

Eventuelle Druckfehler technischer Daten oder zwischenzeitlich eintretende Änderungen jeder Art berechtigen nicht zu Ansprüchen.

Nachdruck von Text und Bildern, auch auszugsweise, ist nicht gestattet.

© DC SWISS SA

ZX
AMPCO
ALU-BRONZE
LEGIERUNGEN

Warnung

Gewindewerkzeuge können durch technisches Versagen oder durch Fahrlässigkeit brechen oder zersplittern und die Gesundheit des Mitarbeitenden gefährden. Befolgen Sie daher die gesetzlichen Sicherheits- und Gesundheitsvorschriften. Zudem ist das Tragen der Schutzbrille unerlässlich. Das Schleifen von Gewindewerkzeugen verursacht gefährlichen Staub und darf nur unter gewissenhaftesten Sicherheitsrichtlinien verrichtet werden.

DC SWISS SA

CH-2735 Malleray

Tel. +41 32 491 63 63

Fax +41 32 491 64 64

E-mail: info@dcswiss.ch

DC SWISS GmbH

Graseggerstraße 125
DE-50737 Köln
Tel. +49 221 995 532-0
Fax +49 221 995 532-10
E-Mail: info@dcswiss.de

DC SWISS s.r.l.

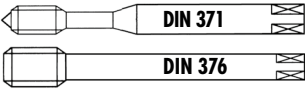
Via Canova 10
IT-20017 Rho
Tel. +39 02 669 40 41
Fax +39 02 669 78 50
E-mail: info@dcswiss.it

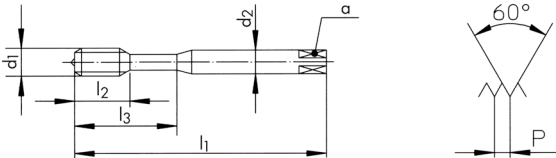
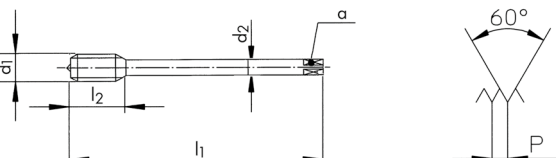
DC SWISS UK Ltd

9 Orgreave Road
UK-Sheffield S13 9LQ
Tel. +44 114 2939013
Fax +44 114 2880936
E-mail: info@dcswiss.co.uk



THREADING
TECHNOLOGY



ZX AMPCO ALU-BRONZE LEGIERUNGEN										ZX320-4	ZX420-4		
ZX320-4 ZX420-4  OIL													
Brinellhärte HB > 280 - 330 Kühlmittel: Schneidöl Schnittgeschwindigkeit: Vc 2 – 3 m/min Optimal: Ampco 21/22													
Brinellhärte HB < 420 Kühlmittel: Schneidöl Schnittgeschwindigkeit: Vc 6 – 10 m/min Schnittgeschwindigkeit: Vc 2 – 3 m/min Geeignet: Ampco 18 Ampco 25/26													
													
Ø d ₁	P	l ₁	l ₂	l ₃	d ₂	a			ID				
M	mm	mm	mm	mm	mm	mm							
4	0.70	63	14.0	21	4.5	3.4	3	3.30 *	143599				
5	0.80	70	15.0	25	6.0	4.9	3	4.20 *	145458				
6	1.00	80	17.0	30	6.0	4.9	3	5.00 *	110232				
8	1.25	90	20.0	35	8.0	6.2	3	6.80 *	110233				
10	1.50	100	22.0	39	10.0	8.0	3	8.50 *	124905				
													
Ø d ₁	P	l ₁	l ₂		d ₂	a			ID				
M	mm	mm	mm		mm	mm							
12	1.75	110	24.0		9.0	7.0	3	10.20 *	110208				
16	2.00	110	30.0		12.0	9.0	3	14.00 *	110207				
* Ampco 25/26 + 0.2 mm													



WEITERE AMPCO BEARBEITUNGSOPTIONEN										H320-4	H420-4	GW3016VS	GF6165VS																																																																																										
H320-4  OIL H420-4  OIL GW3016VS  R10 VS EMULSION OIL GF6165VS  R27 VS EMULSION OIL																																																																																																							
Brinellhärte HB < 200 Kühlmittel: Schneidöl Schnittgeschwindigkeit: Vc 6 – 10 m/min Optimal: Ampco 18																																																																																																							
Brinellhärte HB > 380 - 420 Kühlmittel: Schneidöl/Emulsion Fräsgeschwindigkeit: Vc 25 – 50 m/min Vorschub: fz 0.01 – 0.04 mm/Zahn Optimal: Ampco 25/26																																																																																																							
<table><tr><th>Ø d₁</th><th>P</th><th>l₁</th><th>l₂</th><th>l₃</th><th>d₂</th><th>a</th><th></th><th></th><th>ID</th></tr><tr><th>mm</th><th>mm</th><th>mm</th><th>mm</th><th>mm</th><th>mm</th><th>mm</th><th></th><th></th><th></th></tr><tr><td>3</td><td>0.50</td><td>56</td><td>12.0</td><td>18</td><td>3.5</td><td>2.7</td><td>3</td><td>2.50</td><td>101209</td></tr><tr><td>4</td><td>0.70</td><td>63</td><td>14.0</td><td>21</td><td>4.5</td><td>3.4</td><td>3</td><td>3.30</td><td>101211</td></tr><tr><td>5</td><td>0.80</td><td>70</td><td>15.0</td><td>25</td><td>6.0</td><td>4.9</td><td>3</td><td>4.20</td><td>101213</td></tr><tr><td>6</td><td>1.00</td><td>80</td><td>17.0</td><td>30</td><td>6.0</td><td>4.9</td><td>3</td><td>5.00</td><td>101215</td></tr><tr><td>8</td><td>1.25</td><td>90</td><td>20.0</td><td>35</td><td>8.0</td><td>6.2</td><td>3</td><td>6.80</td><td>101218</td></tr><tr><td>10</td><td>1.50</td><td>100</td><td>22.0</td><td>39</td><td>10.0</td><td>8.0</td><td>3</td><td>8.50</td><td>101205</td></tr></table>										Ø d ₁	P	l ₁	l ₂	l ₃	d ₂	a			ID	mm	mm	mm	mm	mm	mm	mm				3	0.50	56	12.0	18	3.5	2.7	3	2.50	101209	4	0.70	63	14.0	21	4.5	3.4	3	3.30	101211	5	0.80	70	15.0	25	6.0	4.9	3	4.20	101213	6	1.00	80	17.0	30	6.0	4.9	3	5.00	101215	8	1.25	90	20.0	35	8.0	6.2	3	6.80	101218	10	1.50	100	22.0	39	10.0	8.0	3	8.50	101205														
Ø d ₁	P	l ₁	l ₂	l ₃	d ₂	a			ID																																																																																														
mm	mm	mm	mm	mm	mm	mm																																																																																																	
3	0.50	56	12.0	18	3.5	2.7	3	2.50	101209																																																																																														
4	0.70	63	14.0	21	4.5	3.4	3	3.30	101211																																																																																														
5	0.80	70	15.0	25	6.0	4.9	3	4.20	101213																																																																																														
6	1.00	80	17.0	30	6.0	4.9	3	5.00	101215																																																																																														
8	1.25	90	20.0	35	8.0	6.2	3	6.80	101218																																																																																														
10	1.50	100	22.0	39	10.0	8.0	3	8.50	101205																																																																																														
<table><tr><th>Ø d₁</th><th>P</th><th>l₁</th><th>l₂</th><th>d₂</th><th>a</th><th></th><th></th><th>ID</th></tr><tr><th>mm</th><th>mm</th><th>mm</th><th>mm</th><th>mm</th><th>mm</th><th></th><th></th><th></th></tr><tr><td>12</td><td>1.75</td><td>110</td><td>24.0</td><td>9.0</td><td>7.0</td><td>4</td><td>10.20</td><td>101275</td></tr><tr><td>16</td><td>2.00</td><td>110</td><td>30.0</td><td>12.0</td><td>9.0</td><td>4</td><td>14.00</td><td>101279</td></tr></table>										Ø d ₁	P	l ₁	l ₂	d ₂	a			ID	mm	mm	mm	mm	mm	mm				12	1.75	110	24.0	9.0	7.0	4	10.20	101275	16	2.00	110	30.0	12.0	9.0	4	14.00	101279																																																										
Ø d ₁	P	l ₁	l ₂	d ₂	a			ID																																																																																															
mm	mm	mm	mm	mm	mm																																																																																																		
12	1.75	110	24.0	9.0	7.0	4	10.20	101275																																																																																															
16	2.00	110	30.0	12.0	9.0	4	14.00	101279																																																																																															
<table><tr><th>Ø D₁</th><th>P</th><th>d₁</th><th>l₁</th><th>l₂</th><th>d₂ h₅/h₆</th><th>d₃</th><th></th><th></th><th>ID</th></tr><tr><th>mm</th><th>mm</th><th>mm</th><th>mm</th><th>mm</th><th>mm</th><th>mm</th><th></th><th></th><th></th></tr><tr><td>3.0</td><td>0.50</td><td>2.43</td><td>51</td><td>8.4</td><td>5</td><td>1.73</td><td>4</td><td>2.50</td><td>167044</td></tr><tr><td>4.0</td><td>0.70</td><td>3.20</td><td>51</td><td>11.3</td><td>5</td><td>2.22</td><td>4</td><td>3.30</td><td>167046</td></tr><tr><td>5.0</td><td>0.80</td><td>4.08</td><td>51</td><td>14.0</td><td>5</td><td>2.96</td><td>4</td><td>4.20</td><td>167047</td></tr><tr><td>6.0</td><td>1.00</td><td>4.85</td><td>51</td><td>16.8</td><td>5</td><td>3.45</td><td>4</td><td>5.00</td><td>167048</td></tr><tr><td>8.0</td><td>1.25</td><td>5.95</td><td>63</td><td>23.0</td><td>6</td><td>4.20</td><td>5</td><td>6.80</td><td>175243</td></tr><tr><td>10.0</td><td>1.50</td><td>7.95</td><td>67</td><td>28.0</td><td>8</td><td>5.85</td><td>5</td><td>8.50</td><td>175244</td></tr><tr><td>12.0</td><td>1.75</td><td>9.95</td><td>76</td><td>34.0</td><td>10</td><td>7.50</td><td>5</td><td>10.20</td><td>175245</td></tr></table>										Ø D ₁	P	d ₁	l ₁	l ₂	d ₂ h ₅ /h ₆	d ₃			ID	mm	mm	mm	mm	mm	mm	mm				3.0	0.50	2.43	51	8.4	5	1.73	4	2.50	167044	4.0	0.70	3.20	51	11.3	5	2.22	4	3.30	167046	5.0	0.80	4.08	51	14.0	5	2.96	4	4.20	167047	6.0	1.00	4.85	51	16.8	5	3.45	4	5.00	167048	8.0	1.25	5.95	63	23.0	6	4.20	5	6.80	175243	10.0	1.50	7.95	67	28.0	8	5.85	5	8.50	175244	12.0	1.75	9.95	76	34.0	10	7.50	5	10.20	175245				
Ø D ₁	P	d ₁	l ₁	l ₂	d ₂ h ₅ /h ₆	d ₃			ID																																																																																														
mm	mm	mm	mm	mm	mm	mm																																																																																																	
3.0	0.50	2.43	51	8.4	5	1.73	4	2.50	167044																																																																																														
4.0	0.70	3.20	51	11.3	5	2.22	4	3.30	167046																																																																																														
5.0	0.80	4.08	51	14.0	5	2.96	4	4.20	167047																																																																																														
6.0	1.00	4.85	51	16.8	5	3.45	4	5.00	167048																																																																																														
8.0	1.25	5.95	63	23.0	6	4.20	5	6.80	175243																																																																																														
10.0	1.50	7.95	67	28.0	8	5.85	5	8.50	175244																																																																																														
12.0	1.75	9.95	76	34.0	10	7.50	5	10.20	175245																																																																																														
<table><tr><th>Ø D₁</th><th>P</th><th>d₁</th><th>l₁</th><th>l₂</th><th>d₂</th><th></th><th></th><th>ID</th></tr><tr><th>mm</th><th>mm</th><th>mm</th><th>mm</th><th>mm</th><th>mm</th><th></th><th></th><th></th></tr><tr><td>6</td><td>1.00</td><td>4.50</td><td>54</td><td>13.5</td><td>6</td><td>3</td><td>5.00</td><td>116398</td></tr><tr><td>8</td><td>1.25</td><td>5.95</td><td>54</td><td>18.1</td><td>6</td><td>3</td><td>6.80</td><td>116399</td></tr><tr><td>10</td><td>1.50</td><td>7.95</td><td>64</td><td>21.8</td><td>8</td><td>4</td><td>8.50</td><td>116400</td></tr><tr><td>12</td><td>1.75</td><td>9.95</td><td>72</td><td>25.4</td><td>10</td><td>4</td><td>10.20</td><td>116401</td></tr><tr><td>16</td><td>2.00</td><td>11.95</td><td>80</td><td>35.0</td><td>12</td><td>4</td><td>14.00</td><td>115990</td></tr></table>										Ø D ₁	P	d ₁	l ₁	l ₂	d ₂			ID	mm	mm	mm	mm	mm	mm				6	1.00	4.50	54	13.5	6	3	5.00	116398	8	1.25	5.95	54	18.1	6	3	6.80	116399	10	1.50	7.95	64	21.8	8	4	8.50	116400	12	1.75	9.95	72	25.4	10	4	10.20	116401	16	2.00	11.95	80	35.0	12	4	14.00	115990																															
Ø D ₁	P	d ₁	l ₁	l ₂	d ₂			ID																																																																																															
mm	mm	mm	mm	mm	mm																																																																																																		
6	1.00	4.50	54	13.5	6	3	5.00	116398																																																																																															
8	1.25	5.95	54	18.1	6	3	6.80	116399																																																																																															
10	1.50	7.95	64	21.8	8	4	8.50	116400																																																																																															
12	1.75	9.95	72	25.4	10	4	10.20	116401																																																																																															
16	2.00	11.95	80	35.0	12	4	14.00	115990																																																																																															