

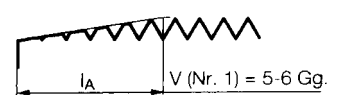
Diametro di foratura per filettature

Filettatura metrica regolare ISO DIN 336					Filettatura metrica fine ISO DIN 336										Filettatura UNC DIN 336 (ISO 5864)							
Ø nominale	passo P	Ø foro	Ø di nocciolo madrevite		Ø nominale	x	passo P	Ø foro	Ø di nocciolo madrevite		Ø nominale	x	passo P	Ø foro	Ø di nocciolo madrevite		Ø nominale	passo P	Ø foro	Ø di nocciolo madrevite		
			min	max					min	max					min	max				min	max	
	(mm)	(mm)	(mm)	(mm)			(mm)	(mm)	(mm)	(mm)			(mm)	(mm)	(mm)	(mm)				(mm)	(mm)	
M 1	0,25	0,75	0,729	-	M 2,5	x	0,35	2,15	2,121	2,221	M 24	x	1,50	22,50	22,376	22,676	N° 1	-	64	1,50	1,425	1,582
M 1,1	0,25	0,85	0,829	-	M 3	x	0,35	2,65	2,621	2,721	M 24	x	2,00	22,00	21,835	22,210	N° 2	-	56	1,85	1,694	1,872
M 1,2	0,25	0,95	0,929	-	M 3,5	x	0,35	3,15	3,121	3,221	M 25	x	1,00	24,00	23,917	24,153	N° 3	-	48	2,10	1,941	2,146
M 1,4	0,30	1,10	1,075	-	M 4	x	0,50	3,50	3,459	3,599	M 25	x	1,50	23,50	23,376	23,676	N° 4	-	40	2,35	2,385	2,156
M 1,6	0,35	1,25	1,221	1,321	M 4,5	x	0,50	4,00	3,959	4,099	M 25	x	2,00	23,00	23,835	23,210	N° 5	-	40	2,65	2,697	2,487
M 1,8	0,35	1,45	1,421	1,521	M 5	x	0,50	4,50	4,459	4,599	M 27	x	1,00	26,00	25,917	26,153	N° 6	-	32	2,85	2,642	2,896
M 2	0,40	1,60	1,567	1,679	M 5,5	x	0,50	5,00	4,959	5,099	M 27	x	1,50	25,50	25,376	25,676	N° 8	-	32	3,50	3,302	3,531
M 2,2	0,45	1,75	1,713	1,838	M 6,0	x	0,75	5,20	5,188	5,378	M 27	x	2,00	25,00	24,835	25,210	N° 10	-	24	3,90	3,683	3,962
M 2,5	0,45	2,05	2,013	2,138	M 7,0	x	0,75	6,20	6,188	6,378	M 28	x	1,00	27,00	26,917	27,153	N° 12	-	24	4,50	4,343	4,597
M 3	0,50	2,50	2,459	2,599	M 8,0	x	0,75	7,20	7,188	7,378	M 28	x	1,50	26,50	26,376	26,678	1/4	-	20	5,10	4,976	5,268
M 3,5	0,60	2,90	2,850	3,010	M 8,0	x	1,00	7,00	6,917	7,153	M 28	x	2,00	26,00	25,853	26,210	5/16	-	18	6,60	6,411	6,734
M 4	0,70	3,30	3,242	3,422	M 9,0	x	0,75	8,20	8,188	8,378	M 30	x	1,00	29,00	28,917	29,153	3/8	-	16	8,00	7,805	8,164
M 4,5	0,75	3,70	3,688	3,878	M 9,0	x	1,00	8,00	7,917	8,153	M 30	x	1,50	28,35	26,676	28,676	7/16	-	14	9,40	9,149	9,550
M 5	0,80	4,20	4,134	4,334	M 10	x	0,75	9,20	9,188	9,378	M 30	x	2,00	28,00	27,835	28,210	1/2	-	13	10,80	10,584	11,013
M 6	1,00	5,00	4,917	5,153	M 10	x	1,00	9,00	8,917	9,153	M 30	x	3,00	27,00	26,752	27,252	9/16	-	12	12,20	11,996	12,456
M 7	1,00	6,00	5,917	6,153	M 10	x	1,25	8,80	8,647	8,912	M 32	x	1,50	30,50	30,376	30,676	5/8	-	11	13,50	13,376	13,868
M 8	1,25	6,80	6,647	6,912	M 11	x	0,75	10,20	10,188	10,378	M 32	x	2,00	30,00	29,835	30,210	3/4	-	10	16,50	16,299	16,833
M 9	1,25	7,80	7,647	7,912	M 11	x	1,00	10,00	9,917	10,153	M 33	x	1,50	31,50	31,376	31,676	7/8	-	9	19,50	19,169	19,748
M 10	1,50	8,50	8,376	8,676	M 12	x	1,00	11,00	10,917	11,153	M 33	x	2,00	31,00	30,835	31,210	1	-	8	22,25	21,963	22,598
M 11	1,50	9,50	9,376	9,676	M 12	x	1,25	10,80	10,647	10,912	M 33	x	3,00	30,00	29,752	30,252	1 1/8	-	7	25,00	24,648	25,349
M 12	1,75	10,20	10,106	10,441	M 12	x	1,50	10,50	10,376	10,676	M 35	x	1,50	33,50	33,376	33,676	1 1/4	-	7	28,00	27,823	28,542
M 14	2,00	12,00	11,835	12,210	M 14	x	1,00	13,00	12,917	13,153	M 36	x	1,50	34,50	34,376	34,676	1 3/8	-	6	30,75	30,343	31,120
M 16	2,00	14,00	13,835	14,210	M 14	x	1,25	12,80	12,647	12,912							1 1/2	-	6	34,00	33,518	34,295
M 18	2,50	15,50	15,294	15,744	M 14	x	1,50	12,50	12,376	12,676							1 3/4	-	5	39,50	38,951	39,814
M 20	2,50	17,50	17,294	17,744	M 15	x	1,00	14,00	13,917	14,153							2	-	4,5	45,00	44,689	45,598
M 22	2,50	19,50	19,294	19,744	M 15	x	1,50	13,50	13,376	13,676												
M 24	3,00	21,00	20,752	21,252	M 16	x	1,00	15,00	14,197	15,153												
M 27	3,00	24,00	23,752	24,252	M 16	x	1,50	14,50	14,376	14,676												
M 30	3,50	26,50	26,211	26,771	M 17	x	1,00	16,00	15,917	16,153												
M 33	3,50	29,50	29,211	29,771	M 17	x	1,50	15,50	15,376	15,676												
M 36	4,00	32,00	31,670	32,270	M 18	x	1,00	17,70	16,917	17,153												
M 39	4,00	35,00	34,670	35,270	M 18	x	1,50	16,50	16,376	16,670												
M 42	4,50	37,50	37,129	37,799	M 18	x	2,00	16,00	15,835	16,210												
M 45	4,50	40,50	40,129	40,799	M 20	x	1,00	19,00	18,917	19,153												
M 48	5,00	43,00	42,587	43,297	M 20	x	1,50	18,50	18,376	18,676												
M 52	5,00	47,00	46,587	47,287	M 20	x	2,00	18,00	17,835	18,210												
M 56	5,50	50,50	50,046	50,796	M 22	x	1,00	21,00	20,917	21,153												
					M 22	x	1,50	20,50	20,376	20,676												
					M 22	x	2,00	20,00	19,835	20,210												
					M 24	x	1,00	23,00	22,917	23,153												

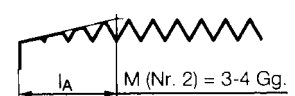
Schema d'imbocco dei filetti nei maschi a mano

I_A Forma d'imbocco

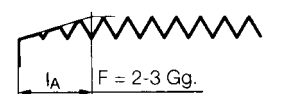
Sbozzatore 5 - 6 fil.



Intermedio 3 - 4 fil.



Finitore 2 - 3 fil.





Diametro di foratura per filettature

Filettatura UNF DIN 336 (ISO 5864)					Filettatura BSW (Whitworth)					Filettatura Gas					Filettatura Pg				
Ø nominale	passo P	Ø foro	Ø di nocciolo madrevite		Ø nominale	passo P	Ø foro	Ø di nocciolo madrevite		Ø nominale	passo P	Ø foro	Ø di nocciolo madrevite		Ø nominale	passo P	Ø foro	Ø di nocciolo madrevite	
per pollice			min	max	per pollice			min	max	per pollice			min	max	per pollice			min	max
(mm)		(mm)	(mm)	(mm)	(mm)		(mm)	(mm)	(mm)	(mm)		(mm)	(mm)	(mm)	(mm)		(mm)	(mm)	(mm)
N° 1	- 72	1,55	1,473	1,613	W 1/8	40	2,50	-	-	G 1/16	28	6,80	6,561	6,843	Pg 7,0	20	11,40	11,280	11,430
N° 2	- 64	1,90	1,755	1,913	W 5/32	32	3,20	-	-	G 1/8	28	8,80	8,566	8,848	Pg 9,0	18	14,00	13,860	14,010
N° 3	- 56	2,15	2,024	2,170	W 3/16	24	3,60	-	-	G 1/4	19	11,80	11,445	11,890	Pg 11,0	18	17,30	17,260	17,410
N° 4	- 48	2,40	2,271	2,459	W 1/4	20	5,10	4,744	5,224	G 3/8	19	15,58	15,395	14,950	Pg 13,5	18	19,00	19,060	19,210
N° 5	- 44	2,70	2,550	2,741	W 5/16	18	6,50	6,151	6,661	G 1/2	14	19,00	18,631	19,172	Pg 16,0	18	21,30	21,160	21,310
N° 6	- 40	2,95	2,819	3,023	W 3/8	16	7,90	7,512	8,052	G 5/8	14	21,00	20,587	21,128	Pg 21,0	16	26,90	26,780	27,030
N° 8	- 36	3,50	3,404	3,607	W 7/16	14	9,20	8,809	9,379	G 3/4	14	24,50	24,117	24,658	Pg 29,0	16	35,50	35,480	35,730
N° 10	- 32	4,10	3,962	4,116	W 1/2	12	10,50	10,015	10,610	G 7/8	14	28,25	27,877	28,418	Pg 36,0	16	45,50	45,480	45,730
N° 12	- 28	4,70	4,496	4,724	W 5/8	11	13,50	12,948	13,598	G 1	11	30,75	30,291	30,931	Pg 42,0	16	52,50	52,480	52,730
1/4	- 28	5,50	5,367	5,580	W 3/4	10	16,25	15,831	16,538	G 1 1/8	11	35,50	34,939	35,579	Pg 48,0	16	57,80	57,780	58,030
5/16	- 24	6,90	6,792	7,038	W 7/8	9	19,25	18,647	19,411	G 1 1/4	11	39,50	38,952	39,592					
3/8	- 24	8,50	8,379	8,626	W 1	8	22,00	21,375	22,185	G 1 1/2	11	45,25	44,845	45,485					
7/16	- 20	9,90	9,739	10,030	W 1 1/8	7	24,50	23,976	24,879	G 1 3/4	11	51,00	50,788	51,428					
1/2	- 20	11,50	11,326	11,618	W 1 1/4	7	27,75	27,151	28,054	G 2	11	57,00	56,656	57,296					
9/16	- 18	12,90	12,761	13,084	W 1 3/8	6	30,50	29,558	30,555										
5/8	- 18	14,50	14,348	14,671	W 1 1/2	6	33,50	32,733	33,730										
3/4	- 16	17,50	17,330	17,689	W 1 5/8	5	35,50	34,834	35,921										
7/8	- 14	20,40	20,262	20,663	W 1 3/4	5	39,00	38,009	39,096										
1	- 12	23,25	23,109	23,569	W 2	4,5	44,50	43,643	44,823										
1 1/8	- 12	26,50	26,284	26,744															
1 1/4	- 12	29,50	29,459	29,919															
1 3/8	- 12	32,75	32,634	33,094															
1 1/2	- 12	36,00	35,809	36,269															

Tabella di conversione della velocità di taglio, in n° di giri al minuto, in funzione del diametro del maschio

Ø = M (mm)	Velocità di taglio (VC) m/min															
	1	2	3	4	5	6	8	10	12	15	20	25	30	40	50	60
	N° giri/min															
1	318	637	955	1274	1592	1911	2548	3185	3822	4777	6369	7962	9554	12739	15924	19108
2	159	318	478	637	796	955	1274	1592	1911	2389	3185	3981	4777	6369	7962	9554
3	106	212	318	425	531	637	849	1062	1274	1592	2123	2654	3185	4246	5308	6369
4	80	159	239	318	396	478	637	796	955	1194	1592	1990	2389	3185	3981	4777
5	64	127	191	255	318	382	510	637	764	955	1274	1592	1911	2548	3185	3822
6	53	106	159	210	265	318	425	531	637	796	1062	1327	1592	2123	2654	3185
8	40	80	119	159	199	239	318	398	478	597	796	995	1194	1592	1990	2389
10	32	64	96	127	159	191	255	318	382	478	637	796	955	1274	1592	1911
12	27	53	80	106	133	159	212	265	318	398	531	663	796	1062	1327	1592
14	23	45	68	91	114	136	182	227	273	341	455	569	682	910	1137	1365
16	20	40	60	80	100	119	159	199	239	299	398	498	597	796	995	1194
18	18	35	53	71	88	106	142	177	212	265	354	442	531	708	885	1062
20	16	32	48	64	80	96	127	159	191	239	318	398	478	637	796	955
25	13	25	38	51	64	76	102	127	153	191	255	318	382	510	637	764
30	11	21	32	42	53	64	85	106	127	159	212	265	318	425	531	637
35	9	18	27	36	45	55	73	91	109	136	182	227	273	364	455	546
40	8	16	24	32	40	48	64	80	96	119	159	199	239	318	398	478
45	7	14	21	28	35	42	57	71	85	106	142	177	212	283	354	425
50	6	13	19	25	32	38	51	64	76	96	127	159	191	255	318	382