | 90        | 7            | 5,5        | 8,80      | 10        | 3     |
| 1/4-19 | 1,337    | 100       | 11           | 9,0        | 11,80     | 15        | 4     |
| 3/8-19 | 1,337    | 100       | 12           | 9,0        | 15,25     | 15        | 4     |
| 1/2-14 | 1,814    | 125       | 16           | 12,0       | 19,00     | 17        | 4     |
| 3/4-14 | 1,814    | 140       | 20           | 16,0       | 24,50     | 20        | 4     |
| 1-11   | 2,309    | 160       | 25           | 20,0       | 30,75     | 24        | 5     |

23 163 ...

EUR  
T919,98 012  
28,48 025  
41,43 037  
53,38 050  
81,86 075  
113,93 100

23 162 ...

EUR  
T936,75 012  
50,55 025  
59,68 037  
89,88 050  
115,41 075  
219,47 100

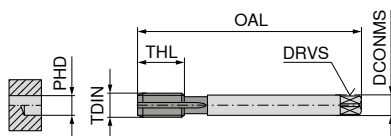
|   |    |    |
|---|----|----|
| P | 12 | 15 |
| M | 7  | 9  |
| K | 12 | 18 |
| N |    | 12 |
| S |    |    |
| H |    |    |
| O |    |    |

Brzina rezanja v<sub>c</sub> (m/min)

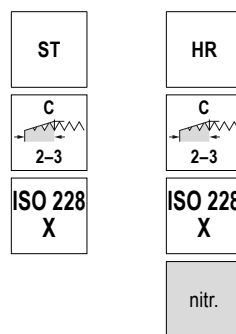
## Strojni ureznik za proboj i sljepi provrt, desni

DuoTap

G



DIN 5156 sa zašiljenim drškom

HSS-E  
FHA 0°  
≤ 750 N/mm²  
≤ 2xDHSS-E  
FHA 0°  
≤ 1400 N/mm²  
≤ 2xD

| TDIN     | TP    | OAL | DCONMS | DRVS | PHD   | THL | Utori |
|----------|-------|-----|--------|------|-------|-----|-------|
| mm       | mm    | mm  | mm     | mm   | mm    | mm  |       |
| 1/16-28  | 0,907 | 90  | 6      | 4,9  | 6,80  | 17  | 3     |
| 1/8-28   | 0,907 | 90  | 7      | 5,5  | 8,80  | 18  | 4     |
| 1/4-19   | 1,337 | 100 | 11     | 9,0  | 11,80 | 22  | 4     |
| 3/8-19   | 1,337 | 100 | 12     | 9,0  | 15,25 | 22  | 4     |
| 1/2-14   | 1,814 | 125 | 16     | 12,0 | 19,00 | 25  | 4     |
| 3/4-14   | 1,814 | 140 | 20     | 16,0 | 24,50 | 28  | 4     |
| 1-11     | 2,309 | 160 | 25     | 20,0 | 30,75 | 30  | 5     |
| 1 1/8-11 | 2,309 | 170 | 28     | 22,0 | 35,50 | 30  | 5     |
| 1 1/4-11 | 2,309 | 170 | 32     | 24,0 | 39,50 | 30  | 6     |
| 1 3/8-11 | 2,309 | 180 | 36     | 29,0 | 41,75 | 32  | 6     |
| 1 1/2-11 | 2,309 | 190 | 36     | 29,0 | 45,25 | 32  | 6     |
| 1 3/4-11 | 2,309 | 190 | 40     | 32,0 | 51,00 | 32  | 6     |

22 347 ...

EUR  
U0

64,28 006  
59,61 012  
71,84 025  
87,46 037  
120,29 050  
183,59 075  
281,10 100  
394,36 112  
465,88 125  
568,64 137  
620,73 150

22 339 ...

EUR  
U0

60,38 012  
81,19 025  
101,77 037  
140,55 050  
221,14 075  
301,97 100  
426,78 112  
502,25 125  
624,66 137  
696,20 150  
939,50 175

|   |    |    |
|---|----|----|
| P | 12 | 6  |
| M |    |    |
| K | 12 | 16 |
| N | 22 | 22 |
| S |    |    |
| H |    |    |
| O |    |    |

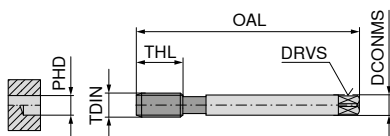
Brzina rezanja  $v_c$  (m/min)

## Strojni uvaljivač navoja za prolazni i slijepi provrt, desni

▲ SN = ureznik s utorima za mazivo

DuoForm

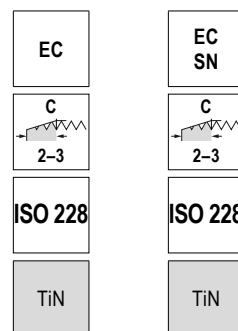
G



DIN 2189 sa zašiljenim drškom

| TDIN   | TP    | OAL | DCONMS | DRVS | PHD   | THL | Utori |
|--------|-------|-----|--------|------|-------|-----|-------|
| mm     | mm    | mm  | mm     | mm   | mm    | mm  |       |
| 1/8-28 | 0,907 | 90  | 7      | 5,5  | 9,25  | 18  |       |
| 1/8-28 | 0,907 | 90  | 7      | 5,5  | 9,25  | 18  | 5     |
| 1/4-19 | 1,337 | 100 | 11     | 9,0  | 12,55 | 22  |       |
| 1/4-19 | 1,337 | 100 | 11     | 9,0  | 12,55 | 22  | 6     |
| 3/8-19 | 1,337 | 100 | 12     | 9,0  | 16,05 | 22  |       |
| 3/8-19 | 1,337 | 100 | 12     | 9,0  | 16,05 | 22  | 6     |
| 1/2-14 | 1,814 | 125 | 16     | 12,0 | 20,10 | 25  |       |
| 1/2-14 | 1,814 | 125 | 16     | 12,0 | 20,10 | 25  | 6     |

|   |    |    |
|---|----|----|
| P | 18 | 18 |
| M | 10 | 10 |
| K | 10 | 10 |
| N | 22 | 22 |
| S |    |    |
| H |    |    |
| O |    |    |

Brzina rezanja  $v_c$  (m/min)

HSS-E  
 $\leq 1100 \text{ N/mm}^2$   
 $\leq 1,5xD$

HSS-E  
 $\leq 1100 \text{ N/mm}^2$   
 $\leq 3xD$

22 360 ...

EUR  
U0

116,46

012

149,73

025

201,70

037

269,31

050

22 359 ...

EUR  
U0

131,38

012

165,23

025

226,39

037

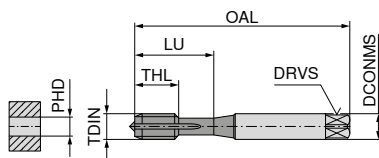
303,16

050

## Strojni ureznik za prolazni provrt, desni

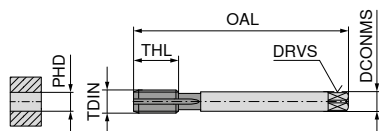
TruTap

UNC



DIN 371 s ojačanim drškom

| TDIN      | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|-----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| Nr. 2-56  | 0,454    | 45        | 2,8          | 2,1        | 1,85      | 7         | 12       | 2     |
| Nr. 4-40  | 0,635    | 56        | 3,5          | 2,7        | 2,35      | 11        | 18       | 2     |
| Nr. 4-40  | 0,635    | 56        | 3,5          | 2,7        | 2,35      | 11        | 18       | 3     |
| Nr. 6-32  | 0,794    | 56        | 4,0          | 3,0        | 2,85      | 12        | 20       | 3     |
| Nr. 8-32  | 0,794    | 63        | 4,5          | 3,4        | 3,50      | 13        | 21       | 3     |
| Nr. 10-24 | 1,058    | 70        | 6,0          | 4,9        | 3,90      | 15        | 25       | 3     |
| Nr. 12-24 | 1,058    | 80        | 6,0          | 4,9        | 4,50      | 16        | 30       | 3     |
| 1/4-20    | 1,270    | 80        | 7,0          | 5,5        | 5,10      | 17        | 30       | 3     |
| 5/16-18   | 1,411    | 90        | 8,0          | 6,2        | 6,60      | 20        | 35       | 3     |
| 3/8-16    | 1,588    | 100       | 10,0         | 8,0        | 8,00      | 22        | 39       | 3     |



DIN 376 sa zašiljenim drškom

| TDIN   | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori |
|--------|----------|-----------|--------------|------------|-----------|-----------|-------|
| 1/2-13 | 1,954    | 110       | 9            | 7,0        | 10,80     | 25        | 3     |
| 5/8-11 | 2,309    | 110       | 12           | 9,0        | 13,50     | 27        | 3     |
| 3/4-10 | 2,540    | 125       | 14           | 11,0       | 16,50     | 30        | 3     |
| 7/8-9  | 2,822    | 140       | 18           | 14,5       | 19,50     | 32        | 3     |
| 1-8    | 3,175    | 160       | 18           | 14,5       | 22,25     | 36        | 3     |

|   |    |   |    |
|---|----|---|----|
| P | 8  | 7 | 12 |
| M | 6  | 7 | 7  |
| K |    |   | 12 |
| N | 22 |   |    |
| S |    | 5 |    |
| H |    |   |    |
| O |    |   |    |

Brzina rezanja  $v_c$  (m/min)

| VA                                      | Ti                                    | UNI                                      |
|-----------------------------------------|---------------------------------------|------------------------------------------|
| B<br>4-5                                | B<br>4-5                              | B<br>4-5                                 |
| 2B                                      | 2BX                                   | 2B                                       |
| nitr.                                   | TiN                                   | nitr. + vap.                             |
|                                         |                                       |                                          |
| HSS-E<br>FHA 0°<br>≤ 900 N/mm²<br>≤ 4xD | HSS-PM<br>FHA 0°<br>≤ 44 HRC<br>≤ 4xD | HSS-E<br>FHA 0°<br>≤ 1100 N/mm²<br>≤ 4xD |

22 250 ...

EUR  
U0

22 269 ...

EUR  
U0

22 572 ...

EUR  
U0

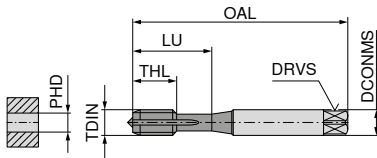
|       |     |
|-------|-----|
| 94,88 | 002 |
| 52,17 | 004 |
| 83,54 | 004 |
| 73,52 | 006 |
| 75,07 | 008 |
| 75,87 | 010 |
| 46,59 | 006 |
| 44,12 | 008 |
| 49,71 | 010 |
| 59,61 | 012 |
| 53,74 | 025 |
| 61,81 | 031 |
| 68,70 | 037 |

|       |     |
|-------|-----|
| 44,50 | 006 |
| 43,72 | 008 |
| 43,72 | 010 |
| 55,56 | 025 |
| 56,10 | 031 |
| 56,87 | 037 |

|        |     |
|--------|-----|
| 83,54  | 004 |
| 73,52  | 006 |
| 75,07  | 008 |
| 75,87  | 010 |
| 80,29  | 025 |
| 89,14  | 031 |
| 104,10 | 037 |

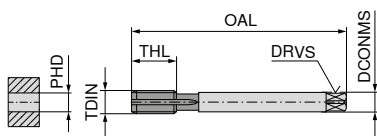
## Strojni ureznik za prolazni provrt, desni

UNC



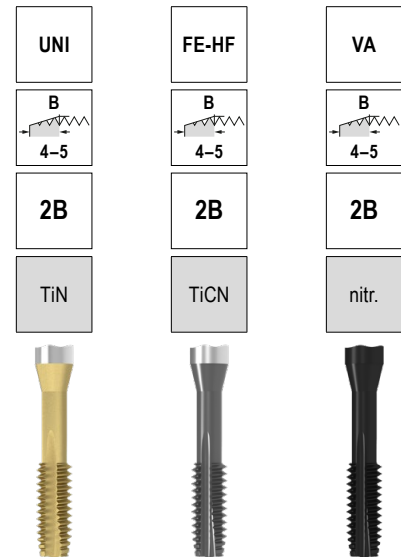
DIN 371 s ojačanim drškom

| TDIN      | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|-----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| Nr. 4-40  | 0,635    | 56        | 3,5          | 2,7        | 2,30      | 11        | 18       | 2     |
| Nr. 6-32  | 0,794    | 56        | 4,0          | 3,0        | 2,85      | 12        | 20       | 3     |
| Nr. 8-32  | 0,794    | 63        | 4,5          | 3,4        | 3,50      | 13        | 21       | 3     |
| Nr. 10-24 | 1,058    | 70        | 6,0          | 4,9        | 3,90      | 15        | 25       | 3     |
| 1/4-20    | 1,270    | 80        | 7,0          | 5,5        | 5,20      | 17        | 30       | 3     |
| 5/16-18   | 1,411    | 90        | 8,0          | 6,2        | 6,60      | 20        | 35       | 3     |
| 3/8-16    | 1,588    | 100       | 10,0         | 8,0        | 8,00      | 22        | 39       | 3     |



DIN 376 sa zašiljenim drškom

| TDIN    | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori |
|---------|----------|-----------|--------------|------------|-----------|-----------|-------|
| 7/16-14 | 1,814    | 100       | 8            | 6,2        | 9,40      | 22        | 3     |
| 1/2-13  | 1,954    | 110       | 9            | 7,0        | 10,75     | 25        | 3     |
| 5/8-11  | 2,309    | 110       | 12           | 9,0        | 13,50     | 27        | 3     |
| 3/4-10  | 2,540    | 125       | 14           | 11,0       | 16,50     | 30        | 3     |

HSS-E  
FHA 0°  
≤ 1000 N/mm²  
≤ 3xDHSS-E  
FHA 0°  
≤ 1100 N/mm²  
≤ 3xDHSS-E  
FHA 0°  
≤ 1000 N/mm²  
≤ 3xD

23 170 ...

EUR  
T9

23,07 004  
22,19 006  
22,19 008  
23,07 010  
30,34 025  
33,16 031  
39,46 037

23 370 ...

EUR  
T9

32,68 004  
31,69 006  
31,69 008  
32,93 010  
45,74 025  
49,82 031  
58,82 037

23 470 ...

EUR  
T9

19,11 004  
17,75 006  
17,26 008  
19,11 010  
20,47 025  
23,30 031  
26,38 037

23 171 ...

EUR  
T9

45,87 043  
51,30 050  
63,99 062  
96,91 075

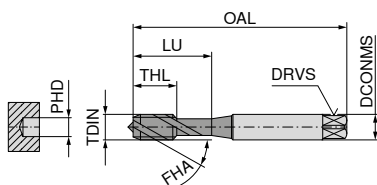
|   |    |    |    |
|---|----|----|----|
| P | 15 | 15 | 8  |
| M | 9  |    | 6  |
| K | 18 | 15 |    |
| N | 12 | 15 | 22 |
| S |    |    |    |
| H |    |    |    |
| O |    |    |    |

Brzina rezanja v<sub>c</sub> (m/min)

## Strojni ureznik za prolazni provrt, desni

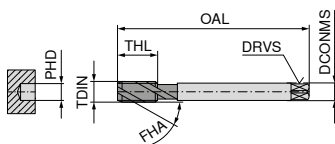
CavTap

UNC



DIN 371 s ojačanim drškom

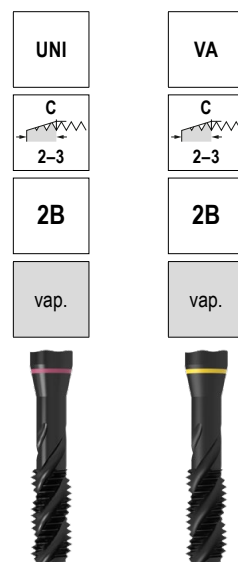
| TDIN      | TP    | OAL | DCONMS | DRVS | PHD  | THL  | LU | Utori |
|-----------|-------|-----|--------|------|------|------|----|-------|
| mm        | mm    | mm  | mm     | mm   | mm   | mm   | mm |       |
| Nr. 2-56  | 0,454 | 45  | 2,8    | 2,1  | 1,85 | 4,5  | 12 | 2     |
| Nr. 4-40  | 0,635 | 56  | 3,5    | 2,7  | 2,35 | 6,0  | 18 | 2     |
| Nr. 6-32  | 0,794 | 56  | 4,0    | 3,0  | 2,85 | 7,0  | 20 | 3     |
| Nr. 8-32  | 0,794 | 63  | 4,5    | 3,4  | 3,50 | 8,0  | 21 | 3     |
| Nr. 10-24 | 1,058 | 70  | 6,0    | 4,9  | 3,90 | 10,0 | 25 | 3     |
| 1/4-20    | 1,270 | 80  | 7,0    | 5,5  | 5,10 | 13,0 | 30 | 3     |
| 5/16-18   | 1,411 | 90  | 8,0    | 6,2  | 6,60 | 14,0 | 35 | 3     |
| 3/8-16    | 1,588 | 100 | 10,0   | 8,0  | 8,00 | 16,0 | 39 | 3     |



DIN 376 sa sašiljenim drškom

| TDIN    | TP    | OAL | DCONMS | DRVS | PHD   | THL | Utori |
|---------|-------|-----|--------|------|-------|-----|-------|
| mm      | mm    | mm  | mm     | mm   | mm    | mm  |       |
| 7/16-14 | 1,814 | 100 | 8      | 6,2  | 9,40  | 18  | 3     |
| 7/16-14 | 1,814 | 100 | 8      | 6,2  | 9,40  | 18  | 4     |
| 1/2-13  | 1,954 | 110 | 9      | 7,0  | 10,80 | 20  | 3     |
| 1/2-13  | 1,954 | 110 | 9      | 7,0  | 10,80 | 20  | 4     |
| 9/16-12 | 2,117 | 110 | 11     | 9,0  | 12,25 | 20  | 3     |
| 5/8-11  | 2,309 | 110 | 12     | 9,0  | 13,50 | 22  | 3     |
| 5/8-11  | 2,309 | 110 | 12     | 9,0  | 13,50 | 22  | 4     |
| 3/4-10  | 2,540 | 125 | 14     | 11,0 | 16,50 | 25  | 3     |
| 3/4-10  | 2,540 | 125 | 14     | 11,0 | 16,50 | 25  | 4     |
| 7/8-9   | 2,822 | 140 | 18     | 14,5 | 19,50 | 27  | 4     |
| 1-8     | 3,175 | 160 | 18     | 14,5 | 22,25 | 30  | 4     |
| 1-8     | 3,175 | 160 | 18     | 14,5 | 22,25 | 30  | 5     |

|   |    |    |
|---|----|----|
| P | 12 | 8  |
| M | 7  | 6  |
| K | 12 |    |
| N |    | 22 |
| S |    |    |
| H |    |    |
| O |    |    |

Brzina rezanja  $v_c$  (m/min)HSS-E  
FHA 42°  
≤ 1100 N/mm²  
≤ 3xDHSS-E  
FHA 42°  
≤ 900 N/mm²  
≤ 3xD

22 582 ...

EUR

U0

75,87

002

47,36

004

41,52

006

44,50

008

46,59

010

50,09

025

53,35

031

59,85

037

22 266 ...

EUR

U0

45,40

006

48,55

008

51,66

010

52,82

025

59,85

031

62,07

037

22 583 ...

EUR

U0

81,99

043

81,99

050

116,33

056

108,00

062

139,24

075

166,53

087

226,39

100

22 267 ...

EUR

U0

104,10

043

91,50

050

117,77

062

144,37

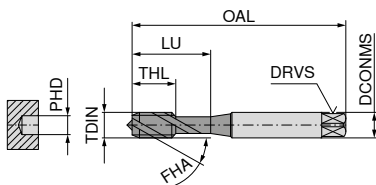
075

242,01

100

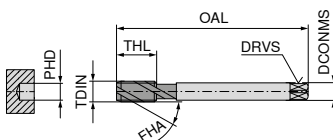
## Strojni ureznik za prolazni provrt, desni

UNC



DIN 371 s ojačanim drškom

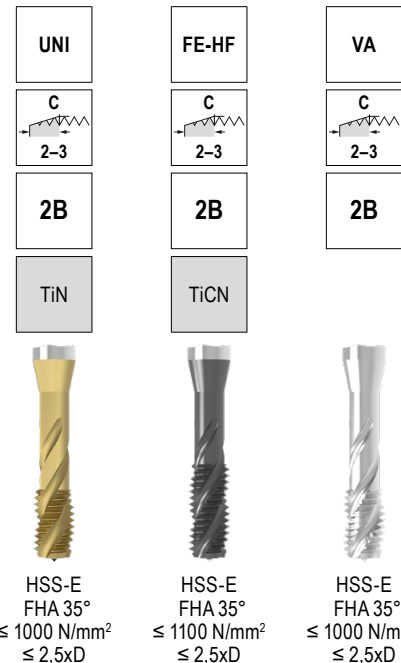
| TDIN      | TP    | OAL | DCONMS | DRVS | PHD  | THL | LU | Utori |
|-----------|-------|-----|--------|------|------|-----|----|-------|
| mm        | mm    | mm  | mm     | mm   | mm   | mm  | mm |       |
| Nr. 4-40  | 0,635 | 56  | 3,5    | 2,7  | 2,30 | 6   | 18 | 2     |
| Nr. 4-40  | 0,635 | 56  | 3,5    | 2,7  | 2,30 | 11  | 18 | 2     |
| Nr. 6-32  | 0,794 | 56  | 4,0    | 3,0  | 2,85 | 7   | 20 | 3     |
| Nr. 6-32  | 0,794 | 56  | 4,0    | 3,0  | 2,85 | 12  | 20 | 3     |
| Nr. 8-32  | 0,794 | 63  | 4,5    | 3,4  | 3,50 | 8   | 21 | 3     |
| Nr. 8-32  | 0,794 | 63  | 4,5    | 3,4  | 3,50 | 13  | 21 | 3     |
| Nr. 10-24 | 1,058 | 70  | 6,0    | 4,9  | 3,90 | 10  | 25 | 3     |
| Nr. 10-24 | 1,058 | 70  | 6,0    | 4,9  | 3,90 | 15  | 25 | 3     |
| 1/4-20    | 1,270 | 80  | 7,0    | 5,5  | 5,20 | 13  | 30 | 3     |
| 1/4-20    | 1,270 | 80  | 7,0    | 5,5  | 5,20 | 17  | 30 | 3     |
| 5/16-18   | 1,411 | 90  | 8,0    | 6,2  | 6,60 | 14  | 35 | 3     |
| 5/16-18   | 1,411 | 90  | 8,0    | 6,2  | 6,60 | 20  | 35 | 3     |
| 3/8-16    | 1,588 | 100 | 10,0   | 8,0  | 8,00 | 16  | 39 | 3     |
| 3/8-16    | 1,588 | 100 | 10,0   | 8,0  | 8,00 | 22  | 39 | 3     |



DIN 376 sa zašiljenim drškom

| TDIN    | TP    | OAL | DCONMS | DRVS | PHD   | THL | Utori |
|---------|-------|-----|--------|------|-------|-----|-------|
| mm      | mm    | mm  | mm     | mm   | mm    | mm  |       |
| 7/16-14 | 1,814 | 100 | 8      | 6,2  | 9,40  | 18  | 3     |
| 1/2-13  | 1,954 | 110 | 9      | 7,0  | 10,75 | 20  | 3     |
| 5/8-11  | 2,309 | 110 | 12     | 9,0  | 13,50 | 22  | 3     |
| 3/4-10  | 2,540 | 125 | 14     | 11,0 | 16,50 | 25  | 3     |

|   |    |    |    |
|---|----|----|----|
| P | 15 | 15 | 8  |
| M | 9  |    | 6  |
| K | 18 | 15 |    |
| N | 12 | 24 | 22 |
| S |    |    |    |
| H |    |    |    |
| O |    |    |    |

Brzina rezanja  $v_c$  (m/min)

23 172 ...

EUR

T9

24,90

004

23 372 ...

EUR

T9

26,13

004

23 472 ...

EUR

T9

31,57

004

22,93 006

24,78 006

29,60 006

24,66 008

26,26 008

30,70 008

25,53 010

27,13 010

31,94 010

32,93 025

36,61 025

35,87 025

32,93 031

38,10 031

37,85 031

40,32 037

45,37 037

42,28 037

51,05 043

53,88 050

66,33 062

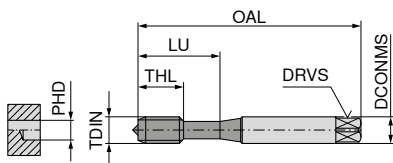
100,37 075

## Strojni uvaljivač navoja za prolazni i slijepi provrt, desni

▲ SN = ureznik s utorima za mazivo

DuoForm

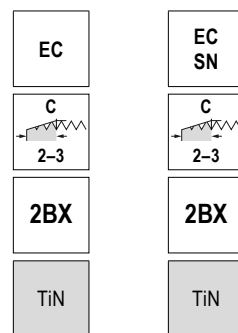
UNC



DIN 2174 s ojačanim drškom

| TDIN      | TP    | OAL | DCONMS | DRVS | PHD  | THL | LU | Utori |
|-----------|-------|-----|--------|------|------|-----|----|-------|
| Nr. 4-40  | 0,635 | 56  | 3,5    | 2,7  | 2,55 | 11  | 18 |       |
| Nr. 4-40  | 0,635 | 56  | 3,5    | 2,7  | 2,55 | 11  | 18 | 3     |
| Nr. 6-32  | 0,794 | 56  | 4,0    | 3,0  | 3,15 | 12  | 20 |       |
| Nr. 6-32  | 0,794 | 56  | 4,0    | 3,0  | 3,15 | 12  | 20 | 3     |
| Nr. 8-32  | 0,794 | 63  | 4,5    | 3,4  | 3,80 | 13  | 21 |       |
| Nr. 8-32  | 0,794 | 63  | 4,5    | 3,4  | 3,80 | 13  | 21 | 4     |
| Nr. 10-24 | 1,058 | 70  | 6,0    | 4,9  | 4,35 | 15  | 25 |       |
| Nr. 10-24 | 1,058 | 70  | 6,0    | 4,9  | 4,35 | 15  | 25 | 4     |
| 1/4-20    | 1,270 | 80  | 7,0    | 5,5  | 5,75 | 17  | 30 |       |
| 1/4-20    | 1,270 | 80  | 7,0    | 5,5  | 5,75 | 17  | 30 | 4     |
| 5/16-18   | 1,411 | 90  | 8,0    | 6,2  | 7,30 | 20  | 35 |       |
| 5/16-18   | 1,411 | 90  | 8,0    | 6,2  | 7,30 | 20  | 35 | 5     |
| 3/8-16    | 1,588 | 100 | 10,0   | 8,0  | 8,80 | 22  | 39 |       |
| 3/8-16    | 1,588 | 100 | 10,0   | 8,0  | 8,80 | 22  | 39 | 5     |

|   |    |    |
|---|----|----|
| P | 18 | 18 |
| M | 10 | 10 |
| K | 10 | 10 |
| N | 22 | 22 |
| S |    |    |
| H |    |    |
| O |    |    |

HSS-E  
≤ 1100 N/mm<sup>2</sup>  
≤ 1,5xDHSS-E  
≤ 1100 N/mm<sup>2</sup>  
≤ 3xD

22 270 ...

22 271 ...

EUR  
U0EUR  
U0

66,89

004

77,30

004

62,32

006

71,84

006

62,59

008

71,84

008

69,74

010

78,98

010

81,07

025

91,50

025

87,46

031

99,03

031

104,88

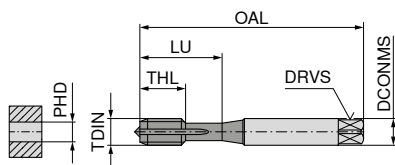
037

115,28

037

Brzina rezanja v<sub>c</sub> (m/min)

## Strojni ureznik za prolazni provrt, za žičane umetke, desni



DIN 371 s ojačanim drškom

UNI

2B  
modnitr. +  
vap.HSS-E  
FHA 0°  
≤ 1100 N/mm<sup>2</sup>  
≤ 4xD

22 668 ...

| TDIN         | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|--------------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| EG Nr. 4-40  | 0,635    | 63        | 4,5          | 3,4        | 3,1       | 13        | 21       | 3     |
| EG Nr. 6-32  | 0,794    | 70        | 6,0          | 4,9        | 3,8       | 14        | 25       | 3     |
| EG Nr. 8-32  | 0,794    | 80        | 6,0          | 4,9        | 4,4       | 16        | 30       | 3     |
| EG Nr. 10-24 | 1,058    | 80        | 7,0          | 5,5        | 5,2       | 17        | 30       | 3     |

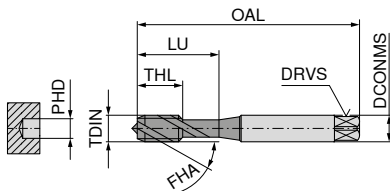
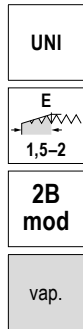
EUR  
U0

|       |     |
|-------|-----|
| 68,70 | 004 |
| 71,18 | 006 |
| 68,33 | 008 |
| 74,30 | 010 |

|   |    |
|---|----|
| P | 12 |
| M | 7  |
| K | 12 |
| N |    |
| S |    |
| H |    |
| O |    |

Brzina rezanja v<sub>c</sub> (m/min)

## Strojni ureznik za slijepi provrt, za žičane umetke, desni



DIN 371 s ojačanim drškom

HSS-E  
FHA 42°  
≤ 1100 N/mm<sup>2</sup>  
≤ 3xD

22 672 ...

| TDIN         | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|--------------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| EG Nr. 4-40  | 0,635    | 63        | 4,5          | 3,4        | 3,1       | 7         | 21       | 3     |
| EG Nr. 6-32  | 0,794    | 70        | 6,0          | 4,9        | 3,8       | 8         | 25       | 3     |
| EG Nr. 8-32  | 0,794    | 80        | 6,0          | 4,9        | 4,4       | 8         | 30       | 3     |
| EG Nr. 10-24 | 1,058    | 80        | 7,0          | 5,5        | 5,2       | 10        | 30       | 3     |

EUR  
U0

|       |     |
|-------|-----|
| 69,61 | 004 |
| 65,18 | 006 |
| 69,22 | 008 |
| 72,74 | 010 |

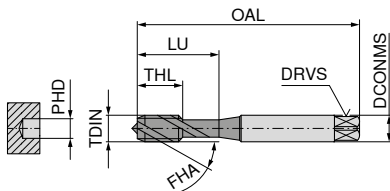
|   |    |
|---|----|
| P | 12 |
| M | 7  |
| K | 12 |
| N |    |
| S |    |
| H |    |
| O |    |

Brzina rezanja v<sub>c</sub> (m/min)

## Strojni ureznik za prolazni provrt, desni

CavTap  
SL

UNJC



DIN 371 s ojačanim drškom

Ti

C

2-3

3BX

TiCN

HSS-E  
FHA 15°  
≤ 1200 N/mm²  
≤ 2xD

22 166 ...

EUR  
U0

| TDIN      | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|-----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| Nr. 4-40  | 0,635    | 56        | 3,5          | 2,7        | 2,30      | 11        | 18       | 2     |
| Nr. 6-32  | 0,794    | 56        | 4,0          | 3,0        | 2,85      | 12        | 20       | 3     |
| Nr. 8-32  | 0,794    | 63        | 4,5          | 3,4        | 3,50      | 13        | 21       | 3     |
| Nr. 10-24 | 1,058    | 70        | 6,0          | 4,9        | 3,90      | 15        | 25       | 3     |
| 1/4-20    | 1,270    | 80        | 7,0          | 5,5        | 5,25      | 17        | 30       | 3     |
| 3/8-16    | 1,588    | 100       | 10,0         | 8,0        | 8,10      | 22        | 39       | 3     |

|        |     |
|--------|-----|
| 91,50  | 004 |
| 93,42  | 006 |
| 92,14  | 008 |
| 96,95  | 010 |
| 124,34 | 025 |
| 150,92 | 037 |

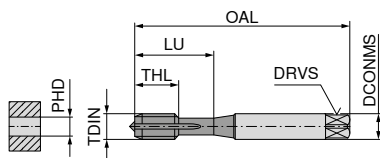
|   |    |
|---|----|
| P | 7  |
| M | 7  |
| K |    |
| N | 22 |
| S | 5  |
| H |    |
| O |    |

Brzina rezanja v<sub>c</sub> (m/min)

## Strojni ureznik za prolazni provrt, desni

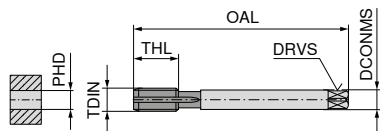
TruTap

UNF



DIN 371 s ojačanim drškom

| TDIN      | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|-----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| Nr. 4-48  | 0,529    | 56        | 3,5          | 2,7        | 2,40      | 11        | 18       | 2     |
| Nr. 6-40  | 0,635    | 56        | 4,0          | 3,0        | 2,95      | 12        | 20       | 3     |
| Nr. 8-36  | 0,706    | 63        | 4,5          | 3,4        | 3,50      | 13        | 21       | 3     |
| Nr. 10-32 | 0,794    | 70        | 6,0          | 4,9        | 4,10      | 15        | 25       | 3     |
| 1/4-28    | 0,907    | 80        | 7,0          | 5,5        | 5,50      | 17        | 30       | 3     |
| 5/16-24   | 1,058    | 90        | 8,0          | 6,2        | 6,90      | 17        | 35       | 3     |



DIN 374 sa zašiljenim drškom

| TDIN     | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori |
|----------|----------|-----------|--------------|------------|-----------|-----------|-------|
| 7/16-20  | 1,270    | 100       | 8            | 6,2        | 9,90      | 22        | 3     |
| 1/2-20   | 1,270    | 100       | 9            | 7,0        | 11,50     | 22        | 3     |
| 9/16-18  | 1,411    | 100       | 11           | 9,0        | 12,90     | 22        | 3     |
| 5/8-18   | 1,411    | 100       | 12           | 9,0        | 14,50     | 22        | 3     |
| 3/4-16   | 1,588    | 110       | 14           | 11,0       | 17,50     | 25        | 4     |
| 7/8-14   | 1,814    | 125       | 18           | 14,5       | 20,50     | 25        | 4     |
| 1-12     | 2,117    | 140       | 18           | 14,5       | 23,25     | 28        | 4     |
| 1 1/8-12 | 2,117    | 150       | 22           | 18,0       | 26,50     | 28        | 4     |
| 1 1/4-12 | 2,117    | 150       | 22           | 18,0       | 29,75     | 28        | 4     |
| 1 3/8-12 | 2,117    | 170       | 28           | 22,0       | 33,00     | 30        | 5     |

|   |    |
|---|----|
| P | 12 |
| M | 7  |
| K | 12 |
| N |    |
| S |    |
| H |    |
| O |    |

Brzina rezanja  $v_c$  (m/min)

UNI

B  
4-5

2B

nitr. +  
vap.HSS-E  
FHA 0°  
≤ 1100 N/mm²  
≤ 4xD

22 602 ...

EUR  
U0

|       |     |
|-------|-----|
| 63,63 | 004 |
| 56,47 | 006 |
| 56,47 | 008 |
| 58,16 | 010 |
| 63,89 | 025 |
| 72,09 | 031 |

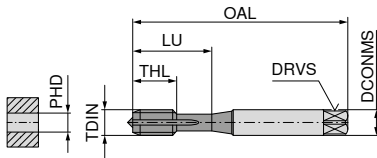
22 603 ...

EUR  
U0

|        |     |
|--------|-----|
| 86,02  | 043 |
| 81,99  | 050 |
| 126,37 | 056 |
| 115,28 | 062 |
| 145,79 | 075 |
| 190,02 | 087 |
| 245,93 | 100 |
| 646,72 | 112 |
| 709,19 | 125 |
| 746,98 | 137 |

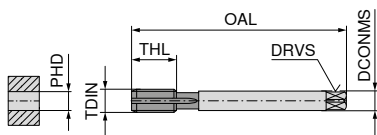
## Strojni ureznik za prolazni provrt, desni

UNF



DIN 371 s ojačanim drškom

| TDIN      | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|-----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| Nr. 10-32 | 0,794    | 70        | 6            | 4,9        | 4,1       | 15        | 25       | 3     |
| 1/4-28    | 0,907    | 80        | 7            | 5,5        | 5,5       | 17        | 30       | 3     |
| 5/16-24   | 1,058    | 90        | 8            | 6,2        | 6,9       | 17        | 35       | 3     |
| 3/8-24    | 1,058    | 90        | 10           | 8,0        | 8,5       | 18        | 35       | 4     |



DIN 374 sa zašiljenim drškom

| TDIN    | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori |
|---------|----------|-----------|--------------|------------|-----------|-----------|-------|
| 7/16-20 | 1,270    | 100       | 8            | 6,2        | 9,9       | 22        | 3     |
| 1/2-20  | 1,270    | 100       | 9            | 7,0        | 11,5      | 22        | 3     |
| 9/16-18 | 1,411    | 100       | 11           | 9,0        | 12,9      | 22        | 3     |
| 5/8-18  | 1,411    | 100       | 12           | 9,0        | 14,5      | 22        | 3     |
| 3/4-16  | 1,588    | 110       | 14           | 11,0       | 17,5      | 25        | 4     |

|   |    |
|---|----|
| P | 15 |
| M | 9  |
| K | 18 |
| N | 12 |
| S |    |
| H |    |
| O |    |

Brzina rezanja  $v_c$  (m/min)

UNI



2B

TiN

HSS-E  
FHA 0°  
≤ 1100 N/mm²  
≤ 3xD

23 180 ...

EUR

T9

26,63 010

34,03 025

37,85 031

41,31 037

23 181 ...

EUR

T9

49,70 043

51,30 050

69,80 056

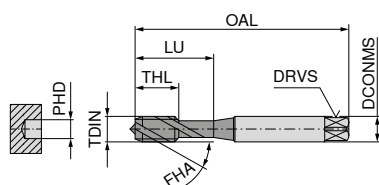
64,62 062

98,03 075

## Strojni ureznik za prolazni provrt, desni

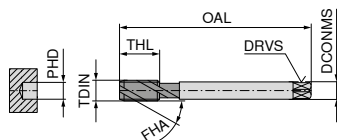
CavTap

UNF



DIN 371 s ojačanim drškom

| TDIN      | TP    | OAL | DCONMS | DRVS | PHD  | THL  | LU | Utori |
|-----------|-------|-----|--------|------|------|------|----|-------|
| mm        | mm    | mm  | mm     | mm   | mm   | mm   | mm |       |
| Nr. 2-64  | 0,397 | 45  | 2,8    | 2,1  | 1,85 | 4,5  | 12 | 2     |
| Nr. 4-48  | 0,529 | 56  | 3,5    | 2,7  | 2,40 | 6,0  | 18 | 2     |
| Nr. 6-40  | 0,635 | 56  | 4,0    | 3,0  | 2,95 | 7,0  | 20 | 3     |
| Nr. 6-40  | 0,635 | 56  | 4,0    | 3,0  | 3,00 | 7,0  | 20 | 3     |
| Nr. 8-36  | 0,706 | 63  | 4,5    | 3,4  | 3,50 | 8,0  | 21 | 3     |
| Nr. 10-32 | 0,794 | 70  | 6,0    | 4,9  | 4,10 | 10,0 | 25 | 3     |
| Nr. 10-32 | 0,794 | 70  | 6,0    | 4,9  | 4,15 | 10,0 | 25 | 3     |
| 1/4-28    | 0,907 | 80  | 7,0    | 5,5  | 5,50 | 10,0 | 30 | 3     |
| 1/4-28    | 0,907 | 80  | 7,0    | 5,5  | 5,55 | 10,0 | 30 | 3     |
| 5/16-24   | 1,058 | 90  | 8,0    | 6,2  | 6,90 | 10,0 | 35 | 3     |
| 5/16-24   | 1,058 | 90  | 8,0    | 6,2  | 6,95 | 10,0 | 35 | 3     |
| 3/8-24    | 1,058 | 90  | 10,0   | 8,0  | 8,50 | 10,0 | 35 | 3     |
| 3/8-24    | 1,058 | 90  | 10,0   | 8,0  | 8,55 | 10,0 | 35 | 3     |



DIN 374 sa zašiljenim drškom

| TDIN     | TP    | OAL | DCONMS | DRVS | PHD   | THL | Utori |
|----------|-------|-----|--------|------|-------|-----|-------|
| mm       | mm    | mm  | mm     | mm   | mm    | mm  |       |
| 7/16-20  | 1,270 | 100 | 8      | 6,2  | 9,90  | 13  | 3     |
| 7/16-20  | 1,270 | 100 | 8      | 6,2  | 9,95  | 13  | 4     |
| 1/2-20   | 1,270 | 100 | 9      | 7,0  | 11,50 | 13  | 4     |
| 1/2-20   | 1,270 | 100 | 9      | 7,0  | 11,55 | 13  | 5     |
| 9/16-18  | 1,411 | 100 | 11     | 9,0  | 12,90 | 15  | 4     |
| 9/16-18  | 1,411 | 100 | 11     | 9,0  | 12,95 | 15  | 5     |
| 5/8-18   | 1,411 | 100 | 12     | 9,0  | 14,50 | 15  | 4     |
| 5/8-18   | 1,411 | 100 | 12     | 9,0  | 14,55 | 15  | 5     |
| 3/4-16   | 1,588 | 110 | 14     | 11,0 | 17,50 | 17  | 4     |
| 3/4-16   | 1,588 | 110 | 14     | 11,0 | 17,55 | 17  | 5     |
| 7/8-14   | 1,814 | 125 | 18     | 14,5 | 20,50 | 17  | 4     |
| 1-12     | 2,117 | 140 | 18     | 14,5 | 23,25 | 20  | 4     |
| 1-12     | 2,117 | 140 | 18     | 14,5 | 23,30 | 20  | 5     |
| 1 1/8-12 | 2,117 | 150 | 22     | 18,0 | 26,50 | 22  | 4     |
| 1 1/4-12 | 2,117 | 150 | 22     | 18,0 | 29,75 | 22  | 5     |
| 1 3/8-12 | 2,117 | 170 | 28     | 22,0 | 33,00 | 24  | 5     |

|   |    |    |    |
|---|----|----|----|
| P | 8  | 12 | 12 |
| M | 6  | 7  | 7  |
| K |    | 12 | 12 |
| N | 22 |    | 22 |
| S |    |    |    |
| H |    |    |    |
| O |    |    |    |

Brzina rezanja v<sub>c</sub> (m/min)

22 308 ...

EUR  
U078,08 002  
58,82 004  
56,47 00656,47 008  
60,38 01062,07 025  
69,22 031

72,48 037

22 606 ...

EUR  
U056,47 004  
50,09 00650,09 008  
52,82 01057,78 025  
65,18 031

22 307 ...

EUR  
U0

78,98 006

83,54 010

87,46 025  
99,53 031

99,53 037

22 607 ...

EUR  
U081,99 043  
81,99 050123,26 056  
108,00 062148,42 075  
179,53 087255,00 100  
347,50 112396,85 125  
482,81 137

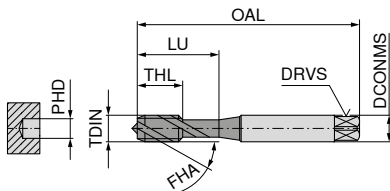
22 409 ...

EUR  
U0125,76 043  
121,00 050171,78 056  
156,17 062210,88 075  
330,57 100

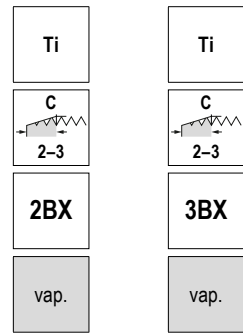
## Strojni ureznik za prolazni provrt, desni

CavTap  
SL

UNF



DIN 371 s ojačanim drškom

HSS-PM  
FHA 30°  
≤ 1400 N/mm²  
≤ 1,5xDHSS-PM  
FHA 30°  
≤ 1400 N/mm²  
≤ 1,5xD

| TDIN      | TP    | OAL | DCONMS | DRVS | PHD | THL | LU | Utori |
|-----------|-------|-----|--------|------|-----|-----|----|-------|
| mm        | mm    | mm  | mm     | mm   | mm  | mm  | mm |       |
| Nr. 10-32 | 0,794 | 70  | 6      | 4,9  | 4,1 | 10  | 25 | 3     |
| 1/4-28    | 0,907 | 80  | 7      | 5,5  | 5,5 | 10  | 30 | 3     |
| 5/16-24   | 1,058 | 90  | 8      | 6,2  | 6,9 | 10  | 35 | 3     |
| 3/8-24    | 1,058 | 90  | 10     | 8,0  | 8,5 | 10  | 35 | 3     |

22 302 ...

EUR  
U0

|        |     |
|--------|-----|
| 109,81 | 010 |
| 119,33 | 025 |
| 141,87 | 031 |
| 140,55 | 037 |

22 303 ...

EUR  
U0

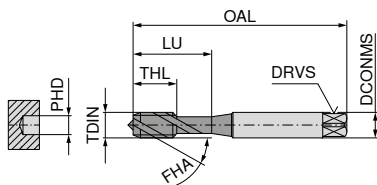
|        |     |
|--------|-----|
| 109,81 | 010 |
| 119,33 | 025 |
| 128,99 | 031 |
| 140,55 | 037 |

|   |    |    |
|---|----|----|
| P | 5  | 5  |
| M | 5  | 5  |
| K |    |    |
| N | 22 | 22 |
| S | 3  | 3  |
| H |    |    |
| O |    |    |

Brzina rezanja v<sub>c</sub> (m/min)

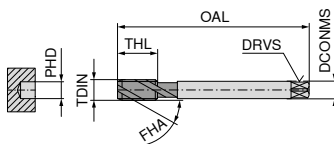
## Strojni ureznik za prolazni provrt, desni

UNF



DIN 371 s ojačanim drškom

| TDIN      | TP    | OAL | DCONMS | DRVS | PHD | THL | LU | Utori |
|-----------|-------|-----|--------|------|-----|-----|----|-------|
| mm        | mm    | mm  | mm     | mm   | mm  | mm  | mm |       |
| Nr. 10-32 | 0,794 | 70  | 6      | 4,9  | 4,1 | 10  | 25 | 3     |
| 1/4-28    | 0,907 | 80  | 7      | 5,5  | 5,5 | 10  | 30 | 3     |
| 5/16-24   | 1,058 | 90  | 8      | 6,2  | 6,9 | 10  | 35 | 3     |
| 3/8-24    | 1,058 | 90  | 10     | 8,0  | 8,5 | 10  | 35 | 3     |



DIN 374 sa zašiljenim drškom

| TDIN    | TP    | OAL | DCONMS | DRVS | PHD  | THL | Utori |
|---------|-------|-----|--------|------|------|-----|-------|
| mm      | mm    | mm  | mm     | mm   | mm   | mm  |       |
| 7/16-20 | 1,270 | 100 | 8      | 6,2  | 9,9  | 13  | 3     |
| 1/2-20  | 1,270 | 100 | 9      | 7,0  | 11,5 | 13  | 4     |
| 9/16-18 | 1,411 | 100 | 11     | 9,0  | 12,9 | 15  | 4     |
| 5/8-18  | 1,411 | 100 | 12     | 9,0  | 14,5 | 15  | 4     |
| 3/4-16  | 1,588 | 110 | 14     | 11,0 | 17,5 | 17  | 4     |

|   |    |    |
|---|----|----|
| P | 15 | 8  |
| M | 9  | 6  |
| K | 18 |    |
| N | 12 | 22 |
| S |    |    |
| H |    |    |
| O |    |    |

Brzina rezanja  $v_c$  (m/min)

UNI



2B

TiN

HSS-E  
FHA 35°  
≤ 1100 N/mm²  
≤ 2,5xD

| 23 182 ... |     |
|------------|-----|
| EUR        |     |
| T9         |     |
| 28,12      | 010 |
| 36,00      | 025 |
| 38,10      | 031 |
| 42,42      | 037 |

VA



2B

TiN

HSS-E  
FHA 35°  
≤ 1100 N/mm²  
≤ 2,5xD

| 23 482 ... |     |
|------------|-----|
| EUR        |     |
| T9         |     |
| 37,47      | 010 |
| 40,93      | 025 |
| 43,40      | 031 |
| 47,09      | 037 |

| 23 183 ... |     |
|------------|-----|
| EUR        |     |
| T9         |     |
| 51,05      | 043 |
| 53,88      | 050 |
| 72,74      | 056 |
| 65,84      | 062 |
| 104,43     | 075 |

| 23 483 ... |     |
|------------|-----|
| EUR        |     |
| T9         |     |
| 58,57      | 043 |
| 59,05      | 050 |
| 82,87      | 056 |
| 72,74      | 062 |
| 98,40      | 075 |

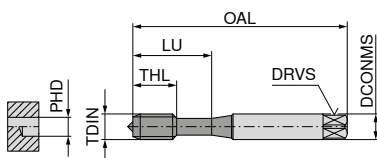
## Strojni uvaljivač navoja za prolazni i slijepi provrt, desni

▲ SN = ureznik s utorima za mazivo

EC  
SNC  
2-3

2BX

TiN



DIN 2174 s ojačanim drškom

HSS-E  
≤ 1100 N/mm<sup>2</sup>  
≤ 3xD

22 312 ...

| TDIN      | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|-----------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| Nr. 4-48  | 0,529    | 56        | 3,5          | 2,7        | 2,62      | 11        | 18       | 3     |
| Nr. 6-40  | 0,635    | 56        | 4,0          | 3,0        | 3,22      | 12        | 20       | 3     |
| Nr. 8-36  | 0,706    | 63        | 4,5          | 3,4        | 3,85      | 13        | 21       | 4     |
| Nr. 10-32 | 0,794    | 70        | 6,0          | 4,9        | 4,45      | 15        | 25       | 4     |
| 1/4-28    | 0,907    | 80        | 7,0          | 5,5        | 5,95      | 17        | 30       | 4     |

EUR

U0

85,87

004

79,76

006

81,84

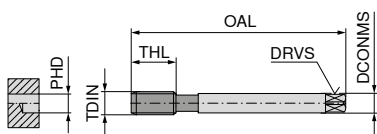
008

88,48

010

103,85

025



DIN 2174 sa zašiljenim drškom

22 313 ...

| TDIN    | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori |
|---------|----------|-----------|--------------|------------|-----------|-----------|-------|
| 7/16-20 | 1,27     | 100       | 8            | 6,2        | 10,55     | 22        | 6     |
| 1/2-20  | 1,27     | 100       | 9            | 7,0        | 12,15     | 22        | 6     |

EUR

U0

154,97

043

158,79

050

|   |    |
|---|----|
| P | 18 |
| M | 10 |
| K | 10 |
| N | 22 |
| S |    |
| H |    |
| O |    |

Brzina rezanja v<sub>c</sub> (m/min)

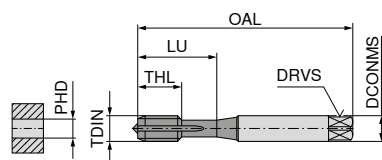
## Strojni ureznik za prolazni provrt, za žičane umetke, desni



UNI

B  
4-5

2B

nitr. +  
vap.HSS-E  
FHA 0°  
≤ 1100 N/mm²  
≤ 4xD

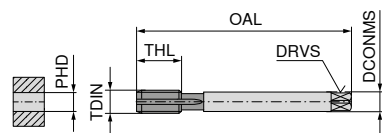
DIN 371 s ojačanim drškom

| TDIN         | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|--------------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| EG Nr. 4-48  | 0,529    | 56        | 4            | 3,0        | 3,0       | 9         | 20       | 3     |
| EG Nr. 6-40  | 0,635    | 70        | 6            | 4,9        | 3,7       | 11        | 25       | 3     |
| EG Nr. 8-36  | 0,706    | 80        | 6            | 4,9        | 4,4       | 13        | 30       | 3     |
| EG Nr. 10-32 | 0,794    | 80        | 6            | 4,9        | 5,1       | 13        | 30       | 3     |
| EG 1/4-28    | 0,907    | 90        | 8            | 6,2        | 6,6       | 17        | 35       | 3     |

22 676 ...

EUR  
U0

|       |     |
|-------|-----|
| 89,14 | 004 |
| 86,02 | 006 |
| 86,02 | 008 |
| 91,50 | 010 |
| 97,73 | 025 |



DIN 374 sa zašiljenim drškom

| TDIN       | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | Utori |
|------------|----------|-----------|--------------|------------|-----------|-----------|-------|
| EG 3/8-24  | 1,058    | 90        | 8            | 6,2        | 9,80      | 18        | 4     |
| EG 7/16-20 | 1,270    | 100       | 9            | 7,0        | 11,50     | 22        | 3     |
| EG 1/2-20  | 1,270    | 100       | 11           | 9,0        | 13,10     | 22        | 3     |
| EG 5/8-18  | 1,411    | 110       | 14           | 11,0       | 16,25     | 25        | 4     |
| EG 3/4-16  | 1,588    | 125       | 16           | 12,0       | 19,50     | 25        | 4     |

22 677 ...

EUR  
U0

|        |     |
|--------|-----|
| 119,33 | 037 |
| 149,73 | 043 |
| 140,55 | 050 |
| 214,58 | 062 |
| 274,54 | 075 |

|   |    |
|---|----|
| P | 12 |
| M | 7  |
| K | 12 |
| N |    |
| S |    |
| H |    |
| O |    |

Brzina rezanja  $v_c$  (m/min)

## Strojni ureznik za slijepi provrt, za žičane umetke, desni

CavTap

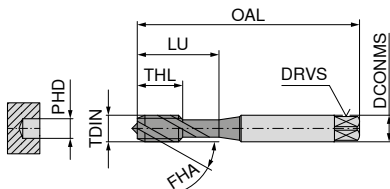
EG  
UNF

UNI

E  
1,5-2

2B

vap.



DIN 371 s ojačanim drškom

HSS-E  
FHA 42°  
≤ 1100 N/mm<sup>2</sup>  
≤ 3xD

22 680 ...

EUR  
U0

| TDIN         | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | PHD<br>mm | THL<br>mm | LU<br>mm | Utori |
|--------------|----------|-----------|--------------|------------|-----------|-----------|----------|-------|
| EG Nr. 4-48  | 0,529    | 56        | 4            | 3,0        | 3,0       | 7         | 20       | 3     |
| EG Nr. 6-40  | 0,635    | 70        | 6            | 4,9        | 3,7       | 8         | 25       | 3     |
| EG Nr. 8-36  | 0,706    | 80        | 6            | 4,9        | 4,4       | 8         | 30       | 3     |
| EG Nr. 10-32 | 0,794    | 80        | 6            | 4,9        | 5,1       | 8         | 30       | 3     |
| EG 1/4-28    | 0,907    | 90        | 8            | 6,2        | 6,6       | 10        | 35       | 3     |

|        |     |
|--------|-----|
| 83,54  | 004 |
| 82,90  | 006 |
| 86,67  | 008 |
| 91,50  | 010 |
| 100,32 | 025 |

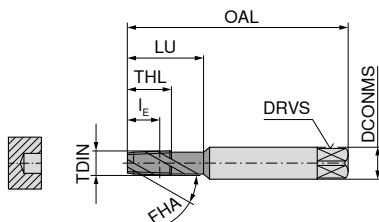
|   |    |
|---|----|
| P | 12 |
| M | 7  |
| K | 12 |
| N |    |
| S |    |
| H |    |
| O |    |

Brzina rezanja v<sub>c</sub> (m/min)

## Strojni ureznik za prolazni provrt, desni

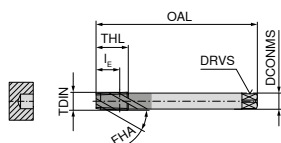
CavTap

NPT



DIN 371 s ojačanim drškom

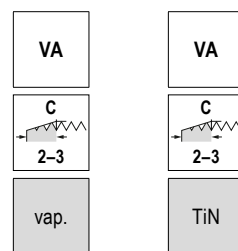
| TDIN    | TP    | OAL | DCONMS | DRVS | LE    | THL  | LU   | Utori |
|---------|-------|-----|--------|------|-------|------|------|-------|
| mm      | mm    | mm  | mm     | mm   | mm    | mm   | mm   |       |
| 1/16-27 | 0,941 | 90  | 8      | 6,2  | 9,24  | 13,0 | 26,0 | 3     |
| 1/8-27  | 0,941 | 90  | 10     | 8,0  | 9,28  | 13,0 | 26,0 | 3     |
| 1/8-27  | 0,941 | 90  | 10     | 8,0  | 9,28  | 12,0 | 26,0 | 4     |
| 1/4-18  | 1,411 | 100 | 14     | 11,0 | 13,55 | 19,5 | 34,5 | 3     |
| 1/4-18  | 1,411 | 100 | 14     | 11,0 | 13,55 | 18,0 | 34,5 | 4     |



DIN 374 sa zašiljenim drškom

| TDIN   | TP    | OAL | DCONMS | DRVS | LE    | THL  | Utori |
|--------|-------|-----|--------|------|-------|------|-------|
| mm     | mm    | mm  | mm     | mm   | mm    | mm   |       |
| 3/8-18 | 1,411 | 110 | 14     | 11   | 13,86 | 18,0 | 5     |
| 3/8-18 | 1,411 | 110 | 14     | 11   | 13,86 | 19,5 | 3     |
| 1/2-14 | 1,814 | 140 | 16     | 12   | 18,11 | 23,0 | 5     |
| 1/2-14 | 1,814 | 140 | 16     | 12   | 18,11 | 25,0 | 5     |
| 3/4-14 | 1,814 | 150 | 20     | 16   | 18,59 | 26,0 | 5     |

|   |    |    |
|---|----|----|
| P | 4  | 5  |
| M | 3  | 4  |
| K |    |    |
| N | 22 | 22 |
| S |    |    |
| H |    |    |
| O |    |    |

Brzina rezanja  $v_c$  (m/min)HSS-E  
FHA 35°  
≤ 900 N/mm<sup>2</sup>HSS-E  
FHA 42°  
≤ 1100 N/mm<sup>2</sup>

22 364 ...

EUR  
U0

113,73

131,38

153,54

006

012

025

22 365 ...

EUR  
U0

171,78

175,72

012

025

22 371 ...

EUR  
U0

188,71

274,54

369,55

037

050

075

22 372 ...

EUR  
U0

285,04

403,41

037

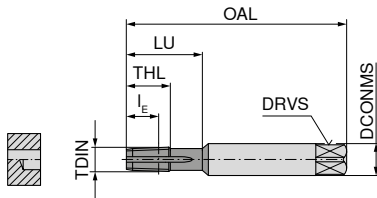
050

## Strojni ureznik za proboj i sljepi provrt, desni

DuoTap

NPT

VG

HSS-E  
FHA 0°  
≤ 1100 N/mm²

DIN 371 s ojačanim drškom

| TDIN    | TP    | OAL | DCONMS | DRVS | I <sub>E</sub> | THL  | LU   | Utori |
|---------|-------|-----|--------|------|----------------|------|------|-------|
| mm      | mm    | mm  | mm     | mm   | mm             | mm   | mm   |       |
| 1/16-27 | 0,941 | 90  | 8      | 6,2  | 9,24           | 13,0 | 26,0 | 3     |
| 1/8-27  | 0,941 | 90  | 10     | 8,0  | 9,28           | 13,0 | 26,0 | 3     |
| 1/4-18  | 1,411 | 100 | 14     | 11,0 | 13,55          | 19,5 | 34,5 | 3     |

22 374 ...

EUR

U0

81,99

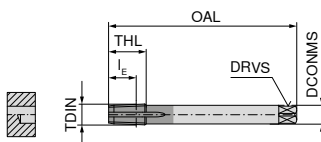
006

106,57

012

112,82

025



DIN 374 sa zašiljenim drškom

| TDIN   | TP    | OAL | DCONMS | DRVS | I <sub>E</sub> | THL  | Utori |
|--------|-------|-----|--------|------|----------------|------|-------|
| mm     | mm    | mm  | mm     | mm   | mm             | mm   |       |
| 3/8-18 | 1,411 | 110 | 14     | 11   | 13,86          | 19,5 | 3     |
| 1/2-14 | 1,814 | 140 | 16     | 12   | 18,11          | 25,0 | 5     |
| 3/4-14 | 1,814 | 150 | 20     | 16   | 18,59          | 26,0 | 5     |
| 1-11,5 | 2,209 | 170 | 25     | 20   | 22,31          | 30,0 | 5     |

22 375 ...

EUR

U0

140,55

037

188,71

050

243,44

075

333,08

100

|   |    |
|---|----|
| P | 4  |
| M |    |
| K | 6  |
| N | 22 |
| S |    |
| H |    |
| O |    |

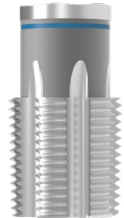
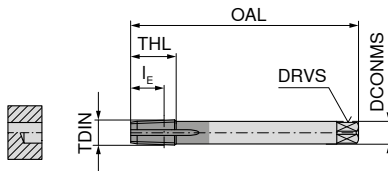
Brzina rezanja v<sub>c</sub> (m/min)

## Strojni ureznik za proboj i sljepi provrt, desni

▲ ES = iznimno kratki

DuoTap

NPT

ST  
ESHSS-E  
FHA 0°  
≤ 750 N/mm²

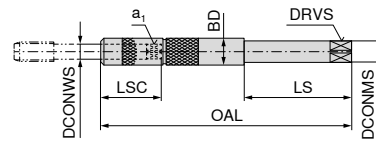
DIN 2181 sa zašiljenim drškom

22 361 ...

| TDIN    | TP<br>mm | OAL<br>mm | DCONMS<br>mm | DRVS<br>mm | I <sub>E</sub><br>mm | THL<br>mm | Utori |               |
|---------|----------|-----------|--------------|------------|----------------------|-----------|-------|---------------|
| 1/16-27 | 0,941    | 63        | 6            | 4,9        | 9,24                 | 13,0      | 4     | EUR 69,88 006 |
| 1/8-27  | 0,941    | 63        | 7            | 5,5        | 9,28                 | 13,0      | 5     | 73,52 012     |
| 1/4-18  | 1,411    | 63        | 11           | 9,0        | 13,55                | 19,5      | 5     | 87,46 025     |
| 3/8-18  | 1,411    | 70        | 12           | 9,0        | 13,86                | 19,5      | 5     | 109,81 037    |
| 1/2-14  | 1,814    | 80        | 16           | 12,0       | 18,11                | 23,0      | 5     | 147,11 050    |
| 3/4-14  | 1,814    | 100       | 20           | 16,0       | 18,59                | 26,0      | 6     | 184,78 075    |
| 1-11,5  | 2,209    | 110       | 25           | 20,0       | 22,31                | 32,0      | 6     | 275,74 100    |
| P       |          |           |              |            |                      |           |       | 6             |
| M       |          |           |              |            |                      |           |       |               |
| K       |          |           |              |            |                      |           |       | 6             |
| N       |          |           |              |            |                      |           |       | 22            |
| S       |          |           |              |            |                      |           |       |               |
| H       |          |           |              |            |                      |           |       |               |
| O       |          |           |              |            |                      |           |       |               |

Brzina rezanja v<sub>c</sub> (m/min)

## Produžetak drška ureznika

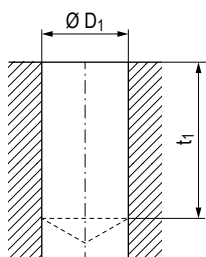


20 450 ...

| DIN 371   | DIN 374 / 376 | DCONWS | a <sub>1</sub> | LSC | BD   | LS | OAL | DRVS | DCONMS | EUR    |     |
|-----------|---------------|--------|----------------|-----|------|----|-----|------|--------|--------|-----|
|           |               | mm     | mm             | mm  | mm   | mm | mm  | mm   | mm     | U0     |     |
| M3        | M4,5 - M5     | 3,5    | 2,7            | 23  | 7,5  | 60 | 130 | 4,9  | 6      | 321,52 | 020 |
| M3,5      | M5,5          | 4,0    | 3,0            | 23  | 8,4  | 60 | 130 | 4,9  | 6      | 380,05 | 030 |
| M4        | M6            | 4,5    | 3,4            | 23  | 8,4  | 60 | 130 | 4,9  | 6      | 380,05 | 040 |
| M4,5 - M6 | M8            | 6,0    | 4,9            | 26  | 12,1 | 60 | 130 | 5,5  | 7      | 383,86 | 050 |
| M7        | M9 - M10      | 7,0    | 5,5            | 26  | 12,1 | 60 | 130 | 5,5  | 7      | 409,85 | 060 |
| M8        | M11           | 8,0    | 6,2            | 30  | 13,0 | 60 | 130 | 6,2  | 8      | 398,17 | 070 |
| M9        | M12           | 9,0    | 7,0            | 31  | 15,0 | 60 | 130 | 7,0  | 9      | 398,17 | 080 |
| M10       |               | 10,0   | 8,0            | 33  | 15,0 | 60 | 130 | 8,0  | 10     | 437,27 | 090 |
|           | M14           | 11,0   | 9,0            | 36  | 18,0 | 90 | 180 | 9,0  | 11     | 584,26 | 100 |
| (M12)     | M16           | 12,0   | 9,0            | 36  | 18,0 | 90 | 180 | 9,0  | 12     | 584,26 | 110 |

# Promjer navojnog jezgrenog otvora za konusne navoje s omjerom konusa 1:16

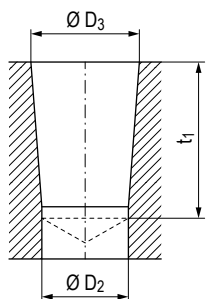
## Cilindrično predbušen bez uporabe razvrtača



|      |       | NPT              |                     | NPTF             |                     |      |       | Rc               |                     |
|------|-------|------------------|---------------------|------------------|---------------------|------|-------|------------------|---------------------|
| Ø D  | P     | Ø D <sub>1</sub> | t <sub>1</sub> min. | Ø D <sub>1</sub> | t <sub>1</sub> min. | Ø D  | P     | Ø D <sub>1</sub> | t <sub>1</sub> min. |
| Inč  | Gg/1" | mm               | mm                  | mm               | mm                  | Inč  | Gg/1" | mm               | mm                  |
| 1/16 | 27    | 6,15             | 12                  | 6,1              | 12                  | 1/16 | 28    | 6,2              | 11,9                |
| 1/8  | 27    | 8,5              | 12                  | 8,45             | 12                  | 1/8  | 28    | 8,2              | 11,9                |
| 1/4  | 18    | 11               | 17,5                | 10,9             | 17,5                | 1/4  | 19    | 10,85            | 16,3                |
| 3/8  | 18    | 14,5             | 17,6                | 14,3             | 17,6                | 3/8  | 19    | 14,5             | 18,1                |
| 1/2  | 14    | 17,85            | 22,9                | 17,6             | 22,9                | 1/2  | 14    | 18               | 24                  |
| 3/4  | 14    | 23,2             | 23                  | 23               | 23                  | 3/4  | 14    | 23,5             | 25,3                |
| 1    | 11½   | 29,5             | 27,4                | 28,75            | 27,4                | 1    | 11    | 29,5             | 30,6                |
| 1¼   | 11½   | 37,8             | 28,1                | 37,5             | 28,1                |      |       |                  |                     |
| 1½   | 11½   | 44               | 28,4                | 43,75            | 28,4                |      |       |                  |                     |
| 2    | 11½   | 56               | 28,4                | 55,75            | 28,4                |      |       |                  |                     |

P = nagib

## Cilindrično predbušeni i konusno izbušeni razvrtačem



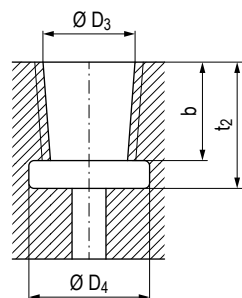
Konus 1:16

|      |       | NPT              |                  |                     | NPTF             |                  |                     |
|------|-------|------------------|------------------|---------------------|------------------|------------------|---------------------|
| Ø D  | P     | Ø D <sub>2</sub> | Ø D <sub>3</sub> | t <sub>1</sub> min. | Ø D <sub>2</sub> | Ø D <sub>3</sub> | t <sub>1</sub> min. |
| Inč  | Gg/1" | mm               | mm               | mm                  | mm               | mm               | mm                  |
| 1/16 | 27    | 5,95             | 6,39             | 12                  | 5,95             | 6,41             | 12                  |
| 1/8  | 27    | 8,25             | 8,74             | 12                  | 8,25             | 8,76             | 12                  |
| 1/4  | 18    | 10,75            | 11,36            | 17,5                | 10,75            | 11,4             | 17,5                |
| 3/8  | 18    | 14,1             | 14,8             | 17,6                | 14,1             | 14,84            | 17,6                |
| 1/2  | 14    | 17,5             | 18,32            | 22,9                | 17,5             | 18,33            | 22,9                |
| 3/4  | 14    | 22,7             | 23,67            | 23                  | 22,7             | 23,68            | 23                  |
| 1    | 11½   | 28,6             | 29,69            | 27,4                | 28,6             | 29,72            | 27,4                |
| 1¼   | 11½   | 37,3             | 38,45            | 28,1                | 37,3             | 38,48            | 28,1                |
| 1½   | 11½   | 43,4             | 44,52            | 28,4                | 43,4             | 44,5             | 28,4                |
| 2    | 11½   | 55,5             | 56,56            | 28,4                | 55,5             | 56,59            | 28,4                |

|      |       | Rc               |                  |                     |
|------|-------|------------------|------------------|---------------------|
| Ø D  | P     | Ø D <sub>2</sub> | Ø D <sub>3</sub> | t <sub>1</sub> min. |
| Inč  | Gg/1" | mm               | mm               | mm                  |
| 1/16 | 28    | 6,1              | 6,56             | 11,9                |
| 1/8  | 28    | 8,1              | 8,57             | 11,9                |
| 1/4  | 19    | 10,75            | 11,45            | 17,7                |
| 3/8  | 19    | 14,25            | 14,95            | 18,1                |
| 1/2  | 14    | 17,75            | 18,63            | 24                  |
| 3/4  | 14    | 23               | 24,12            | 25,3                |
| 1    | 11    | 29               | 30,29            | 30,6                |

P = nagib

## Preporuka za pripreme radnje kod bušenja slijepih provrta



Konus 1:16

|      |       | NPT              |      |                     |                       | NPTF             |      |                     |                       |
|------|-------|------------------|------|---------------------|-----------------------|------------------|------|---------------------|-----------------------|
| Ø D  | P     | Ø D <sub>3</sub> | b    | t <sub>2</sub> min. | Ø D <sub>4</sub> min. | Ø D <sub>3</sub> | b    | t <sub>2</sub> min. | Ø D <sub>4</sub> min. |
| Inč  | Gg/1" | mm               | mm   | mm                  | mm                    | mm               | mm   | mm                  | mm                    |
| 1/16 | 27    | 6,39             | 7    | 10                  | 7,6                   | 6,41             | 8    | 11                  | 7,4                   |
| 1/8  | 27    | 8,74             | 7    | 10                  | 10                    | 8,76             | 8    | 11                  | 9,8                   |
| 1/4  | 18    | 11,36            | 10,2 | 14,5                | 13,1                  | 11,4             | 11,6 | 15,5                | 12,9                  |
| 3/8  | 18    | 14,8             | 10,6 | 15                  | 16,5                  | 14,84            | 12   | 16                  | 16,3                  |
| 1/2  | 14    | 18,32            | 13,8 | 19                  | 20,5                  | 18,33            | 15,6 | 20,5                | 20,3                  |
| 3/4  | 14    | 23,67            | 14,2 | 20                  | 25,8                  | 23,68            | 16   | 21,5                | 25,6                  |
| 1    | 11½   | 29,69            | 17   | 24                  | 32,2                  | 29,72            | 19,2 | 26                  | 32                    |
| 1¼   | 11½   | 38,45            | 17,5 | 24,5                | 41                    | 38,48            | 19,7 | 26,5                | 40,8                  |
| 1½   | 11½   | 44,52            | 17,5 | 24,5                | 47,2                  | 44,5             | 19,7 | 26,5                | 47                    |
| 2    | 11½   | 56,56            | 18   | 25                  | 59,2                  | 56,59            | 20,2 | 27                  | 59                    |

|      |       | Rc               |      |                     |                       |
|------|-------|------------------|------|---------------------|-----------------------|
| Ø D  | P     | Ø D <sub>3</sub> | b    | t <sub>2</sub> min. | Ø D <sub>4</sub> min. |
| Inč  | Gg/1" | mm               | mm   | mm                  | mm                    |
| 1/16 | 28    | 6,56             | 5,6  | 9,5                 | 7,6                   |
| 1/8  | 28    | 8,57             | 5,6  | 9,5                 | 9,6                   |
| 1/4  | 19    | 11,45            | 8,4  | 14                  | 13                    |
| 3/8  | 19    | 14,95            | 8,8  | 14,4                | 16,5                  |
| 1/2  | 14    | 18,63            | 11,4 | 19                  | 20,6                  |
| 3/4  | 14    | 24,12            | 12,7 | 20,3                | 26                    |
| 1    | 11    | 30,29            | 14,5 | 24,3                | 32,8                  |

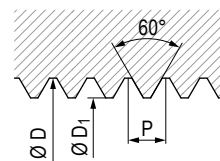
P = nagib

## Promjer rupe predbušenja za konusne navoje

M

Metrički navoj prema ISO standardu 6H u skladu s DIN 13 i DIN ISO 965-1 (M1–M1,4 = 5H)

| Nazivni Ø navoja |      | Ø D <sub>1</sub> |       | Bušenje jezgrenih rupa | Nazivni Ø navoja |      | Ø D <sub>1</sub> |        | Bušenje jezgrenih rupa |
|------------------|------|------------------|-------|------------------------|------------------|------|------------------|--------|------------------------|
| D                | P    | Min.             | Maks. |                        | D                | P    | Min.             | Maks.  |                        |
| M1               | 0,25 | 0,729            | 0,785 | 0,75                   | M12              | 1,75 | 10,106           | 10,441 | 10,2                   |
| M1,1             | 0,25 | 0,829            | 0,885 | 0,85                   | M14              | 2    | 11,835           | 12,210 | 12                     |
| M1,2             | 0,25 | 0,929            | 0,985 | 0,95                   | M16              | 2    | 13,835           | 14,210 | 14                     |
| M1,4             | 0,3  | 1,075            | 1,142 | 1,1                    | M18              | 2,5  | 15,294           | 15,744 | 15,5                   |
| M1,6             | 0,35 | 1,221            | 1,321 | 1,25                   | M20              | 2,5  | 17,294           | 17,744 | 17,5                   |
| M1,8             | 0,35 | 1,421            | 1,521 | 1,45                   | M22              | 2,5  | 19,294           | 19,744 | 19,5                   |
| M2               | 0,4  | 1,567            | 1,679 | 1,6                    | M24              | 3    | 20,752           | 21,252 | 21                     |
| M2,2             | 0,45 | 1,713            | 1,838 | 1,75                   | M27              | 3    | 23,752           | 24,252 | 24                     |
| M2,5             | 0,45 | 2,013            | 2,138 | 2,05                   | M30              | 3,5  | 26,211           | 26,771 | 26,5                   |
| M3               | 0,5  | 2,459            | 2,599 | 2,5                    | M33              | 3,5  | 29,211           | 29,771 | 29,5                   |
| M3,5             | 0,6  | 2,850            | 3,01  | 2,9                    | M36              | 4    | 31,67            | 32,270 | 32                     |
| M4               | 0,7  | 3,242            | 3,422 | 3,3                    | M39              | 4    | 34,67            | 35,270 | 35                     |
| M4,5             | 0,75 | 3,688            | 3,878 | 3,7                    | M42              | 4,5  | 37,129           | 37,799 | 37,5                   |
| M5               | 0,8  | 4,134            | 4,334 | 4,2                    | M45              | 4,5  | 40,129           | 40,799 | 40,5                   |
| M6               | 1    | 4,917            | 5,153 | 5                      | M48              | 5    | 42,587           | 43,297 | 43                     |
| M7               | 1    | 5,917            | 6,153 | 6                      | M52              | 5    | 46,587           | 47,297 | 47                     |
| M8               | 1,25 | 6,647            | 6,912 | 6,8                    | M56              | 5,5  | 50,046           | 50,796 | 50,5                   |
| M9               | 1,25 | 7,647            | 7,912 | 7,8                    | M60              | 5,5  | 54,046           | 54,796 | 54,5                   |
| M10              | 1,5  | 8,376            | 8,676 | 8,5                    | M64              | 6    | 57,505           | 58,305 | 58                     |
| M11              | 1,5  | 9,376            | 9,676 | 9,5                    | M68              | 6    | 61,505           | 62,305 | 62                     |

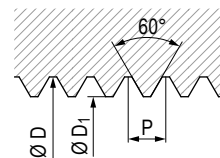


6

MF

Metrički ISO fini navoj 6H u skladu s DIN 13 i DIN ISO 965-1

| Nazivni Ø navoja |   |      | Ø D <sub>1</sub> |        | Bušenje jezgrenih rupa | Nazivni Ø navoja |   |     | Ø D <sub>1</sub> |         | Bušenje jezgrenih rupa |
|------------------|---|------|------------------|--------|------------------------|------------------|---|-----|------------------|---------|------------------------|
| D                | x | P    | Min.             | Maks.  |                        | D                | x | P   | Min.             | Maks.   |                        |
| M2               | x | 0,25 | 1,729            | 1,774  | 1,75                   | M20              | x | 1,0 | 18,917           | 19,153  | 19                     |
| M2,2             | x | 0,25 | 1,929            | 1,974  | 1,95                   | M20              | x | 1,5 | 18,376           | 18,676  | 18,5                   |
| M2,5             | x | 0,35 | 2,121            | 2,221  | 2,15                   | M20              | x | 2,0 | 17,835           | 18,210  | 18                     |
| M3               | x | 0,35 | 2,621            | 2,721  | 2,65                   | M24              | x | 1,5 | 22,376           | 22,676  | 22,5                   |
| M3,5             | x | 0,35 | 3,121            | 3,221  | 3,15                   | M30              | x | 2,0 | 27,835           | 28,210  | 28                     |
| M4               | x | 0,35 | 3,621            | 3,721  | 3,65                   | M36              | x | 1,5 | 34,376           | 34,676  | 34,5                   |
| M4               | x | 0,5  | 3,459            | 3,599  | 3,5                    | M36              | x | 3,0 | 32,752           | 33,252  | 33                     |
| M4,5             | x | 0,5  | 3,959            | 4,099  | 4                      | M42              | x | 2,0 | 39,835           | 40,210  | 40                     |
| M5               | x | 0,5  | 4,459            | 4,599  | 4,5                    | M48              | x | 1,5 | 46,376           | 46,676  | 46,5                   |
| M6               | x | 0,5  | 5,459            | 5,599  | 5,5                    | M48              | x | 3,0 | 44,752           | 45,252  | 45                     |
| M6               | x | 0,75 | 5,188            | 5,378  | 5,2                    | M48              | x | 4,0 | 43,67            | 44,270  | 44                     |
| M8               | x | 0,75 | 7,188            | 7,378  | 7,2                    | M56              | x | 1,5 | 54,376           | 54,676  | 54,5                   |
| M8               | x | 1,0  | 6,917            | 7,153  | 7                      | M56              | x | 2,0 | 53,835           | 54,210  | 54                     |
| M10              | x | 0,75 | 9,188            | 9,378  | 9,2                    | M56              | x | 3,0 | 52,752           | 53,252  | 53                     |
| M10              | x | 1,0  | 8,917            | 9,153  | 9                      | M56              | x | 4,0 | 51,670           | 52,270  | 52                     |
| M10              | x | 1,25 | 8,647            | 8,912  | 8,8                    | M64              | x | 3,0 | 60,752           | 61,252  | 61                     |
| M12              | x | 1,0  | 10,917           | 11,153 | 11                     | M64              | x | 4,0 | 59,670           | 60,270  | 60                     |
| M12              | x | 1,5  | 10,376           | 10,676 | 10,5                   | M72              | x | 4,0 | 67,670           | 68,270  | 68                     |
| M14              | x | 1,25 | 12,647           | 12,912 | 12,8                   | M80              | x | 6,0 | 73,505           | 74,305  | 74                     |
| M16              | x | 1,0  | 14,917           | 15,153 | 15                     | M95              | x | 6,0 | 88,505           | 89,305  | 89                     |
| M16              | x | 1,5  | 14,376           | 14,676 | 14,5                   | M110             | x | 6,0 | 103,505          | 104,305 | 104                    |



Mjere u mm; P = nagib

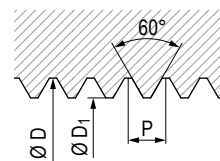
## Oblikovanje navoja s promjerom predbušenja

M

Metrički navoj prema ISO standardu 6H u skladu s DIN 13 i DIN ISO 965-1 (M1–M1,4 = 5H)

| Nazivni Ø navoja |      | Ø D <sub>1</sub> |       | Bušenje jezgrenih rupa |
|------------------|------|------------------|-------|------------------------|
| D                | P    | Min.             | Maks. |                        |
| M1               | 0,25 | 0,89             |       | 0,9                    |
| M1,2             | 0,25 | 1,09             |       | 1,1                    |
| M1,4             | 0,3  | 1,26             |       | 1,28                   |
| M1,6             | 0,35 | 1,45             |       | 1,47                   |
| M1,8             | 0,35 | 1,65             |       | 1,67                   |
| M2               | 0,4  | 1,83             | 1,86  | 1,85                   |
| M2,2             | 0,45 | 2                | 2,04  | 2,03                   |
| M2,5             | 0,45 | 2,3              | 2,34  | 2,33                   |
| M3               | 0,5  | 2,77             | 2,82  | 2,8                    |
| M3,5             | 0,6  | 3,23             | 3,28  | 3,25                   |
| M4               | 0,7  | 3,68             | 3,73  | 3,7                    |
| M4,5             | 0,75 | 4,15             | 4,21  | 4,2                    |
| M5               | 0,8  | 4,63             | 4,68  | 4,65                   |

| Nazivni Ø navoja |      | Ø D <sub>1</sub> |       | Bušenje jezgrenih rupa |
|------------------|------|------------------|-------|------------------------|
| D                | P    | Min.             | Maks. |                        |
| M6               | 1    | 5,51             | 5,59  | 5,6                    |
| M7               | 1    | 6,51             | 6,59  | 6,6                    |
| M8               | 1,25 | 7,39             | 7,48  | 7,45                   |
| M9               | 1,25 | 8,39             | 8,48  | 8,45                   |
| M10              | 1,5  | 9,25             | 9,35  | 9,35                   |
| M11              | 1,5  | 10,25            | 10,35 | 10,35                  |
| M12              | 1,75 | 11,12            | 11,25 | 11,25                  |
| M14              | 2    | 13               | 13,15 | 13,1                   |
| M16              | 2    | 15               | 15,15 | 15,1                   |
| M18              | 2,5  | 16,72            | 16,9  | 16,85                  |
| M20              | 2,5  | 18,72            | 18,9  | 18,85                  |
| M22              | 2,5  | 20,72            | 20,9  | 20,85                  |
| M24              | 3    | 22,46            | 22,7  | 22,65                  |

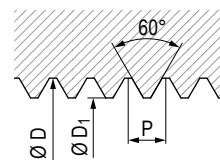


MF

Metrički ISO fini navoj 6H u skladu s DIN 13 i DIN ISO 965-1

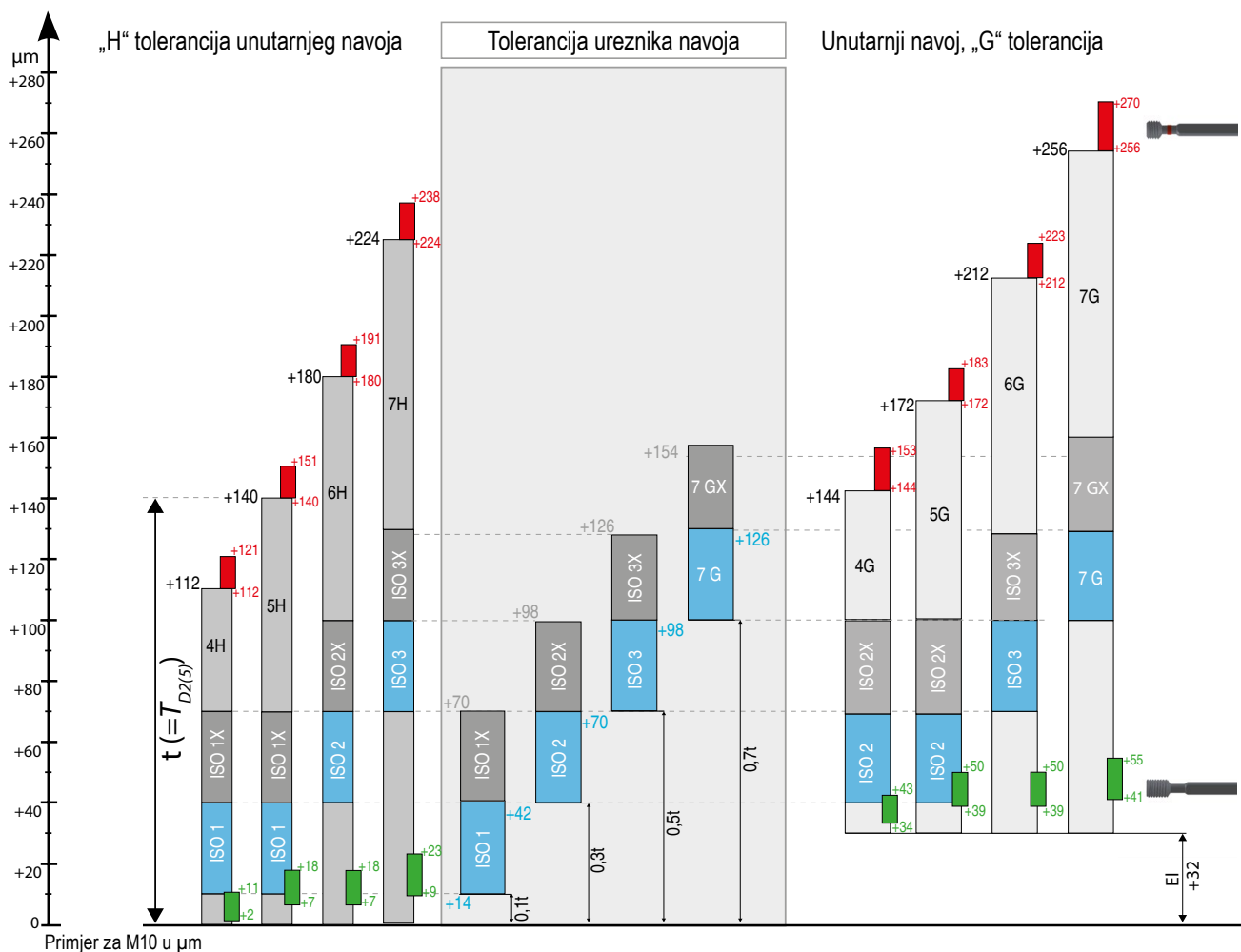
| Nazivni Ø navoja |   |      | Ø D <sub>1</sub> |       | Bušenje jezgrenih rupa |
|------------------|---|------|------------------|-------|------------------------|
| D                | x | P    | Min.             | Maks. |                        |
| M2               | x | 0,25 | 1,89             |       | 1,9                    |
| M2,2             | x | 0,25 | 2,09             |       | 2,1                    |
| M2,5             | x | 0,25 | 2,39             |       | 2,4                    |
| M2,5             | x | 0,35 | 2,35             |       | 2,37                   |
| M3               | x | 0,25 | 2,89             |       | 2,9                    |
| M3               | x | 0,35 | 2,85             |       | 2,88                   |
| M3,5             | x | 0,35 | 3,35             |       | 3,38                   |
| M3,5             | x | 0,5  | 3,27             | 3,32  | 3,3                    |
| M4               | x | 0,35 | 3,85             |       | 3,88                   |
| M4               | x | 0,5  | 3,77             | 3,82  | 3,8                    |
| M4,5             | x | 0,5  | 4,27             | 4,32  | 4,3                    |
| M5               | x | 0,5  | 4,77             | 4,82  | 4,8                    |
| M5               | x | 0,75 | 4,65             | 4,71  | 4,7                    |
| M5,5             | x | 0,5  | 5,27             | 5,32  | 5,3                    |
| M6               | x | 0,5  | 5,78             | 5,83  | 5,8                    |
| M6               | x | 0,75 | 5,65             | 5,71  | 5,7                    |
| M7               | x | 0,5  | 6,78             | 6,83  | 6,8                    |
| M7               | x | 0,75 | 6,65             | 6,71  | 6,7                    |
| M8               | x | 0,5  | 7,78             | 7,83  | 7,8                    |
| M8               | x | 0,75 | 7,65             | 7,71  | 7,7                    |
| M8               | x | 1,0  | 7,51             | 7,59  | 7,6                    |
| M9               | x | 0,5  | 8,78             | 8,83  | 8,8                    |
| M9               | x | 0,75 | 8,65             | 8,71  | 8,7                    |
| M9               | x | 1,0  | 8,51             | 8,59  | 8,6                    |
| M10              | x | 0,5  | 9,78             | 9,83  | 9,8                    |
| M10              | x | 0,75 | 9,65             | 9,71  | 9,7                    |
| M10              | x | 1,0  | 9,51             | 9,59  | 9,6                    |
| M10              | x | 1,25 | 9,39             | 9,48  | 9,45                   |
| M11              | x | 0,75 | 10,65            | 10,71 | 10,7                   |
| M11              | x | 1,0  | 10,51            | 10,59 | 10,6                   |
| M12              | x | 0,75 | 11,66            | 11,72 | 11,7                   |

| Nazivni Ø navoja |   |      | Ø D <sub>1</sub> |       | Bušenje jezgrenih rupa |
|------------------|---|------|------------------|-------|------------------------|
| D                | x | P    | Min.             | Maks. |                        |
| M12              | x | 1,0  | 11,52            | 11,6  | 11,6                   |
| M12              | x | 1,25 | 11,4             | 11,49 | 11,45                  |
| M12              | x | 1,5  | 11,26            | 11,36 | 11,35                  |
| M13              | x | 0,75 | 12,66            | 12,72 | 12,7                   |
| M13              | x | 1,0  | 12,52            | 12,6  | 12,6                   |
| M13              | x | 1,5  | 12,26            | 12,36 | 12,35                  |
| M14              | x | 0,75 | 13,66            | 13,72 | 13,7                   |
| M14              | x | 1,0  | 13,52            | 13,6  | 13,6                   |
| M14              | x | 1,25 | 13,4             | 13,49 | 13,45                  |
| M14              | x | 1,5  | 13,26            | 13,36 | 13,35                  |
| M15              | x | 0,75 | 14,66            | 14,72 | 14,7                   |
| M15              | x | 1,0  | 14,52            | 14,6  | 14,6                   |
| M15              | x | 1,5  | 14,26            | 14,36 | 14,35                  |
| M16              | x | 0,75 | 15,66            | 15,72 | 15,7                   |
| M16              | x | 1,0  | 15,52            | 15,6  | 15,6                   |
| M16              | x | 1,5  | 15,26            | 15,36 | 15,35                  |
| M18              | x | 1,0  | 17,52            | 17,6  | 17,6                   |
| M18              | x | 1,5  | 17,26            | 17,36 | 17,35                  |
| M18              | x | 2,0  | 17               | 17,15 | 17,1                   |
| M20              | x | 1,0  | 19,52            | 19,6  | 19,6                   |
| M20              | x | 1,5  | 19,26            | 19,36 | 19,35                  |
| M20              | x | 2,0  | 19               | 19,15 | 19,1                   |
| M22              | x | 1,5  | 21,26            | 21,36 | 21,35                  |
| M22              | x | 2,0  | 21               | 21,15 | 21,1                   |
| M24              | x | 1,5  | 23,26            | 23,38 | 23,35                  |
| M24              | x | 2,0  | 23,01            | 23,16 | 23,1                   |
| M25              | x | 1,5  | 24,26            | 24,38 | 24,35                  |
| M26              | x | 1,5  | 25,26            | 25,38 | 25,35                  |
| M27              | x | 2,0  | 26,01            | 26,16 | 26,1                   |
| M28              | x | 1,5  | 27,26            | 27,38 | 27,35                  |
| M30              | x | 1,5  | 29,26            | 29,38 | 29,35                  |
| M30              | x | 2,0  | 29,01            | 29,16 | 29,1                   |



Mjere u mm; P = nagib

## Tolerancije navoja i preporučene tolerancije izrade



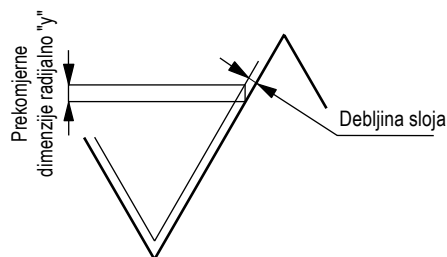
Radni komadi koji se prevlače zahtijevaju ureznik prekomjernih dimenzija  
Prekomjerne dimenzije ovise o debljini sloja i bočnom kutu.

Kod

60° Bočni kut      Prekomj. dimenzije = 4 x debljina sloja

|               |                                             |
|---------------|---------------------------------------------|
| 55° Bočni kut | Prekomj. dimenzije = 4,331 x debljina sloja |
|---------------|---------------------------------------------|

30° Bočni kut      Prekomj. dimenzije = 7,727 x debljina sloja



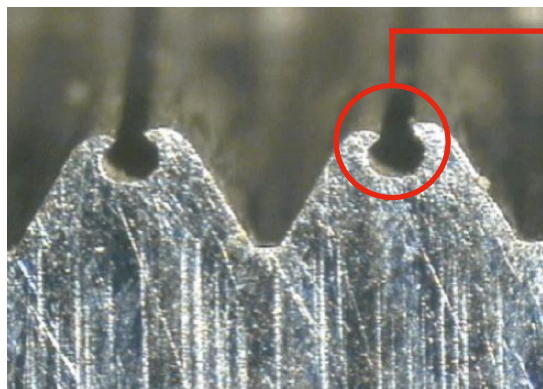
| Razred primjene ureznika navoja,<br>oznaka prema |      | Razred tolerancije za narezivanje unutarnjih navoja |      |      |    |    |
|--------------------------------------------------|------|-----------------------------------------------------|------|------|----|----|
| DIN                                              | ISO  |                                                     |      |      |    |    |
| 4H                                               | ISO1 | 4H                                                  | 5H   | –    | –  | –  |
| 6H                                               | ISO2 | 4G                                                  | 5G   | 6H   | –  | –  |
| 6G                                               | ISO3 | –                                                   | (4E) | 6G   | 7H | 8H |
| 7G                                               | –    | –                                                   | –    | (6E) | 7G | 8G |



Kod specijalnih slučajeva obrade, npr. abrazivnih lijevanih materijala ili plastike, treba odabrati druge dimenzije, koje se određuju na temelju empirijskih vrijednosti. U takvim slučajevima kratica razreda tolerancije dobiva slovo „X“, npr. ISO 2X, pri čemu se dodjeljivanje polja tolerancije unutarnjeg navoja može ograničiti (6HX za polje tolerancije 6H i 5G). Također treba napomenuti da dimenzije narezanog unutarnjeg navoja ne ovise samo o dimenzijama ureznika navoja, već o materijalu koji se treba rezati i o ukupnim proizvodnim uvjetima. Za prednji i srednji rezač nisu navedene dimenzije navoja.

## Uvaljivači

Alat za oblikovanje navoja bez strugotina za materijale koji se mogu hladno oblikovati do 1400 N/mm<sup>2</sup> ili minimalnim istezanjem pukotine 5 %. Navoj se izrađuje plastičnom deformacijom. Na taj način oblikovani navoji postižu vrlo visoku čvrstoću.



### » Važno

Prije oblikovanja navoja uvjerite se da se klijent složio s oblikom navoja. U nekim granama industrije oblikovanje navoja **nije** dopušteno. Prljavština ili bakterije mogu se stvarati u oblikovanoj kruni.

## Stupnjevito preoblikovanje pritiskom



← Izradak

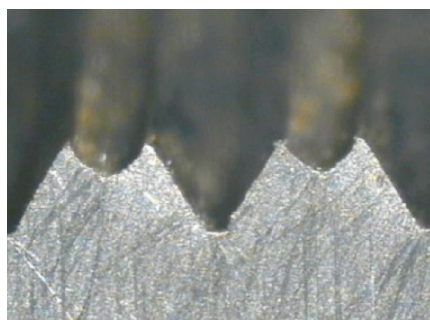
← Uvaljivači



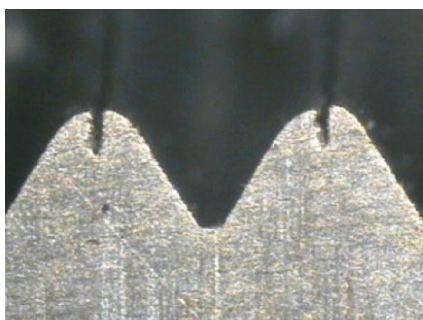
Profil navoja postupno se pritišće od početka (zasjeka) detalja navoja u materijal.

## Svojstva

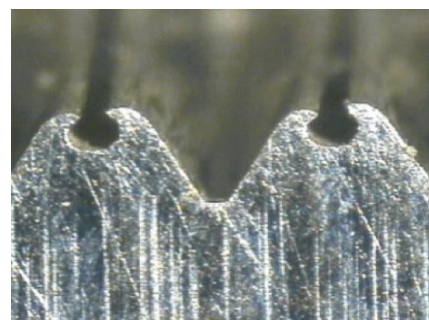
- ▲ Jedan tip primjenjiv u različitim materijalima
- ▲ Za prolazne navoje i navoje slijepih provrta
- ▲ Vrlo dobra kvaliteta površine navoja
- ▲ Visoka statička i dinamička čvrstoća navoja
- ▲ Sigurna obrada dubokih i duboko položenih navoja
- ▲ Kratko vrijeme obrade
- ▲ Bez problema sa strugotinama
- ▲ Bez rezanja
- ▲ Visoka procesna sigurnost
- ▲ Rezni materijal HSS-E i HSS-PM do oko 33 HRC kod istezanja materijala na pukotini min. 5 %



Preslabo formiran – jezgrena rupa prevelika



Prejako formiran (preoblikovan) – jezgrena rupa premala



Idealno oblikovani – jezgrena rupa u redu

## Uklanjanje problema

### Kratak vijek trajanja

#### Uzroci

- ▲ Pukotine zbog preopterećenja na reznim bridovima u području zasjeka
- ▲ Tvrdća ili osnovni materijal alata nisu prikladni za obradu
- ▲ Pilot provrt je premalen ili je otvrdnuo
- ▲ Nedovoljno podmazivanje ili pogrešan parametar primjene

#### Mjere

- ▲ Dulji zasjek ili više utora uz istu duljinu zasjeka, time veći broj reznih zuba
- ▲ Kod naoštrenih alata može se sniziti osnovna tvrdoća, primjenjujući odgovarajuće parametre za oštrenje
- ▲ Češća zamjena ili ponovno oštrenje alata za bušenje
- ▲ Koristite odgovarajuće parametre primjene za alat za bušenje
- ▲ Pravilno odaberite mazivo i pazite na dovoljnu opskrbu

### Aksijalno narezani navoj

#### Uzroci

- ▲ Odabrana geometrija rezanja nije prikladna
- ▲ Broj okretaja vretena ne odgovara posmaku (pogreška sinkronizacije)
- ▲ Ureznici za slijepe provrte upotrebljavaju se s prevelikim pritiskom urezivanja
- ▲ Ureznici za proboje upotrebljavaju se s premalim pritiskom urezivanja

#### Mjere

- ▲ Provjerite programiranje odn. vodeću patronu ili drugi sinkroni davač
- ▲ Koristite rezu glavu za navoje s kompenzacijom duljine
- ▲ Vratite pritisak urezivanja
- ▲ Povećajte pritisak urezivanja

### Navoj je prevelik

#### Uzroci

- ▲ Tolerancije navoja alata i mjerke za navoje se ne podudaraju
- ▲ Neravne oštrice alata nakon oštrenja
- ▲ Hladno zavarivanje pritiskom

#### Mjere

- ▲ Koristite odgovarajuće tolerancije za alat i mjerku za navoje
- ▲ Pažljivo očistite
- ▲ Koristite odgovarajuću (pozitivnu) geometriju
- ▲ Smanjite brzinu rezanja
- ▲ Koristite drugačiju obradu površine ili prevlaku
- ▲ Koristite rezu glavu za navoje s kompenzacijom duljine
- ▲ Koristite odgovarajuće sredstvo za podmazivanje

### Lom alata

#### Uzroci

- ▲ Alat je otupio
- ▲ Dovođenje alata na dno provrta
- ▲ Navarivanja
- ▲ Pilot provrt je premalen
- ▲ Zapletanje strugotina
- ▲ Pogrešna brzina rezanja
- ▲ Zastoj strugotine u utoru
- ▲ Nedostatno hlađenje/podmazivanje

#### Mjere

- ▲ Koristite komplet ureznika
- ▲ Koristite alat s manjim spiralama
- ▲ Koristite alat s kraćim/duljim zasjekom
- ▲ Kontrola dubine pilot provrta i dubine navoja
- ▲ Pilot provrt izbušite dublje
- ▲ Korigirajte brzinu rezanja
- ▲ Druga prevlaka ili obrada površine
- ▲ Koristite prihvatač alata s kompenzacijom duljine
- ▲ Koristite odgovarajuće sredstvo za podmazivanje
- ▲ Koristite pravilan promjer pilot provrta
- ▲ Promijenite geometriju i/ili oblik utora
- ▲ Pazite na oblik i stvaranje strugotina

## Prevlake

vap.

- ▲ Obradeno isparavanjem
- ▲ Isparivanje (izlazak pare) sprječava nastanak hladnog zavarivanja na alatu te povećava tvrdoću površine, a time i otpornost na trošenje

nitr.

- ▲ Nitriran
- ▲ Nitriranje povećava otpornost na habanje i daje materijal dobrim kliznim svojstvima

vap.  
+  
nitr.

- ▲ Isparivan + nitriran
- ▲ Kombinacija povećane tvrdoće površine i nosača maziva

TiN

- ▲ Prevlaka TiN-a
- ▲ Maksimalna temperatura primjene: 450 °C

TiN  
GS

- ▲ Klizni sloj titan-nitrid
- ▲ Visoka otpornost na habanje s dobrim kliznim svojstvima
- ▲ Maksimalna temperatura primjene: 450 °C

TiCN

- ▲ Višeslojno prevlačenje TiCN
- ▲ Maksimalna temperatura primjene: 450 °C

DLC

- ▲ Karbonska prevlaka slična dijamantu
- ▲ Specijalno za strojnu obradu neželjeznih metala
- ▲ Maksimalna temperatura primjene: 400 °C

Ti200

- ▲ Prevlaka TiN-a
- ▲ Prikladan za velike brzine rezanja tijekom oblikovanja navoja
- ▲ Maksimalna temperatura primjene: 450 °C

OSM

- ▲ Sloj tvrdog materijala i klizni sloj
- ▲ Za primjenu kod čelika visoke čvrstoće

CH

- ▲ Amorfni sloj ugljika
- ▲ Za upotrebu u obojenim metalima ili aluminiju
- ▲ Smanjuje adheziju materijala

HCr

- ▲ Tvrdi kromirani
- ▲ Za upotrebu u obojenim metalima ili aluminiju
- ▲ Vrlo niska hrapavost površine

CrN

- ▲ Prevlaka krom-nitrid
- ▲ Prevlaka otporna na habanje
- ▲ Posebno pogodno za upotrebu u aluminiju, ali i za P, M i S materijale

AlTiN-  
HD

- ▲ Tvrdi prevlaka s nano-slojem bazirana na AlTiN
- ▲ Maksimalna temperatura primjene: 500 °C

