



REDLINE

Pełna oferta płytek o podwyższonej grubości do gwintów



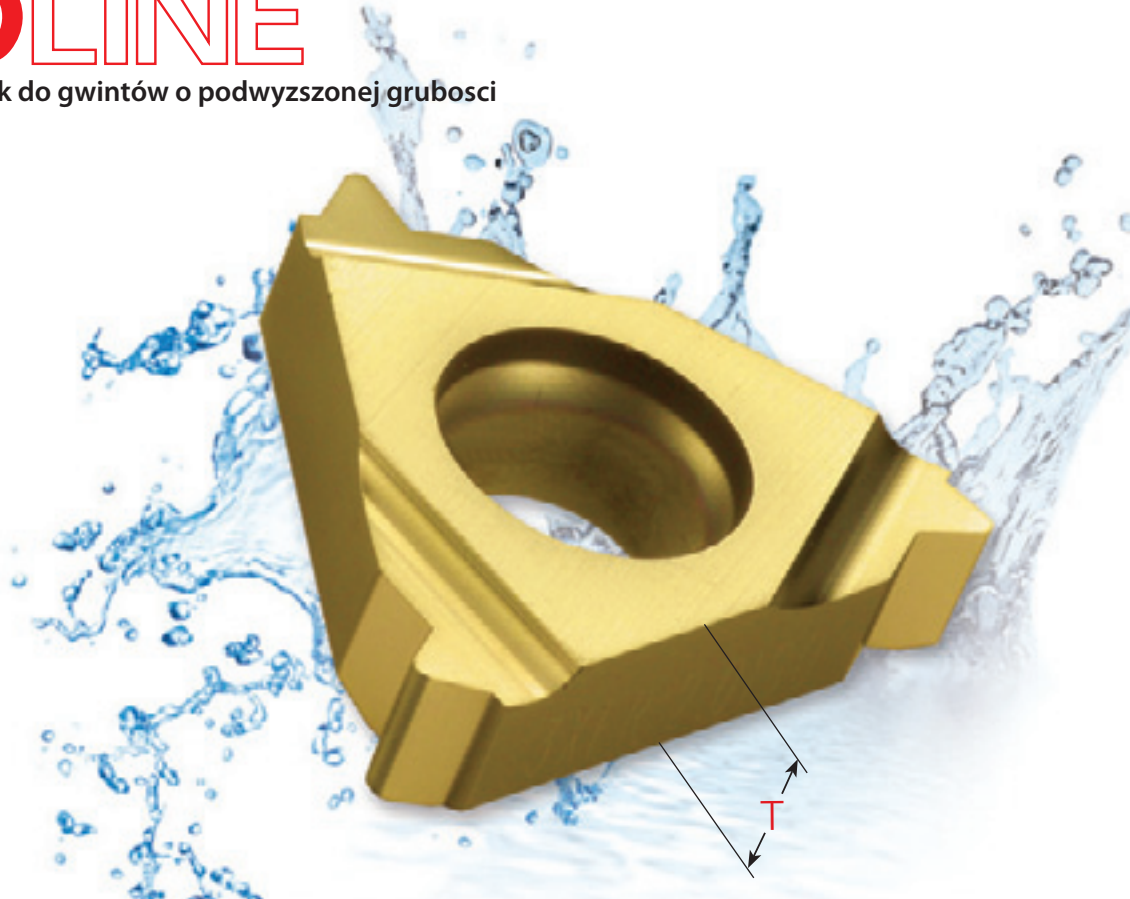
METRYCZNY

VARDEX

Advanced Threading Solutions



Pełna oferta płytek do gwintów o podwyższonej grubości

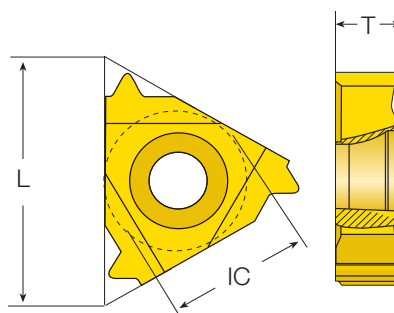


- Pasuje do standardowych opravek na płytki o podwyższonej grubości
- Nie wymaga wymiany opravek na płytki o normalnej grubości
- Produkowane w najnowszym gatunku VKX



Grubość płytek Redline (T)

| I.C. | L (mm) | T - Standard (mm) | T - Redline (mm) |
|------|--------|-------------------|------------------|
| 1/4" | 11 | 3.17 | 3.39 |
| 3/8" | 16 | 3.60 | 4.30 |
| 1/2" | 22 | 4.76 | 5.90 |



KATALOG REDLINE

INSERTS

| | |
|-----------------------------|-----------|
| ■ Profil niepełny 60° | Strona 4 |
| ■ Profil niepełny 55° | Strona 4 |
| ■ American UN | Strona 5 |
| ■ ISO Metryczny | Strona 6 |
| ■ Whitworth for BSW, BSP | Strona 7 |
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| ■ API | Strona 11 |
| ■ API Buttress Casing | Strona 12 |
| ■ API Round Casing & Tubing | Strona 12 |

OPRAWKA

| | |
|--------------|-----------|
| ■ Zewnętrzna | Strona 13 |
| ■ Wewnętrzna | Strona 13 |

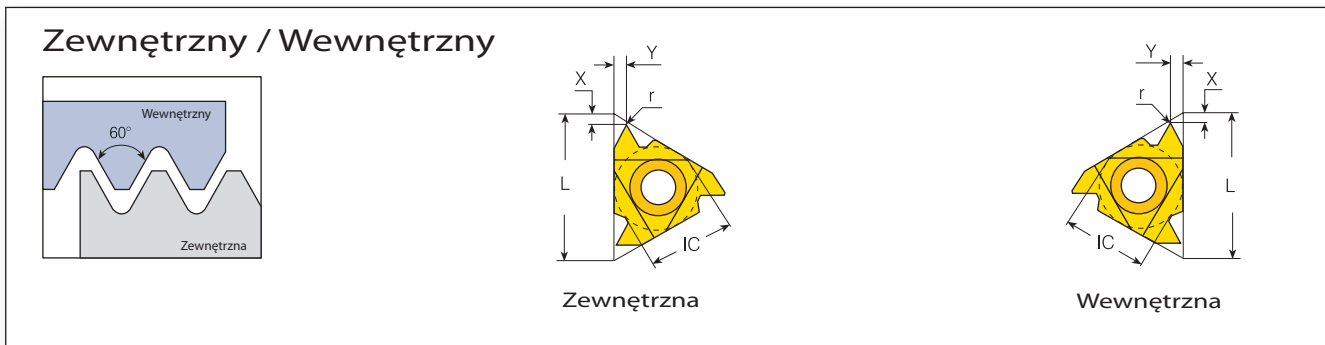
TECHNICAL DATA

| | |
|--|-----------|
| ■ Kat pochylenia linii śrubowej gwintu i wybór płytek podkładowych | Strona 14 |
| ■ Rysunki standardu API | Strona 15 |
| ■ Parametry skrawania | Strona 16 |



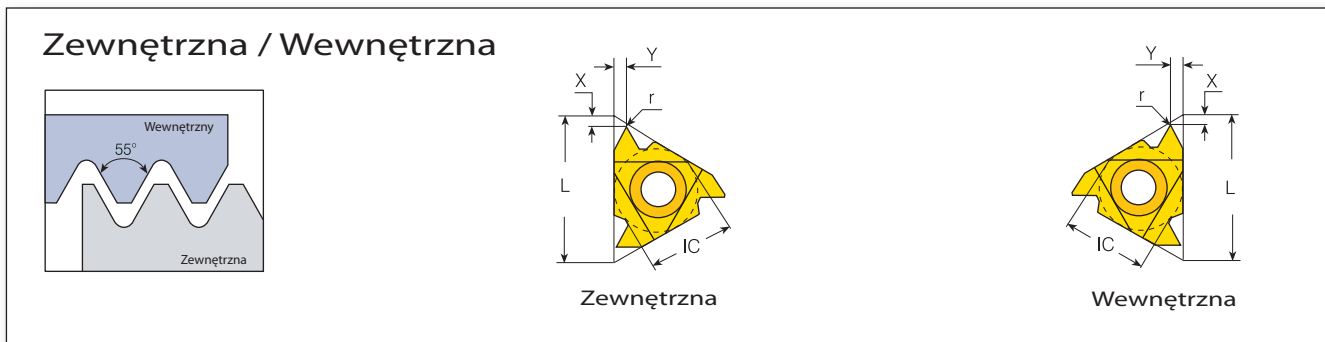
Program TT GEN może być zainstalowany i uaktualniany ze strony www.vargus.com

Profil niepełny 60°



| | Wielkość płytki | | Skok | | Oznaczenie | Wymiary (mm) | | | Podkładka | | | | | | |
|--|-----------------|------|------|----------|------------|--------------|-------|------------|-----------|---------|-----------|------|------|-----|-----------|
| | IC | L mm | mm | tpi | RH | r | X | Y | RH | Oprawka | | | | | |
| | Zewnętrzna | 3/8" | 16 | 0.5-1.5 | 48-16 | 3XERA60... | 0.05 | 1.04 | 0.99 | YE3 | AL...-3X | | | | |
| | | | | 1.75-3.0 | 14-8 | 3XERG60... | 0.27 | 1.10 | 1.65 | | | | | | |
| | | | | 0.5-3.0 | 48-8 | 3XERAG60... | 0.08 | 1.17 | 1.70 | | | | | | |
| | Wewnętrzna | 3/8" | 16 | 0.5-1.5 | 48-16 | 3XIRA60... | 0.05 | 1.04 | 0.94 | YI3 | AVR...-3X | | | | |
| | | | | 1.75-3.0 | 14-8 | 3XIRG60... | 0.16 | 1.12 | 1.60 | | | | | | |
| | | | | 0.5-3.0 | 48-8 | 3XIRAG60... | 0.05 | 1.28 | 1.60 | | | | | | |
| | | | | 1/2" | 22 | 3.5-6.0 | 7-5 | 4XIRP60... | 0.30 | | | 0.68 | 2.60 | YI4 | AVR...-4X |
| | | | | 1/4" | 11 | 0.5-1.5 | 48-16 | 2XIRA60... | 0.05 | | | 0.72 | 0.90 | - | NVR...-2X |

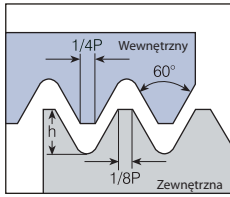
Profil niepełny 55°



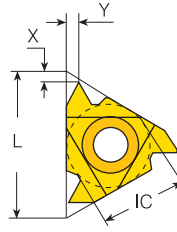
| | Wielkość płytki | | Skok | | Oznaczenie | Wymiary (mm) | | | Podkładka | | | | | | |
|--|-----------------|------|------|----------|------------|--------------|-------|------------|-----------|---------|-----------|------|------|-----|-----------|
| | IC | L mm | mm | tpi | RH | r | X | Y | RH | Oprawka | | | | | |
| | Zewnętrzna | 3/8" | 16 | 0.5-1.5 | 48-16 | 3XERA55... | 0.05 | 1.04 | 0.99 | YE3 | AL...-3X | | | | |
| | | | | 1.75-3.0 | 14-8 | 3XERG55... | 0.21 | 1.10 | 1.65 | | | | | | |
| | | | | 0.5-3.0 | 48-8 | 3XERAG55... | 0.07 | 1.13 | 1.70 | | | | | | |
| | Wewnętrzna | 3/8" | 16 | 0.5-1.5 | 48-16 | 3XIRA55... | 0.05 | 1.04 | 0.90 | YI3 | AVR...-3X | | | | |
| | | | | 1.75-3.0 | 14-8 | 3XIRG55... | 0.21 | 1.12 | 1.65 | | | | | | |
| | | | | 0.5-3.0 | 48-8 | 3XIRAG55... | 0.07 | 1.12 | 1.70 | | | | | | |
| | | | | 1/2" | 22 | 3.5-6.0 | 7-4 | 4XIRP55... | 0.43 | | | 0.25 | 2.75 | YI4 | AVR...-4X |
| | | | | 1/4" | 11 | 0.5-1.5 | 48-16 | 2XIRA55... | 0.05 | | | 0.72 | 0.90 | - | NVR...-2X |

ISO Metryczny

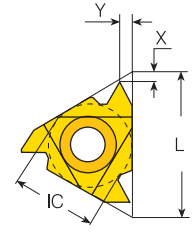
Zewnętrzny / Wewnętrzny





Określony w: R262 (DIN 13)
Klasa tolerancji: 6g/6H



Zewnętrzna

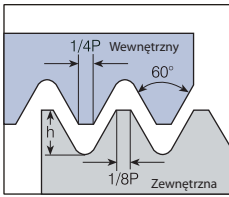


Wewnętrzna

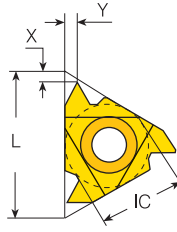
| | Wielkość płytki | | Skok mm | Oznaczenie RH | Wymiary (mm) | | | Podkładka | |
|---|-----------------|---------------|---------------|------------------|--------------|------|------|-----------|-----------|
| | IC | L mm | | | h min | X | Y | RH | Oprawka |
|  Zewnętrzna | 3/8" | 16 | 0.5 | 3XER0.5ISO... | 0.31 | 1.32 | 0.50 | YE3 | AL...-3X |
| | | | 0.75 | 3XER0.75ISO... | 0.46 | 1.32 | 0.50 | | |
| | | | 0.8 | 3XER0.8ISO... | 0.49 | 1.32 | 0.60 | | |
| | | | 1.0 | 3XER1.0ISO... | 0.61 | 1.32 | 0.80 | | |
| | | | 1.25 | 3XER1.25ISO... | 0.77 | 1.32 | 0.80 | | |
| | | | 1.5 | 3XER1.5ISO... | 0.92 | 1.32 | 1.00 | | |
| | | | 1.75 | 3XER1.75ISO... | 1.07 | 1.32 | 1.20 | | |
| | | | 2.0 | 3XER2.0ISO... | 1.23 | 1.32 | 1.40 | | |
| | | | 2.5 | 3XER2.5ISO... | 1.53 | 1.32 | 1.40 | | |
| | 3.0 | 3XER3.0ISO... | 1.84 | 1.32 | 1.80 | | | | |
| | 1/2" | 22 | 3.5 | 4XER3.5ISO... | 2.15 | 1.67 | 2.40 | YE4 | AL...-4X |
| | | | 4.0 | 4XER4.0ISO... | 2.45 | 1.67 | 2.40 | | |
| | | | 4.5 | 4XER4.5ISO... | 2.76 | 1.67 | 2.35 | | |
| | | | 5.0 | 4XER5.0ISO... | 3.07 | 1.38 | 2.50 | | |
| 6.0 | | | 4XER6.0ISO... | 3.68 | 0.88 | 2.80 | | | |
|  Wewnętrzna | 1/4" | 11 | 0.5 | 2XIR0.5ISO... | 0.29 | 0.72 | 0.50 | - | NVR...-2X |
| | | | 0.75 | 2XIR0.75ISO... | 0.43 | 0.72 | 0.60 | | |
| | | | 1.0 | 2XIR1.0ISO... | 0.58 | 0.72 | 0.85 | | |
| | | | 1.5 | 2XIR1.5ISO... | 0.87 | 0.72 | 0.90 | | |
| | | | 2.0 | 2XIR2.0ISO... | 1.15 | 0.72 | 0.92 | | |
| | 3/8" | 16 | 0.75 | 3XIR0.75ISO... | 0.43 | 1.30 | 0.50 | YI3 | AVR...-3X |
| | | | 1.0 | 3XIR1.0ISO... | 0.58 | 1.30 | 0.80 | | |
| | | | 1.25 | 3XIR1.25ISO... | 0.72 | 1.30 | 0.80 | | |
| | | | 1.5 | 3XIR1.5ISO... | 0.87 | 1.30 | 1.00 | | |
| | | | 1.75 | 3XIR1.75ISO... | 1.01 | 1.30 | 1.20 | | |
| | | | 2.0 | 3XIR2.0ISO... | 1.15 | 1.30 | 1.40 | | |
| | | | 2.5 | 3XIR2.5ISO... | 1.44 | 1.30 | 1.40 | | |
| | | | 3.0 | 3XIR3.0ISO... | 1.73 | 1.30 | 1.80 | | |
| | 1/2" | 22 | 3.5 | 4XIR3.5ISO... | 2.02 | 1.64 | 2.40 | YI4 | AVR...-4X |
| 4.0 | | | 4XIR4.0ISO... | 2.31 | 1.64 | 2.40 | | | |
| 4.5 | | | 4XIR4.5ISO... | 2.60 | 1.64 | 2.40 | | | |
| 5.0 | | | 4XIR5.0ISO... | 2.89 | 1.35 | 2.50 | | | |
| 6.0 | | | 4XIR6.0ISO... | 3.46 | 0.87 | 2.40 | | | |

American UN

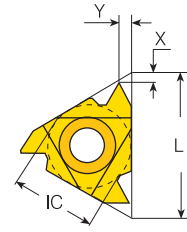
Zewnętrzny / Wewnętrzny





Określony w: ANSI B1.1:74
Klasa tolerancji: 2A/2B



Zewnętrzna

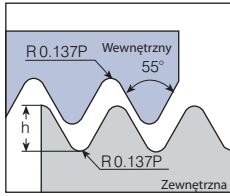


Wewnętrzna

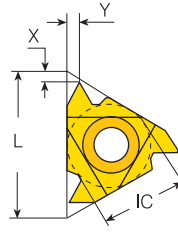
| | Wielkość płytki | | Skok | Oznaczenie | Wymiary (mm) | | | Podkładka | | |
|---|-----------------|------|------|-------------|--------------|------|------|-----------|-----------|-----------|
| | IC | L mm | | | h min | X | Y | RH | Oprawka | |
|  | Zewnętrzna | 3/8" | 16 | 32 | 3XER32UN... | 0.49 | 1.32 | 0.50 | YE3 | AL...-3X |
| | | | | 28 | 3XER28UN... | 0.56 | 1.32 | 0.80 | | |
| | | | | 24 | 3XER24UN... | 0.65 | 1.32 | 0.80 | | |
| | | | | 20 | 3XER20UN... | 0.78 | 1.32 | 0.80 | | |
| | | | | 18 | 3XER18UN... | 0.87 | 1.32 | 1.00 | | |
| | | | | 16 | 3XER16UN... | 0.97 | 1.32 | 1.00 | | |
| | | | | 14 | 3XER14UN... | 1.11 | 1.32 | 1.20 | | |
| | | | | 13 | 3XER13UN... | 1.20 | 1.32 | 1.40 | | |
| | | | | 12 | 3XER12UN... | 1.30 | 1.32 | 1.40 | | |
| | | | | 8 | 3XER8UN... | 1.95 | 1.32 | 1.45 | | |
|  | Wewnętrzna | 1/4" | 11 | 32 | 2XIR32UN... | 0.46 | 0.72 | 0.60 | - | NVR...-2X |
| | | | | 28 | 2XIR28UN... | 0.52 | 0.72 | 0.80 | | |
| | | | | 24 | 2XIR24UN... | 0.61 | 0.72 | 0.85 | | |
| | | | | 20 | 2XIR20UN... | 0.73 | 0.72 | 0.90 | | |
| | | | | 18 | 2XIR18UN... | 0.81 | 0.72 | 0.90 | | |
| | | | | 16 | 2XIR16UN... | 0.92 | 0.72 | 0.90 | | |
| | | | | 14 | 2XIR14UN... | 1.05 | 0.80 | 1.10 | | |
| | 3/8" | 16 | 20 | 3XIR20UN... | 0.73 | 1.30 | 0.80 | YI3 | AVR...-3X | |
| | | | 18 | 3XIR18UN... | 0.81 | 1.30 | 1.00 | | | |
| | | | 16 | 3XIR16UN... | 0.92 | 1.30 | 1.00 | | | |
| | | | 14 | 3XIR14UN... | 1.05 | 1.30 | 1.20 | | | |
| | | | 13 | 3XIR13UN... | 1.13 | 1.30 | 1.40 | | | |
| | | | 12 | 3XIR12UN... | 1.22 | 1.30 | 1.40 | | | |
| | | | 8 | 3XIR8UN... | 1.83 | 1.30 | 1.40 | | | |

Whitworth – BSW, BSP, BSF, BSB

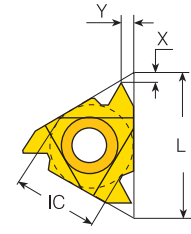
Zewnętrzny / Wewnętrzny



Określony w: BS.84:1956, DIN 259, ISO228/1:1982
Klasa tolerancji: Medium class A



Zewnętrzna

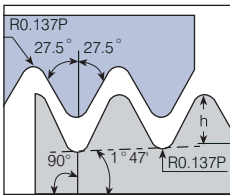


Wewnętrzna

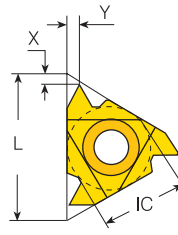
| | Wielkość płytki | | Skok tpi | Oznaczenie RH | Wymiary (mm) | | | Podkładka | | |
|--|-----------------|------|-------------|------------------|--------------|------|------|-----------|---------|-----------|
| | IC | L mm | | | h min | X | Y | RH | Oprawka | |
| | Zewnętrzna | 3/8" | 16 | 28 | 3XER28W... | 0.58 | 1.32 | 0.80 | YE3 | AL...-3X |
| | | | | 19 | 3XER19W... | 0.86 | 1.32 | 0.80 | | |
| | | | | 16 | 3XER16W... | 1.02 | 1.32 | 1.00 | | |
| | | | | 14 | 3XER14W... | 1.16 | 1.32 | 1.40 | | |
| | | | | 11 | 3XER11W... | 1.48 | 1.32 | 1.40 | | |
| | Wewnętrzna | 1/4" | 11 | 19 | 2XIR19W... | 0.86 | 0.72 | 0.90 | - | NVR...-2X |
| | | | | 14 | 2XIR14W... | 1.16 | 0.72 | 0.95 | | |
| | | 3/8" | 16 | 16 | 3XIR16W... | 1.02 | 1.30 | 1.00 | YI3 | AVR...-3X |
| | | | | 14 | 3XIR14W... | 1.16 | 1.30 | 1.20 | | |
| | | | | 11 | 3XIR11W... | 1.48 | 1.30 | 1.40 | | |

BSPT

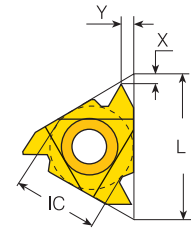
Zewnętrzna / Wewnętrzna



Określony w: B.S. 21:1985
Klasa tolerancji: Standard BSPT



Zewnętrzna

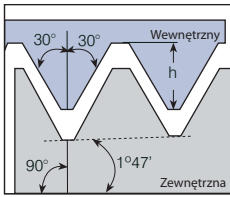


Wewnętrzna

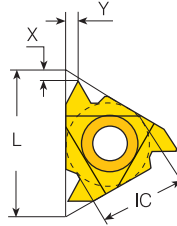
| | Wielkość płytki | | Skok tpi | Oznaczenie RH | Wymiary (mm) | | | Podkładka | | |
|--|-----------------|------|-------------|------------------|---------------|------|------|-----------|---------|-----------|
| | IC | L mm | | | h min | X | Y | RH | Oprawka | |
| | Zewnętrzna | 3/8" | 16 | 19 | 3XER19BSPT... | 0.86 | 1.32 | 0.80 | YE3 | AL...-3X |
| | | | | 14 | 3XER14BSPT... | 1.16 | 1.32 | 1.20 | | |
| | | | | 11 | 3XER11BSPT... | 1.48 | 1.32 | 1.40 | | |
| | Wewnętrzna | 1/4" | 11 | 19 | 2XIR19BSPT... | 0.86 | 0.72 | 0.85 | - | NVR...-2X |
| | | | | 14 | 2XIR14BSPT... | 1.16 | 0.72 | 0.95 | | |
| | | 3/8" | 16 | 14 | 3XIR14BSPT... | 1.16 | 1.30 | 1.20 | YI3 | AVR...-3X |
| | | | | 14 | 3XIR14BSPT... | 1.16 | 1.30 | 1.20 | | |
| | | | | 11 | 3XIR11BSPT... | 1.48 | 1.30 | 1.40 | | |

NPT

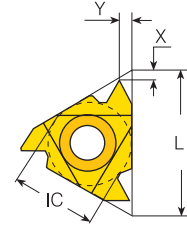
Zewnętrzny / Wewnętrzny





Określony w: USAS B2.1:1968
Klasa tolerancji: Standard NPT



Zewnętrzna

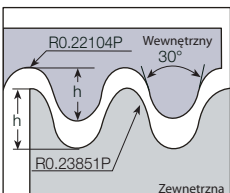


Wewnętrzna

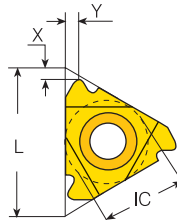
| | Wielkość płytki | | Skok | Oznaczenie | Wymiary (mm) | | | Podkładka | |
|--|-----------------|------|------|----------------|--------------|------|------|-----------|-----------|
| | IC | L mm | tpi | RH | h min | X | Y | RH | Oprawka |
|  Zewnętrzna | 3/8" | 16 | 27 | 3XER27NPT... | 0.66 | 1.03 | 0.80 | YE3 | AL...-3X |
| | | | 18 | 3XER18NPT... | 1.01 | 1.03 | 1.00 | | |
| | | | 14 | 3XER14NPT... | 1.33 | 1.03 | 1.20 | | |
| | | | 11.5 | 3XER11.5NPT... | 1.64 | 1.03 | 1.40 | | |
| | | | 8 | 3XER8NPT... | 2.42 | 1.03 | 1.55 | | |
|  Wewnętrzna | 1/4" | 11 | 18 | 2XIR18NPT... | 1.01 | 0.72 | 0.85 | - | NVR...-2X |
| | | | 14 | 2XIR14NPT... | 1.33 | 0.72 | 1.00 | | |
| | 3/8" | 16 | 14 | 3XIR14NPT... | 1.33 | 1.01 | 1.20 | YI3 | AVR...-3X |
| | | | 11.5 | 3XIR11.5NPT... | 1.64 | 1.01 | 1.40 | | |
| | | | 8 | 3XIR8NPT... | 2.42 | 1.01 | 1.55 | | |

Round (DIN 405)

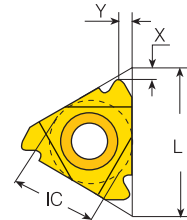
Zewnętrzna / Wewnętrzna





Określony w: DIN 405
Klasa tolerancji: 7h/7H



Zewnętrzna

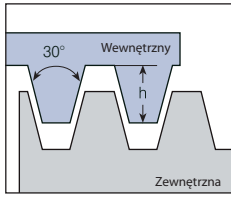


Wewnętrzna

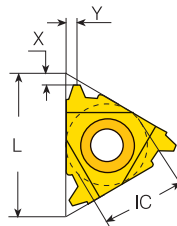
| | Wielkość płytki | | Skok | Oznaczenie | Wymiary (mm) | | | Podkładka | |
|---|-----------------|------|------|------------|--------------|------|------|-----------|-----------|
| | IC | L mm | tpi | RH | h min | X | Y | RH | Oprawka |
|  Zewnętrzna | 3/8" | 16 | 6 | 3XER6RD... | 2.12 | 1.43 | 1.60 | YE3 | AL...-3X |
| | 1/2" | 22 | 4 | 4XER4RD... | 3.18 | 2.12 | 2.13 | YE4 | AL...-4X |
|  Wewnętrzna | 3/8" | 16 | 6 | 3XIR6RD... | 2.12 | 1.45 | 1.60 | YI3 | AVR...-3X |
| | 1/2" | 22 | 4 | 4XIR4RD... | 3.18 | 2.18 | 2.25 | YI4 | AVR...-4X |

Trapez

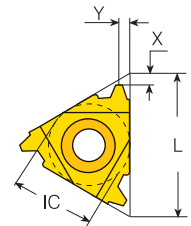
Zewnętrzny / Wewnętrzny





Określony w: DIN 103
Klasa tolerancji: 7e/7H



Zewnętrzna

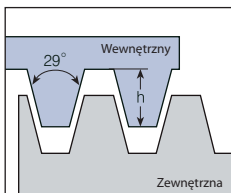


Wewnętrzna

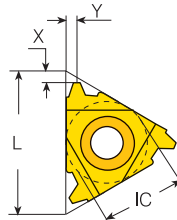
| | Wielkość płytki | | Skok mm | Oznaczenie RH | Wymiary (mm) | | | Podkładka | |
|--|-----------------|------|------------|------------------|--------------|------|------|-----------|-----------|
| | IC | L mm | | | h min | X | Y | RH | Oprawka |
|  Zewnętrzna | 3/8" | 16 | 2.0 | 3XER2.0TR... | 1.25 | 1.37 | 1.10 | YE3 | AL...-3X |
| | | | 3.0 | 3XER3.0TR... | 1.75 | 1.27 | 1.30 | | |
| | | | 4.0 | 4XER4.0TR... | 2.25 | 1.42 | 2.45 | | |
| | 1/2" | 22 | 5.0 | 4XER5.0TR... | 2.75 | 1.42 | 2.45 | YE4 | AL...-4X |
| | | | 6.0 | 4XER6.0TR... | 3.50 | 0.81 | 2.40 | | |
| | | | | | | | | | |
|  Wewnętrzna | 3/8" | 16 | 2.0 | 3XIR2.0TR... | 1.25 | 1.40 | 1.10 | YI3 | AVR...-3X |
| | | | 3.0 | 3XIR3.0TR... | 1.75 | 1.29 | 1.40 | | |
| | | | 4.0 | 4XIR4.0TR... | 2.25 | 1.45 | 2.45 | | |
| | 1/2" | 22 | 5.0 | 4XIR5.0TR... | 2.75 | 1.45 | 2.45 | YI4 | AVR...-4X |
| | | | 6.0 | 4XIR6.0TR... | 3.50 | 0.83 | 2.40 | | |
| | | | | | | | | | |

American ACME

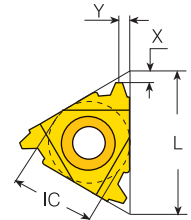
Zewnętrzna / Wewnętrzna





Określony w: ANSI B115:1988
Klasa tolerancji: 3G



Zewnętrzna

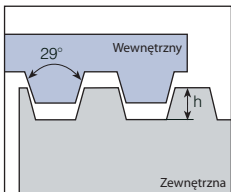
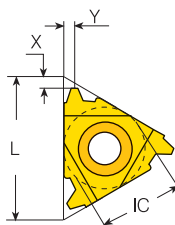
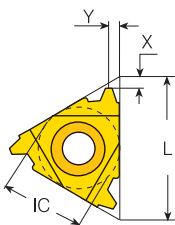


Wewnętrzna

| | Wielkość płytki | | Skok tpi | Oznaczenie RH | Wymiary (mm) | | | Podkładka | |
|---|-----------------|------|-------------|------------------|--------------|------|------|-----------|-----------|
| | IC | L mm | | | h min | X | Y | RH | Oprawka |
|  Zewnętrzna | 3/8" | 16 | 12 | 3XER12ACME... | 1.19 | 1.33 | 1.20 | YE3 | AL...-3X |
| | | | 10 | 3XER10ACME... | 1.52 | 1.33 | 1.30 | | |
| | | | 8 | 3XER8ACME... | 1.84 | 1.50 | 1.30 | | |
| | 1/2" | 22 | 6 | 4XER6ACME... | 2.37 | 1.37 | 2.50 | YE4 | AL...-4X |
| | | | 5 | 4XER5ACME... | 2.79 | 1.37 | 2.50 | | |
| | | | 4 | 4XER4ACME... | 3.43 | 0.76 | 2.40 | | |
|  Wewnętrzna | 3/8" | 16 | 12 | 3XIR12ACME... | 1.19 | 1.30 | 1.20 | YI3 | AVR...-3X |
| | | | 10 | 3XIR10ACME... | 1.52 | 1.30 | 1.30 | | |
| | | | 8 | 3XIR8ACME... | 1.84 | 1.20 | 1.25 | | |
| | 1/2" | 22 | 6 | 4XIR6ACME... | 2.37 | 1.37 | 2.40 | YI4 | AVR...-4X |
| | | | 5 | 4XIR5ACME... | 2.79 | 1.37 | 2.30 | | |
| | | | 4 | 4XIR4ACME... | 3.43 | 0.76 | 2.40 | | |



Stub ACME

Zewnętrzny / Wewnętrzny

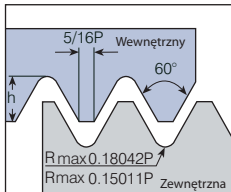
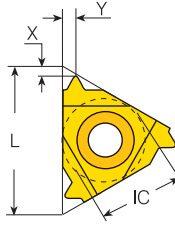
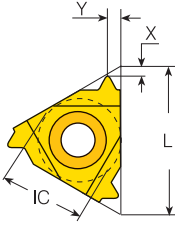
Określony w: ANSI B1.8:1988
Klasa tolerancji: 2G

Zewnętrzna **Wewnętrzna**

| | Wielkość płytki | | Skok | Oznaczenie | Wymiary (mm) | | | Podkładka | | |
|---|-----------------|------|------|------------|-----------------|------|------|-----------|---------|-----------|
| | IC | L mm | tpi | RH | h min | X | Y | RH | Oprawka | |
|  | Zewnętrzna | 3/8" | 16 | 12 | 3XER12STACME... | 0.76 | 1.33 | 1.10 | YE3 | AL...-3X |
| | | | | 10 | 3XER10STACME... | 1.02 | 1.33 | 1.20 | | |
| | | | | 8 | 3XER8STACME... | 1.21 | 1.14 | 1.15 | | |
| | | | | 6 | 3XER6STACME... | 1.52 | 1.67 | 1.50 | | |
|  | Wewnętrzna | 3/8" | 16 | 12 | 3XIR12STACME... | 0.76 | 1.33 | 1.10 | YI3 | AVR...-3X |
| | | | | 10 | 3XIR10STACME... | 1.02 | 1.33 | 1.20 | | |
| | | | | 8 | 3XIR8STACME... | 1.21 | 1.14 | 1.10 | | |
| | | | | 6 | 3XIR6STACME... | 1.52 | 1.67 | 1.60 | | |


UNJ

Zewnętrzna / Wewnętrzna

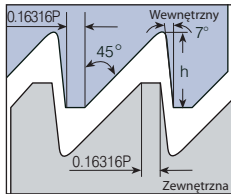
Określony w: MIL-S-8879C
Klasa tolerancji: 3A/3B

Zewnętrzna **Wewnętrzna**

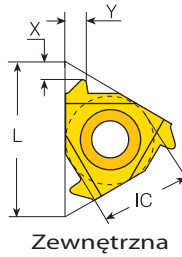
| | Wielkość płytki | | Skok | Oznaczenie | Wymiary (mm) | | | Podkładka | | |
|---|-----------------|------|------|------------|--------------|------|------|-----------|---------|-----------|
| | IC | L mm | tpi | RH | h min | X | Y | RH | Oprawka | |
|  | Zewnętrzna | 3/8" | 16 | 24 | 3XER24UNJ... | 0.61 | 1.32 | 0.80 | YE3 | AL...-3X |
| | | | | 20 | 3XER20UNJ... | 0.73 | 1.32 | 0.80 | | |
| | | | | 18 | 3XER18UNJ... | 0.81 | 1.32 | 1.00 | | |
| | | | | 16 | 3XER16UNJ... | 0.92 | 1.32 | 1.00 | | |
|  | Wewnętrzna | 1/4" | 11 | 18 | 2XIR18UNJ... | 0.74 | 0.72 | 0.90 | - | NVR...-2X |
| | | | | 14 | 2XIR14UNJ... | 0.95 | 0.72 | 0.95 | | |
| | Wewnętrzna | 3/8" | 16 | 16 | 3XIR16UNJ... | 0.83 | 1.30 | 1.00 | YI3 | AVR...-3X |
| | | | | 12 | 3XIR12UNJ... | 1.11 | 1.30 | 1.40 | | |

American Buttress

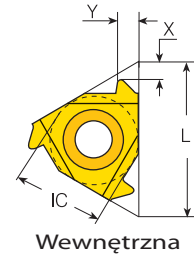
Zewnętrzny / Wewnętrzny



Określony w: ANSI B1.9:1973
Klasa tolerancji: Class 2





Zewnętrzna



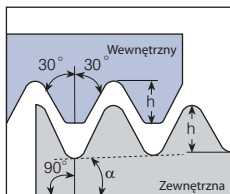
Wewnętrzna



| | Wielkość płytki | | Skok | Oznaczenie | Wymiary (mm) | | | Podkładka | | |
|--|-----------------|------|------|------------|---------------|------|------|-----------|---------|-----------|
| | IC | L mm | | | h min | X | Y | RH | Oprawka | |
|  | Zewnętrzna | 3/8" | 16 | 12 | 3XER12ABUT... | 1.40 | 1.40 | 1.40 | YE3 | AL...-3X |
|  | Wewnętrzna | 3/8" | 16 | 12 | 3XIR12ABUT... | 1.40 | 1.40 | 1.40 | YI3 | AVR...-3X |

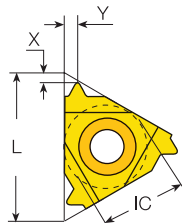
API

Zewnętrzna / Wewnętrzna

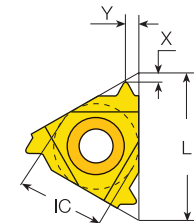


$$\alpha = \arctg (IPF/24)$$

Określony w: API SPEC 7:1990
Klasa tolerancji: Standard API





Zewnętrzna



Wewnętrzna

Dodatkowe informacje o standardzie, wymiarach, tolerancji zobacz str. 15.

| | Wielkość płytki | | Skok | Thread | Taper | Oznaczenie | Size | Wymiary (mm) | | | Podkładka | | |
|---|-----------------|------|------|--------|----------|------------|----------------|----------------------------|------|------|-----------|---------|-----------|
| | IC | L mm | | | | | | h nominal | X | Y | RH | Oprawka | |
|  | Zewnętrzna | 1/2" | 22 | 4 | V-0.038R | 2 | 4XER4API382... | NC23-NC50 | 3.09 | 1.67 | 2.60 | | |
| | | | | 4 | V-0.038R | 3 | 4XER4API383... | NC56-NC77 | 3.08 | 1.67 | 2.70 | | |
| | | | | 4 | V-0.050 | 2 | 4XER4API502... | 6 5/8" REG | 3.75 | 0.98 | 2.80 | YE4 | AL...-4X |
| | | | | 4 | V-0.050 | 3 | 4XER4API503... | 5 1/2", 7 5/8", 8 5/8" REG | 3.74 | 0.98 | 2.90 | | |
| | | | | 5 | V-0.040 | 3 | 4XER5API403... | 2 3/8" - 4 1/2" REG | 2.99 | 1.38 | 2.50 | | |
|  | Wewnętrzna | 1/2" | 22 | 4 | V-0.038R | 2 | 4XIR4API382... | NC23-NC50 | 3.09 | 1.64 | 2.60 | | |
| | | | | 4 | V-0.038R | 3 | 4XIR4API383... | NC56-NC77 | 3.08 | 1.64 | 2.70 | | |
| | | | | 4 | V-0.050 | 2 | 4XIR4API502... | 6 5/8" REG | 3.75 | 0.98 | 2.80 | YI4 | AVR...-4X |
| | | | | 4 | V-0.050 | 3 | 4XIR4API503... | 5 1/2", 7 5/8", 8 5/8" REG | 3.74 | 0.98 | 2.90 | | |
| | | | | 5 | V-0.040 | 3 | 4XIR5API403... | 2 3/8" - 4 1/2" REG | 2.99 | 1.35 | 2.50 | | |

API Buttress Casing

Zewnętrzny / Wewnętrzny

Określony w: STD.5b.1979
Klasa tolerancji: Standard API

Zewnętrzna **Wewnętrzna**

Dodatkowe informacje o standardzie, wymiarach, tolerancji zobacz str. 15.



| | Wielkość płytki | | Skok | Taper | Oznaczenie | Wymiary (mm) | | | Podkładka | | |
|--|-----------------|------|------|-------|------------|---------------|------|------|-----------|---------|-----------|
| | IC | L mm | tpi | IPF | RH | h nominal | X | Y | RH | Oprawka | |
| | Zewnętrzna | 1/2" | 22 | 5 | 0.75 | 4XER5BUT75... | 1.57 | 1.97 | 2.60 | YE4 | AL...-4X |
| | | | | 5 | 1 | 4XER5BUT1... | 1.57 | 1.97 | 2.41 | | |
| | Wewnętrzna | 1/2" | 22 | 5 | 0.75 | 4XIR5BUT75... | 1.57 | 1.93 | 2.89 | YI4 | AVR...-4X |
| | | | | 5 | 1 | 4XIR5BUT1... | 1.57 | 1.93 | 2.09 | | |

API Round Casing & Tubing

Zewnętrzna / Wewnętrzna

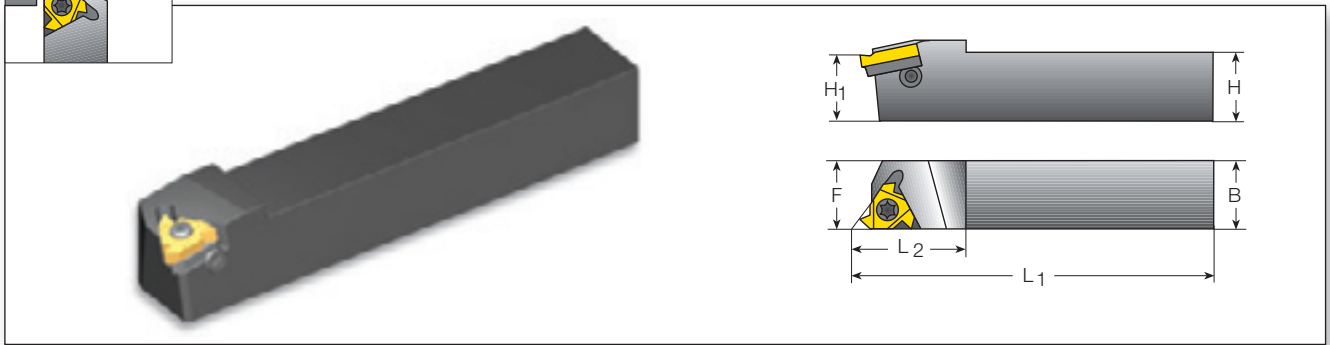
Określony w: API STD.5B:1979
Klasa tolerancji: Standard API RD

Zewnętrzna **Wewnętrzna**

Dodatkowe informacje o standardzie, wymiarach, tolerancji zobacz str. 15.

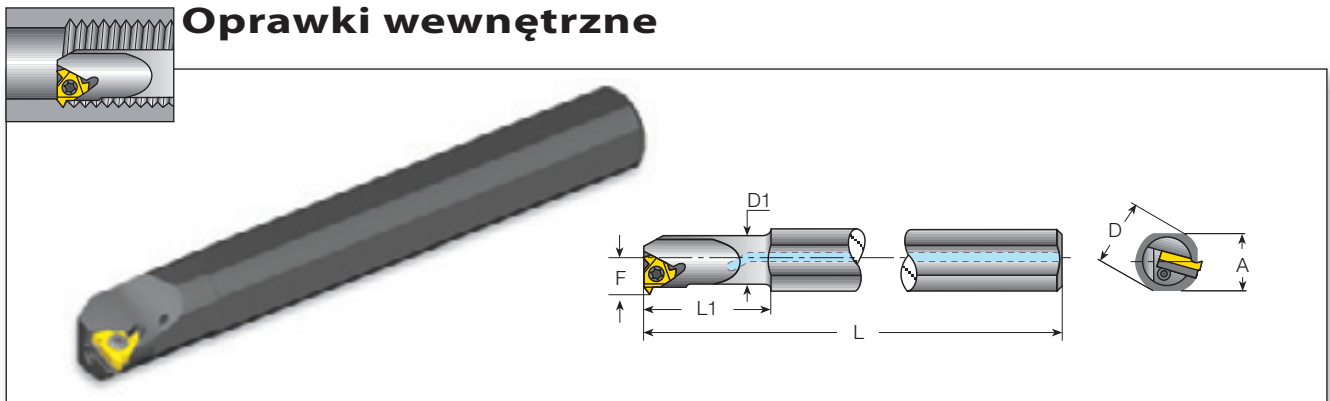
| | Wielkość płytki | | Skok | Oznaczenie | Wymiary (mm) | | | Podkładka | | |
|--|-----------------|------|------|------------|----------------|------|------|-----------|---------|-----------|
| | IC | L mm | tpi | RH | h nominal | X | Y | RH | Oprawka | |
| | Zewnętrzna | 3/8" | 16 | 10 | 3XER10APIRD... | 1.41 | 1.32 | 1.30 | YE3 | AL...-3X |
| | | | | 8 | 3XER8APIRD... | 1.81 | 1.32 | 1.50 | | |
| | | 1/2" | 22 | 10 | 4XER10APIRD... | 1.41 | 1.67 | 2.40 | YE4 | AL...-4X |
| | | | | 8 | 4XER8APIRD... | 1.81 | 1.67 | 2.40 | | |
| | Wewnętrzna | 3/8" | 16 | 10 | 3XIR10APIRD... | 1.41 | 1.30 | 1.30 | YI3 | AVR...-3X |
| | | | | 8 | 3XIR8APIRD... | 1.81 | 1.30 | 1.50 | | |
| | | 1/2" | 22 | 10 | 4XIR10APIRD... | 1.41 | 1.64 | 2.20 | YI4 | AVR...-4X |
| | | | | 8 | 4XIR8APIRD... | 1.81 | 1.64 | 2.20 | | |

Oprawki zewnętrzne



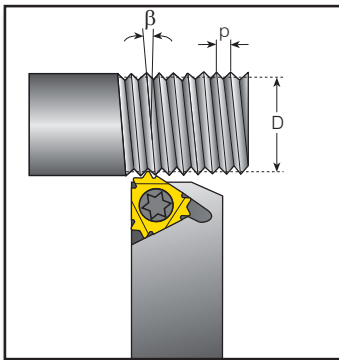
| Wielkość płytki | Oznaczenie | Wymiary (mm) | | | | Części zamienne | | | | |
|-----------------|------------|--------------|----|-------|------|-----------------|------------------|---------|--------------|--------------|
| | | H=H1=B | F | L1 | L2 | Śrubka płytki | Śrubka podkładki | Kluczyk | Podkładka RH | Podkładka LH |
| 3/8" | AL 12-3X | 12 | 16 | 83.2 | 22 | SA3TS | SY3T | K3T | YE3 | YI3 |
| | AL 16-3X | 16 | 16 | 100 | 20.5 | | | | | |
| | AL 20-3X | 20 | 20 | 128.6 | 30 | | | | | |
| | AL 25-3X | 25 | 25 | 153.6 | 30 | | | | | |
| | AL 32-3X | 32 | 32 | 173.6 | 30 | | | | | |
| 1/2" | AL 25-4X | 25 | 25 | 153 | 31 | SA4TS | SY4T | K4T | YE4 | YI4 |
| | AL 32-4X | 32 | 32 | 173 | 34 | | | | | |

Oprawki wewnętrzne



| Wielkość płytki | Oznaczenie | Wymiary (mm) | | | | | | | Minimalna średnica otworu | Części zamienne | | | | |
|-----------------|------------|--------------|-----|----|----|------|-------|----|---------------------------|-----------------|------------------|---------|--------------|--------------|
| | | A | L | L1 | D | D1 | F | mm | | Śrubka płytki | Śrubka podkładki | Kluczyk | Podkładka RH | Podkładka LH |
| 1/4" | NVRC 10-2X | 18 | 180 | 27 | 20 | 10 | 6.64 | 13 | SN2TS | - | K2T | - | - | |
| | NVRC 13-2X | 18 | 180 | 33 | 20 | 13 | 8.17 | 16 | | | | | | |
| 3/8" | NVRC 13-3X | 18 | 180 | 32 | 20 | 12.7 | 10.3 | 17 | SN3TS | - | K3T | - | - | |
| | NVRC 16-3X | 18 | 180 | 40 | 20 | 16 | 11.5 | 20 | | | | | | |
| | AVRC 20-3X | 18 | 180 | 40 | 20 | 20 | 13.4 | 24 | | | | | | |
| | AVRC 25-3X | 29 | 250 | 60 | 32 | 25 | 16.3 | 29 | SA3TS | SY3T | K3T | YI3 | YE3 | |
| | AVRC 32-3X | 29 | 250 | 60 | 32 | 32 | 19.6 | 36 | | | | | | |
| | AVRC 40-3X | 36 | 300 | 60 | 40 | 40 | 23.8 | 44 | | | | | | |
| 1/2" | NVRC 20-4X | 18 | 180 | 51 | 20 | 19.6 | 13.72 | 26 | SN4TS | - | K4T | - | - | |
| | AVRC 25-4X | 28.8 | 250 | 61 | 32 | 25 | 15.91 | 32 | | | | | | |
| | AVRC 32-4X | 28.8 | 250 | 51 | 32 | 31.6 | 19.41 | 38 | SA4TS | SY4T | K4T | YI4 | YE4 | |
| | AVRC 40-4X | 36 | 300 | 61 | 40 | 39.7 | 24.01 | 46 | | | | | | |

Obliczanie kąta pochylenia linii śrubowej β



Kąt pochylenia linii śrubowej gwintu jest obliczany z następującego wzoru:

$$\beta = \arctan \frac{P \times N}{\pi \times D}$$

β - kąt pochylenia linii śrubowej gwintu [°]

P - skok [mm]

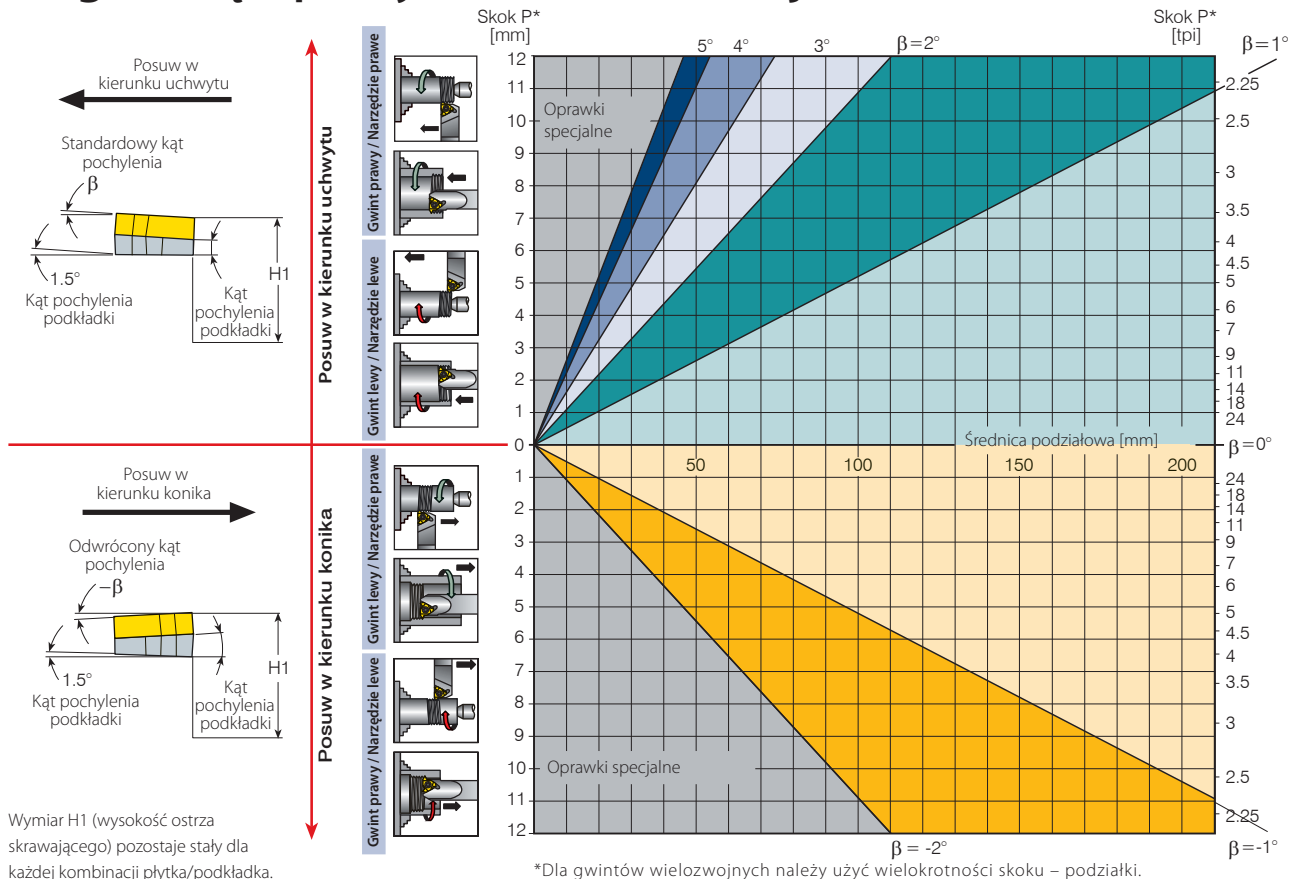
N - ilość zwoi

D - średnica podziałowa [mm]

Podziałka = P x N

Kąt pochylenia linii śrubowej gwintu może być także odczytany z poniższego diagramu.

Diagram kąta pochylenia linii śrubowej

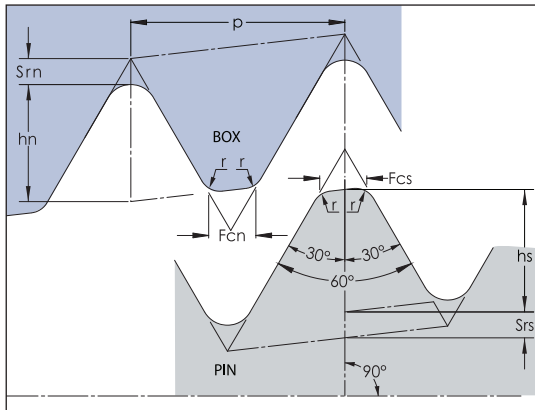


Podkładka

| Kąt pochylenia płytki | | 4.5° | | 3.5° | | 2.5° | | 1.5° | | 0.5° | | 0° | | -0.5° | | -1.5° | |
|-----------------------|------|---------|--------|--------|--------|------|--------|----------|--------|--------|--|------------|--|-------|--|-------|--|
| Wielkość płytki | | Oprawka | | | | | | | | | | Oznaczenie | | | | | |
| IC | L mm | | | | | | | | | | | | | | | | |
| "3/8 | 16 | ER / IL | YE3-3P | YE3-2P | YE3-1P | YE3 | YE3-1N | YE3-1.5N | YE3-2N | YE3-3N | | | | | | | |
| | | EL / IR | YI3-3P | YI3-2P | YI3-1P | YI3 | YI3-1N | YI3-1.5N | YI3-2N | YI3-3N | | | | | | | |
| "1/2 | 22 | ER / IL | YE4-3P | YE4-2P | YE4-1P | YE4 | YE4-1N | YE4-1.5N | YE4-2N | YE4-3N | | | | | | | |
| | | EL / IR | YI4-3P | YI4-2P | YI4-1P | YI4 | YI4-1N | YI4-1.5N | YI4-2N | YI4-3N | | | | | | | |

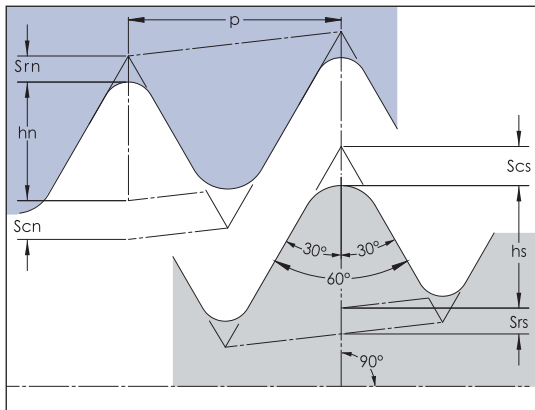
Rysunki standardu API

API



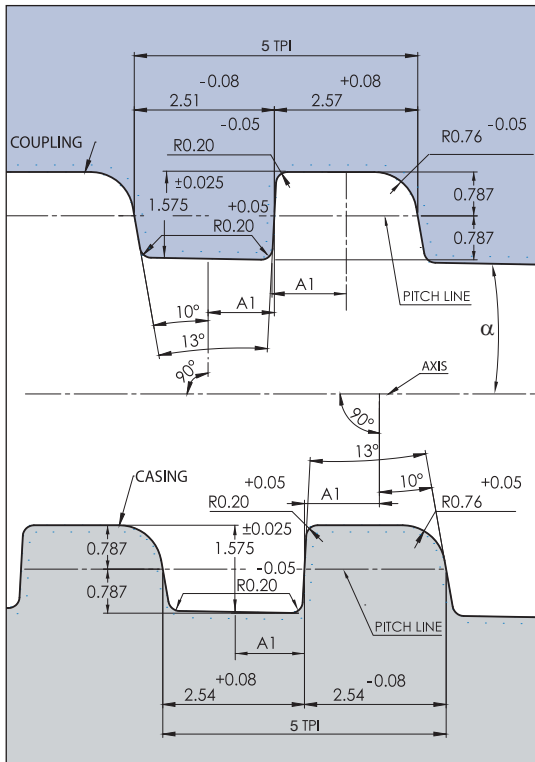
| Thread form | IPF | Thread height truncated $h_s = h_n$ | Root Truncation $S_{rn} = S_{rs}$ | Width of flat $f_{cn} = f_{cs}$ | Radius at thread corners (r) | Skok (TPI) |
|-------------|-----|-------------------------------------|-----------------------------------|---------------------------------|------------------------------|------------|
| V 0.038R | 2 | + 0.03 - 0.08 3.09 | + 0.03 - 0.03 0.96 | + 0.05 1.65 | + 0.05 - 0.05 0.38 | 4 |
| V 0.038R | 3 | + 0.03 - 0.08 3.08 | + 0.03 - 0.03 0.96 | + 0.05 1.65 | + 0.05 - 0.05 0.38 | 4 |
| V 0.040 | 3 | + 0.03 - 0.08 2.99 | + 0.03 - 0.03 0.51 | + 0.05 1.02 | + 0.05 - 0.05 0.38 | 5 |
| V 0.050 | 2 | + 0.03 - 0.08 3.75 | + 0.03 - 0.03 0.63 | + 0.05 1.27 | + 0.05 - 0.05 0.38 | 4 |
| V 0.050 | 3 | + 0.03 - 0.08 3.74 | + 0.03 - 0.03 0.63 | + 0.05 1.27 | + 0.05 - 0.05 0.38 | 4 |

API Round Casing & Tubing



| Thread Data | 8 TPI | 10 TPI |
|-------------------|-------------------------|-------------------------|
| $h_s = h_n$ | +0.05 - 0.10 1.81 | +0.05 - 0.10 1.41 |
| $S_{rn} = S_{rs}$ | 0.43 | 0.36 |
| $S_{cs} = S_{cn}$ | 0.51 | 0.43 |

API Buttress Casing



| Taper | A1, mm | α | Profile Height |
|-------|--------|--------------------|----------------|
| 0.75 | - | $1^\circ 47' 24''$ | ± 0.025 |
| 1 | 1.27 | $2^\circ 23' 17''$ | 1.575 |

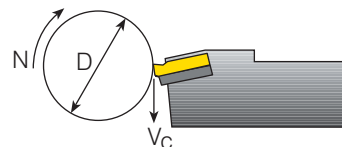
Zalecane gatunki i prędkości skrawania Vc [m/min]

| Grupa materiałowa | Vardex No. | Materiał | Twardość Brinell HB | Vc [m/min] | |
|--------------------------------------|--------------------------------------|---|--------------------------------------|------------|---------|
| | | | | Coated | VKX |
| P Stal | 1 | Stal | Niskowęglowa (C=0.1-0.25%) | 125 | 115-190 |
| | 2 | | Średniowęglowa (C=0.25-0.55%) | 150 | 100-175 |
| | 3 | | Wysokowęglowa (C=0.55-0.85%) | 170 | 90-165 |
| | 4 | Stal niskostopowa (dodatki stopowe ≤ 5%) | Nieulepszona | 180 | 100-180 |
| | 5 | | Ulepszona | 275 | 75-140 |
| | 6 | | Ulepszona | 350 | 70-135 |
| | 7 | Stal wysokostopowa (dodatki stopowe > 5%) | Wyżarzona | 200 | 80-120 |
| | 8 | | Ulepszona | 325 | 50-100 |
| | 9 | Staliwo | Niskostopowe (dodatki stopowe < 5%) | 200 | 70-130 |
| | 10 | | Wysokostopowe (dodatki stopowe > 5%) | 225 | 60-120 |
| M stal nierdzewna | 11 | Stal nierdzewna ferrytyczna | Nieulepszona | 200 | 70-130 |
| | 12 | | Ulepszona | 330 | 60-115 |
| | 13 | Austenityczna | Austenityczna | 180 | 90-140 |
| | 14 | | Superaustenityczna | 200 | 40-110 |
| | 15 | Stal nierdzewna odlewana ferrytyczna | Nieulepszona | 200 | 90-120 |
| | 16 | | Ulepszona | 330 | 65-110 |
| | 17 | Stal nierdzewna odlewana austenityczna | Austenityczna | 200 | 85-110 |
| | 18 | | Ulepszona | 330 | 60-100 |
| K Żelazo | 28 | Żelivo ciągliwe | Ferrytyczne (krótkie wióry) | 130 | 60-70 |
| | 29 | | Perlityczne (długie wióry) | 230 | 60-145 |
| | 30 | Żelivo szare | Niska wytrzymałość | 180 | 70-130 |
| | 31 | | Wysoka wytrzymałość | 260 | 60-115 |
| | 32 | Żelivo sferoidalne | Ferrytyczne | 160 | 125-160 |
| | 33 | | Perlityczne | 260 | 90-120 |
| N(K) Materiały nieżelazne | 34 | Stopy aluminium do przeróbki plastycznej | Niestarzone | 60 | 100-365 |
| | 35 | | Starzone | 100 | 80-220 |
| | 36 | Stopy aluminium | Odlewnicze | 75 | 200-400 |
| | 37 | | Odlewnicze i starzone | 90 | 200-280 |
| | 38 | Stopy aluminium | Odlewnicze Si 13-22% | 130 | 60-180 |
| | 39 | Miedź i stopy miedzi | Mosiądz | 90 | 80-225 |
| | 40 | | Brązy | 100 | 80-255 |
| | S(M) Materiały żaroodporne | 19 | Stopy żarowytrzymałe | Wyżarzane | 200 |
| 20 | | Starzone | | 280 | 30-50 |
| 21 | | Wyżarzane niklowe lub kobaltowe | | 250 | 20-30 |
| 22 | | Niklowe lub kobaltowe | | 350 | 15-25 |
| 23 | | Stopy tytanu | Tytan 99.5% | 400Rm | 140-170 |
| 24 | | | Stopy α+β | 1050Rm | 50-70 |
| H(K) Materiały zahartowane | 25 | Stale bardzo twarde | Ulepszona | 45-50HRc | 45-60 |
| | 26 | | 51-55HRc | 40-50 | |

Obliczanie prędkości obrotowej [obr/min]

$$N = \frac{1000 \times V_c}{\pi \times D}$$

$$V_c = \frac{N \times \pi \times D}{1000}$$



N - Obroty [Obr/Min]

V_c - Prędkość skrawania [m/min]

D - Średnica obrabianego materiału

Gatunek:

VKX



Wyśmienity gatunek ogólnego zastosowania.

Ilość przejść

| Skok | mm | 0.50 | 0.75 | 1.00 | 1.25 | 1.50 | 1.75 | 2.00 | 2.50 | 3.00 | 3.50 | 4.00 | 4.50 | 5.00 | 5.50 | 6.00 |
|---------------|-----|------|------|------|------|------|------|------|------|------|-------|-------|-------|-------|-------|-------|
| | tpi | 48 | 32 | 24 | 20 | 16 | 14 | 12 | 10 | 8 | 7 | 6 | 5.5 | 5 | 4.5 | 4 |
| Ilość przejść | | 4-6 | 4-7 | 4-8 | 5-9 | 6-10 | 7-12 | 7-12 | 8-14 | 9-16 | 10-18 | 11-18 | 11-19 | 12-20 | 12-20 | 12-20 |