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ZX
AMPCO
ALU-BRONZE-ALLOYS

Warning

Thread tools can break or shatter either through technical failure or negligence, and can endanger the health of the operator. Always obey the safety and health regulations, also the wearing of safety glasses is compulsory.

The grinding of threading tools causes hazardous particles, and must be performed only under most rigorous safety standards.

For all available standard sizes, please consult our main catalogue or visit our website www.dcswiss.com

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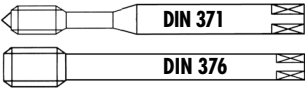
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THREADING
TECHNOLOGY



ZX AMPCO ALU-BRONZE-ALLOYS										ZX320-4	ZX420-4																																																																								
ZX320-4 ZX420-4 OIL																																																																																			
Hardness Brinell HB > 280 - 330 Lubricant: cutting oil Cutting speed: Vc 2 – 3 m/min										Optimal: Ampco 21/22																																																																									
Hardness Brinell HB < 420 Lubricant: cutting oil Cutting speed: Vc 6 – 10 m/min Cutting speed: Vc 2 – 3 m/min										Suitable: Ampco 18 Ampco 25/26																																																																									
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<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>M</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>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>143599</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>145458</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>110232</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>110233</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>124905</td></tr></table>										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				
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* Ampco 25/26 + 0.2 mm																																																																																			



ALTERNATIVE AMPCO THREADING SOLUTIONS										H320-4	H420-4	GW3016VS	GF6165VS																																																																																
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H420-4 OIL																																																																																													
GW3016VS VS EMULSION OIL																																																																																													
GF6165VS VS EMULSION OIL																																																																																													
Hardness Brinell HB < 200 Lubricant: cutting oil Cutting speed: Vc 6 – 10 m/min																																																																																													
Hardness Brinell HB > 380 - 420 Lubricant: cutting oil/emulsion Milling speed: Vc 25 – 50 m/min – Feed: 0.01 – 0.04																																																																																													
Optimal: Ampco 18																																																																																													
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<table><tr><th>Ø d₁ M</th><th>P mm</th><th>l₁ mm</th><th>l₂ mm</th><th>l₃ mm</th><th>d₂ mm</th><th>α mm</th><th></th><th></th><th>ID</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 M	P mm	l ₁ mm	l ₂ mm	l ₃ mm	d ₂ mm	α mm			ID	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														
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Ø D ₁ M	P mm	d ₁ mm	l ₁ mm	l ₃ mm	d ₂ h ₅ /h ₆ mm	d ₃ mm			ID																																																																																				
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