



GWⁱ
SERIES 3000

GW
SERIES 3000

DE-ID-1017



DIE BESTE LÖSUNG FÜR ROSTFREIE STÄHLE UND SONDERLEGIERUNGEN

Ø 0.8 - 6.5 mm

GW*i*
SERIES 3000



Ø 6.5 - 20 mm



Spanabfuhr



Doppelte Standzeit



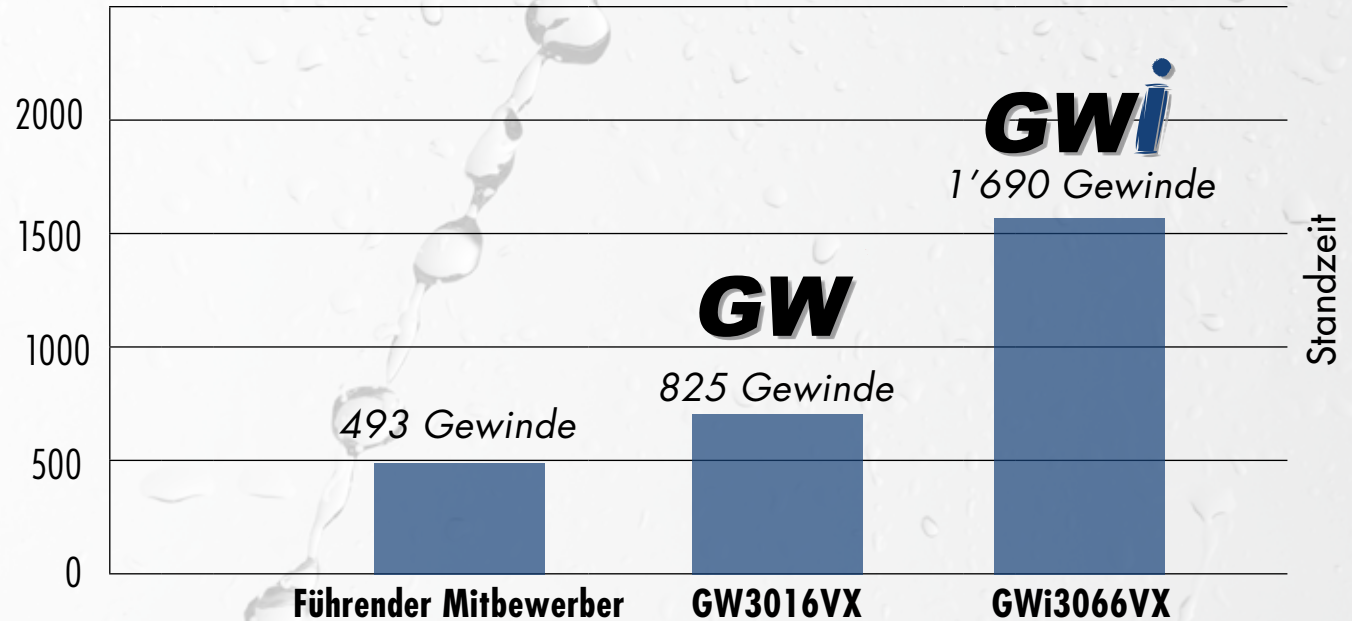
Prozesssicherheit



Keine Aufschweissungen

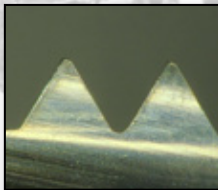
LEISTUNG

Material: Rostfreier Stahl, 1.4301
Maschine: DMC 650V
Lochart: Sackloch
Gewindeabmessung: M3 6H
Gewindetiefe: $2 \times D_1$
Kühlschmiermittel: Emulsion 8%
Vc & Vorschub: 50 m/min & 0.02 mm/Zahn

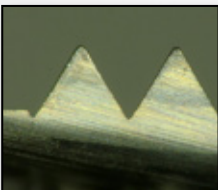


VERSCHLEISSBILD

GWi VX
 1'690 Gewinde

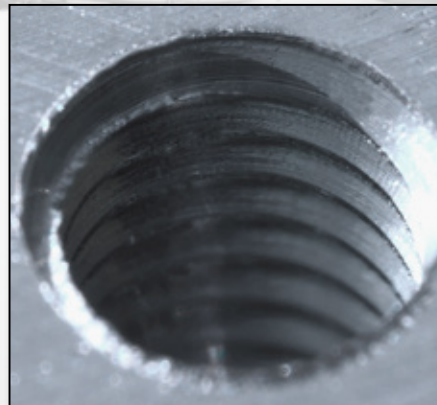


GW VX
 825 Gewinde



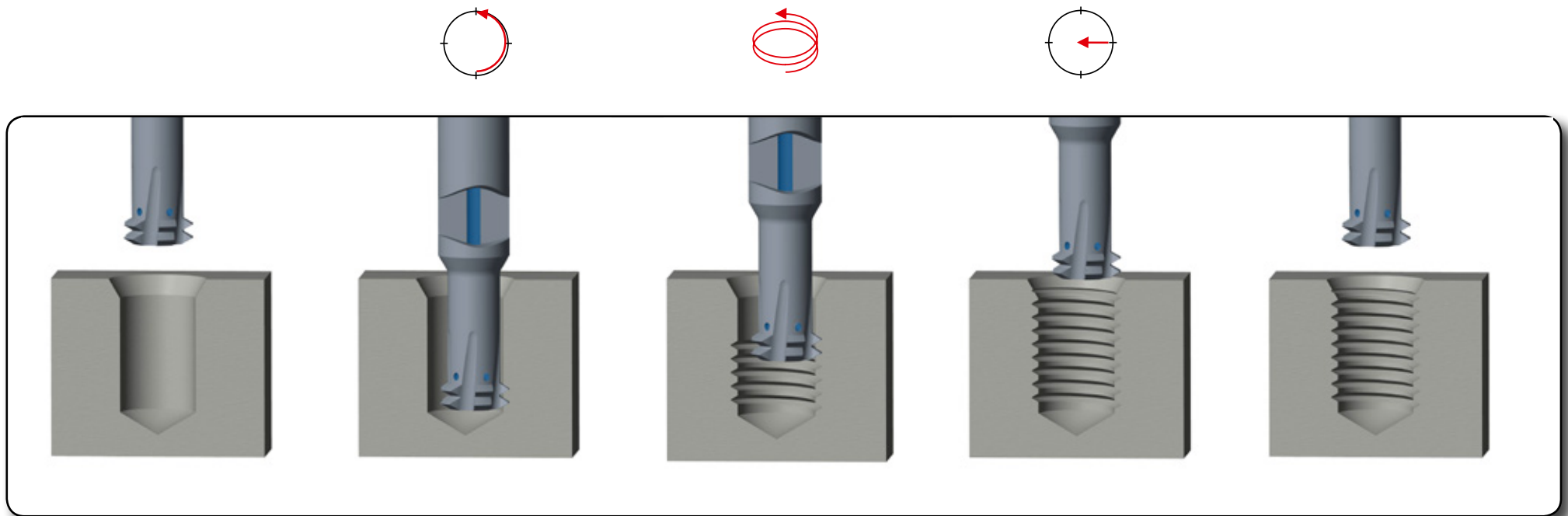
OBERFLÄCHENQUALITÄT

1'690 Gewinde



1'690 Gewinde in Material 1.4301
Anzahl CNC-Radius-Korrekturen: 2
(Mitbewerber: 5)

PROGRAMMIERZYKLUS



PIKTOGRAMME



Gewindelänge $2.5 \times D_1$



Gewindelänge $3 \times D_1$



Gewindelänge $4 \times D_1$



Verschleisschutzschicht



Verschleisschutzschicht



Vollhartmetall



Innengewinde



Toleranzklasse



HSC-Bearbeitung



Innenkühlung GWi



Profil GW



Ab Lager



Lieferung in 3 Wochen

ANWENDUNGSTABELLE

EINSATZ

 Optimal

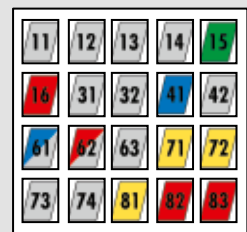
 Geeignet

ANWENDUNGSGRUPPEN

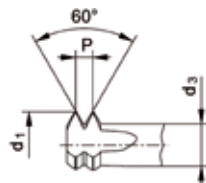
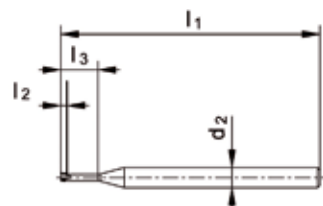
Werkstoff		Werkstoffbezeichnung	Härte (HB)	Festigkeit Rm (N/mm²)	Dehnung A (%)
Stahl	11	Automatenstahl	<200	<700	<10
	12	Baustahl, Einsatzstahl	<200	<700	<30
	13	Kohlenstoffstahl	<300	<1000	<20
	14	Stahl legiert <850 N/mm²	<250	<850	<30
	15	Stahl legiert / vergütet >850 - <1150 N/mm²	>250	>850	<30
	16	Hochfester Stahl	>250	>850	<12
Rostfreier Stahl	21	Rostfreier Stahl / geschwefelt	<250	<850	<25
	22	Austenitisch	<250	<850	>20
	23	Ferritisch, martensitisch <850 N/mm²	<250	<850	>20
	24	Ferritisch, martensitisch >850 - <1150 N/mm²	>250	>850	>15
Guss	31	Grauguss	<250	<850	<10
	32	Kugelgraphitguss, Temperguss	<250	<850	>10
Titan	41	Reintitan	<250	<850	>20
	42	Titanlegierung	>250	>850	<20
Nickel	51	Nickellegierung 1 <850 N/mm²	<250	<850	>25
	52	Nickellegierung 2 >850 - <1150 N/mm²	>250	>850	<25
	53	Nickellegierung 3 >1150 - ≤1600 N/mm²	>340	>1150	<20
Kupfer	61	Reinkupfer (Elektrolytkupfer)	<120	<400	>12
	62	Messing, Bronze, Rotguss (kurzspanend)	<200	<700	<12
	63	Messing (langspanend)	<200	<700	>12
Aluminium Magnesium	71	Al unlegiert	<100	<350	>15
	72	Al legiert Si < 1.5 %	<150	<500	>15
	73	Al legiert Si > 1.5 % - < 10 %	<120	<400	<15
	74	Al legiert Si > 10 %, Mg-Legierung	<120	<400	<10
Kunststoff	81	Thermoplaste	-	-	-
	82	Duroplaste	-	-	-
	83	Faserverstärkte Kunststoffe	-	-	-

GWi GW		Vc (m/min)		Vorschub fz (mm/Zahn)			
VS	VX	VS	VX	Ø 0.3 - 1.0	Ø 1.01 - 3.0	Ø 3.01 - 6.0	Ø 6.01 - 20.0
				80 – 100	0.004 – 0.01	0.01 – 0.05	0.04 – 0.10
				80 – 100	0.004 – 0.01	0.01 – 0.05	0.04 – 0.10
				70 – 90	0.004 – 0.01	0.01 – 0.05	0.02 – 0.10
				70 – 90	0.004 – 0.01	0.01 – 0.05	0.02 – 0.10
				30 – 50	0.004 – 0.01	0.01 – 0.05	0.02 – 0.08
				15 – 40	0.003 – 0.01	0.006 – 0.03	0.008 – 0.05
				40 – 60	0.004 – 0.01	0.01 – 0.05	0.02 – 0.10
				30 – 50	0.004 – 0.01	0.01 – 0.03	0.02 – 0.05
				30 – 50	0.004 – 0.01	0.01 – 0.03	0.02 – 0.05
				30 – 50	0.004 – 0.01	0.01 – 0.03	0.02 – 0.05
				90 – 120	0.004 – 0.01	0.01 – 0.05	0.04 – 0.10
				70 – 90	0.004 – 0.01	0.01 – 0.05	0.02 – 0.10
				20 – 40	0.004 – 0.01	0.01 – 0.03	0.02 – 0.05
				15 – 35	0.004 – 0.01	0.01 – 0.03	0.02 – 0.05
				20 – 40	0.004 – 0.01	0.01 – 0.03	0.02 – 0.05
				20 – 40	0.004 – 0.01	0.01 – 0.03	0.02 – 0.05
				20 – 30	0.003 – 0.01	0.006 – 0.03	0.008 – 0.05
				200 – 250	0.004 – 0.01	0.01 – 0.05	0.02 – 0.10
				150 – 200	0.004 – 0.01	0.01 – 0.05	0.04 – 0.10
				150 – 200	0.004 – 0.01	0.01 – 0.05	0.02 – 0.10
				200 – 300	0.004 – 0.01	0.01 – 0.05	0.05 – 0.10
				200 – 300	0.004 – 0.01	0.01 – 0.05	0.05 – 0.10
				200 – 300	0.004 – 0.01	0.01 – 0.05	0.05 – 0.10
				200 – 300	0.004 – 0.01	0.01 – 0.05	0.04 – 0.10
				200 – 300	0.004 – 0.01	0.01 – 0.05	0.05 – 0.10
				100 – 200	0.004 – 0.01	0.01 – 0.05	0.04 – 0.10
				80 – 100	0.004 – 0.01	0.01 – 0.05	0.04 – 0.10

GWi3066VS
GWi3067VS
GWi3069VS



GWi3066VX
GWi3067VX



GWi3066VS

GWi3067VS

GWi3069VS

GWi3066VX

GWi3067VX



D ₁	P	d ₁	l ₁ 2.5 - 3 x D ₁	l ₃ 2.5 x D ₁	l ₃ 3 x D ₁	l ₁ 4 x D ₁	l ₃ 4 x D ₁	d ₂ h6	d ₃		
M 0.8	0.2	0.57	40	2.3	2.7	40	3.5	3	0.29	3	0.65
0.9	0.225	0.64	40	2.6	3.0	40	3.9	3	0.33	3	0.70
1	0.25	0.71	40	2.9	3.4	40	4.4	3	0.36	3	0.75
1.2	0.25	0.91	40	3.4	4.0	40	5.2	3	0.56	3	0.95
1.4	0.3	1.06	40	3.9	4.6	40	6.0	4	0.64	3	1.10
1.6	0.35	1.20	40	4.5	5.3	40	6.9	4	0.71	3	1.25
1.8	0.35	1.40	40	5.0	5.9	40	7.7	4	0.91	3	1.45
2	0.4	1.54	40	5.6	6.6	40	8.6	4	0.98	3	1.60
2.5	0.45	1.98	40	6.9	8.1	40	10.6	4	1.35	3	2.05
3	0.5	2.43	51	8.4	9.9	51	12.9	5	1.73	4	2.50
3.5	0.6	2.81	51	9.9	11.6	51	15.1	6	1.97	4	2.90
4	0.7	3.20	51	11.3	13.3	51	17.3	6	2.22	4	3.30
5	0.8	4.08	51	14.0	16.5	51	21.5	8	2.96	4	4.20
6	1	4.85	51	16.8	19.8	51	25.8	8	3.45	4	5.00
8	1.25	5.95	75	23.0	27.0	75	35.0	6	4.20	5	6.80
10	1.5	7.95	83	28.0	33.0	83	43.0	8	5.85	5	8.50
12	1.75	9.95	95	34.0	40.0	95	52.0	10	7.50	5	10.25
14	2	10.95	120	44.0	52.0	120	68.0	12	8.15	5	12.00
16	2	10.95	120	44.0	52.0	120	68.0	12	8.15	5	14.00
18	2.5	13.95	135	55.0	65.0	135	85.0	14	10.45	6	15.50
20	2.5	13.95	135	55.0	65.0	135	85.0	14	10.45	6	17.50

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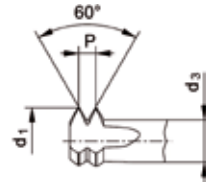
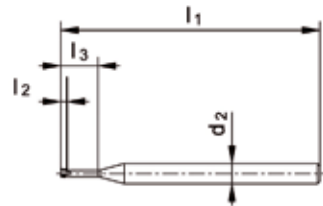
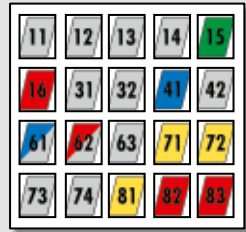
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GW3066VS
GW3067VS
GW3069VS



GW3066VX
GW3067VX



GW3066VS

GW3067VS

GW3069VS

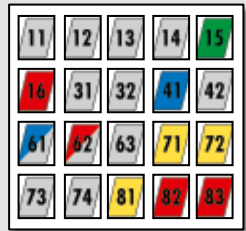
GW3066VX

GW3067VX

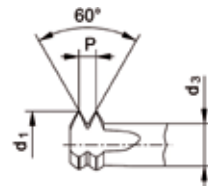
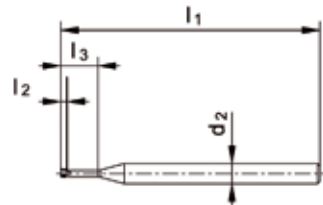


D ₁	P	d ₁	l ₁ 2.5 - 3 x D ₁	l ₃ 2.5 x D ₁	l ₃ 3 x D ₁	l ₁ 4 x D ₁	l ₃ 4 x D ₁	d ₂ h6	d ₃			ID					
MF2	0.2	1.77	40	5.3	6.3		40	8.3	4	1.49	3	1.80	186086	186488		187346	187470
2	0.25	1.71	40	5.4	6.4		40	8.4	4	1.36	3	1.75	186087	186489		187347	187471
2.5	0.2	2.27	40	6.6	7.8		40	10.3	4	1.99	3	2.30	186088	186490		187348	187472
2.5	0.25	2.21	40	6.6	7.9		40	10.4	4	1.86	3	2.25	186089	186491		187349	187473
3	0.35	2.60	51	8.2	9.7		51	12.7	5	2.11	4	2.65	186090	186492	186620	187350	187474
4	0.5	3.43	51	10.9	12.9		51	16.9	6	2.73	4	3.50	186091	186493	186621	187351	187475
5	0.5	4.43	51	13.4	15.9		51	20.9	8	3.73	4	4.50	186092	186494	186622	187352	187476
6	0.75	4.95	51	16.4	19.4		51	25.4	8	3.90	4	5.25	186093	186495	186623	187353	187477
8	1	5.95	75	22.0	26.0		75	34.0	6	4.55	5	7.00	186094	186496	186624	187354	187478
10	1	7.95	83	27.0	32.0		83	42.0	8	6.55	5	9.00	186095	186497	186625	187355	187479
10	1.25	7.95	83	28.0	33.0		83	43.0	8	6.20	5	8.75	186096	186498	186626	187356	187480
12	1.5	9.95	95	33.0	39.0		95	51.0	10	7.85	5	10.50	186097	186499	186627	187357	187481
14	1.5	10.95	120	43.0	51.0		120	67.0	12	8.85	5	12.50	186098	186500	186628	187358	187482
16	1.5	10.95	120	43.0	51.0		120	67.0	12	8.85	5	14.50	186819	186827	186835	187359	187483
18	1.5	13.95	135	53.0	63.0		135	83.0	14	11.85	6	16.50	186099	186501	186629	187360	187484
20	1.5	13.95	135	53.0	63.0		135	83.0	14	11.85	6	18.50	186820	186828	186836	187361	187485

GW3016VS
GW3017VS
GW3019VS



GW3016VX
GW3017VX



GW3016VS

GW3017VS

GW3019VS

GW3016VX

GW3017VX



D ₁	P	d ₁	l ₁ 2.5 - 3 x D ₁	l ₃ 2.5 x D ₁	l ₃ 3 x D ₁	l ₁ 4 x D ₁	l ₃ 4 x D ₁	d ₂ h5	d ₃		
MF2	0.2	1.77	39	5.3	6.3	39	8.3	3	1.49	3	1.80
2	0.25	1.71	39	5.4	6.4	39	8.4	3	1.36	3	1.75
2.5	0.2	2.27	39	6.6	7.8	39	10.3	3	1.99	3	2.30
2.5	0.25	2.21	39	6.6	7.9	39	10.4	3	1.86	3	2.25
3	0.35	2.60	51	8.2	9.7	51	12.7	5	2.11	4	2.65
4	0.5	3.43	51	10.9	12.9	51	16.9	5	2.73	4	3.50
5	0.5	4.43	51	13.4	15.9	51	20.9	5	3.73	4	4.50
6	0.75	4.95	51	16.4	19.4	51	25.4	5	3.90	4	5.25
8	1	5.95	63	22.0	26.0	75	34.0	6*	4.55	5	7.00
10	1	7.95	67	27.0	32.0	83	42.0	8*	6.55	5	9.00
10	1.25	7.95	67	28.0	33.0	83	43.0	8*	6.20	5	8.75
12	1.5	9.95	76	33.0	39.0	95	51.0	10*	7.85	5	10.50
14	1.5	10.95	95	43.0	51.0	120	67.0	12*	8.85	5	12.50
16	1.5	10.95	95	43.0	51.0	120	67.0	12*	8.85	5	14.50
18	1.5	13.95	105	53.0	63.0	135	83.0	14*	11.85	6	16.50
20	1.5	13.95	105	53.0	63.0	135	83.0	14*	11.85	6	18.50

* tol. h6

ID



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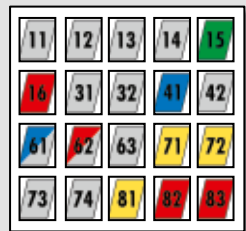
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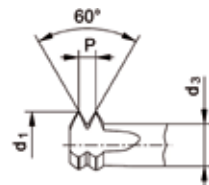
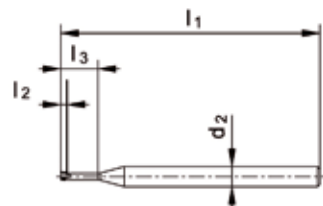
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GW3066VS
GW3067VS
GW3069VS



GW3066VX
GW3067VX



GW3066VS

GW3067VS

GW3069VS

GW3066VX

GW3067VX



D ₁	P	D ₁	d ₁	l ₁	l ₃	l ₃	l ₁	l ₃	d ₂ h6	d ₃		
TPI		mm		2.5 - 3 x D ₁	2.5 x D ₁	3 x D ₁	4 x D ₁	4 x D ₁				
UNC 2	56	2.18	1.66	40	6.1	7.2	40	9.4	4	1.02	3	1.80
3	48	2.51	1.90	40	7.0	8.3	40	10.8	4	1.16	3	2.00
4	40	2.84	2.11	40	8.0	9.4	40	12.2	5	1.22	3	2.30
5	40	3.17	2.44	51	9.1	10.7	51	13.9	5	1.55	4	2.60
6	32	3.50	2.59	51	10.2	12.0	51	15.5	6	1.48	4	2.80
8	32	4.16	3.25	51	11.9	14.0	51	18.1	6	2.14	4	3.40
10	24	4.82	3.60	51	14.0	16.4	51	21.2	8	2.12	4	3.80
12	24	5.48	4.26	51	15.7	18.4	51	23.9	8	2.78	4	4.50
1/4	20	6.35	4.89	51	18.2	21.4	51	27.7	8	3.11	4	5.10
5/16	18	7.93	5.95	75	23.0	27.0	75	35.0	6	3.97	5	6.60
3/8	16	9.52	7.10	83	27.0	32.0	83	41.0	8	4.87	5	8.00
7/16	14	11.11	7.95	83	32.0	37.0	83	48.0	8	5.41	5	9.30
1/2	13	12.70	9.95	95	36.0	42.0	95	55.0	10	7.21	5	10.80

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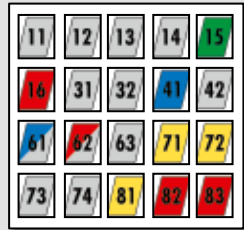


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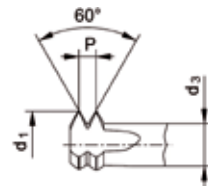
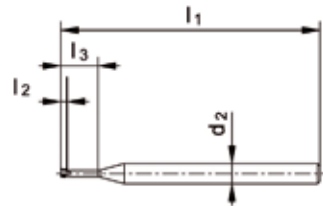
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GW3016VS
GW3017VS
GW3019VS



GW3016VX
GW3017VX



GW3016VS

GW3017VS

GW3019VS

GW3016VX

GW3017VX



D ₁	P	D ₁	d ₁	I ₁	I ₃	I ₃	I ₁	I ₃	d ₂	h ₅	d ₃		
TPI		mm		2.5 - 3 x D ₁	2.5 x D ₁	3 x D ₁	4 x D ₁	4 x D ₁					
UNC 2	56	2.18	1.66	39	6.1	7.2	39	9.4	3	1.02	3	1.80	
3	48	2.51	1.90	39	7.0	8.3	39	10.8	3	1.16	3	2.00	
4	40	2.84	2.11	39	8.0	9.4	39	12.2	3	1.22	3	2.30	
5	40	3.17	2.44	51	9.1	10.7	51	13.9	5	1.55	4	2.60	
6	32	3.50	2.59	51	10.2	12.0	51	15.5	5	1.48	4	2.80	
8	32	4.16	3.25	51	11.9	14.0	51	18.1	5	2.14	4	3.40	
10	24	4.82	3.60	51	14.0	16.4	51	21.2	5	2.12	4	3.80	
12	24	5.48	4.26	51	15.7	18.4	51	23.9	5	2.78	4	4.50	
1/4	20	6.35	4.89	51	18.2	21.4	51	27.7	5	3.11	4	5.10	
5/16	18	7.93	5.95	63	23.0	27.0	75	35.0	6*	3.97	5	6.60	
3/8	16	9.52	7.10	67	27.0	32.0	83	41.0	8*	4.87	5	8.00	
7/16	14	11.11	7.95	67	32.0	37.0	83	48.0	8*	5.41	5	9.30	
1/2	13	12.70	9.95	76	36.0	42.0	95	55.0	10*	7.21	5	10.80	

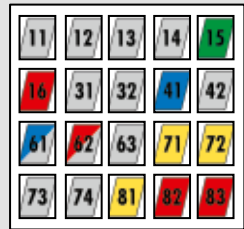
* tol. h6

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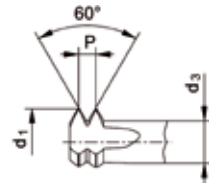
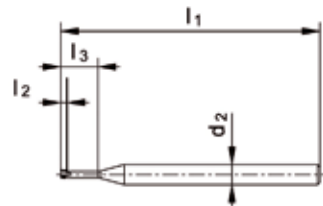


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186236	186366	186601	187299	187427
167501	186367	167508	187300	187428
186237	186368	186602	187301	187429
167502	186369	167509	187302	187430
167503	186370	167510	187303	187431
173986	186371	173979	187304	187432
186238	186372	186603	187305	187433
167504	186373	167511	187306	187434
175246	186374	175277	187307	187435
173546	186375	175278	187308	187436
186239	186376	186604	187309	187437
175247	186377	175279	187310	187438

GW3066VS
GW3067VS
GW3069VS



GW3066VX
GW3067VX



GW3066VS

GW3067VS

GW3069VS

GW3066VX

GW3067VX



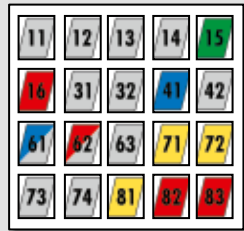
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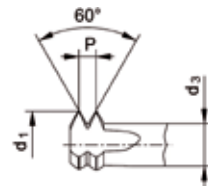
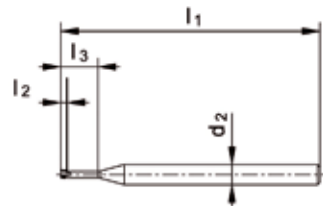
D ₁	P	D ₁	d ₁	l ₁	l ₃	l ₃	l ₁	l ₃	d ₂ h6	d ₃		
TPI		mm		2.5 - 3 x D ₁	2.5 x D ₁	3 x D ₁	4 x D ₁	4 x D ₁				
UNF 0	80	1.52	1.15	40	4.3	5.0	40	6.6	4	0.71	3	1.20
1	72	1.85	1.44	40	5.1	6.1	40	7.9	4	0.95	3	1.50
2	64	2.18	1.72	40	6.0	7.1	40	9.3	4	1.16	3	1.80
4	48	2.84	2.23	40	7.9	9.3	40	12.1	5	1.49	3	2.40
5	44	3.17	2.51	51	9.0	10.6	51	13.8	5	1.70	4	2.60
6	40	3.50	2.77	51	10.0	11.7	51	15.2	6	1.88	4	2.90
8	36	4.16	3.35	51	11.7	13.8	51	18.0	6	2.36	4	3.50
10	32	4.82	3.91	51	13.5	15.9	51	20.8	8	2.80	4	4.10
12	28	5.48	4.44	51	15.4	18.1	51	23.6	8	3.17	4	4.60
1/4	28	6.35	4.95	51	17.6	20.7	51	27.1	8	3.68	4	5.50
5/16	24	7.93	5.95	75	22.0	26.0	75	34.0	6	4.47	5	6.90
3/8	24	9.52	7.10	83	26.0	31.0	83	40.0	8	5.62	5	8.50
7/16	20	11.11	7.95	83	31.0	36.0	83	47.0	8	6.17	5	9.90
1/2	20	12.70	9.95	95	35.0	41.0	95	54.0	10	8.17	5	11.50

186167	187375		
186168	187376		
186169	187377		
186170	186559	187378	187497
186171	186560	187379	187498
186172	186561	186639	187499
186173	186562	186640	187500
186174	186563	186641	187501
186175	186564	186642	187502
186176	186565	186643	187503
186177	186566	186644	187504
186178	186567	186645	187505
186179	186568	186646	187506
186180	186569	186647	187507

GW3016VS
GW3017VS
GW3019VS



GW3016VX
GW3017VX



GW3016VS

GW3017VS

GW3019VS

GW3016VX

GW3017VX



D ₁	P	D ₁	d ₁	l ₁	l ₃	l ₃	l ₁	l ₃	d ₂ h5	d ₃		
TPI		mm		2.5 - 3 x D ₁	2.5 x D ₁	3 x D ₁	4 x D ₁	4 x D ₁				
UNF 0	80	1.52	1.15	39	4.3	5.0	39	6.6	3	0.71	3	1.20
1	72	1.85	1.44	39	5.1	6.1	39	7.9	3	0.95	3	1.50
2	64	2.18	1.72	39	6.0	7.1	39	9.3	3	1.16	3	1.80
4	48	2.84	2.23	39	7.9	9.3	39	12.1	3	1.49	3	2.40
5	44	3.17	2.51	51	9.0	10.6	51	13.8	5	1.70	4	2.60
6	40	3.50	2.77	51	10.0	11.7	51	15.2	5	1.88	4	2.90
8	36	4.16	3.35	51	11.7	13.8	51	18.0	5	2.36	4	3.50
10	32	4.82	3.91	51	13.5	15.9	51	20.8	5	2.80	4	4.10
12	28	5.48	4.44	51	15.4	18.1	51	23.6	5	3.17	4	4.60
1/4	28	6.35	4.95	51	17.6	20.7	51	27.1	5	3.68	4	5.50
5/16	24	7.93	5.95	63	22.0	26.0	75	34.0	6*	4.47	5	6.90
3/8	24	9.52	7.10	67	26.0	31.0	83	40.0	8*	5.62	5	8.50
7/16	20	11.11	7.95	67	31.0	36.0	83	47.0	8*	6.17	5	9.90
1/2	20	12.70	9.95	76	35.0	41.0	95	54.0	10*	8.17	5	11.50

* tol. h6

ID



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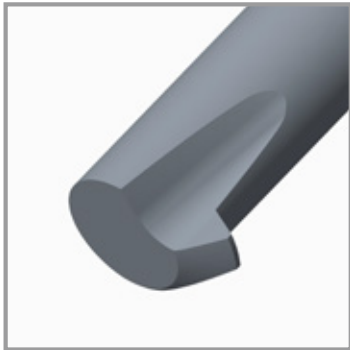
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187452

BREITES GEWINDEFÄHRER PROGRAMM

GW
SERIES 1000

VS

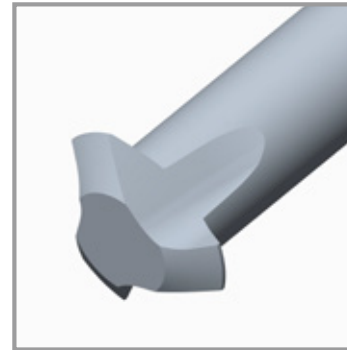


GW1116 / GW1116VS

S 0.3 – S 1.4

GW
SERIES 2000

VS



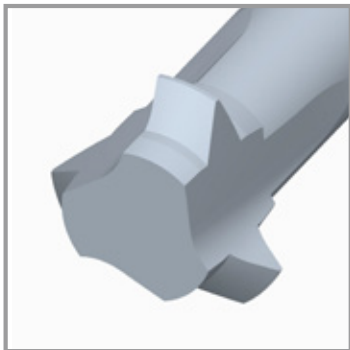
GW2016 / GW2016VS

M 0.8 – M 6

S 0.8 – S 1.4

GW
SERIES 4000

VS



GW4116 / GW4116VS

GW4119 / GW4119VS

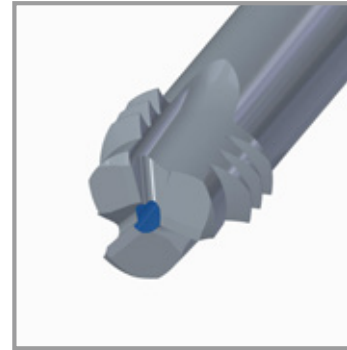
M 0.8 – M 6

UNC 2-56 – UNC 1/4-20

UNF 10-32 – UNF 1/4-28

ZBGF

VS



ZBGF6065VS / ZBGF6067VS

M 3 – M 16

UNC 4-40 – UNC 5/8-11

UNF 4-48 – UNF 5/8-18

► **GEWINDELEHREN**



► **GEWINDEBOHREN**



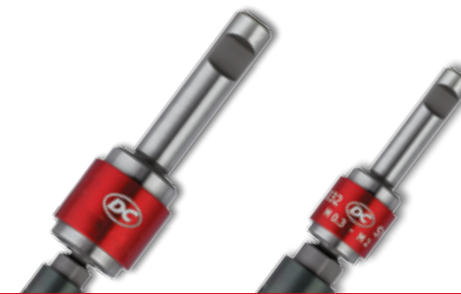
► **GEWINDEFORMEN**



► **GEWINDEFÄSEN**



► **GEWINDESCHNEIDFUTTER**



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