

SKR

$\varnothing D = 3,3 - 17,5$

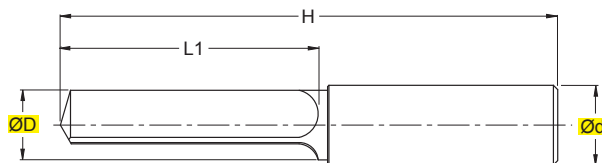
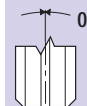
GENERICO / ALL PURPOSE

$V_c = 120 \div 150 \text{ m/min}$

$f_n = 0,03 \div 0,05 \text{ mm/giro} - \text{mm/rev.}$

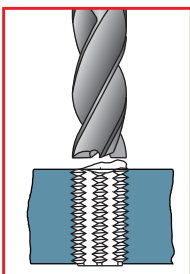
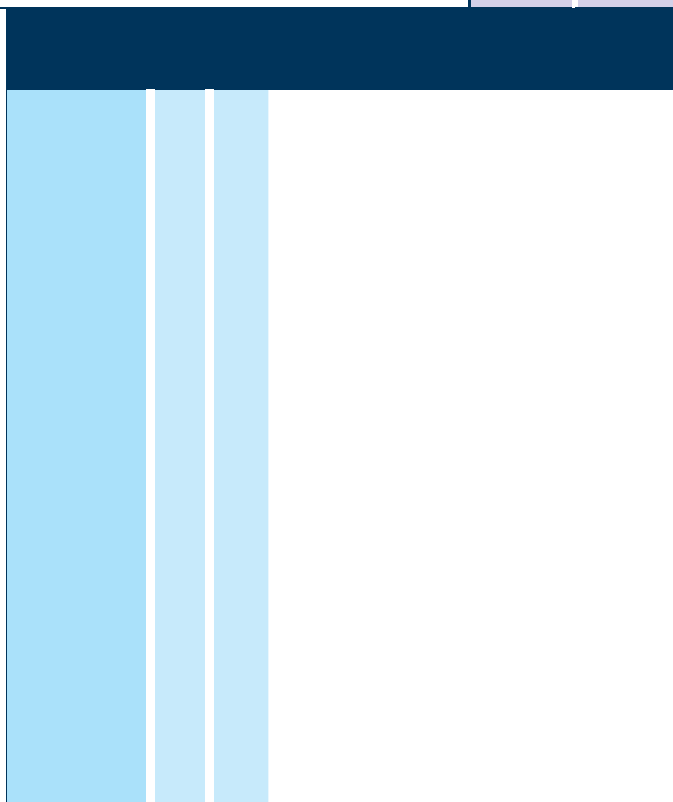
RIVESTIM.
COATED

TIN



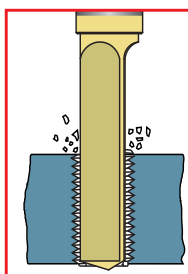
TOLLERANZE	D	d
TOLLERANCE RANGE	e9	h6

ART.	$\varnothing D$	$\varnothing d$	H	L1	Z	Filetto Thread
SKR01M04	3,3	6	50	15	3	M4
SKR01M05	4,2	6	50	15	3	M5
SKR01M06	5,0	6	50	15	3	M6
SKR01M08	6,8	8	60	20	3	M8
SKR01M10	8,5	10	70	25	3	M10
SKR01M12	10,2	12	75	30	3	M12
SKR01M14	12,0	12	75	30	3	M14
SKR01M16	14,0	14	100	40	3	M16
SKR01M18	15,5	16	100	40	3	M18
SKR01M20	17,5	18	100	50	3	M20



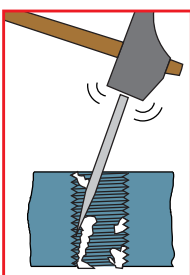
Fase 1. Con una fresa M.D.I. cercare di pareggiare il piano di rottura del maschio.

Step 1. With an HM mill try to level off the tap breakage plane.



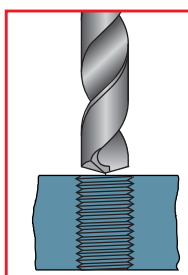
Fase 2. Cominciare la perforazione con il DGM. La refrigerazione può anche essere ad acqua.

Step 2. Begin the hole with the DGM. Water cooling can also be used.



Fase 3. È importante eliminare le scaglie di acciaio rimanenti sulle pareti del filetto. Utilizzare un qualsiasi utensile appuntito.

Step 3. It is important to remove the steel flakes left on the sides of the thread. Use any pointed tool.



Fase 4. Si consiglia di ripassare il foro con una punta M.D.I. del diametro di pre-foro.

Step 4. The hole should be re-machined with a HM bit with a diameter corresponding to the pre-hole.