



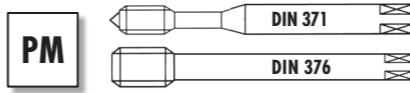
ZX

AMPCO

**ALU-BRONZE
LEGIERUNGEN**



**THREADING
TECHNOLOGY**



ZX AMPCO ALU-BRONZE LEGIERUNGEN		ZX320-4	ZX420-4																																																												
<p>ZX320-4 ZX420-4</p>																																																															
<p>Brinellhärte HB > 280 - 330 Kühlmittel: Schneidöl Schnittgeschwindigkeit: Vc 2 – 3 m/min</p> <p>Optimal: Ampco 21/22</p>																																																															
<p>Brinellhärte HB < 420 Kühlmittel: Schneidöl Schnittgeschwindigkeit: Vc 6 – 10 m/min Schnittgeschwindigkeit: Vc 2 – 3 m/min</p> <p>Geeignet: Ampco 18 Ampco 25/26</p>																																																															
<table border="1"> <thead> <tr> <th>∅ d₁ M</th> <th>P mm</th> <th>l₁ mm</th> <th>l₂ mm</th> <th>l₃ mm</th> <th>d₂ mm</th> <th>a mm</th> <th></th> <th></th> <th>ID</th> </tr> </thead> <tbody> <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> </tbody> </table>		∅ d ₁ M	P mm	l ₁ mm	l ₂ mm	l ₃ mm	d ₂ mm	a mm			ID	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



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<p>Brinellhärte HB < 200 Kühlmittel: Schneidöl Schnittgeschwindigkeit: Vc 6 – 10 m/min</p> <p>Optimal: Ampco 18</p>																																																																																													
<p>Brinellhärte HB > 380 - 420 Kühlmittel: Schneidöl/Emulsion Fräsgeschwindigkeit: Vc 25 – 50 m/min Vorschub: fz 0.01 – 0.04 mm/Zahn</p> <p>Optimal: Ampco 25/26</p>																																																																																													
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