

ГОСУДАРСТВЕННЫЙ СТАНДАРТ СОЮЗА ССР

ПРОТЯЖКИ КРУГЛЫЕ ПЕРЕМЕННОГО РЕЗАНИЯ
ДИАМЕТРОМ ОТ 14 ДО 90 ММ

Конструкция и размеры

Broaches round of variable cutting of diameters
from 14 to 90 mm.
Design and dimensionsГОСТ
20365—74*Взамен
МН 4172—62Постановлением Государственного комитета стандартов Совета Министров СССР
от 17 декабря 1974 г. № 2739 срок введения установлен

с 01.01.76

Проверен в 1981 г.

Несоблюдение стандарта преследуется по закону

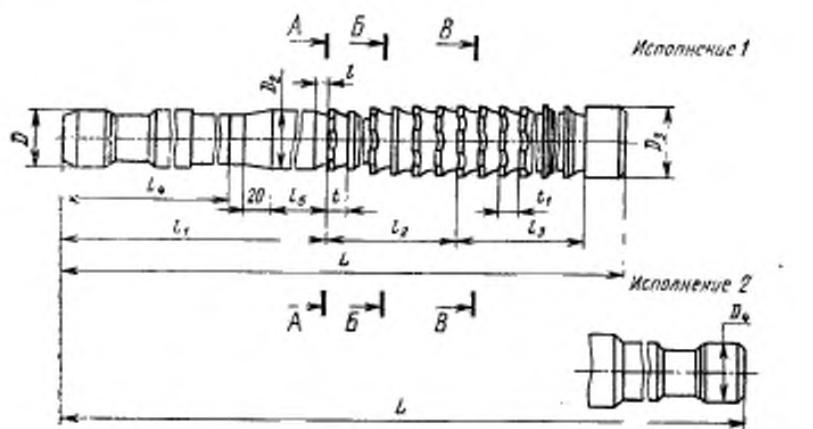
1. Настоящий стандарт распространяется на протяжки универсального назначения переменного резания, равной стойкости черновой и чистовой частей, предназначенных для обработки цилиндрических отверстий диаметром от 14 до 90 мм.
2. Конструкция и размеры протяжек должны соответствовать указанным на черт. 1 и в табл. 1, 2.

Издание официальное

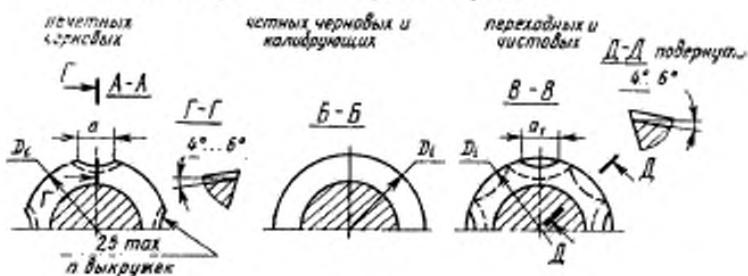


Перепечатка воспрещена

* Переиздание марта 1983 г. с Изменениями № 1, № 2, № 3, утвержденными в августе 1977 г., июне 1981 г., мае 1982 г. (ИУС № 9—1977 г., ИУС № 9—1981 г., ИУС № 8—1982 г.).



Форма зубьев и расположение выкружек на зубьях:



Черт. 1

Таблица 3
Размеры в мм

| Обозначение протяжек | Приме- нение | Испол- нение | Диаметр отверстия | | D | D ₁ | D ₄ | D ₆ | L | I | I ₁ |
|----------------------|-----------------|-----------------|-------------------|-------------------------|---|----------------|----------------|----------------|-----|---|----------------|
| | | | Номин. | Показ. допус- кок | | | | | | | |
| 2400-0061 | | 1 | | H7 | | | | | 460 | | |
| 2400-0062 | | 2 | | | | | | | 560 | | |
| 2400-1001 | | 1 | 14,00 | H8 | | 13,4 | 14,00 | | 460 | | |
| 2400-1002 | | 2 | | | | | | | 560 | | |
| 2400-0063 | | 1 | | H9 | | | | | 460 | | 255 |
| 2400-0064 | | 2 | | | | | | | 560 | | |
| 2400-0065 | | 1 | 13,76 | H7 | | 13,1 | 13,76 | | 460 | | |
| 2400-0066 | | 2 | | | | | | | 560 | | |
| 2400-0067 | | 1 | | H7 | | | | | 515 | | |
| 2400-0068 | | 2 | | | | | | | 615 | | |
| 2400-1003 | | 1 | 14,00 | H8 | | 13,4 | 14,00 | | 515 | | |
| 2400-1004 | | 2 | | | | | | | 615 | | 265 |
| 2400-0069 | | 1 | | H9 | | | | | 515 | | |
| 2400-0070 | | 2 | | | | | | | 615 | | |
| 2400-0071 | | 1 | 13,76 | H7 | | 13,1 | 13,76 | | 530 | | |
| 2400-0072 | | 2 | | | | | | | 630 | | |
| 2400-0073 | | 1 | | H7 | | | | | 460 | | |
| 2400-0074 | | 2 | | | | | | | 560 | | |
| 2400-1005 | | 1 | 15,00 | H8 | | 14,4 | 15,00 | | 460 | | |
| 2400-1006 | | 2 | | | | | | | 560 | | 255 |
| 2400-0075 | | 1 | | H9 | | | | | 460 | | |
| 2400-0076 | | 2 | | | | | | | 560 | | |
| 2400-0077 | | 1 | 14,76 | H7 | | 14,1 | 14,76 | | 460 | | |
| 2400-0078 | | 2 | | | | | | | 560 | | |
| 2400-0079 | | 1 | | H7 | | | | | 580 | | |
| 2400-0080 | | 2 | 15,00 | H8 | | 14,4 | 15,00 | | 680 | | |
| 2400-1007 | | 1 | | | | | | | 580 | | 270 |

Продолжение табл. 1

Размеры в мм

| Обозначение протяжек | t_1 | t_2 | t_3 | t_4 | Зубья протяжек | | | | | | Выкружки | |
|-------------------------|-------|-------|-------|-------|--------------------------|-----|------------------------|---------------------------|-------|------------------------|----------|--|
| | | | | | Черновые и переходные | | | Чистовые и калибрующие | | | | |
| | | | | | Число зубьев | t | Номер про- филя* | Число зубьев | t_1 | Номер про- филя* | | |
| 2400-0061 | | | | | | | | | | | | |
| 2400-0062 | 84 | 99,0 | | | 12 | | | 18 | | | | |
| 2400-1001 | | | | | | | | | | | | |
| 2400-1002 | | | | | | | | | | | | |
| 2400-0063 | | | | | | | | | | | | |
| 2400-0064 | 98 | 88,5 | | | 25 | 7 | 4 | 5,0 | 2 | | | |
| 2400-0055 | | | | | | | | | | | | |
| 2400-0056 | | | | | | | | | | | | |
| 2400-0067 | | | | | | | | | | | | |
| 2400-0068 | | | | | | | | | | | | |
| 2400-1003 | 128 | | | | | | | | | | | |
| 2400-1004 | | | | | | | | | | | | |
| 2400-0069 | | | | | | | | | | | | |
| 2400-0070 | | | | | | | | | | | | |
| 2400-0071 | 144 | | | | | | | | | | | |
| 2400-0072 | | | | | | | | | | | | |
| 2400-0073 | | | | | | | | | | | | |
| 2400-0074 | 84 | 99,0 | | | | | | | | | | |
| 2400-1005 | | | | | | | | | | | | |
| 2400-1006 | | | | | | | | | | | | |
| 2400-0075 | | | | | | | | | | | | |
| 2400-0076 | 98 | 88,5 | | | | | | | | | | |
| 2400-0077 | | | | | | | | | | | | |
| 2400-0078 | | | | | | | | | | | | |
| 2400-0079 | | | | | | | | | | | | |
| 2400-0080 | 162 | 113,0 | | | 40 | 18 | 9 | 4У | 16 | 6,0 | 3 | |
| 2400-1007 | | | | | | | | | | | | |

Продолжение табл. 1

Размеры в мм

| Обозначение протяжек | Применение | Исполнение | Диаметр отверстия | | D | D ₁ | D ₂ | D ₄ | L | I | I ₁ |
|----------------------|------------|------------|-------------------|--------------|----|----------------|----------------|----------------|-----|---|----------------|
| | | | Номинал | Поле допуска | | | | | | | |
| 2400-1008 | | 2 | 15,00 | H8 | | 14,4 | 15,00 | | 680 | | |
| 2400-0081 | | 1 | | H9 | | | | | 580 | | |
| 2400-0082 | | 2 | | | 12 | | | | 680 | 5 | 270 |
| 2400-0083 | | 1 | 14,76 | H7 | | 14,1 | 14,76 | | 600 | | |
| 2400-0084 | | 2 | | | | | | | 700 | | |
| 2400-0085 | | 1 | | H7 | | | | | 490 | | |
| 2400-0086 | | 2 | | | | | | | 590 | | |
| 2400-1009 | | 1 | 16,00 | H8 | | 15,4 | 16,00 | | 490 | | |
| 2400-1011 | | 2 | | | | | | | 590 | | |
| 2400-0087 | | 1 | | H9 | | | | | 490 | 4 | 265 |
| 2400-0088 | | 2 | | | | | | | 590 | | |
| 2400-0089 | | 1 | 15,76 | H7 | | 15,1 | 15,76 | | 500 | | |
| 2400-0090 | | 2 | | | | | | | 600 | | |
| 2400-0091 | | 1 | | H7 | | | | | 580 | | |
| 2400-0092 | | 2 | | | | | | | 680 | | |
| 2400-1012 | | 1 | 16,00 | H8 | 14 | 15,4 | 16,00 | | 580 | | |
| 2400-1013 | | 2 | | | | | | | 680 | 5 | 280 |
| 2400-0093 | | 1 | | H9 | | | | | 580 | | |
| 2400-0094 | | 2 | | | | | | | 680 | | |
| 2400-0095 | | 1 | 15,76 | H7 | | 15,1 | 15,76 | | 580 | | |
| 2400-0096 | | 2 | | | | | | | 680 | | |
| 2400-0097 | | 1 | | H7 | | | | | 490 | | |
| 2400-0098 | | 2 | | | | | | | 590 | | |
| 2400-1014 | | 1 | 17,00 | H8 | | 16,4 | 17,00 | | 490 | 4 | 265 |
| 2400-1015 | | 2 | | | | | | | 590 | | |
| 2400-0099 | | 1 | | H9 | | | | | 490 | | |
| 2400-0100 | | 2 | | | | | | | 590 | | |

Продолжение табл. 1

Размеры в мм

| Обозначение протяжек | I_2 | I_3 | I_4 | I_5 | Зубья протяжек | | | | | | Выкружки | | | |
|----------------------|-------|-------|-------|-------|-----------------------|-----|----------------|------------------------|-------|----------------|----------|-----|-------|-----|
| | | | | | Черновые и переходные | | | Чистовые и калибрующие | | | n | a | a_1 | |
| | | | | | Число зубьев | t | Номер профиля* | Число зубьев | t_1 | Номер профиля* | | | | |
| 2400-1008 | | | | | 18 | | | | | | | | | |
| 2400-0081 | 162 | | | | | | | | | | | | | |
| 2400-0082 * | | 113,0 | 195 | 40 | | 9 | 4У | 16 | 6,0 | 3 | 4 | 6 | 4,5 | |
| 2400-0083 | 180 | | | | 20 | | | | | | | | | |
| 2400-0084 | | | | | | | | | | | | | | |
| 2400-0085 | | | | | | | | | | | | | | |
| 2400-0086 | | | | | | | | | | | | | | |
| 2400-1009 | 112 | | | | 16 | | | | | | | | | |
| 2400-1011 | | 88,5 | | 30 | | 7 | 4 | 16 | 5 | 3 | | | | |
| 2400-0087 | | | | | | | | | | | | | | |
| 2400-0088 | | | | | | | | | | | | | | |
| 2400-0089 | 126 | | | | 18 | | | | | | | | | |
| 2400-0090 | | | | | | | | | | | | | 6 | 4,0 |
| 2400-0091 | | | | | | | | | | | | | | 2,5 |
| 2400-0092 | | | | | | | | | | | | | | |
| 2400-1012 | 144 | | 200 | | 16 | | | | | | | | | |
| 2400-1013 | | 113,0 | | 45 | | 9 | 5 | 16 | 6 | 4 | | | | |
| 2400-0093 | | | | | | | | | | | | | | |
| 2400-0094 | | | | | | | | | | | | | | |
| 2400-0095 | 162 | | | | 18 | | | | | | | | | |
| 2400-0096 | | | | | | | | | | | | | | |
| 2400-0097 | | | | | | | | | | | | | | |
| 2400-0098 | | | | | | | | | | | | | | |
| 2400-1014 | 112 | 88,5 | | 30 | 16 | 7 | 4 | 16 | 5 | 3 | 6 | 4,5 | 3,0 | |
| 2400-1015 | | | | | | | | | | | | | | |
| 2400-0099 | | | | | | | | | | | | | | |
| 2400-0100 | | | | | | | | | | | | | | |

Продолжение табл. 1

Размеры в мм

| Обозначение протяжек | Приме- ните- мость | Испол- нение | Диаметр отверстия | | D | D ₁ | D ₆ | D ₈ | L | I | I ₁ |
|----------------------|--------------------------|-----------------|----------------------|----------------------|----|----------------|----------------|----------------|-----|-----|----------------|
| | | | Номин. | Поле допус- ка | | | | | | | |
| 2400-0101 | | 1 | 16,76 | H7 | | 16,1 | 16,76 | | 500 | 4 | 265 |
| 2400-0102 | | 2 | | | | | | | 600 | | |
| 2400-0103 | | 1 | | | | | | | 580 | | |
| 2400-0104 | | 2 | | | | | | | 680 | | |
| 2400-1016 | | 1 | 17,00 | H8 | | 16,4 | 17,00 | | 580 | | |
| 2400-1017 | | 2 | | | 14 | | | | 680 | 5 | 280 |
| 2400-0105 | | 1 | | | | | | | 580 | | |
| 2400-0106 | | 2 | | | | | | | 680 | | |
| 2400-0107 | | 1 | 16,76 | H7 | | 16,1 | 16,76 | | 580 | | |
| 2400-0108 | | 2 | | | | | | | 680 | | |
| 2400-0109 | | 1 | | | | | | | 480 | | |
| 2400-0110 | | 2 | | | | | | | 580 | | |
| 2400-1018 | | 1 | 18,00 | H8 | | 17,4 | 18,00 | | 480 | | |
| 2400-1019 | | 2 | | | | | | | 580 | 4,0 | 260 |
| 2400-0111 | | 1 | | | | | | | 480 | | |
| 2400-0112 | | 2 | | | | | | | 580 | | |
| 2400-0113 | | 1 | 17,76 | H7 | | 17,1 | 17,76 | | 480 | | |
| 2400-0114 | | 2 | | | | | | | 580 | | |
| 2400-0115 | | 1 | | | | | | | 580 | | |
| 2400-0116 | | 2 | | | | | | | 680 | | |
| 2400-1021 | | 1 | 18,00 | H8 | | 17,4 | 18,00 | | 580 | | |
| 2400-1022 | | 2 | | | | | | | 680 | 5,5 | 280 |
| 2400-0117 | | 1 | | | | | | | 580 | | |
| 2400-0118 | | 2 | | | | | | | 680 | | |
| 2400-0119 | | 1 | 17,76 | H7 | | 17,1 | 17,76 | | 600 | | |
| 2400-0120 | | 2 | | | | | | | 700 | | |
| 2400-0127 | | 1 | (19,00) | H7 | | 18,1 | 19,00 | | 515 | 5,0 | 260 |

Продолжение табл. I

Размеры в мм

| Обозначение протяжек | t_2 | t_3 | t_4 | t_5 | Зубья протяжек | | | | | Выкружки | | |
|----------------------|-------|-------|-------|-------|-----------------------|-----|-----------------|------------------------|-------|--------------------|-----|-------|
| | | | | | Черновые и переходные | | | Чистовые и калибрующие | | Число выкружек n | a | a_1 |
| | | | | | Число зубьев | t | Номер профилей* | Число зубьев | t_1 | Номер профилей* | | |
| 2400-0101 | 126 | 88,5 | | 30 | 18 | 7 | 4 | 16 | 5 | 3 | | |
| 2400-0102 | | — | | | | | | | | | | |
| 2400-0103 | | | | | | | | | | | | |
| 2400-0104 | | | | | | | | | | | | |
| 2400-1016 | 144 | | | | | | | | | | | |
| 2400-1017 | 113,0 | 200 | 45 | 16 | | 9 | 5 | 16 | 6 | 4 | 4,5 | 3,0 |
| 2400-0105 | | | | | | | | | | | | |
| 2400-0106 | | | | | | | | | | | | |
| 2400-0107 | 162 | | | 18 | | | | | | | | |
| 2400-0108 | | | | | | | | | | | | |
| 2400-0109 | | | | | | | | | | | | |
| 2400-0110 | | | | | | | | | | | | |
| 2400-1018 | 98 | | | | | | | | | | | |
| 2400-1019 | 88,5 | 30 | 14 | | 7 | 5 | 16 | 5,0 | 3 | 6 | | |
| 2400-0111 | | | | | | | | | | | | |
| 2400-0112 | | | | | | | | | | | | |
| 2400-0113 | 112 | | | 16 | | | | | | | | |
| 2400-0114 | | | | | | | | | | | | |
| 2400-0115 | | | | | | | | | | | | |
| 2400-0116 | | | | | | | | | | | | |
| 2400-1021 | 144 | | | | | | | | | | | |
| 2400-1022 | 113,0 | 50 | 16 | | 9 | 6 | 16 | 6,0 | 3 | | | |
| 2400-0117 | | | | | | | | | | | | |
| 2400-0118 | | | | | | | | | | | | |
| 2400-0119 | 162 | | 18 | | | | | | | | | |
| 2400-0120 | | | | | | | | | | | | |
| 2400-0127 | 128 | 96,5 | 30 | 16 | 8 | 5 | 16 | 5,5 | 3 | | | |

Продолжение табл. I

Размеры в мм

| Обозначение протяжек | Приме- нение- мость | Испол- нение | Диаметр отверстия | | D | D ₁ | D ₂ | D ₄ | L | t | t ₁ |
|-------------------------|---------------------------|-----------------|----------------------|----------------------|----|----------------|----------------|----------------|-----|-----|----------------|
| | | | Номинал | Поле допус- ка | | | | | | | |
| 2400-0128 | | 2 | | H7 | | | | | 615 | | |
| 2400-1023 | | 1 | | H8 | | | | | 515 | | |
| 2400-1024 | | 2 | (19,00) | H9 | | 18,1 | 19,00 | | 615 | | |
| 2400-0129 | | 1 | | | | | | | 515 | 5,0 | 260 |
| 2400-0130 | | 2 | | | | | | | 615 | | |
| 2400-0131 | | 1 | 18,72 | H7 | | 17,8 | 18,72 | | 515 | | |
| 2400-0132 | | 2 | | | | | | | 615 | | |
| 2400-0133 | | 1 | | H7 | | | | | 650 | | |
| 2400-0134 | | 2 | | | | | | | 750 | | |
| 2400-1025 | | 1 | (19,00) | H8 | | 18,1 | 19,00 | | 650 | | |
| 2400-1026 | | 2 | | | | | | | 750 | | 280 |
| 2400-0135 | | 1 | | H9 | | | | | 650 | | |
| 2400-0136 | | 2 | | | | | | | 750 | | |
| 2400-0137 | | 1 | 18,72 | H7 | 16 | 17,8 | 18,72 | 12 | 650 | | |
| 2400-0138 | | 2 | | | | | | | 750 | | |
| 2400-0139 | | 1 | | H7 | | | | | 710 | 5,5 | |
| 2400-0140 | | 2 | | | | | | | 810 | | |
| 2400-1027 | | 1 | (19,00) | H8 | | 18,1 | 19,00 | | 710 | | |
| 2400-1028 | | 2 | | | | | | | 810 | | 300 |
| 2400-0141 | | 1 | | H9 | | | | | 710 | | |
| 2400-0142 | | 2 | | | | | | | 810 | | |
| 2400-0143 | | 1 | 18,72 | H7 | | 17,8 | 18,72 | | 710 | | |
| 2400-0144 | | 2 | | | | | | | 810 | | |
| 2400-0145 | | 1 | | H7 | | | | | 550 | | |
| 2400-0146 | | 2 | 20,00 | | | 19,1 | 20,00 | | 650 | | 270 |
| 2400-1029 | | 1 | | H8 | | | | | 550 | | |
| 2400-1031 | | 2 | | | | | | | 650 | | |

Размеры в мм

Продолжение табл. I

| Обозначение протяжек | l_2 | l_3 | l_4 | l_5 | Зубья протяжек | | | | | | Выкружки | |
|----------------------|-------|-------|-------|-------|-----------------------|-----|----------------------------|------------------------|-------|----------------------------|----------|-----|
| | | | | | Черновые и переходные | | | Чистовые и калибрующие | | | | |
| | | | | | Число зубьев | t | Номер профиля ⁴ | Число зубьев | t_1 | Номер профиля ⁴ | | |
| 2400-0128 | | | | | | | | | | | | |
| 2400-1023 | | | | | | | | | | | | |
| 2400-1024 | | | | | | | | | | | | |
| 2400-0129 | 128 | 96,5 | | 30 | 16 | 8 | 5 | 16 | 5,5 | 3 | | |
| 2400-0130 | | | | | | | | | | | | |
| 2400-0131 | | | | | | | | | | | | |
| 2400-0132 | | | | 195 | | | | | | | | |
| 2400-0133 | | | | | | | | | | | | |
| 2400-0134 | | | | | | | | | | | | |
| 2400-1025 | | | | | | | | | | | | |
| 2400-1026 | | | | | | | | | | | | |
| 2400-0135 | 200 | 129,0 | | 50 | 20 | 10 | 6 | 16 | 7,0 | 4 | | |
| 2400-0136 | | | | | | | | | | | | |
| 2400-0137 | | | | | | | | | | | 6 | 5 |
| 2400-0138 | | | | | | | | | | | | 3,5 |
| 2400-0139 | | | | | | | | | | | | |
| 2400-0140 | | | | | | | | | | | | |
| 2400-1027 | | | | | | | | | | | | |
| 2400-1028 | | | | | | | | | | | | |
| 2400-0141 | 240 | 129 | 200 | 65 | 24 | 10 | 6 | 16 | 7 | 4 | | |
| 2400-0142 | | | | | | | | | | | | |
| 2400-0143 | | | | | | | | | | | | |
| 2400-0144 | | | | | | | | | | | | |
| 2400-0145 | | | | | | | | | | | | |
| 2400-0146 | | | | | | | | | | | | |
| 2400-1029 | 144 | 113 | 195 | 40 | 16 | 9 | 6 | 16 | 6 | 3 | | |
| 2400-1031 | | | | | | | | | | | | |

Размеры в мм

Продолжение табл. 1

| Обозначение протяжек | Приме- нение | Исполн- ение | Диаметр отверстия | | D | D ₁ | D ₂ | D ₃ | L | t | L ₁ |
|----------------------|-----------------|-----------------|----------------------|--------------|----|----------------|----------------|----------------|-----|-----|----------------|
| | | | Номинал | Поле допуска | | | | | | | |
| 2400-0147 | | 1 | 20,00 | H9 | | 19,1 | 20,00 | | 550 | | |
| 2400-0148 | | 2 | | | 16 | | | | 650 | | |
| 2400-0149 | | 1 | 19,72 | H7 | | 18,8 | 19,72 | | 550 | | 270 |
| 2400-0150 | | 2 | | | | | | | 650 | | |
| 2400-0151 | | 1 | | | | | | | 710 | | |
| 2400-0152 | | 2 | | | | | | | 810 | | |
| 2400-1032 | | 1 | 20,00 | H8 | | 19,1 | 20,00 | | 710 | | |
| 2400-1033 | | 2 | | | | | | | 810 | | |
| 2400-0153 | | 1 | | | | | | | 710 | | 300 |
| 2400-0154 | | 2 | | | | | | | 810 | 5,5 | |
| 2400-0155 | | 1 | 19,72 | H7 | | 18,8 | 19,72 | | 710 | | |
| 2400-0156 | | 2 | | | | | | | 810 | | |
| 2400-0157 | | 1 | | | | | | | 580 | | |
| 2400-0158 | | 2 | | | | | | | 680 | | |
| 2400-1034 | | 1 | (21,00) | H8 | | 19,9 | 21,00 | | 580 | | |
| 2400-1035 | | 2 | | | 18 | | | | 680 | | 270 |
| 2400-0159 | | 1 | | | | | | | 580 | | |
| 2400-0160 | | 2 | | | | | | | 680 | | |
| 2400-0161 | | 1 | 20,72 | H7 | | 19,6 | 20,72 | | 580 | | |
| 2400-0162 | | 2 | | | | | | | 680 | | |
| 2400-0163 | | 1 | | | | | | | 775 | | |
| 2400-0164 | | 2 | | | | | | | 875 | | |
| 2400-1036 | | 1 | (21,00) | H8 | | 19,9 | 21,00 | | 775 | | |
| 2400-1037 | | 2 | | | | | | | 875 | 6,5 | 300 |
| 2400-0165 | | 1 | | | | | | | 775 | | |
| 2400-0166 | | 2 | | | | | | | 875 | | |
| 2400-0167 | | 1 | 20,72 | H7 | | 19,6 | 20,72 | | 775 | | |

Размеры в мм

Продолжение табл. 1

| Обозначение протяжек | l_1 | l_2 | l_3 | l_4 | Зубья протяжек | | | | | Выкружки | | | | |
|----------------------|-------|-------|-------|-------|-----------------------|-----|----------------|------------------------|-------|----------------|----------------|-----|-------|--|
| | | | | | Черновые и переходные | | | Чистовые и калибрующие | | | Число выкружек | a | a_1 | |
| | | | | | Число зубьев | t | Номер профиля* | Число зубьев | t_1 | Номер профиля* | | | | |
| 2400-0147 | | | | | | | | | | | | | | |
| 2400-0148 | 144 | 113 | 195 | 40 | 16 | 9 | 6 | 16 | 6 | 3 | | | | |
| 2400-0149 | | | | | | | | | | | | | | |
| 2400-0150 | | | | | | | | | | | | | | |
| 2400-0151 | | | | | | | | | | | | | | |
| 2400-0152 | | | | | | | | | | | | | | |
| 2400-1032 | | | | | | | | | | | | | | |
| 2400-1033 | | | | | | | | | | | | | | |
| 2400-0153 | 240 | 129 | 200 | 65 | 24 | 10 | 6 | 16 | 7 | 5 | | | | |
| 2400-0154 | | | | | | | | | | | | | | |
| 2400-0155 | | | | | | | | | | | | | | |
| 2400-0156 | | | | | | | | | | | | | | |
| 2400-0157 | | | | | | | | | | | | 6 | | |
| 2400-0158 | | | | | | | | | | | | | | |
| 2400-1034 | | | | | | | | | | | | | | |
| 2400-1035 | | | | | | | | | | | | | | |
| 2400-0159 | 162 | 126 | 195 | 40 | 18 | 9 | 6 | 18 | 6 | 3 | | | | |
| 2400-0160 | | | | | | | | | | | | | | |
| 2400-0161 | | | | | | | | | | | | | | |
| 2400-0162 | | | | | | | | | | | | | | |
| 2400-0163 | | | | | | | | | | | | | | |
| 2400-0164 | | | | | | | | | | | | | | |
| 2400-1036 | | | | | | | | | | | | | | |
| 2400-1037 | 288 | 145 | 200 | 65 | 24 | 12 | 7 | 16 | 8 | 5 | | | | |
| 2400-0165 | | | | | | | | | | | | | | |
| 2400-0166 | | | | | | | | | | | | | | |
| 2400-0167 | | | | | | | | | | | | | | |

Размеры в мм

Продолжение табл. 1

| Обозначение протяжек | Приме- нение | Испол- нение | Диаметр отверстия | | D | D ₂ | D ₃ | D ₄ | L | l | l ₁ |
|-------------------------|-----------------|-----------------|----------------------|------------------------|----|----------------|----------------|----------------|-----|-----|----------------|
| | | | Номин. | Пози- ция апуска | | | | | | | |
| 2400-0168 | | 2 | 20,72 | H7 | 18 | 19,6 | 20,72 | | 875 | 6,5 | 300 |
| 2400-0169 | | 1 | | H7 | | | | | 580 | | |
| 2400-0170 | | 2 | | | | | | | 680 | | |
| 2400-1038 | | 1 | 22,00 | H8 | | | 20,9 | 22,00 | 580 | | |
| 2400-1039 | | 2 | | | | | | | 680 | | |
| 2400-0171 | | 1 | | H9 | | | | | 580 | 5,5 | 270 |
| 2400-0172 | | 2 | | | | | | | 680 | | |
| 2400-0173 | | 1 | 21,72 | H7 | | 20,6 | 21,72 | | 580 | | |
| 2400-0174 | | 2 | | | 20 | | | | 680 | | |
| 2400-0175 | | 1 | | H7 | | | | | 760 | | |
| 2400-0176 | | 2 | | | | | | | 860 | | |
| 2400-1041 | | 1 | 22,00 | H8 | | | 20,9 | 22,00 | 760 | | |
| 2400-1042 | | 2 | | | | | | | 860 | 7,0 | 310 |
| 2400-0177 | | 1 | | H9 | | | | | 760 | | |
| 2400-0178 | | 2 | | | | | | | 860 | | |
| 2400-0179 | | 1 | 21,72 | H7 | | 20,6 | 21,72 | | 760 | | |
| 2400-0180 | | 2 | | | | | | | 860 | | |
| 2400-0181 | | 1 | | H7 | | | | | 580 | | |
| 2400-0182 | | 2 | | | | | | | 680 | | |
| 2400-1043 | | 1 | 24,00 | H8 | | | 22,9 | 24,00 | 580 | | |
| 2400-1044 | | 2 | | | | | | | 680 | 5,5 | 270 |
| 2400-0183 | | 1 | | H9 | 22 | | | | 580 | | |
| 2400-0184 | | 2 | | | | | | | 680 | | |
| 2400-0185 | | 1 | 23,72 | H7 | | 22,6 | 23,72 | | 580 | | |
| 2400-0186 | | 2 | | | | | | | 680 | | |
| 2400-0187 | | 1 | 24,00 | H7 | | 22,9 | 24,00 | | 720 | 8,0 | 320 |
| 2400-0188 | | 2 | | | | | | | 820 | | |

Продолжение табл. I

Размеры в мм

| Обозначение протяжек | l_2 | l_3 | l_4 | l_5 | Зубья протяжек | | | | | | Выкружки | | |
|----------------------|-------|-------|-------|-------|-----------------------|-----|----------------|------------------------|-------|----------------|--------------------|-----|-------|
| | | | | | Черновые и переходные | | | Чистовые и калибрующие | | | Число выкружек n | a | a_1 |
| | | | | | Число зубьев | f | Номер профиля* | Число зубьев | f_1 | Номер профиля* | | | |
| 2400-0168 | 288 | 145 | 200 | 65 | 24 | 12 | 7 | 16 | 8 | 5 | | | |
| 2400-0169 | | | | | | | | | | | | | |
| 2400-0170 | | | | | | | | | | | | | |
| 2400-1038 | | | | | | | | | | | | | |
| 2400-1039 | | | | | | | | | | | | | |
| 2400-0171 | 162 | 126 | 195 | 40 | 18 | 9 | 6 | 18 | 6 | 4 | | | |
| 2400-0172 | | | | | | | | | | | | | |
| 2400-0173 | | | | | | | | | | | | | |
| 2400-0174 | | | | | | | | | | | | | |
| 2400-0175 | | | | | | | | | | | | 5,5 | 4,0 |
| 2400-0176 | | | | | | | | | | | | | |
| 2400-1041 | | | | | | | | | | | | | |
| 2400-1042 | | | | | | | | | | | | | |
| 2400-0177 | 234 | 180 | 210 | 65 | 18 | 13 | 8 | 18 | 9 | 5 | 6 | | |
| 2400-0178 | | | | | | | | | | | | | |
| 2400-0179 | | | | | | | | | | | | | |
| 2400-0180 | | | | | | | | | | | | | |
| 2400-0181 | | | | | | | | | | | | | |
| 2400-0182 | | | | | | | | | | | | | |
| 2400-1043 | | | | | | | | | | | | | |
| 2400-1044 | 140 | 144 | 195 | 40 | 14 | 10 | 7 | 18 | 7 | 4 | 6,0 | 4,5 | |
| 2400-0183 | | | | | | | | | | | | | |
| 2400-0184 | | | | | | | | | | | | | |
| 2400-0185 | | | | | | | | | | | | | |
| 2400-0186 | | | | | | | | | | | | | |
| 2400-0187 | 182 | 180 | 225 | 60 | 14 | 13 | 8 | 16 | 9 | 5 | 6 | 4,5 | |
| 2400-0188 | | | | | | | | | | | | | |

Продолжение табл. 1

Размеры в мм

| Обозначение протяжек | Приме- ните- мость | Испол- нение | Диаметр отверстия | | D | D ₂ | D ₃ | D ₄ | L | I | I ₄ |
|----------------------|--------------------------|-----------------|-------------------|----------------------|----|----------------|----------------|----------------|-----|---|----------------|
| | | | Номин. | Поле допус- ка | | | | | | | |
| 2400-1045 | | 1 | | H8 | | | | | 720 | | |
| 2400-1046 | | 2 | 24,00 | | | 22,9 | 24,0 | | 820 | | |
| 2400-0189 | | 1 | | H9 | | | | | 720 | | 8,0 |
| 2400-0190 | | 2 | | | | | | | 820 | | 320 |
| 2400-0191 | | 1 | 23,72 | H7 | | 22,6 | 23,72 | | 720 | | |
| 2400-0192 | | 2 | | | | | | | 820 | | |
| 2400-0193 | | 1 | | H7 | | | | | 680 | | |
| 2400-0194 | | 2 | | | | | | | 680 | | |
| 2400-1047 | | 1 | 25,00 | H8 | | 23,9 | 25,00 | | 580 | | |
| 2400-1048 | | 2 | | | | | | | 680 | | |
| 2400-0195 | | 1 | | H9 | | | | | 580 | | 6,5 |
| 2400-0196 | | 2 | | | | | | | 680 | | 270 |
| 2400-0197 | | 1 | 24,72 | H7 | 22 | 23,6 | 24,72 | 18 | 580 | | |
| 2400-0198 | | 2 | | | | | | | 680 | | |
| 2400-0199 | | 1 | | H7 | | | | | 825 | | |
| 2400-0200 | | 2 | | | | | | | 925 | | |
| 2400-1049 | | 1 | 25,00 | H8 | | 23,9 | 25,00 | | 825 | | |
| 2400-1051 | | 2 | | | | | | | 925 | | |
| 2400-0201 | | 1 | | H9 | | | | | 825 | | 8,0 |
| 2400-0202 | | 2 | | | | | | | 925 | | 345 |
| 2400-0203 | | 1 | 24,72 | H7 | | 23,6 | 24,72 | | 825 | | |
| 2400-0204 | | 2 | | | | | | | 925 | | |
| 2400-0205 | | 1 | | H7 | | | | | 580 | | |
| 2400-0206 | | 2 | | | | | | | 680 | | |
| 2400-1052 | | 1 | 26,00 | | | 24,9 | 26,00 | | 580 | | 6,5 |
| 2400-1053 | | 2 | | | | | | | 680 | | 270 |
| 2400-0207 | | 1 | | H9 | | | | | 580 | | |

Продолжение табл. 1

Размеры в мм

| Обозначение протяжек | I_1 | I_2 | I_3 | I_4 | Зубья протяжек | | | | | Выкружки | | |
|----------------------|-------|-------|-------|-------|-----------------------|-----|-----------------|------------------------|-------|--------------------|-----|-------|
| | | | | | Черновые и переходные | | | Чистовые и калибрующие | | Число выкружек n | a | a_1 |
| | | | | | Число зубьев | t | Номер профилья* | Число зубьев | t_1 | Номер профилья* | | |
| 2400-1045 | | | | | | | | | | | | |
| 2400-1046 | | | | | | | | | | | | |
| 2400-0189 | 182 | 180 | 225 | 60 | 14 | 13 | 8 | 16 | 9 | 5 | 6 | 4,5 |
| 2400-0190 | | | | | | | | | | | | |
| 2400-0191 | | | | | | | | | | | | |
| 2400-0192 | | | | | | | | | | | | |
| 2400-0193 | | | | | | | | | | | | |
| 2400-0194 | | | | | | | | | | | | |
| 2400-1047 | | | | | | | | | | | | |
| 2400-1048 | 160 | 129 | 195 | 40 | 16 | 10 | 7 | 16 | 7 | 4 | 6 | |
| 2400-0195 | | | | | | | | | | | | |
| 2400-0196 | | | | | | | | | | | | |
| 2400-0197 | | | | | | | | | | | | |
| 2400-0198 | | | | | | | | | | | | 6,5 |
| 2400-0199 | | | | | | | | | | | | 5,0 |
| 2400-0200 | | | | | | | | | | | | |
| 2400-1049 | | | | | | | | | | | | |
| 2400-1051 | 260 | 161 | 230 | 80 | 20 | 13 | 9 | 16 | 9 | 5 | | |
| 2400-0201 | | | | | | | | | | | | |
| 2400-0202 | | | | | | | | | | | | |
| 2400-0203 | | | | | | | | | | | | |
| 2400-0204 | | | | | | | | | | | | |
| 2400-0205 | | | | | | | | | | | | |
| 2400-0206 | | | | | | | | | | | | |
| 2400-1052 | 160 | 129 | 195 | 40 | 16 | 10 | 7 | 16 | 7 | 4 | 8 | 5 |
| 2400-1053 | | | | | | | | | | | | |
| 2400-0207 | | | | | | | | | | | | 3,5 |

Продолжение табл. 1

Размеры в мм

| Обозначение протяжки | Приме- нение моста | Испол- нение | Диаметр отверстий | | D | D ₂ | D ₃ | D ₄ | L | I | I ₁ |
|-------------------------|--------------------------|-----------------|----------------------|----------------------|----|----------------|----------------|----------------|-----|-----|----------------|
| | | | Номин | Позв допус- ка | | | | | | | |
| 2400-0208 | | 2 | 26,00 | H3 | | 21,9 | 26,00 | | 630 | | |
| 2400-0209 | | 1 | 25,72 | H7 | | 24,6 | 25,72 | | 580 | 6,5 | 270 |
| 2400-0210 | | 2 | | | | | | | 680 | | |
| 2400-0211 | | 1 | | | | | | | 825 | | |
| 2400-0212 | | 2 | | | | | | | 925 | | |
| 2400-1054 | | 1 | 23,00 | H8 | 22 | 24,9 | 26,00 | 18 | 825 | | |
| 2400-1055 | | 2 | | | | | | | 925 | | |
| 2400-0213 | | 1 | | | | | | | 825 | 8,0 | 345 |
| 2400-0214 | | 2 | | | | | | | 925 | | |
| 2400-0215 | | 1 | 25,72 | H7 | | 21,6 | 25,72 | | 825 | | |
| 2400-0216 | | 2 | | | | | | | 925 | | |
| 2400-0217 | | 1 | | | | | | | 560 | | |
| 2400-0218 | | 2 | | | | | | | 675 | | |
| 2400-1056 | | 1 | (27,00) | H8 | | 25,9 | 27,00 | | 560 | | |
| 2400-1057 | | 2 | | | | | | | 675 | 6,5 | 270 |
| 2400-0219 | | 1 | | | | | | | 560 | | |
| 2400-0220 | | 2 | | | | | | | 675 | | |
| 2400-0221 | | 1 | 26,72 | H7 | 25 | 25,6 | 26,72 | 25 | 560 | | |
| 2400-0222 | | 2 | | | | | | | 633 | | |
| 2400-0223 | | 1 | | | | | | | 820 | | |
| 2400-0224 | | 2 | | | | | | | 935 | | |
| 2400-1058 | | 1 | (27,00) | H8 | | 25,9 | 27,00 | | 820 | | |
| 2400-1059 | | 2 | | | | | | | 935 | 8,0 | 340 |
| 2400-0225 | | 1 | | | | | | | 820 | | |
| 2400-0226 | | 2 | | | | | | | 935 | | |
| 2400-0227 | | 1 | 26,72 | H7 | | 25,6 | 26,72 | | 820 | | |
| 2400-0228 | | 2 | | | | | | | 935 | | |

Продолжение табл. I

Размеры в мм

| Обозначение протяжек | l_1 | l_2 | l_3 | t_3 | Зубья протяжек | | | | | Выступки | | | | |
|----------------------|-------|-------|-------|-------|-----------------------|-----|----------------|----------------------|-------|----------------|-----|-----|-------|--|
| | | | | | Черновые и переходные | | | Чистовые и наливющие | | | n | a | a_1 | |
| | | | | | Число зубьев | t | Номер профилей | Число зубьев | t_1 | Номер профилей | | | | |
| 2400-0208 | | | | | | | | | | | | | | |
| 2400-0209 | 160 | 129 | 195 | 40 | 16 | 10 | 7 | 16 | 7 | 4 | 5 | 3,5 | | |
| 2400-0210 | | | | | | | | | | | | | | |
| 2400-0211 | | | | | | | | | | | | | | |
| 2400-0212 | | | | | | | | | | | | | | |
| 2400-1054 | | | | | | | | | | | | | | |
| 2400-1055 | | | | | | | | | | | | | | |
| 2400-0213 | 260 | 161 | 230 | 80 | 20 | 13 | 9 | 16 | 9 | 6 | 5,0 | 3,5 | | |
| 2400-0214 | | | | | | | | | | | | | | |
| 2400-0215 | | | | | | | | | | | | | | |
| 2400-0216 | | | | | | | | | | | | | | |
| 2100-0217 | | | | | | | | | | | | | | |
| 2100-0218 | | | | | | | | | | | | | | |
| 2100-1056 | | | | | | | | | | | | | | |
| 2100-1057 | | | | | | | | | | | | | | |
| 2400-0219 | 110 | 129 | 200 | 35 | 14 | 10 | 7 | 16 | 7 | 4 | 8 | | | |
| 2400-0220 | | | | | | | | | | | | | | |
| 2400-0221 | | | | | | | | | | | | | | |
| 2400-0222 | | | | | | | | | | | | | | |
| 2400-0223 | | | | | | | | | | | | | | |
| 2400-0224 | | | | | | | | | | | | | | |
| 2400-1058 | | | | | | | | | | | | | | |
| 2400-1059 | 260 | 161 | 215 | 90 | 20 | 13 | 9 | 16 | 9 | 6 | | | | |
| 2400-0225 | | | | | | | | | | | | | | |
| 2400-0226 | | | | | | | | | | | | | | |
| 2400-0227 | | | | | | | | | | | | | | |
| 2400-0228 | | | | | | | | | | | | | | |

Продолжение табл. 1

Размеры в мм

| Обозначение протяжек | Примене- мость | Испол- нение | Диаметр отверстий | | D | D ₁ | D ₂ | D ₄ | L | I | L ₁ |
|----------------------|-------------------|-----------------|----------------------|------------------|----|----------------|----------------|----------------|-----|-----|----------------|
| | | | Номин. | Полос допуска | | | | | | | |
| 2400-0229 | | 1 | | H7 | | | | | 560 | | |
| 2400-0230 | | 2 | | | | | | | 673 | | |
| 2400-1061 | | 1 | 28,00 | H8 | | | 28,00 | | 560 | | |
| 2400-1062 | | 2 | | | | | | | 675 | 6,5 | 270 |
| 2400-0231 | | 1 | | H9 | | | | | 560 | | |
| 2400-0232 | | 2 | | | | | | | 675 | | |
| 2400-0233 | | 1 | 27,72 | H7 | | 26,6 | 27,72 | | 560 | | |
| 2400-0234 | | 2 | | | 25 | | | | 675 | | |
| 2100-0235 | | 1 | | H7 | | | | | 820 | | |
| 2400-0236 | | 2 | | | | | | | 935 | | |
| 2400-1063 | | 1 | 28,00 | H8 | | 26,9 | 28,00 | | 820 | | |
| 2400-1064 | | 2 | | | | | | | 935 | 9,5 | 345 |
| 2400-0237 | | 1 | | H9 | | | | | 820 | | |
| 2400-0238 | | 2 | | | | | | | 935 | | |
| 2400-0239 | | 1 | 27,72 | H7 | | 26,6 | 27,72 | | 820 | | |
| 2400-0240 | | 2 | | | | | | | 935 | | |
| 2400-0241 | | 1 | | H7 | | | | | 880 | | |
| 2400-0242 | | 2 | | | | | | | 695 | | |
| 2400-1065 | | 1 | 30,00 | H8 | | 28,9 | 30,00 | | 580 | | |
| 2400-1066 | | 2 | | | | | | | 695 | 6,5 | 290 |
| 2400-0243 | | 1 | | H9 | 28 | | | | 580 | | |
| 2400-0244 | | 2 | | | | | | | 695 | | |
| 2400-0245 | | 1 | 29,72 | H7 | | 28,6 | 29,72 | | 580 | | |
| 2400-0216 | | 2 | | | | | | | 695 | | |
| 2400-0247 | | 1 | | H7 | | | | | 795 | | |
| 2400-0248 | | 2 | 30,00 | | | 28,9 | 30,00 | | 910 | 8,0 | 365 |
| 2400-1037 | | 1 | | H8 | | | | | 795 | | |

Продолжение табл. 1

Размеры в мм

| Обозначение протяжки | t_2 | t_3 | t_4 | t_5 | Зубья протяжек | | | | | Выкружки | |
|----------------------|-------|-------|-------|-------|-----------------------|-----|----------------|------------------------|-------|----------------|-----|
| | | | | | Черновые и переходные | | | Чистовые и калибрующие | | | |
| | | | | | Число зубьев | t | Номер профилья | Число зубьев | t_4 | Номер профилья | |
| 2400-0229 | | | | | | | | | | | |
| 2400-0230 | | | | | | | | | | | |
| 2400-1061 | | | | | | | | | | | |
| 2400-1062 | 140 | 129 | 200 | 35 | 14 | 10 | 7 | 16 | 7 | 4 | |
| 2400-0231 | | | | | | | | | | | |
| 2400-0232 | | | | | | | | | | | |
| 2400-0233 | | | | | | | | | | | |
| 2400-0234 | | | | | | | | | | | 5,5 |
| 2400-0235 | | | | | | | | | | | 4,0 |
| 2400-0236 | | | | | | | | | | | |
| 2400-1063 | | | | | | | | | | | |
| 2400-1064 | 224 | 177 | 220 | 90 | 16 | 14 | 10 | 16 | 10 | 7 | 8 |
| 2400-0237 | | | | | | | | | | | |
| 2400-0238 | | | | | | | | | | | |
| 2400-0239 | | | | | | | | | | | |
| 2400-0240 | | | | | | | | | | | |
| 2400-0241 | | | | | | | | | | | |
| 2400-0242 | | | | | | | | | | | |
| 2400-1065 | | | | | | | | | | | |
| 2400-1066 | 140 | 129 | | 35 | 14 | 10 | 7 | 16 | 7 | 4 | |
| 2400-0243 | | | | | | | | | | | |
| 2400-0244 | | | | | | | | | | | |
| 2400-0245 | | | | | | | | | | | |
| 2400-0246 | | | | | | | | | | | |
| 2400-0247 | | | | | | | | | | | |
| 2400-0248 | 208 | 161 | 260 | 70 | 16 | 13 | 9 | 16 | 9 | 5 | |
| 2400-1067 | | | | | | | | | | | |

Продолжение табл. 1

Размеры в мм

| Обозначение протяжек | Приме- нение- мость | Испол- нение | Диаметр отверстия | | D | D ₁ | D ₃ | D ₄ | L | I | I ₁ |
|----------------------|---------------------------|-----------------|----------------------|-----------------|----|----------------|----------------|----------------|-----|-----|----------------|
| | | | Номин. | Поле допуска | | | | | | | |
| 2400-0249 | | 2 | | H8 | | | | | 910 | | |
| 2400-0250 | | 1 | 30,00 | H9 | | 28,9 | 30,00 | | 795 | | |
| 2400-0251 | | 2 | | | | | | | 910 | 8,0 | 365 |
| 2400-0252 | | 1 | 29,72 | H7 | | 28,6 | 29,72 | | 795 | | |
| 2400-0253 | | 2 | | | | | | | 910 | | |
| 2400-0254 | | 1 | | H7 | | | | | 580 | | |
| 2400-0255 | | 2 | | | | | | | 695 | | |
| 2400-1069 | | 1 | 32,00 | H8 | | 30,8 | 32,00 | | 580 | | |
| 2400-1071 | | 2 | | | | | | | 695 | | |
| 2400-0256 | | 1 | | H9 | 28 | | | | 580 | 6,5 | 290 |
| 2400-0257 | | 2 | | | | | | | 695 | | |
| 2400-0258 | | 1 | 31,66 | H7 | | 30,5 | 31,66 | | 25 | | |
| 2400-0259 | | 2 | | | | | | | 820 | | |
| 2400-0260 | | 1 | | H7 | | | | | 935 | | |
| 2400-1072 | | 2 | 32,00 | H8 | | 30,8 | 32,00 | | 820 | | |
| 2400-1073 | | 1 | | | | | | | 935 | | |
| 2400-0261 | | 2 | | H9 | | | | | 820 | 9,5 | 335 |
| 2400-0262 | | 1 | | | | | | | 935 | | |
| 2400-0263 | | 2 | 31,66 | H7 | | 30,5 | 31,66 | | 820 | | |
| 2400-0264 | | 1 | | | | | | | 935 | | |
| 2.00-0265 | | 2 | | H7 | | | | | 600 | | |
| 2400-0266 | | 1 | | | | | | | 715 | | |
| 2400-1074 | | 2 | 34,00 | H8 | 32 | 32,8 | 34,00 | | 600 | | |
| 2400-1075 | | 1 | | | | | | | 715 | 6,5 | 295 |
| 2400-0267 | | 2 | | H9 | | | | | 600 | | |
| 2400-0268 | | 1 | | | | | | | 715 | | |

Продолжение табл. I

| Обозначение протяжек | Размеры в мм | | | | | Зубья протяжек | | | | | | Выкружки Число выкружек n | a | a_1 | | | |
|----------------------|--------------|-------|-------|-------|-------|-----------------------|-----|-----------------|------------------------|-------|-----------------|--------------------------------|-----|-------|--|--|--|
| | t_1 | t_2 | t_3 | t_4 | t_5 | Черновые и переходные | | | Чистовые и калибрующие | | | | | | | | |
| | | | | | | Число зубьев | t | Номер профилья* | Число зубьев | t_1 | Номер профилья* | | | | | | |
| 2400-1068 | | | | | | | | | | | | | | | | | |
| 2400-0249 | | | | | | | | | | | | | | | | | |
| 2400-0250 | 208 | 161 | 260 | 70 | 16 | 13 | 9 | | 16 | 9 | 5 | | | | | | |
| 2400-0251 | | | | | | | | | | | | | | | | | |
| 2400-0252 | | | | | | | | | | | | | | | | | |
| 2400-0253 | | | | | | | | | | | | | | | | | |
| 2400-0254 | | | | | | | | | | | | | | | | | |
| 2400-1069 | | | | | | | | | | | | | | | | | |
| 2400-1071 | 140 | 129 | 220 | 35 | 14 | 10 | 7 | | 16 | 7 | 4 | | 6,0 | 4,5 | | | |
| 2400-0255 | | | | | | | | | | | | | | | | | |
| 2400-0256 | | | | | | | | | | | | | | | | | |
| 2400-0257 | | | | | | | | | | | | | | | | | |
| 2400-0258 | | | | | | | | | | | | | 8 | | | | |
| 2400-0259 | | | | | | | | | | | | | | | | | |
| 2400-0260 | | | | | | | | | | | | | | | | | |
| 2400-1072 | | | | | | | | | | | | | | | | | |
| 2400-1073 | 224 | 177 | 250 | 80 | 16 | 14 | 10 | | 16 | 10 | 7 | | | | | | |
| 2400-0261 | | | | | | | | | | | | | | | | | |
| 2400-0262 | | | | | | | | | | | | | | | | | |
| 2400-0263 | | | | | | | | | | | | | | | | | |
| 2400-0264 | | | | | | | | | | | | | | | | | |
| 2400-0265 | | | | | | | | | | | | | | | | | |
| 2400-0266 | | | | | | | | | | | | | | | | | |
| 2400-1074 | 140 | 129 | 225 | 35 | 14 | 10 | 7 | | 16 | 7 | 4 | | 6,5 | 5,0 | | | |
| 2400-1075 | | | | | | | | | | | | | | | | | |
| 2400-0267 | | | | | | | | | | | | | | | | | |
| 2400-0268 | | | | | | | | | | | | | | | | | |

Размеры в мм

Продолжение табл. I

| О обозначение протяжки | Приме- нение | Испол- нение | Диаметр отверстия | | D | D ₂ | D ₃ | D ₄ | L | I | I ₁ |
|---------------------------|-----------------|-----------------|----------------------|-----------------|----|----------------|----------------|----------------|-----|-----|----------------|
| | | | Номин. | Поле допуска | | | | | | | |
| 2400-0269 | | 1 | 33,66 | H7 | | 32,5 | 33,66 | | 600 | 6,5 | 295 |
| 2400-0270 | | 2 | | | | | | | 715 | | |
| 2400-0271 | | 1 | | | | | | | 820 | | |
| 2400-0272 | | 2 | | | | | | | 935 | | |
| 2400-1076 | | 1 | | | | | | | 820 | | |
| 2400-1077 | | 2 | 34,00 | H8 | | 32,8 | 34,00 | | 935 | | |
| 2400-0273 | | 1 | | | | | | | 820 | 9,5 | 365 |
| 2400-0274 | | 2 | | | | | | | 935 | | |
| 2400-0275 | | 1 | 33,66 | H7 | | 32,5 | 33,66 | | 820 | | |
| 2400-0276 | | 2 | | | | | | | 935 | | |
| 2400-0277 | | 1 | | | | | | | 600 | | |
| 2400-0278 | | 2 | | | | | | | 715 | | |
| 2400-1078 | | 1 | | | | | | | 600 | | |
| 2400-1079 | | 2 | (35,00) | H8 | 32 | 33,8 | 35,00 | 25 | 715 | | |
| 2400-0279 | | 1 | | | | | | | 600 | 6,5 | 295 |
| 2400-0280 | | 2 | | | | | | | 715 | | |
| 2400-0281 | | 1 | 34,66 | H7 | | 33,5 | 34,66 | | 600 | | |
| 2400-0282 | | 2 | | | | | | | 715 | | |
| 2400-0283 | | 1 | | | | | | | 820 | | |
| 2400-0284 | | 2 | | | | | | | 935 | | |
| 2400-1081 | | 1 | | | | | | | 820 | | |
| 2400-1082 | | 2 | (35,00) | H8 | | 33,8 | 35,00 | | 935 | | |
| 2400-0285 | | 1 | | | | | | | 820 | 9,5 | 365 |
| 2400-0285 | | 2 | | | | | | | 935 | | |
| 2400-0287 | | 1 | 34,66 | H7 | | 33,5 | 34,66 | | 820 | | |
| 2400-0288 | | 2 | | | | | | | 935 | | |
| 2400-0289 | | 1 | 36,00 | H7 | | 34,8 | 36,00 | | 600 | 6,5 | 295 |

Размеры в мм

Продолжение табл. 1

| Означение протяжек | t_1 | t_2 | t_3 | t_4 | t_5 | Зубья протяжен | | | | | | Выкружки | |
|-----------------------|-------|-------|-------|-------|-------|--------------------------|-----|------------------------------------|-------------------------|-------|------------------------------------|----------|--|
| | | | | | | Черновые и переходные | | | Чистовые и каспающие | | | | |
| | | | | | | Число зубьев | t | Номер про- фляя [*] | Число зубьев | t_1 | Номер про- фляя [*] | | |
| 2400-0269 | 140 | 129 | | 35 | 14 | 10 | 7 | | 16 | 7 | 4 | | |
| 2400-0270 | | | | | | | | | | | | | |
| 2400-0271 | | | | | | | | | | | | | |
| 2400-0272 | | | | | | | | | | | | | |
| 2400-1076 | | | | | | | | | | | | | |
| 2400-1077 | 224 | 177 | | 85 | 16 | 14 | 10 | | 16 | 10 | 7 | 6,5 5,0 | |
| 2400-0273 | | | | | | | | | | | | | |
| 2400-0274 | | | | | | | | | | | | | |
| 2400-0275 | | | | | | | | | | | | | |
| 2400-0276 | | | | | | | | | | | | | |
| 2400-0277 | | | | | | | | | | | | | |
| 2400-0278 | | | | | | | | | | | | | |
| 2400-1078 | | | 225 | | | | | | | | | 8 | |
| 2400-1079 | 140 | 129 | | 35 | 14 | 10 | 7 | | 16 | 7 | 4 | | |
| 2400-0279 | | | | | | | | | | | | | |
| 2400-0280 | | | | | | | | | | | | | |
| 2400-0281 | | | | | | | | | | | | | |
| 2400-0282 | | | | | | | | | | | | | |
| 2400-0283 | | | | | | | | | | | | 7,0 5,0 | |
| 2400-0284 | | | | | | | | | | | | | |
| 2400-1081 | | | | | | | | | | | | | |
| 2400-1082 | 224 | 177 | | 85 | 16 | 14 | 10 | | 16 | 10 | 7 | | |
| 2400-0285 | | | | | | | | | | | | | |
| 2400-0286 | | | | | | | | | | | | | |
| 2400-0287 | | | | | | | | | | | | | |
| 2400-0288 | | | | | | | | | | | | | |
| 2400-0289 | 140 | 129 | | 35 | 14 | 10 | 7 | | 16 | 7 | 4 | | |

Размеры в мм

Продолжение табл. 1

| Обозначение протяжек | Приме- нен- ность | Испол- нение | Диаметр отверстия | | D | D ₂ | D ₃ | D ₄ | L | I | I ₁ |
|----------------------|-------------------------|-----------------|-------------------|--------------|----|----------------|----------------|----------------|-----|-----|----------------|
| | | | Номин. | Поле допуска | | | | | | | |
| 2400-0290 | | 2 | | H7 | | | | | 715 | | |
| 2400-1083 | | 1 | | | | | | | 600 | | |
| 2400-1084 | | 2 | 36,00 | H8 | | 34,8 | 36,00 | | 715 | | |
| 2400-0291 | | 1 | | | | | | | 600 | 6,5 | 235 |
| 2400-0292 | | 2 | | | | | | | 715 | | |
| 2400-0293 | | 1 | 35,66 | H7 | | 34,5 | 35,66 | | 600 | | |
| 2400-0294 | | 2 | | | | | | | 715 | | |
| 2400-0295 | | 1 | | | | | | | 830 | | |
| 2400-0296 | | 2 | | | | | | | 945 | | |
| 2400-1085 | | 1 | 36,00 | H8 | | 34,8 | 36,00 | | 830 | | |
| 2400-1086 | | 2 | | | | | | | 945 | | |
| 2400-0297 | | 1 | | | 32 | | | | 25 | 9,5 | 380 |
| 2400-0298 | | 2 | | | | | | | 830 | | |
| 2400-0299 | | 1 | 35,66 | H7 | | 34,5 | 35,66 | | 830 | | |
| 2400-0300 | | 2 | | | | | | | 945 | | |
| 2400-1087 | | 1 | | | | | | | 600 | | |
| 2400-1088 | | 2 | | | | | | | 715 | | |
| 2400-1089 | | 1 | | | | | | | 600 | | 295 |
| 2400-1091 | | 2 | | | | | | | 715 | | |
| 2400-1092 | | 1 | (37,00) | | | | | | 830 | 6,5 | |
| 2400-1093 | | 2 | | | | | | | 945 | | |
| 2400-1094 | | 1 | | | | | | | 830 | | |
| 2400-1095 | | 2 | | | | | | | 945 | | |
| 2400-0301 | | 1 | | | | | | | 600 | | |
| 2400-0302 | | 2 | 38,00 | | 36 | 36,8 | 38,00 | 36 | 725 | 6,5 | 295 |
| 2400-1096 | | 1 | | | | | | | 600 | | |
| 2400-1097 | | 2 | | | | | | | 725 | | |

Продолжение табл. 1

Размеры в мм

| Обозначение протяжек | t_1 | t_2 | t_3 | t_4 | Зубья протяжек | | | | | Выкружки | | | |
|----------------------|-------|-------|-------|-------|-----------------------|-----|-----------------|------------------------|-------|-----------------|-----|-----|-------|
| | | | | | Черновые и переходные | | | Чистовые и калибрующие | | | c | a | c_1 |
| | | | | | Число зубьев | t | Номер профилей* | Число зубьев | t_2 | Номер профилей* | | | |
| 2400-0290 | | | | | | | | | | | | | |
| 2400-1083 | | | | | | | | | | | | | |
| 2400-1084 | | | | | | | | | | | | | |
| 2400-0291 | 140 | 129 | 225 | 35 | 14 | 10 | 7 | 16 | 7 | 4 | | | |
| 2400-0292 | | | | | | | | | | | | | |
| 2400-0293 | | | | | | | | | | | | | |
| 2400-0294 | | | | | | | | | | | | | |
| 2400-0295 | | | | | | | | | | | | 7,0 | 5,0 |
| 2400-0296 | | | | | | | | | | | | | |
| 2400-1085 | | | | | | | | | | | | | |
| 2400-1086 | 224 | 177 | 265 | 85 | 16 | 14 | 10 | 16 | 10 | 7 | | | |
| 2400-0297 | | | | | | | | | | | | | |
| 2400-0298 | | | | | | | | | | | | | |
| 2400-0299 | | | | | | | | | | | | | |
| 2400-0300 | | | | | | | | | | | | | |
| 2400-1087 | | | | | | | | | | | | | |
| 2400-1088 | 140 | 129 | 225 | 35 | 14 | 10 | 7 | 16 | 7 | 4 | | | |
| 2400-1089 | | | | | | | | | | | | | |
| 2400-1091 | | | | | | | | | | | | | |
| 2400-1092 | | | | | | | | | | | | | |
| 2400-1093 | 224 | 177 | 265 | 80 | 16 | 14 | 10 | 16 | 10 | 7 | | | |
| 2400-1094 | | | | | | | | | | | | | |
| 2400-1095 | | | | | | | | | | | | | |
| 2400-0301 | | | | | | | | | | | | | |
| 2400-0302 | 140 | 129 | 225 | 35 | 14 | 10 | 7 | 16 | 7 | 4 | | | |
| 2400-1096 | | | | | | | | | | | | | |
| 2400-1097 | | | | | | | | | | | | | |

Размеры в мм

Продолжение табл. 1

| Обозначение протяжек | Приме- ните- льность | Испол- нение | Диаметр отверстия | | D | D ₂ | D ₃ | D ₄ | L | l | l ₁ |
|-------------------------|----------------------------|-----------------|-----------------------|-----------------|---|----------------|----------------|----------------|------|-----|----------------|
| | | | Номи- наль- ный | Поле допуска | | | | | | | |
| 2400-0303 | | 1 | 38,00 | H9 | | 36,8 | 38,00 | | 600 | | |
| 2400-0304 | | 2 | | | | | | | 725 | 6,5 | 295 |
| 2400-0305 | | 1 | 37,66 | H7 | | 36,5 | 37,66 | | 600 | | |
| 2400-0306 | | 2 | | | | | | | 725 | | |
| 2400-0307 | | 1 | | | | | | | 830 | | |
| 2400-0308 | | 2 | | | | | | | 955 | | |
| 2400-1088 | | 1 | 38,00 | H8 | | 36,8 | 38,00 | | 830 | | |
| 2400-1099 | | 2 | | | | | | | 955 | | |
| 2400-0309 | | 1 | | | | | | | 830 | 9,5 | 380 |
| 2400-0310 | | 2 | | | | | | | 955 | | |
| 2400-0311 | | 1 | 37,66 | H7 | | 36,5 | 37,66 | | 830 | | |
| 2400-0312 | | 2 | | | | | | | 955 | | |
| 2400-0313 | | 1 | | | | | | | 640 | | |
| 2400-0314 | | 2 | | | | | | | 765 | | |
| 2400-1101 | | 1 | 40,00 | H8 | | 38,8 | 40,00 | | 640 | | |
| 2400-1102 | | 2 | | | | | | | 765 | 7,0 | 315 |
| 2400-0315 | | 1 | | | | | | | 640 | | |
| 2400-0316 | | 2 | | | | | | | 765 | | |
| 2400-0317 | | 1 | 39,66 | H7 | | 38,5 | 39,66 | | 640 | | |
| 2400-0318 | | 2 | | | | | | | 765 | | |
| 2400-0319 | | 1 | | | | | | | 880 | | |
| 2400-0320 | | 2 | | | | | | | 1005 | | |
| 2400-1103 | | 1 | 40,00 | H8 | | 38,8 | 40,00 | | 880 | | |
| 2400-1104 | | 2 | | | | | | | 1005 | 9,5 | 400 |
| 2400-0321 | | 1 | | | | | | | 880 | | |
| 2400-0322 | | 2 | | | | | | | 1005 | | |
| 2400-0323 | | 1 | 39,66 | H7 | | 38,5 | 39,66 | | 880 | | |

Размеры в мм

Продолжение табл. I

| Обозначение протяжек | t_1 | t_3 | t_4 | t_5 | Зубья протяжек | | | | | | Выкрутки | |
|-------------------------|-------|-------|-------|-------|--------------------------|-----|------------------------------------|---------------------------|-------|------------------------------------|----------|-----|
| | | | | | Черновые и переходные | | | Чистовые и калибрующие | | | | |
| | | | | | Число зубьев | t | Номер про- фляя [*] | Число зубьев | t_1 | Номер про- фляя [*] | | |
| 2100-0303 | | | | | | | | | | | | |
| 21400-0304 | 140 | 129 | 225 | 35 | 14 | 10 | 7 | 16 | 7 | 4 | | |
| 2100-0305 | | | | | | | | | | | | |
| 2100-0306 | | | | | | | | | | | | |
| 2100-0307 | | | | | | | | | | | | |
| 2100-0308 | | | | | | | | | | | | |
| 2100-1098 | | | | | | | | | | | | |
| 2100-1099 | | | | | | | | | | | | |
| 2400-0309 | 224 | 177 | 265 | 80 | 16 | 14 | 10 | 16 | 10 | 7 | | |
| 2400-0310 | | | | | | | | | | | | |
| 2100-0311 | | | | | | | | | | | | |
| 2100-0312 | | | | | | | | | | | | |
| 2430-0313 | | | | | | | | | | | 8 | 7,5 |
| 2100-0314 | | | | | | | | | | | | 5,5 |
| 2100-1101 | | | | | | | | | | | | |
| 2400-1102 | | | | | | | | | | | | |
| 2400-0315 | 154 | 129 | 240 | 40 | 14 | 11 | 8 | 16 | 7 | 4 | | |
| 2400-0316 | | | | | | | | | | | | |
| 2400-0317 | | | | | | | | | | | | |
| 2400-0318 | | | | | | | | | | | | |
| 2400-0319 | | | | | | | | | | | | |
| 2400-0320 | | | | | | | | | | | | |
| 2400-1103 | | | | | | | | | | | | |
| 2400-1104 | 252 | 177 | 265 | 100 | 18 | 14 | 10 | 16 | 10 | 6 | | |
| 2400-0321 | | | | | | | | | | | | |
| 2100-0322 | | | | | | | | | | | | |
| 2100-0323 | | | | | | | | | | | | |

Размеры в мм

Продолжение табл. I

| Обозначение прокладок | Приме- нение | Исполне- ние | Диаметр отверстия | | D | D ₁ | D ₂ | D ₃ | D ₄ | L | l | l ₁ |
|-----------------------|-----------------|-----------------|-------------------|--------------|----|----------------|----------------|----------------|----------------|------|-----|----------------|
| | | | Номин. | Поле допуска | | | | | | | | |
| 2400-0324 | | 2 | 39,66 | H7 | 36 | 38,5 | 39,66 | | | 1005 | 9,5 | 400 |
| 2400-0325 | | 1 | | H7 | | | | | | 665 | | |
| 2400-0326 | | 2 | | | | | | | | 790 | | |
| 2400-1105 | | 1 | 42,00 | H8 | | 40,7 | 42,00 | | | 655 | | |
| 2400-1106 | | 2 | | | | | | | | 790 | | |
| 2400-0327 | | 1 | | H9 | | | | | | 665 | 7 | 335 |
| 2400-0328 | | 2 | | | | | | | | 790 | | |
| 2400-0329 | | 1 | 41,66 | H7 | | 40,4 | 41,66 | | | 665 | | |
| 2400-0330 | | 2 | | | | | | | | 790 | | |
| 2400-0331 | | 1 | | H7 | | | | | | 900 | | |
| 2400-0332 | | 2 | | | | | | | | 1025 | | |
| 2400-1107 | | 1 | 42,00 | H8 | | 40,7 | 42,00 | | | 900 | | |
| 2400-1108 | | 2 | | | | | | | | 1025 | | |
| 2400-0333 | | 1 | | H9 | 40 | | | | | 900 | 11 | 415 |
| 2400-0334 | | 2 | | | | | | | | 1025 | | |
| 2400-0335 | | 1 | 41,66 | H7 | | 40,4 | 41,66 | | | 900 | | |
| 2400-0336 | | 2 | | | | | | | | 1025 | | |
| 2400-0337 | | 1 | | H7 | | | | | | 665 | | |
| 2400-0338 | | 2 | | | | | | | | 790 | | |
| 2400-1109 | | 1 | 45,00 | H8 | | 43,7 | 45,00 | | | 665 | | |
| 2400-1111 | | 2 | | | | | | | | 790 | 7 | 335 |
| 2400-0339 | | 1 | | H9 | | | | | | 665 | | |
| 2400-0340 | | 2 | | | | | | | | 790 | | |
| 2400-0341 | | 1 | 44,66 | H7 | | 43,4 | 44,66 | | | 665 | | |
| 2400-0342 | | 2 | | | | | | | | 790 | | |
| 2400-0343 | | 1 | 45,00 | H7 | | 43,7 | 45,00 | | | 900 | 11 | 415 |
| 2400-0344 | | 2 | | | | | | | | 1025 | | |

Размеры в мм

Продолжение табл. 1

| Обозначение протяжек | t_3 | t_2 | t_4 | t_5 | Зубья протяжек | | | | | | Выкружки | | | |
|----------------------|-------|-------|-------|-------|-----------------------|-----|----------------|------------------------|-------|----------------|----------|-----------------|-------|-----------------|
| | | | | | Черновые и переходные | | | Чистовые и калибрующие | | | t_1 | Номер профилей* | t_2 | Номер профилей* |
| | | | | | Число зубьев | t | Номер профиля* | Число зубьев | t_1 | Номер профиля* | | | | |
| 2400-0324 | 252 | 177 | 265 | 100 | 18 | 14 | 10 | 16 | 10 | 6 | 8 | — | 7,5 | 5,5 |
| 2400-0325 | | | | | | | | | | | | | | |
| 2400-0326 | | | | | | | | | | | | | | |
| 2400-1105 | | | | | | | | | | | | | | |
| 2400-1106 | | | | | | | | | | | | | | |
| 2400-0327 | 176 | 129 | 260 | 40 | 16 | 11 | 8 | 16 | 7 | 4 | | | | |
| 2400-0328 | | | | | | | | | | | | | | |
| 2400-0329 | | | | | | | | | | | | | | |
| 2400-0330 | | | | | | | | | | | | | 6,5 | 4,5 |
| 2400-0331 | | | | | | | | | | | | | | |
| 2400-0332 | | | | | | | | | | | | | | |
| 2400-1107 | | | | | | | | | | | | | | |
| 2400-1108 | | | | | | | | | | | | | | |
| 2400-0333 | 224 | 193 | 290 | 90 | 14 | 16 | 11 | 16 | 11 | 7 | | 10 | | |
| 2400-0334 | | | | | | | | | | | | | | |
| 2400-0335 | | | | | | | | | | | | | | |
| 2400-0336 | | | | | | | | | | | | | | |
| 2400-0337 | | | | | | | | | | | | | | |
| 2400-0338 | | | | | | | | | | | | | | |
| 2400-1109 | | | | | | | | | | | | | | |
| 2400-1111 | | | | | | | | | | | | | | |
| 2400-0339 | 176 | 129 | 260 | 40 | 16 | 11 | 8 | 16 | 7 | 4 | | | | |
| 2400-0340 | | | | | | | | | | | | | | |
| 2400-0341 | | | | | | | | | | | | | | |
| 2400-0342 | | | | | | | | | | | | | | |
| 2400-0343 | 224 | 193 | 290 | 90 | 14 | 16 | 11 | 16 | 11 | 7 | | | | |
| 2400-0344 | | | | | | | | | | | | | | |

Размеры в мм

Продолжение табл. 1

| Обозначение протяжек | Приме- нение | Испол- нение | Диаметр отверстия | | D | D ₂ | D ₄ | D ₆ | L | I | I ₁ |
|-------------------------|-----------------|-----------------|----------------------|------------------|----|----------------|----------------|----------------|------|---|----------------|
| | | | Номинал | После запуска | | | | | | | |
| 2400-1112 | | 1 | | H8 | | | | | 900 | | |
| 2400-1113 | | 2 | 45,00 | | | 43,7 | 45,00 | | 1025 | | |
| 2400-0345 | | 1 | | H9 | | | | | 900 | | |
| 2400-0346 | | 2 | | | | | | | 1025 | | |
| 2400-0347 | | 1 | 44,66 | H7 | | 43,4 | 44,66 | | 900 | | |
| 2400-0348 | | 2 | | | | | | | 1025 | | |
| 2400-1114 | | 1 | | H7 | 40 | | | | 665 | | |
| 2400-1115 | | 2 | | | | | | | 790 | | |
| 2400-1116 | | 1 | | H9 | | | | | 665 | | |
| 2400-1117 | | 2 | (47,00) | | | | | | 790 | | |
| 2400-1118 | | 1 | | H7 | | 45,7 | 47,00 | | 900 | | |
| 2400-1119 | | 2 | | | | | | | 1025 | | |
| 2400-1121 | | 1 | | H9 | | | | | 900 | | |
| 2400-1122 | | 2 | | | | | | | 1025 | | |
| 2400-0349 | | 1 | | H7 | | | | | 665 | | |
| 2400-0350 | | 2 | | | | | | | 790 | | |
| 2400-1123 | | 1 | 48,00 | H8 | | 46,7 | 48,00 | | 665 | | |
| 2400-1124 | | 2 | | | | | | | 790 | | |
| 2400-0351 | | 1 | | H9 | | | | | 665 | | |
| 2400-0352 | | 2 | | | 45 | | | | 790 | | |
| 2400-0353 | | 1 | 47,66 | H7 | | 46,4 | 47,66 | | 665 | | |
| 2400-0354 | | 2 | | | | | | | 790 | | |
| 2400-0355 | | 1 | | H7 | | | | | 900 | | |
| 2400-0356 | | 2 | | | | | | | 1025 | | |
| 2400-1125 | | 1 | 48,00 | H8 | | 46,7 | 48,00 | | 900 | | |
| 2400-1126 | | 2 | | | | | | | 1025 | | |
| 2400-0357 | | 1 | | H9 | | | | | 900 | | |

Продолжение табл. 1

Размеры в мм

| Обозначен с протяжек | t_2 | t_3 | t_4 | t_5 | Зубья протяжек | | | | | Выкружки | |
|----------------------|-------|-------|-------|-------|-----------------------|-----|----------------|-------------------------|-------|----------------|-----|
| | | | | | Черновые и переходные | | | Чистовые и зализирующие | | | |
| | | | | | Число зубьев | t | Номер профиля* | Число зубьев | t_2 | Номер профиля* | |
| 2400-1112 | | | | | | | | | | | |
| 2400-1113 | | | | | | | | | | | |
| 2400-0345 | 224 | 193 | 290 | 90 | 14 | 16 | 11 | 16 | 11 | 7 | 7,0 |
| 2400-0346 | | | | | | | | | | | 5,0 |
| 2400-0347 | | | | | | | | | | | |
| 2400-0348 | | | | | | | | | | | |
| 2400-1114 | | | | | | | | | | | |
| 2400-1115 | 176 | 129 | 260 | 40 | 16 | 11 | 8 | 16 | 7 | 4 | |
| 2400-1116 | | | | | | | | | | | |
| 2400-1117 | | | | | | | | | | | |
| 2400-1118 | | | | | | | | | | | |
| 2400-1119 | 224 | 193 | 290 | 90 | 14 | 16 | 11 | 16 | 11 | 7 | |
| 2400-1121 | | | | | | | | | | | |
| 2400-1122 | | | | | | | | | | | |
| 2400-0349 | | | | | | | | | | | 10 |
| 2400-0350 | | | | | | | | | | | 7,5 |
| 2400-1123 | | | | | | | | | | | 5,5 |
| 2400-1124 | 176 | 129 | 260 | 40 | 16 | 11 | 8 | 16 | 7 | 4 | |
| 2400-0351 | | | | | | | | | | | |
| 2400-0352 | | | | | | | | | | | |
| 2400-0353 | | | | | | | | | | | |
| 2400-0354 | | | | | | | | | | | |
| 2400-0355 | | | | | | | | | | | |
| 2400-0356 | | | | | | | | | | | |
| 2400-1125 | 224 | 193 | 290 | 90 | 14 | 16 | 11 | 16 | 11 | 7 | |
| 2400-1126 | | | | | | | | | | | |
| 2400-0357 | | | | | | | | | | | |

Продолжение табл. 1

Размеры в мм

| Обозначение протяжек | Приме- нение | Испол- нение | Диаметр отверстия | | D | D ₀ | D ₁ | D ₂ | L | t | t ₂ |
|----------------------|-----------------|-----------------|----------------------|-----------------|----|----------------|----------------|----------------|------|----|----------------|
| | | | Номин. | Поле допуска | | | | | | | |
| 2400-0358 | | 2 | 48,00 | H9 | | 46,7 | 48,00 | | 1025 | | |
| 2400-0359 | | 1 | 47,66 | H7 | | 46,4 | 47,66 | | 900 | 11 | 415 |
| 2400-0360 | | 2 | | | | | | | 1025 | | |
| 2400-0361 | | 1 | | H7 | | | | | 665 | | |
| 2400-0362 | | 2 | | | | | | | 790 | | |
| 2400-1127 | | 1 | 50,00 | H8 | | 48,7 | 50,00 | | 665 | | |
| 2400-1128 | | 2 | | | | | | | 790 | 7 | 335 |
| 2400-0363 | | 1 | | H9 | | | | | 665 | | |
| 2400-0364 | | 2 | | | | | | | 790 | | |
| 2400-0365 | | 1 | 49,66 | H7 | | 48,4 | 49,66 | | 665 | | |
| 2400-0366 | | 2 | | | | | | | 790 | | |
| 2400-0367 | | 1 | | H7 | 45 | | | | 900 | | |
| 2400-0368 | | 2 | | | | | | | 1025 | | |
| 2400-1129 | | 1 | 50,00 | H8 | | 48,7 | 50,00 | | 900 | | |
| 2400-1131 | | 2 | | | | | | | 1025 | 11 | 415 |
| 2400-0369 | | 1 | | H9 | | | | | 900 | | |
| 2400-0370 | | 2 | | | | | | | 1025 | | |
| 2400-0371 | | 1 | 49,66 | H7 | | 48,4 | 49,66 | | 900 | | |
| 2400-0372 | | 2 | | | | | | | 1025 | | |
| 2400-0373 | | 1 | | H7 | | | | | 665 | | |
| 2400-0374 | | 2 | | | | | | | 790 | | |
| 2400-1132 | | 1 | 52,00 | H8 | | 50,6 | 52,00 | | 665 | | |
| 2400-1133 | | 2 | | | | | | | 790 | 7 | 335 |
| 2400-0375 | | 1 | | H9 | | | | | 665 | | |
| 2400-0376 | | 2 | | | | | | | 790 | | |
| 2400-0377 | | 1 | 51,60 | H7 | | 50,2 | 51,60 | | 665 | | |
| 2400-0378 | | 2 | | | | | | | 790 | | |

Продолжение табл. 1

Размеры в мм

| Обозначение протяжек | <i>l₁</i> | <i>l₃</i> | <i>l₄</i> | <i>l₅</i> | Зубья протяжек | | | | | | Выкружки | <i>a</i> | <i>a₁</i> | | | | |
|----------------------|----------------------|----------------------|----------------------|----------------------|-----------------------|----------|----------------|-----------------------|----------------------|----------------|----------|----------|----------------------|--|--|--|--|
| | | | | | Черновые и переходные | | | Чистовые и залипающие | | | | | | | | | |
| | | | | | Число зубьев | <i>t</i> | Номер профиля* | Число зубьев | <i>t₁</i> | Номер профиля* | | | | | | | |
| 2400-0358 | | | | | | | | | | | | | | | | | |
| 2400-0359 | 224 | 193 | 290 | 90 | 14 | 16 | 11 | 16 | 11 | 7 | | | | | | | |
| 2400-0360 | | | | | | | | | | | | | | | | | |
| 2400-0361 | | | | | | | | | | | | | | | | | |
| 2400-0362 | | | | | | | | | | | | | | | | | |
| 2400-1127 | | | | | | | | | | | | | | | | | |
| 2400-1128 | | | | | | | | | | | | | | | | | |
| 2400-0363 | 176 | 129 | 260 | 40 | 16 | 11 | 8 | 16 | 7 | 4 | | | | | | | |
| 2400-0364 | | | | | | | | | | | | | | | | | |
| 2400-0365 | | | | | | | | | | | | | | | | | |
| 2400-0366 | | | | | | | | | | | | | | | | | |
| 2400-0367 | | | | | | | | | | | | | | | | | |
| 2400-0368 | | | | | | | | | | | | | | | | | |
| 2400-1129 | | | | | | | | | | | | | | | | | |
| 2400-1131 | | | | | | | | | | | | | | | | | |
| 2400-0369 | 224 | 193 | 290 | 90 | 14 | 16 | 11 | 16 | 11 | 7 | | | | | | | |
| 2400-0370 | | | | | | | | | | | | | | | | | |
| 2400-0371 | | | | | | | | | | | | | | | | | |
| 2400-0372 | | | | | | | | | | | | | | | | | |
| 2400-0373 | | | | | | | | | | | | | | | | | |
| 2400-0374 | | | | | | | | | | | | | | | | | |
| 2400-1132 | | | | | | | | | | | | | | | | | |
| 2400-1133 | 176 | 129 | 260 | 40 | 16 | 11 | 8 | 16 | 7 | 4 | | | | | | | |
| 2400-0375 | | | | | | | | | | | | | | | | | |
| 2400-0376 | | | | | | | | | | | | | | | | | |
| 2400-0377 | | | | | | | | | | | | | | | | | |
| 2400-0378 | | | | | | | | | | | | | | | | | |

Продолжение табл. 1

Размеры в мм

| Обозначение протяжек | Приме- нение | Испол- нение | Диаметр отверстия | | D | D ₂ | D ₃ | D ₄ | L | t | t ₁ |
|----------------------|-----------------|-----------------|-------------------|--------------|----|----------------|----------------|----------------|------|---|----------------|
| | | | Номин. | Поле допуска | | | | | | | |
| 2400-0379 | | 1 | | H7 | | | | | 925 | | |
| 2400-0380 | | 2 | | | | | | | 1050 | | |
| 2400-1134 | | 1 | 52,00 | H8 | | | | | 925 | | |
| 2400-1135 | | 2 | | | | | | | 1050 | | |
| 2400-0381 | | 1 | | H9 | | | | | 925 | | |
| 2400-0382 | | 2 | | | | | | | 1050 | | |
| 2400-0383 | | 1 | 51,60 | H7 | | | | | 925 | | |
| 2400-0384 | | 2 | | | | | | | 1050 | | |
| 2400-1136 | | 1 | | H7 | | | | | 665 | | |
| 2400-1137 | | 2 | | | | | | | 790 | | |
| 2400-1138 | | 1 | 53,00 | H8 | | | | | 665 | | |
| 2400-1139 | | 2 | | | | | | | 790 | | |
| 2400-1141 | | 1 | | H9 | 45 | | | | 665 | | |
| 2400-1142 | | 2 | | | | | | | 790 | | |
| 2400-1143 | | 1 | 52,60 | H7 | | | | | 665 | | |
| 2400-1144 | | 2 | | | | | | | 790 | | |
| 2400-1145 | | 1 | | H7 | | | | | 925 | | |
| 2400-1146 | | 2 | | | | | | | 1050 | | |
| 2400-1147 | | 1 | 53,00 | H8 | | | | | 925 | | |
| 2400-1148 | | 2 | | | | | | | 1050 | | |
| 2400-1149 | | 1 | | H9 | | | | | 925 | | |
| 2400-1151 | | 2 | | | | | | | 1050 | | |
| 2400-1152 | | 1 | 52,6 | H7 | | | | | 925 | | |
| 2400-1153 | | 2 | | | | | | | 1050 | | |
| 2400-0385 | | 1 | | H7 | | | | | 665 | | |
| 2400-0386 | | 2 | 55,0 | H7 | | | | | 790 | | |
| 2400-1154 | | 1 | | H8 | | | | | 665 | | |

Продолжение табл. 1

Размеры в мм

| Обозначение протяжек | t_3 | t_4 | t_5 | t_6 | Зубья протяжек | | | | | | Выкружки | | | |
|----------------------|-------|-------|-------|-------|-----------------------|-----|-----------------|------------------------|-------|-----------------|----------------|-----|-------|--|
| | | | | | Черновые и переходные | | | Чистовые и калибрующие | | | Число выкружек | a | a_1 | |
| | | | | | Число зубьев | t | Номер профилья* | Число зубьев | t_1 | Номер профилья* | | | | |
| 2400-0379 | | | | | | | | | | | | | | |
| 2400-0380 | | | | | | | | | | | | | | |
| 2400-1134 | | | | | | | | | | | | | | |
| 2400-1135 | | | | | | | | | | | | | | |
| 2400-0381 | 256 | 193 | 290 | 90 | 16 | 16 | 11 | 16 | 11 | 7 | | 8,0 | 6,0 | |
| 2400-0382 | | | | | | | | | | | | | | |
| 2400-0383 | | | | | | | | | | | | | | |
| 2400-0384 | | | | | | | | | | | | | | |
| 2400-1136 | | | | | | | | | | | | | | |
| 2400-1137 | | | | | | | | | | | | | | |
| 2400-1138 | | | | | | | | | | | | | | |
| 2400-1139 | | | | | | | | | | | | | | |
| 2400-1141 | 176 | 129 | 260 | 40 | 16 | 11 | 8 | 16 | 7 | 4 | 10 | | | |
| 2400-1142 | | | | | | | | | | | | | | |
| 2400-1143 | | | | | | | | | | | | | | |
| 2400-1144 | | | | | | | | | | | | | | |
| 2400-1145 | | | | | | | | | | | | 8,5 | 6,5 | |
| 2400-1146 | | | | | | | | | | | | | | |
| 2400-1147 | | | | | | | | | | | | | | |
| 2400-1148 | | | | | | | | | | | | | | |
| 2400-1149 | 256 | 193 | 290 | 90 | 16 | 16 | 11 | 16 | 11 | 7 | | | | |
| 2400-1151 | | | | | | | | | | | | | | |
| 2400-1152 | | | | | | | | | | | | | | |
| 2400-1153 | | | | | | | | | | | | | | |
| 2400-0385 | | | | | | | | | | | | | | |
| 2400-0386 | 176 | 129 | 260 | 40 | 16 | 11 | 8 | 16 | 7 | 4 | | | | |
| 2400-1154 | | | | | | | | | | | | | | |

Продолжение табл. 1

Размеры в мм

| Обозначение протяжек | Приме- ните- льность | Испол- нение | Диаметр отверстия | | D | D ₁ | D ₂ | D ₄ | L | t | L ₁ |
|----------------------|----------------------------|-----------------|-----------------------|-----------------|----|----------------|----------------|----------------|------|----|----------------|
| | | | Номи- наль- ный | Поле допуска | | | | | | | |
| 2400-1155 | | 2 | | H8 | | | | | 790 | | |
| 2400-0387 | | 1 | 55,0 | H9 | | 53,6 | 55,0 | | 665 | 7 | 335 |
| 2400-0388 | | 2 | | | | | | | 790 | | |
| 2400-0389 | | 1 | 54,6 | H7 | | 53,2 | 54,6 | | 665 | | |
| 2400-0390 | | 2 | | | | | | | 790 | | |
| 2400-0391 | | 1 | | H7 | | | | | 925 | | |
| 2400-0392 | | 2 | | | | | | | 1050 | | |
| 2400-1156 | | 1 | 55,0 | H8 | | 53,6 | 55,0 | | 925 | | |
| 2400-1157 | | 2 | | | | | | | 1050 | 11 | 415 |
| 2400-0393 | | 1 | | H9 | | | | | 925 | | |
| 2400-0394 | | 2 | | | | | | | 1050 | | |
| 2400-0395 | | 1 | 54,6 | H7 | | 53,2 | 54,6 | | 925 | | |
| 2400-0396 | | 2 | | | | | | | 1050 | | |
| 2400-1158 | | 1 | | H7 | 45 | | | | 665 | | |
| 2400-1159 | | 2 | | | | | | | 790 | | |
| 2400-1161 | | 1 | 56,0 | H8 | | 54,6 | 56,0 | | 665 | | |
| 2400-1162 | | 2 | | | | | | | 790 | 7 | 335 |
| 2400-1163 | | 1 | | H9 | | | | | 665 | | |
| 2400-1164 | | 2 | | | | | | | 790 | | |
| 2400-1165 | | 1 | 55,6 | H7 | | 54,2 | 55,6 | | 665 | | |
| 2400-1166 | | 2 | | | | | | | 790 | | |
| 2400-1167 | | 1 | | H7 | | | | | 925 | | |
| 2400-1168 | | 2 | | | | | | | 1050 | | |
| 2400-1169 | | 1 | 56,0 | H8 | | 54,6 | 56,0 | | 925 | 11 | 415 |
| 2400-1171 | | 2 | | | | | | | 1050 | | |
| 2400-1172 | | 1 | | H9 | | | | | 925 | | |
| 2400-1173 | | 2 | | | | | | | 1050 | | |

Продолжение табл. 1

Размеры в мм

| Обозначение протяжек | t_2 | t_3 | t_4 | t_5 | Зубья протяжек | | | | | | Выкружки | |
|----------------------|-------|-------|-------|-------|-----------------------|-----|-----------------|------------------------|-------|-----------------|----------|-----|
| | | | | | Черновые и переходные | | | Чистовые и калибрующие | | | | |
| | | | | | Число зубьев | t | Номер профилей* | Число зубьев | t_1 | Номер профилей* | | |
| 2400-1155 | | | | | | | | | | | | |
| 2400-0387 | 176 | 129 | 260 | 40 | 16 | 11 | 8 | 16 | 7 | 4 | | |
| 2400-0388 | | | | | | | | | | | | |
| 2400-0389 | | | | | | | | | | | | |
| 2400-0390 | | | | | | | | | | | | |
| 2400-0391 | | | | | | | | | | | | |
| 2400-0392 | | | | | | | | | | | | |
| 2400-1156 | | | | | | | | | | | 10 | 8,5 |
| 2400-1157 | 256 | 193 | 290 | 90 | 16 | 16 | 11 | 16 | 11 | 7 | | 6,5 |
| 2400-0393 | | | | | | | | | | | | |
| 2400-0394 | | | | | | | | | | | | |
| 2400-0395 | | | | | | | | | | | | |
| 2400-0396 | | | | | | | | | | | | |
| 2400-1158 | | | | | | | | | | | | |
| 2400-1159 | | | | | | | | | | | | |
| 2400-1161 | | | | | | | | | | | | |
| 2400-1162 | | | | | | | | | | | | |
| 2400-1163 | 176 | 129 | 260 | 40 | 16 | 11 | 8 | 16 | 7 | 4 | | |
| 2400-1164 | | | | | | | | | | | | |
| 2400-1165 | | | | | | | | | | | | |
| 2400-1166 | | | | | | | | | | | 12 | 7,5 |
| 2400-1167 | | | | | | | | | | | | 5,5 |
| 2400-1168 | | | | | | | | | | | | |
| 2400-1169 | 256 | 193 | 290 | 90 | 16 | 16 | 11 | 16 | 11 | 7 | | |
| 2400-1171 | | | | | | | | | | | | |
| 2400-1172 | | | | | | | | | | | | |
| 2400-1173 | | | | | | | | | | | | |

Продолжение табл. 1

Размеры в мм

| Обозначение протяжек | Приме- нение | Испол- нение | Диаметр отверстия | | <i>D</i> | <i>D₁</i> | <i>D₂</i> | <i>D₄</i> | <i>L</i> | <i>t</i> | <i>L₁</i> |
|-------------------------|-----------------|-----------------|----------------------|------------------|----------|----------------------|----------------------|----------------------|----------|----------|----------------------|
| | | | Номин | Полос допуска | | | | | | | |
| 2400-1174 | | 1 | 55,6 | <i>H7</i> | | 54,2 | 55,6 | | 925 | 11 | 415 |
| 2400-1175 | | 2 | | | | | | | 1050 | | |
| 2400-0397 | | 1 | | | | | | | 665 | | |
| 2400-0398 | | 2 | | | | | | | 790 | | |
| 2400-1176 | | 1 | (58,0) | <i>H8</i> | | 56,6 | 58,0 | | 665 | | |
| 2400-1177 | | 2 | | | | | | | 790 | 7 | 335 |
| 2400-0399 | | 1 | | <i>H9</i> | | | | | 665 | | |
| 2400-0400 | | 2 | | | | | | | 790 | | |
| 2400-0401 | | 1 | 57,6 | <i>H7</i> | | 56,2 | 57,6 | | 665 | | |
| 2400-0402 | | 2 | | | | | | | 790 | | |
| 2400-0403 | | 1 | | | | | | | 960 | | |
| 2400-0404 | | 2 | | | | | | | 1075 | | |
| 2400-1178 | | 1 | (58,0) | <i>H8</i> | 45 | 56,6 | 58,0 | 36 | 950 | | |
| 2400-1177 | | 2 | | | | | | | 1075 | 11 | 435 |
| 2400-0405 | | 1 | | | | | | | 950 | | |
| 2400-0406 | | 2 | | | | | | | 1075 | | |
| 2400-0407 | | 1 | 57,6 | <i>H7</i> | | 56,2 | 57,6 | | 950 | | |
| 2400-0408 | | 2 | | | | | | | 1075 | | |
| 2400-0409 | | 1 | | | | | | | 690 | | |
| 2400-0410 | | 2 | | | | | | | 815 | | |
| 2400-1181 | | 1 | 60,0 | <i>H8</i> | | 58,6 | 60,0 | | 690 | | |
| 2400-1182 | | 2 | | | | | | | 815 | 7 | 350 |
| 2400-0411 | | 1 | | | | | | | 690 | | |
| 2400-0412 | | 2 | | | | | | | 815 | | |
| 2400-0413 | | 1 | 59,6 | <i>H7</i> | | 58,2 | 59,6 | | 690 | | |
| 2400-0414 | | 2 | | | | | | | 815 | | |
| 2400-0415 | | 1 | 60,0 | <i>H7</i> | | 58,6 | 60,0 | | 950 | 11 | 440 |

Продолжение табл. 1

Размеры в мм

| Обозначение протяжек | l_2 | l_3 | l_4 | l_5 | Зубья протяжек | | | | | | Выкружки | |
|----------------------|-------|-------|-------|-------|-----------------------|-----|-----------------|------------------------|-------|-----------------|----------|--|
| | | | | | Черновые и переходные | | | Чистовые и калибрующие | | | | |
| | | | | | Число зубьев | t | Номер профилья* | Число зубьев | t_1 | Номер профилья* | | |
| 2400-1174 | 256 | 193 | 290 | 90 | 16 | 16 | 11 | 16 | 11 | 7 | | |
| 2400-1175 | — | — | — | — | — | — | — | — | — | — | | |
| 2400-0397 | | | | | | | | | | | | |
| 2400-0398 | | | | | | | | | | | | |
| 2400-1176 | | | | | | | | | | | | |
| 2400-1177 | | | | | | | | | | | | |
| 2400-0399 | 176 | 129 | 260 | 40 | 16 | 11 | 8 | 16 | 7 | 4 | | |
| 2400-0400 | | | | | | | | | | | | |
| 2400-0401 | | | | | | | | | | | | |
| 2400-0402 | | | | | | | | | | | | |
| 2400-0403 | | | | | | | | | | | | |
| 2400-0404 | | | | | | | | | | | | |
| 2400-1178 | | | | | | | | | | | 12 | |
| 2400-1179 | | | | | | | | | | | 7,5 | |
| 2400-0405 | 256 | 193 | 310 | 90 | 16 | 16 | 11 | 16 | 11 | 7 | 5,5 | |
| 2400-0406 | | | | | | | | | | | | |
| 2400-0407 | | | | | | | | | | | | |
| 2400-0408 | | | | | | | | | | | | |
| 2400-0409 | | | | | | | | | | | | |
| 2400-0410 | | | | | | | | | | | | |
| 2400-1181 | | | | | | | | | | | | |
| 2400-1182 | 176 | 129 | 275 | 40 | 16 | 11 | 8 | 16 | 7 | 4 | | |
| 2400-0411 | | | | | | | | | | | | |
| 2400-0412 | | | | | | | | | | | | |
| 2400-0413 | | | | | | | | | | | | |
| 2400-0414 | | | | | | | | | | | | |
| 2400-0415 | 256 | 193 | 315 | 90 | 16 | 16 | 11 | 16 | 11 | 7 | | |

Продолжение табл. I

Размеры в мм

| Обозначение протяжки | Примен- мость | Испол- нение | Диаметр отверстия | | D | D ₂ | D ₃ | D ₄ | L | l | l ₁ |
|----------------------|------------------|-----------------|----------------------|-----------------|----|----------------|----------------|----------------|------|------|----------------|
| | | | Номин. | Поле допуска | | | | | | | |
| 2400-0416 | | 2 | | H7 | | | | | 1075 | | |
| 2400-1183 | | 1 | | H8 | | | | | 950 | | |
| 2400-1184 | | 2 | 60,0 | | | | | | 1075 | | |
| 2400-0417 | | 1 | | H9 | 45 | 58,6 | 60,0 | | 36 | 950 | 11 440 |
| 2400-0418 | | 2 | | | | | | | | 1075 | |
| 2400-0419 | | 1 | | H7 | | 58,2 | 59,6 | | | 950 | |
| 2400-0420 | | 2 | 59,6 | | | | | | | 1075 | |
| 2400-0421 | | 1 | | H7 | | | | | | 690 | |
| 2400-0422 | | 2 | | | | | | | | 815 | |
| 2400-1185 | | 1 | | H8 | | 61,6 | 63,0 | | | 690 | |
| 2400-1186 | | 2 | | | | | | | | 815 | |
| 2400-0423 | | 1 | | H9 | | | | | | 690 | 7 350 |
| 2400-0424 | | 2 | | | | | | | | 815 | |
| 2400-0425 | | 1 | 62,6 | H7 | | 61,2 | 62,6 | | | 690 | |
| 2400-0426 | | 2 | | | | | | | | 815 | |
| 2400-0427 | | 1 | | H7 | 50 | | | | 50 | 950 | |
| 2400-0428 | | 2 | | | | | | | | 1075 | |
| 2400-1187 | | 1 | | H8 | | 61,6 | 63,0 | | | 950 | |
| 2400-1188 | | 2 | | | | | | | | 1075 | 11 440 |
| 2400-0429 | | 1 | | H9 | | | | | | 950 | |
| 2400-0430 | | 2 | | | | | | | | 1075 | |
| 2400-0431 | | 1 | 62,6 | H7 | | 61,2 | 62,6 | | | 950 | |
| 2400-0432 | | 2 | | | | | | | | 1075 | |
| 2400-0433 | | 1 | | H7 | | | | | | 690 | |
| 2400-0434 | | 2 | 65,0 | | | 63,6 | 65,0 | | | 815 | 7 350 |
| 2400-1189 | | 1 | | H8 | | | | | | 690 | |
| 2400-1191 | | 2 | | | | | | | | 815 | |

Продолжение табл. 1

Размеры в мм

| Обозначение протяжек | I_1 | I_3 | I_4 | I_5 | Зубья протяжек | | | | | Выкружка | |
|----------------------|-------|-------|-------|------------------------------|-----------------------|-----|-----------------|------------------------|-------|-----------------|---------|
| | | | | | Черновые и переходные | | | Чистовые и калибрующие | | | |
| | | | | | Число зубьев | t | Номер профилья* | Число зубьев | t_1 | Номер профилья* | |
| 2400-0416 | | | | | | | | | | | |
| 2400-1183 | | | | | | | | | | | |
| 2400-1184 | | | | | | | | | | | |
| 2400-0417 | 256 | 193 | 315 | 90 ⁹ ₇ | 16 | 16 | 11 | 16 | 11 | 7 | 7,5 5,5 |
| 2400-0418 | | | | | | | | | | | |
| 2400-0419 | | | | | | | | | | | |
| 2400-0420 | | | | | | | | | | | |
| 2400-0421 | | | | | | | | | | | |
| 2400-0422 | | | | | | | | | | | |
| 2400-1185 | | | | | | | | | | | |
| 2400-1186 | | | | | | | | | | | |
| 2400-0423 | 176 | 129 | 275 | 40 | 16 | 11 | 8 | 16 | 7 | 4 | 12 |
| 2400-0424 | | | | | | | | | | | |
| 2400-0425 | | | | | | | | | | | |
| 2400-0426 | | | | | | | | | | | |
| 2400-0427 | | | | | | | | | | | 8,0 6,0 |
| 2400-0428 | | | | | | | | | | | |
| 2400-1187 | | | | | | | | | | | |
| 2400-1188 | | | | | | | | | | | |
| 2400-0429 | 256 | 193 | 315 | 90 | 16 | 16 | 11 | 16 | 11 | 7 | |
| 2400-0430 | | | | | | | | | | | |
| 2400-0431 | | | | | | | | | | | |
| 2400-0432 | | | | | | | | | | | |
| 2400-0433 | | | | | | | | | | | |
| 2400-0434 | 176 | 129 | 275 | 40 | 16 | 11 | 8 | 16 | 7 | 4 | 8,5 6,5 |
| 2400-1189 | | | | | | | | | | | |
| 2400-1191 | | | | | | | | | | | |

Продолжение табл. 1

Размеры в мм

| Обозначение протяжки | Примене- мость | Испол- нение | Диаметр отверстия | | D | D ₂ | D ₃ | D ₅ | L | I | I ₁ |
|----------------------|-------------------|-----------------|----------------------|-----------------|----|----------------|----------------|----------------|------|----|----------------|
| | | | Номин. | Поле допуска | | | | | | | |
| 2400-0435 | | 1 | 65,0 | H9 | | 63,6 | 65,0 | | 690 | | |
| 2400-0436 | | 2 | | | | | | | 815 | 7 | 350 |
| 2400-0437 | | 1 | 64,6 | H7 | | 63,2 | 64,6 | | 690 | | |
| 2400-0438 | | 2 | | | | | | | 815 | | |
| 2400-0439 | | 1 | | H7 | | | | | 975 | | |
| 2400-0440 | | 2 | | | | | | | 1100 | | |
| 2400-1192 | | 1 | 65,0 | H8 | | 63,6 | 65,0 | | 975 | | |
| 2400-1193 | | 2 | | | | | | | 1100 | 11 | 450 |
| 2400-0441 | | 1 | | H9 | | | | | 975 | | |
| 2400-0442 | | 2 | | | | | | | 1100 | | |
| 2400-0443 | | 1 | 64,6 | H7 | | 63,2 | 64,6 | | 975 | | |
| 2400-0444 | | 2 | | | | | | | 1100 | | |
| 2400-0445 | | 1 | | H7 | 50 | | | 50 | 750 | | |
| 2400-0446 | | 2 | | | | | | | 875 | | |
| 2400-1194 | | 1 | 70,0 | H8 | | 68,6 | 70,0 | | 750 | | |
| 2400-1195 | | 2 | | | | | | | 875 | 8 | 350 |
| 2400-0447 | | 1 | | H9 | | | | | 750 | | |
| 2400-0448 | | 2 | | | | | | | 875 | | |
| 2400-0449 | | 1 | 69,6 | H7 | | 68,2 | 69,6 | | 750 | | |
| 2400-0450 | | 2 | | | | | | | 875 | | |
| 2400-0451 | | 1 | | H7 | | | | | 1060 | | |
| 2400-0452 | | 2 | | | | | | | 1185 | | |
| 2400-1196 | | 1 | 70,0 | H8 | | 68,6 | 70,0 | | 1060 | | |
| 2400-1197 | | 2 | | | | | | | 1185 | 12 | 465 |
| 2400-0453 | | 1 | | H9 | | | | | 1060 | | |
| 2400-0454 | | 2 | | | | | | | 1185 | | |
| 2400-0455 | | 1 | 69,6 | H7 | | 68,2 | 69,6 | | 1060 | | |

Продолжение табл. 1

| Обозначение протяжек | Размеры в мм | | | | | | | | | | Выкружки | |
|----------------------|--------------|-------|-------|-------|-----------------------|-----|------------------------|--------------|-------|----------------|---------------------------|--|
| | | | | | Зубья протяжек | | | | | | | |
| | | | | | Черновые и переходные | | Чистовые и калибрующие | | | | | |
| | t_2 | t_3 | t_4 | t_5 | Число зубьев | t | Номер профиля* | Число зубьев | t_1 | Номер профиля* | Число выкружек и α | |
| 2400-0435 | | | | | | | | | | | | |
| 2400-0436 | 176 | 129 | 275 | 40 | 16 | 11 | 8 | 16 | 7 | 4 | | |
| 2400-0437 | | | | | | | | | | | | |
| 2400-0438 | | | | | | | | | | | | |
| 2400-0439 | | | | | | | | | | | | |
| 2400-0440 | | | | | | | | | | | | |
| 2400-1192 | | | | | | | | | | | 8,5 | |
| 2400-1193 | 256 | 193 | 315 | 100 | 16 | 16 | 11 | 16 | 11 | 7 | 6,5 | |
| 2400-0441 | | | | | | | | | | | | |
| 2400-0442 | | | | | | | | | | | | |
| 2400-0443 | | | | | | | | | | | | |
| 2400-0444 | | | | | | | | | | | | |
| 2400-0445 | | | | | | | | | | | 12 | |
| 2400-0446 | | | | | | | | | | | | |
| 2400-1194 | | | | | | | | | | | | |
| 2400-1195 | 192 | 145 | 275 | 40 | 16 | 12 | 9 | 16 | 8 | 5 | | |
| 2400-0447 | | | | | | | | | | | | |
| 2400-0448 | | | | | | | | | | | | |
| 2400-0449 | | | | | | | | | | | | |
| 2400-0450 | | | | | | | | | | | 9,0 | |
| 2400-0451 | | | | | | | | | | | 7,0 | |
| 2400-0452 | | | | | | | | | | | | |
| 2400-1196 | | | | | | | | | | | | |
| 2400-1197 | 288 | 225 | 320 | 110 | 16 | 18 | 12 | 16 | 13 | 9 | | |
| 2400-0453 | | | | | | | | | | | | |
| 2400-0454 | | | | | | | | | | | | |
| 2400-0455 | | | | | | | | | | | | |

Продолжение табл. 1

Размеры в мм

| Обозначение протяжек | Приме- нение | Испол- нение | Диаметр отверстия | | D | D ₁ | D ₂ | D ₃ | L | t | L ₁ |
|-------------------------|-----------------|-----------------|----------------------|-------------------|----|----------------|----------------|----------------|------|----|----------------|
| | | | Номинал | Полоса допуска | | | | | | | |
| 2400-0456 | | 2 | 69,6 | H7 | | 68,2 | 69,6 | | 1185 | 12 | 465 |
| 2400-1198 | | 1 | | H7 | | | | | 750 | | |
| 2400-1199 | | 2 | | | | | | | 875 | | |
| 2400-1201 | | 1 | 71,0 | H8 | | 69,6 | 71,0 | | 750 | | |
| 2400-1202 | | 2 | | | | | | | 875 | | |
| 2400-1203 | | 1 | | H9 | | | | | 750 | | |
| 2400-1204 | | 2 | | | | | | | 875 | | |
| 2400-1205 | | 1 | 70,6 | H7 | | 69,2 | 70,6 | | 750 | | |
| 2400-1206 | | 2 | | | 50 | | | | 875 | | |
| 2400-1207 | | 1 | | H7 | | | | | 1060 | | |
| 2400-1208 | | 2 | | | | | | | 1185 | | |
| 2400-1209 | | 1 | 71,0 | H8 | | 69,6 | 71,0 | | 1060 | | |
| 2400-1211 | | 2 | | | | | | | 1185 | | |
| 2400-1212 | | 1 | | H9 | | | | | 1060 | | |
| 2400-1213 | | 2 | | | | | | | 1185 | | |
| 2400-1214 | | 1 | 70,6 | H7 | | 69,2 | 70,6 | | 1060 | | |
| 2400-1215 | | 2 | | | | | | | 1185 | | |
| 2400-0457 | | 1 | | H7 | | | | | 825 | | |
| 2400-0458 | | 2 | | | | | | | 950 | | |
| 2400-1216 | | 1 | 75,0 | H8 | | 73,5 | 75,0 | | 825 | | |
| 2400-1217 | | 2 | | | | | | | 950 | | |
| 2400-0459 | | 1 | | H9 | | | | | 825 | | |
| 2400-0460 | | 2 | | | 63 | | | | 950 | | |
| 2400-0461 | | 1 | 74,6 | H7 | | 73,1 | 74,6 | | 825 | | |
| 2400-0462 | | 2 | | | | | | | 950 | | |
| 2400-0463 | | 1 | 75,0 | H7 | | 73,5 | 75,0 | | 1070 | 12 | 495 |
| 2400-0464 | | 2 | | | | | | | 1195 | | |

Продолжение табл. I

Размеры в мм

| Обозначение протяжек | t_2 | t_3 | I_1 | I_1 | Зубья протяжек | | | | | Выкружки | | | |
|----------------------|-------|-------|-------|-------|-----------------------|-----|-----------------|------------------------|-------|--------------|-------|-----------------|-----|
| | | | | | Черновые и переходные | | | Чистовые и калибрующие | | Число зубьев | t_1 | Номер профилей* | |
| | | | | | Число зубьев | t | Номер профилей* | Число зубьев | t_1 | | | | |
| 2400-0456 | 288 | 225 | 320 | 110 | 16 | 18 | 12 | 16 | 13 | 9 | 7 | 9,0 | 7,0 |
| 2400-1198 | | | | | | | | | | | | | |
| 2400-1199 | | | | | | | | | | | | | |
| 2400-1201 | | | | | | | | | | | | | |
| 2400-1202 | 192 | 145 | 275 | 40 | 16 | 12 | 9 | 16 | 8 | 5 | | | |
| 2400-1203 | | | | | | | | | | | | | |
| 2400-1204 | | | | | | | | | | | | | |
| 2400-1205 | | | | | | | | | | | | | |
| 2400-1206 | | | | | | | | | | | | | |
| 2400-1207 | | | | | | | | | | | | | |
| 2400-1208 | | | | | | | | | | | | | |
| 2400-1209 | | | | | | | | | | | | | |
| 2400-1211 | 288 | 225 | 320 | 110 | 16 | 18 | 12 | 16 | 13 | 9 | | 12 | 9,5 |
| 2400-1212 | | | | | | | | | | | | | |
| 2400-1213 | | | | | | | | | | | | | |
| 2400-1214 | | | | | | | | | | | | | |
| 2400-1215 | | | | | | | | | | | | | |
| 2400-0457 | | | | | | | | | | | | | |
| 2400-0458 | | | | | | | | | | | | | |
| 2400-1216 | | | | | | | | | | | | | |
| 2400-1217 | 216 | 145 | 325 | 40 | 18 | 12 | 9 | 16 | 8 | 5 | | | |
| 2400-0459 | | | | | | | | | | | | | |
| 2400-0460 | | | | | | | | | | | | | |
| 2400-0461 | | | | | | | | | | | | | |
| 2400-0462 | | | | | | | | | | | | | |
| 2400-0463 | 288 | 225 | 350 | 110 | 16 | 18 | 12 | 16 | 13 | 9 | | | |
| 2400-0464 | | | | | | | | | | | | | |

Продолжение табл. 1

Размеры в мм

| Обозначение протяжек | Приме- нение | Испол- нение | Диаметр отверстия | | D | D ₂ | D ₃ | D ₄ | L | I | I ₁ |
|----------------------|-----------------|-----------------|-------------------|----------------|----|----------------|----------------|----------------|------|-----|----------------|
| | | | Номин. | Полоса допуска | | | | | | | |
| 2400-1218 | | 1 | | H8 | | | | | 1070 | | |
| 2400-1219 | | 2 | 75,0 | | | 73,5 | 75,0 | | 1195 | | |
| 2400-0465 | | 1 | | H9 | | | | | 1070 | 12 | 495 |
| 2400-0466 | | 2 | | | | | | | 1195 | | |
| 2400-0467 | | 1 | 74,6 | H7 | | 73,1 | 74,6 | | 1070 | | |
| 2400-0468 | | 2 | | | | | | | 1195 | | |
| 2400-0469 | | 1 | | H7 | | | | | 825 | | |
| 2400-0470 | | 2 | | | | | | | 950 | | |
| 2400-1221 | | 1 | 80,0 | H8 | | 78,5 | 80,0 | | 825 | | |
| 2400-1222 | | 2 | | | | | | | 950 | | 8 · 400 |
| 2400-0471 | | 1 | | H9 | | | | | 825 | | |
| 2400-0472 | | 2 | | | | | | | 950 | | |
| 2400-0473 | | 1 | 79,6 | H7 | 63 | 78,1 | 79,6 | 50 | 825 | | |
| 2400-0474 | | 2 | | | | | | | 950 | | |
| 2400-0475 | | 1 | | H7 | | | | | 1130 | | |
| 2400-0476 | | 2 | | | | | | | 1255 | | |
| 2400-1223 | | 1 | 80,00 | H8 | | 78,5 | 80,00 | | 1130 | 12 | 495 |
| 2400-1224 | | 2 | | | | | | | 1255 | | |
| 2400-0477 | | 1 | | H9 | | | | | 1130 | | |
| 2400-0478 | | 2 | | | | | | | 1255 | | |
| 2400-0479 | | 1 | 79,60 | H7 | | 78,1 | 79,60 | | 1130 | | |
| 2400-0480 | | 2 | | | | | | | 1255 | | |
| 2400-0481 | | 1 | | H7 | | | | | 875 | | |
| 2400-0482 | | 2 | 85,00 | | | 83,5 | 85,00 | | 1000 | 9,5 | 425 |
| 2400-1225 | | 1 | | H8 | | | | | 875 | | |
| 2400-1226 | | 2 | | | | | | | 1000 | | |
| 2400-0483 | | 1 | | H9 | | | | | 875 | | |

Продолжение табл. 1

| Обозначение протяжек | Размеры в мм | | | | | | | | Выкружки | | |
|----------------------|--------------|-------|-------|-------|-----------------------|-----|------------------------|--------------|----------|----------------|--------------------|
| | t_1 | t_2 | t_3 | t_4 | Зубья протяжек | | | | n | a | a_1 |
| | | | | | Черновые и переходные | | Чистовые и калибрующие | | | | |
| | | | | | Число зубьев | t | Номер профилей | Число зубьев | t_1 | Номер профилей | Число выкружек n |
| 2400-1218 | | | | | | | | | | | |
| 2400-1219 | | | | | | | | | | | |
| 2400-0465 | 288 | 225 | 350 | 110 | 16 | 18 | 12 | 16 | 13 | 9 | 12 |
| 2400-0466 | | | | | | | | | | | |
| 2400-0467 | | | | | | | | | | | |
| 2400-0468 | | | | | | | | | | | |
| 2400-0469 | | | | | | | | | | | |
| 2400-0470 | | | | | | | | | | | |
| 2400-1221 | | | | | | | | | | | |
| 2400-1222 | 216 | 145 | 325 | 40 | 18 | 12 | 9 | 16 | 8 | 5 | |
| 2400-0471 | | | | | | | | | | | |
| 2400-0472 | | | | | | | | | | | |
| 2400-0473 | | | | | | | | | | | |
| 2400-0474 | | | | | | | | | | | |
| 2400-0475 | | | | | | | | | | | |
| 2400-0476 | | | | | | | | | | | |
| 2400-1223 | | | | | | | | | | | |
| 2400-1224 | 324 | 225 | 350 | 110 | 18 | 18 | 12 | 16 | 13 | 9 | |
| 2400-0477 | | | | | | | | | | | |
| 2400-0478 | | | | | | | | | | | |
| 2400-0479 | | | | | | | | | | | |
| 2400-0480 | | | | | | | | | | | |
| 2400-0481 | | | | | | | | | | | |
| 2400-0482 | 224 | 177 | 330 | 60 | 16 | 14 | 10 | 16 | 10 | 7 | |
| 2400-1225 | | | | | | | | | | | |
| 2400-1226 | | | | | | | | | | | |
| 2400-0483 | | | | | | | | | | | |

Продолжение табл. 1

Размеры в мм

| Обозначение протяжек | Примес- нкость | Испол- нение | Диаметр отверстия | | D | D ₂ | -D ₃ | D ₄ | L | I | I ₁ |
|----------------------|-------------------|-----------------|----------------------|-----------------|----|----------------|-----------------|----------------|------|-----|----------------|
| | | | Номин. | Поле допуска | | | | | | | |
| 2400-0484 | | 2 | 85,00 | H9 | | 83,5 | 85,00 | | 1000 | | |
| 2400-0485 | | 1 | 84,54 | H7 | | 83,0 | 84,54 | | 875 | 9,5 | 425 |
| 2400-0486 | | 2 | | | | | | | 1000 | | |
| 2400-0487 | | 1 | | H7 | | | | | 1135 | | |
| 2400-0488 | | 2 | | | | | | | 1260 | | |
| 2400-1227 | | 1 | 85,00 | H8 | | 83,5 | 85,00 | | 1135 | | |
| 2400-1228 | | 2 | | | | | | | 1260 | | |
| 2400-0498 | | 1 | | H9 | | | | | 1135 | | |
| 2400-0490 | | 2 | | | | | | | 1260 | | |
| 2400-0491 | | 1 | 84,54 | H7 | | 83,0 | 84,54 | 50 | 1135 | | |
| 2400-0492 | | 2 | | | | | | | 1260 | | |
| 2400-0493 | | 1 | | H7 | 63 | | | | 975 | | |
| 2400-0494 | | 2 | | | | | | | 1100 | | |
| 2400-1229 | | 1 | 90,00 | H8 | | 88,5 | 90,00 | | 975 | | |
| 2400-1231 | | 2 | | | | | | | 1100 | | |
| 2400-0495 | | 1 | | H9 | | | | | 975 | | |
| 2400-0496 | | 2 | | | | | | | 1100 | | |
| 2400-0497 | | 1 | 89,54 | H7 | | 88,0 | 89,54 | | 975 | | |
| 2400-0498 | | 2 | | | | | | | 1100 | | |
| 2400-0499 | | 1 | | H7 | | | | | 1240 | | |
| 2400-0500 | | 2 | | | | | | | 1380 | | |
| 2400-1232 | | 1 | 90,00 | H8 | | 88,5 | 90,00 | | 1240 | | |
| 2400-1233 | | 2 | | | | | | | 1380 | 14 | 530 |
| 2400-0501 | | 1 | | H9 | | | | | 1240 | | |
| 2400-0502 | | 2 | | | | | | | 1380 | | |
| 2400-0503 | | 1 | 89,54 | H7 | | 88,0 | 89,54 | | 1240 | | |
| 2400-0504 | | 2 | | | | | | | 1380 | | |

Размеры в мм

Продолжение табл. 1

| Обозначение протяжек | l_1 | l_2 | l_3 | l_4 | l_5 | Зубья протяжек | | | | Выкружки | | |
|----------------------|-------|-------|-------|-------|-------|-----------------------|-----|----------------|------------------------|----------|---------------|----------------|
| | | | | | | Черновые и переходные | | | Чистовые и калибрующие | | | Число выкружек |
| | | | | | | Число зубьев | t | Номер профиля* | Число зубьев | t | Номер профиля | |
| 2400-0484 | 224 | 177 | 330 | 60 | | 16 | 14 | 10 | 16 | 10 | 7 | |
| 2400-0485 | | | | | | | | | | | | |
| 2400-0486 | | | | | | | | | | | | |
| 2400-0487 | | | | | | | | | | | | |
| 2400-0488 | | | | | | | | | | | | 9,5 |
| 2400-1227 | | | | | | | | | | | | 7,5 |
| 2400-1228 | 324 | 225 | 355 | 120 | | 18 | 18 | 12 | 16 | 13 | 9 | |
| 2400-0489 | | | | | | | | | | | | |
| 2400-0490 | | | | | | | | | | | | |
| 2400-0491 | | | | | | | | | | | | |
| 2400-0492 | | | | | | | | | | | | |
| 2400-0493 | | | | | | | | | | | | |
| 2400-0494 | | | | | | | | | | | | |
| 2400-1229 | | | | | | | | | | | | |
| 2400-1231 | 256 | 193 | 330 | 90 | | 16 | 16 | 11 | 16 | 11 | 7 | 14 |
| 2400-0495 | | | | | | | | | | | | |
| 2400-0495 | | | | | | | | | | | | |
| 2400-0497 | | | | | | | | | | | | |
| 2400-0498 | | | | | | | | | | | | |
| 2400-0499 | | | | | | | | | | | | |
| 2400-0500 | | | | | | | | | | | | |
| 2400-1232 | | | | | | | | | | | | |
| 2400-1233 | 360 | 241 | 365 | 120 | | 18 | 20 | 13 | 16 | 14 | 10 | 10 |
| 2400-0501 | | | | | | | | | | | | |
| 2400-0502 | | | | | | | | | | | | |
| 2400-0503 | | | | | | | | | | | | |
| 2400-0504 | | | | | | | | | | | | |

* Номер профиля зубьев протяжек указан в рекомендуемом приложении 2.

Пример условного обозначения протяжки длиной $L=900$ мм для обработки отверстия диаметром 45Н7, группы заточки II (приложение 1) исполнения 1:

Протяжка 2400-0343 II ГОСТ 20365-74

Таблица 2

| | | Размеры в мм | | | | | | | | | |
|----------------------|--------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|--|
| Обозначение профилей | | 2400-0061: 2400-0062 | 2400-1001: 2400-1002 | 2400-0063: 2400-0064 | 2400-0065: 2400-0066 | 2400-0067: 2400-0068 | 2400-1003: 2400-1004 | 2400-0069: 2400-1070 | 2400-0071: 2400-1072 | 2400-0073: 2400-1074 | 2400- 1065: 2400- 1066: 0075 |
| Диаметр отверстия | 14H7 | 14H8 | 14H9 | 13,76H7 | 14H7 | 14H8 | 14H9 | 13,76H7 | 15H7 | 15H8 | 15H9 |
| 1 | 13,490 | 13,490 | 13,490 | 13,190 | 13,470 | 13,470 | 13,470 | 13,170 | 14,490 | 14,490 | 14,490 |
| 2 | 13,470 | 13,470 | 13,470 | 13,170 | 13,450 | 13,450 | 13,450 | 13,150 | 14,470 | 14,470 | 14,470 |
| 3 | 13,580 | 13,580 | 13,580 | 13,280 | 13,540 | 13,540 | 13,540 | 13,240 | 14,580 | 14,580 | 14,580 |
| 4 | 13,560 | 13,560 | 13,560 | 13,260 | 13,520 | 13,520 | 13,520 | 13,220 | 14,560 | 14,560 | 14,560 |
| 5 | 13,670 | 13,670 | 13,670 | 13,370 | 13,610 | 13,610 | 13,610 | 13,310 | 14,670 | 14,670 | 14,670 |
| 6 | 13,660 | 13,660 | 13,660 | 13,350 | 13,590 | 13,590 | 13,590 | 13,290 | 14,660 | 14,660 | 14,660 |
| 7 | 13,760 | 13,760 | 13,760 | 13,460 | 13,680 | 13,680 | 13,680 | 13,380 | 14,760 | 14,760 | 14,760 |
| 8 | 13,740 | 13,740 | 13,740 | 13,440 | 13,660 | 13,660 | 13,660 | 13,360 | 14,740 | 14,740 | 14,740 |
| 9 | 13,860 | 13,860 | 13,860 | 13,560 | 13,750 | 13,750 | 13,750 | 13,450 | 14,850 | 14,850 | 14,850 |
| 10 | 13,840 | 13,840 | 13,840 | 13,530 | 13,730 | 13,730 | 13,730 | 13,430 | 14,840 | 14,840 | 14,830 |
| 11 | 13,890 | 13,890 | 13,890 | 13,640 | 13,820 | 13,820 | 13,820 | 13,520 | 14,900 | 14,900 | 14,900 |
| 12 | | | | 13,630 | 13,820 | 13,820 | 13,820 | 13,500 | 14,890 | 14,890 | 14,890 |
| 13 | 13,930 | 13,930 | 13,940 | 13,680 | 13,880 | 13,890 | 13,890 | 13,590 | 14,930 | 14,930 | 14,930 |
| 14 | | | | | 13,870 | 13,880 | 13,880 | 13,570 | | | |
| 15 | 13,960 | 13,960 | 13,970 | 13,720 | 13,920 | 13,930 | 13,930 | 13,640 | 14,960 | 14,960 | 14,970 |
| 16 | | | | | | | | 13,630 | | | |
| 17 | 13,960 | 13,960 | 14,000 | 13,740 | 13,960 | 13,960 | 13,970 | 13,680 | 14,980 | 14,980 | 15,000 |
| 18 | | | | | | | | | | | |
| 19 | 14,000 | 14,000 | 14,020 | 13,760 | 13,980 | 13,980 | 14,000 | 13,720 | 15,000 | 15,000 | 15,020 |
| 20 | | | | | | | | | | | |

Диаметр отверстия D, мм

Приложение табл. 2

| Диаметр отверстия | Размеры в мм | | | | | | | | | | Каналы по длине D, мм по |
|-------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|--------------------------|
| | Обозначение протяжки | 2400-0061: 2400-0052 | 2400-1001: 2400-1002 | 2400-0053: 2400-0054 | 2400-0055: 2400-0056 | 2400-0057: 2400-0058 | 2400-1003: 2400-1004 | 2400-0059: 2400-0070 | 2400-0071: 2400-0072 | 2400-0073: 2400-0074 | 2400-0075: 2400-0076 |
| 14Р7 | 14H8 | 14H9 | 13,70H7 | 13H7 | 14H8 | 14H9 | 13,76H7 | 13H7 | 15H8 | 15H9 | |
| 21 | 14,010 | 14,017 | 14,033 | 13,770 | 14,000 | 14,020 | 13,740 | 15,010 | 15,017 | 15,033 | |
| 22 | | | | | | | | | | | |
| 23 | 14,018 | 14,027 | 14,043 | 13,778 | 14,010 | 14,017 | 14,033 | 13,760 | 15,018 | 15,027 | 15,043 |
| 24 | | | | | | | | | | | |
| 25 | | | | | | | | | | | |
| 26 | | | | | | | | | | | |
| 27 | 14,018 | 14,027 | 14,043 | 13,778 | | | | 13,778 | 15,018 | 15,027 | 15,043 |
| 28 | | | | | | | | | | | |
| 29 | | | | | | | | | | | |
| 30 | | | | | | | | | | | |
| 31 | | | | | | | | | | | |
| 32 | | | | | | | | | | | |
| 33 | | | | | | | | | | | |
| 34 | | | | | | | | | | | |
| 35 | | | | | | | | | | | |
| 36 | | | | | | | | | | | |
| 37 | | | | | | | | | | | |
| 38 | | | | | | | | | | | |
| 39 | | | | | | | | | | | |
| 40 | | | | | | | | | | | |

Продолжение табл. 2

| Размеры в мм | | | | | | | | | | |
|-------------------------|-------------------------|-----------|-------------------------|-----------|-------------------------|-----------|-------------------------|-----------|-------------------------|-----------|
| Обозначение противес | 2400-0077; 2500-0078 | | 2400-0139; 2400-0390 | | 2400-1007; 2400-1068 | | 2400-0035; 2400-0056 | | 2400-1009; 2400-1011 | |
| | 2400-0078 | 2400-0390 | 2400-0139 | 2400-0390 | 2400-1007 | 2400-1068 | 2400-0035 | 2400-0056 | 2400-1009 | 2400-1011 |
| Диаметр отверстия | 14,76Н7 | 15Н7 | 15Н8 | 15Н9 | 14,75Н7 | 16Н7 | 16Н8 | 16Н9 | 15,76Н7 | 16Н7 |
| 1 | 14,190 | 14,460 | 14,460 | 14,460 | 14,160 | 15,470 | 15,470 | 15,470 | 15,170 | 15,470 |
| 2 | 14,170 | 14,440 | 14,440 | 14,440 | 14,140 | 15,450 | 15,450 | 15,450 | 15,150 | 15,450 |
| 3 | 14,280 | 14,520 | 14,520 | 14,520 | 14,220 | 15,540 | 15,540 | 15,540 | 15,240 | 15,540 |
| 4 | 14,260 | 14,500 | 14,500 | 14,500 | 14,200 | 15,520 | 15,520 | 15,520 | 15,220 | 15,520 |
| 5 | 14,370 | 14,580 | 14,580 | 14,580 | 14,280 | 15,610 | 15,610 | 15,610 | 15,310 | 15,610 |
| 6 | 14,350 | 14,560 | 14,560 | 14,560 | 14,260 | 15,590 | 15,590 | 15,590 | 15,290 | 15,590 |
| 7 | 14,460 | 14,640 | 14,640 | 14,640 | 14,340 | 15,680 | 15,680 | 15,680 | 15,380 | 15,680 |
| 8 | 14,440 | 14,620 | 14,620 | 14,620 | 14,320 | 15,660 | 15,660 | 15,660 | 15,360 | 15,660 |
| 9 | 14,550 | 14,700 | 14,700 | 14,700 | 14,400 | 15,750 | 15,750 | 15,750 | 15,450 | 15,750 |
| 10 | 14,530 | 14,680 | 14,680 | 14,680 | 14,380 | 15,730 | 15,730 | 15,730 | 15,430 | 15,730 |
| 11 | 14,640 | 14,760 | 14,760 | 14,760 | 14,460 | 15,820 | 15,820 | 15,820 | 15,520 | 15,820 |
| 12 | 14,630 | 14,740 | 14,740 | 14,740 | 14,440 | 15,800 | 15,800 | 15,800 | 15,500 | 15,800 |
| 13 | 14,620 | 14,820 | 14,820 | 14,820 | 14,520 | 15,880 | 15,880 | 15,880 | 15,590 | 15,880 |
| 14 | 14,680 | 14,800 | 14,800 | 14,800 | 14,500 | 15,870 | 15,880 | 15,880 | 15,570 | 15,880 |
| 15 | 14,680 | 14,880 | 14,880 | 14,880 | 14,580 | 15,920 | 15,930 | 15,930 | 15,640 | 15,930 |
| 16 | 14,720 | 14,870 | 14,870 | 14,870 | 14,560 | 15,960 | 15,960 | 15,960 | 15,630 | 15,960 |
| 17 | 14,740 | 14,920 | 14,920 | 14,920 | 14,640 | 14,630 | 15,970 | 15,970 | 15,680 | 15,960 |
| 18 | 14,760 | 14,960 | 14,960 | 14,960 | 14,680 | 15,980 | 15,980 | 16,000 | 15,720 | 15,980 |

Продолжение табл. 2

| Размеры в мм | | | | | | | | | |
|----------------------|------------|------------|------------|------------|------------|------------|------------|------------|------------|
| Обозначение проекции | 2400-0077; | 2400-0079; | 2400-1007; | 2400-1063; | 2400-0081; | 2400-0083; | 2400-1009; | 2400-0087; | 2400-0089; |
| Диаметр отверстий | 14,7677 | 15,777 | 15,78 | 15,79 | 14,7677 | 16,77 | 16,78 | 16,79 | 15,777 |
| 21 | 14,770 | 14,980 | 14,980 | 15,000 | 14,720 | 16,000 | 16,000 | 16,020 | 15,740 |
| 22 | | | | | | | | | |
| 23 | 14,778 | 15,000 | 15,000 | 15,020 | 14,740 | 16,010 | 16,017 | 16,033 | 15,760 |
| 24 | | | | | | | | | |
| 25 | 15,010 | 15,017 | 15,033 | 14,760 | 15,018 | 16,027 | 16,043 | 15,770 | 15,018 |
| 26 | | | | | | | | | |
| 27 | 14,778 | 15,018 | 15,027 | 15,043 | 14,770 | | | | |
| 28 | | | | | | | | | |
| 29 | | | | | 14,778 | 16,018 | 16,027 | 16,043 | 15,778 |
| 30 | | | | | | | | | |
| 31 | | 15,018 | 15,027 | 15,043 | | | | | |
| 32 | | | | | | | | | |
| 33 | | | | | | 14,778 | | | |
| 34 | | | | | | | | | |
| 35 | | | | | | | | | |
| 36 | | | | | | | | | |
| 37 | | | | | | | | | |
| 38 | | | | | | | | | |
| 39 | | | | | | | | | |
| 40 | | | | | | | | | |

Диаметр отверстия D; номера

Продолжение табл. 2

Размеры в мм

| Обозначение протяжек | 2400-0095; 2400-0094 | 2400-0095; 2400-0096 | 2400-0097; 2400-0096 | 2400-0098; 2400-0096 | 2400-1014; 2400-1015 | 2400-0100; 2400-0102 | 2400-0101; 2400-0104 | 2400-0103; 2400-0104 | 2400-1016; 2400-1017 | 2400-0106; 2400-0106 | 2400-0107; 2400-0108 | 2400-0108; 2400-0108 |
|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|
| Диаметр отверстия | 16H9 | 15,76H7 | 17H7 | 17H8 | 17H9 | 16,76H7 | 17H7 | 17H8 | 17H9 | 17H9 | 16,76H7 | 18H7 |
| 1 | 15,470 | 15,170 | 16,470 | 16,470 | 16,470 | 16,170 | 16,470 | 16,470 | 16,470 | 16,470 | 16,170 | 17,480 |
| 2 | 15,450 | 15,150 | 16,450 | 16,450 | 16,450 | 16,150 | 16,450 | 16,450 | 16,450 | 16,450 | 16,150 | 17,460 |
| 3 | 15,540 | 15,240 | 16,540 | 16,540 | 16,540 | 16,240 | 16,540 | 16,540 | 16,540 | 16,540 | 16,240 | 17,560 |
| 4 | 15,520 | 15,220 | 16,520 | 16,520 | 16,520 | 16,220 | 16,520 | 16,520 | 16,520 | 16,520 | 16,220 | 17,540 |
| 5 | 15,610 | 15,310 | 16,610 | 16,610 | 16,610 | 16,310 | 16,610 | 16,610 | 16,610 | 16,610 | 16,310 | 17,640 |
| 6 | 15,590 | 15,290 | 16,590 | 16,590 | 16,590 | 16,290 | 16,590 | 16,590 | 16,590 | 16,590 | 16,290 | 17,620 |
| 7 | 15,680 | 15,380 | 16,680 | 16,680 | 16,680 | 16,380 | 16,680 | 16,680 | 16,680 | 16,680 | 16,380 | 17,720 |
| 8 | 15,660 | 15,360 | 16,660 | 16,660 | 16,660 | 16,360 | 16,660 | 16,660 | 16,660 | 16,660 | 16,360 | 17,700 |
| 9 | 15,750 | 15,450 | 16,750 | 16,750 | 16,750 | 16,450 | 16,750 | 16,750 | 16,750 | 16,750 | 16,450 | 17,800 |
| 10 | 15,730 | 15,430 | 16,730 | 16,730 | 16,730 | 16,430 | 16,730 | 16,730 | 16,730 | 16,730 | 16,430 | 17,780 |
| 11 | 15,820 | 15,520 | 16,820 | 16,820 | 16,820 | 16,520 | 16,820 | 16,820 | 16,820 | 16,820 | 16,520 | 17,880 |
| 12 | 15,800 | 15,500 | 16,800 | 16,800 | 16,800 | 16,500 | 16,800 | 16,800 | 16,800 | 16,800 | 16,500 | 17,870 |
| 13 | 15,890 | 15,590 | 16,890 | 16,890 | 16,890 | 16,590 | 16,890 | 16,890 | 16,890 | 16,890 | 16,590 | 17,920 |
| 14 | 15,880 | 15,570 | 16,880 | 16,880 | 16,880 | 16,570 | 16,880 | 16,880 | 16,880 | 16,880 | 16,570 | |
| 15 | 15,930 | 15,640 | 16,930 | 16,930 | 16,930 | 16,640 | 16,930 | 16,930 | 16,930 | 16,930 | 16,640 | |
| 16 | 15,920 | 15,630 | 16,920 | 16,920 | 16,920 | 16,630 | 16,920 | 16,920 | 16,920 | 16,920 | 16,630 | |
| 17 | 15,970 | 15,680 | 16,960 | 16,960 | 16,970 | 16,680 | 16,960 | 16,960 | 16,960 | 16,970 | 16,680 | |
| 18 | | | | | | | | | | | | |
| 19 | 16,000 | 15,720 | 15,980 | 16,980 | 17,000 | 16,720 | 16,980 | 16,980 | 16,980 | 17,000 | 16,720 | 18,000 |

Диаметр зигзага D, мм

Продолжение табл. 2

| | | Размеры в мм | | | | | | | | | | | |
|---------------------|--------|-------------------------|-------------------------|-------------------------|-------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|
| | | 2400-0093, 2400-0394 | 2400-0095, 2400-0396 | 2400-0097, 2400-0397 | 2400-0098, 2400-0398 | 2400-0101, 2400-03100 | 2400-0102, 2400-03100 | 2400-0103, 2400-03104 | 2400-0104, 2400-03107 | 2400-0105, 2400-03105 | 2400-0106, 2400-03106 | 2400-0107, 2400-03107 | 2400-0108, 2400-03108 |
| Диаметр стаканов | | 16,79 | 15,76 | 17,77 | 17,98 | 17,99 | 16,76 | 17,77 | 17,98 | 17,99 | 16,76 | 17,77 | 18,01 |
| 21 | 16,020 | 15,740 | 17,000 | 17,000 | 17,020 | 16,740 | 17,000 | 17,000 | 17,020 | 17,020 | 16,740 | 17,020 | 18,010 |
| 22 | | | | | | | | | | | | | |
| 23 | 16,033 | 15,760 | 17,010 | 17,017 | 17,033 | 16,760 | 17,010 | 17,017 | 17,033 | 16,760 | 18,018 | | |
| 24 | | | | | | | | | | | | | |
| 25 | 16,043 | 15,770 | 17,018 | 17,027 | 17,043 | 16,770 | 17,018 | 17,027 | 17,043 | 16,770 | | | |
| 26 | | | | | | | | | | | | | |
| 27 | | 15,778 | | | | 16,778 | | | | 16,778 | | | |
| 28 | | | | | | | | | | | | | |
| 29 | 16,043 | | 17,018 | 17,027 | 17,043 | | 17,018 | 17,027 | 17,043 | | | | |
| 30 | | | | | | | | | | | | | |
| 31 | | | | | | | 15,778 | | | | | | |
| 32 | | | | | | | | | | | | | |
| 33 | | | | | | | | | | | | | |
| 34 | | | | | | | | | | | | | |
| 35 | | | | | | | | | | | | | |
| 36 | | | | | | | | | | | | | |
| 37 | | | | | | | | | | | | | |
| 38 | | | | | | | | | | | | | |
| 39 | | | | | | | | | | | | | |
| 40 | | | | | | | | | | | | | |

Параметры зеркал D_1 , номинальные

Продолжение табл. 2

| Размеры в мм | | | | | | | | | |
|----------------------|--------|----------------------|--------|----------------------|--------|----------------------|--------|----------------------|--------|
| Обозначение протяжек | | 2400-1018; 2400-1019 | | 2400-0111; 2400-0112 | | 2400-0113; 2400-0114 | | 2400-0115; 2400-0116 | |
| Диаметр отверстия | | 18F8 | 18F9 | 17,76H7 | 18H7 | 18f8 | 18f9 | 17,76H7 | 19H7 |
| 1 | 17,480 | 17,480 | 17,180 | 17,470 | 17,470 | 17,470 | 17,470 | 17,170 | 18,220 |
| 2 | 17,460 | 17,460 | 17,160 | 17,450 | 17,450 | 17,450 | 17,450 | 17,150 | 18,200 |
| 3 | 17,560 | 17,560 | 17,260 | 17,540 | 17,540 | 17,540 | 17,540 | 17,240 | 18,340 |
| 4 | 17,540 | 17,540 | 17,240 | 17,520 | 17,520 | 17,520 | 17,520 | 17,220 | 18,320 |
| 5 | 17,640 | 17,640 | 17,340 | 17,610 | 17,610 | 17,610 | 17,610 | 17,310 | 18,460 |
| 6 | 17,620 | 17,620 | 17,320 | 17,590 | 17,590 | 17,590 | 17,590 | 17,290 | 18,440 |
| 7 | 17,720 | 17,720 | 17,420 | 17,680 | 17,680 | 17,680 | 17,680 | 17,380 | 18,580 |
| 8 | 17,700 | 17,700 | 17,400 | 17,660 | 17,660 | 17,660 | 17,660 | 17,360 | 18,560 |
| 9 | 17,800 | 17,800 | 17,500 | 17,750 | 17,750 | 17,750 | 17,750 | 17,450 | 18,700 |
| 10 | 17,780 | 17,780 | 17,480 | 17,730 | 17,730 | 17,730 | 17,730 | 17,430 | 18,680 |
| 11 | 17,880 | 17,880 | 17,580 | 17,820 | 17,820 | 17,820 | 17,820 | 17,520 | 18,820 |
| 12 | 17,870 | 17,870 | 17,560 | 17,800 | 17,800 | 17,800 | 17,800 | 17,500 | 18,800 |
| 13 | 17,920 | 17,920 | 17,930 | 17,890 | 17,890 | 17,890 | 17,890 | 17,590 | 18,890 |
| 14 | | | | 17,630 | 17,880 | 17,880 | 17,880 | 17,570 | 18,880 |
| 15 | 17,960 | 17,970 | 17,680 | 17,930 | 17,930 | 17,930 | 17,930 | 17,650 | 18,930 |
| 16 | 17,980 | 18,000 | 17,720 | 17,960 | 17,960 | 17,960 | 17,960 | 17,640 | 18,970 |
| 17 | | | | | | | | | 18,980 |
| 18 | 18,000 | 18,020 | 17,740 | 17,980 | 17,980 | 17,980 | 17,980 | 17,720 | 19,010 |
| 19 | | | | | | | | | 18,700 |
| 20 | | | | | | | | | |

Измерения в миллиметрах

Продолжение табл. 2

| | | Размеры в мм | | | | | | | | |
|----------------------|-------------------|--------------|------------|------------|------------|------------|------------|------------|------------|--------|
| Обозначение проекции | Диаметр отверстия | 2400-0108; | 2400-0111; | 2400-0113; | 2400-0115; | 2400-0117; | 2400-0119; | 2400-0121; | 2400-0123; | 2400- |
| | | 2400-1019 | 2400-0112 | 2400-0114 | 2400-0116 | 2400-0118 | 2400-0120 | 2400-0122 | 2400-0124 | 0131; |
| 18/8 | 15,49 | 17,76/17 | 18,47 | 18,68 | 18,99 | 19,19 | 17,76/17 | 19,47 | 19,68 | 19,49 |
| 21 | 18,017 | 18,033 | 17,760 | 18,000 | 18,020 | 17,740 | 19,000 | 19,010 | 19,030 | 18,720 |
| 22 | | | | | | | | | | |
| 23 | 18,027 | 18,043 | 17,770 | 18,010 | 18,017 | 18,033 | 17,760 | 19,011 | 19,023 | 19,042 |
| 24 | | | | | | | | | | 18,731 |
| 25 | | | | | | | | | | |
| 26 | 18,027 | 18,043 | 17,778 | 18,018 | 18,027 | 18,043 | 17,770 | 19,021 | 19,033 | 19,052 |
| 27 | | | | | | | | | | 18,741 |
| 28 | | | | | | | | | | |
| 29 | | | | | | | | | | |
| 30 | | | | | | | | | | |
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| 38 | | | | | | | | | | |
| 39 | | | | | | | | | | |
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Линейные размеры D₁ и D₂ в миллиметрах

Продолжение табл. 2

| Обозначение протяжек | 2400-0135; 2400-0134 | Размеры в мм | | | | | | 2400- 0145; 2400-0144 | 2400- 0145; 2400-0146 | 2400- 0145; 2400-0146 | |
|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-----------------------------|-----------------------------|-----------------------------|--------|
| | | 2400-0135; 2400-0136 | 2400-0135; 2400-0136 | 2400-0135; 2400-0136 | 2400-0135; 2400-0136 | 2400-0140; 2400-0140 | 2400-0140; 2400-0140 | | | | |
| Диаметр стержней | 19,47 | 19,58 | 19,69 | 18,72/77 | 19,57 | 19,68 | 19,69 | 18,72/77 | 20,67 | 20,68 | 20,69 |
| 1 | 18,190 | 18,190 | 18,190 | 17,890 | 18,170 | 18,170 | 18,170 | 17,870 | 19,220 | 19,220 | 19,220 |
| 2 | 18,170 | 18,170 | 18,170 | 17,870 | 18,150 | 18,150 | 18,150 | 17,850 | 19,190 | 19,190 | 19,190 |
| 3 | 18,280 | 18,280 | 18,280 | 17,980 | 18,240 | 18,240 | 18,240 | 17,940 | 19,340 | 19,340 | 19,340 |
| 4 | 18,260 | 18,260 | 18,260 | 17,960 | 18,220 | 18,220 | 18,220 | 17,920 | 19,310 | 19,310 | 19,310 |
| 5 | 18,370 | 18,370 | 18,370 | 18,070 | 18,310 | 18,310 | 18,310 | 18,010 | 19,490 | 19,490 | 19,490 |
| 6 | 18,350 | 18,350 | 18,350 | 18,050 | 18,290 | 18,290 | 18,290 | 17,990 | 19,430 | 19,430 | 19,430 |
| 7 | 18,460 | 18,460 | 18,460 | 18,160 | 18,380 | 18,380 | 18,380 | 18,080 | 19,580 | 19,580 | 19,580 |
| 8 | 18,440 | 18,440 | 18,440 | 18,140 | 18,360 | 18,360 | 18,360 | 18,060 | 19,550 | 19,550 | 19,550 |
| 9 | 18,550 | 18,550 | 18,550 | 18,250 | 18,450 | 18,450 | 18,450 | 18,150 | 19,700 | 19,700 | 19,700 |
| 10 | 18,530 | 18,530 | 18,530 | 18,230 | 18,430 | 18,430 | 18,430 | 18,130 | 19,670 | 19,670 | 19,670 |
| 11 | 18,640 | 18,640 | 18,640 | 18,340 | 18,520 | 18,520 | 18,520 | 18,220 | 19,820 | 19,820 | 19,820 |
| 12 | 18,620 | 18,620 | 18,620 | 18,320 | 18,500 | 18,500 | 18,500 | 18,200 | 19,790 | 19,790 | 19,790 |
| 13 | 18,730 | 18,730 | 18,730 | 18,430 | 18,590 | 18,590 | 18,590 | 18,290 | 19,890 | 19,890 | 19,890 |
| 14 | 18,710 | 18,710 | 18,710 | 18,410 | 18,570 | 18,570 | 18,570 | 18,270 | 19,870 | 19,870 | 19,881 |
| 15 | 18,820 | 18,820 | 18,820 | 18,520 | 18,660 | 18,660 | 18,660 | 18,360 | 19,930 | 19,930 | 19,940 |
| 16 | 18,800 | 18,800 | 18,800 | 18,500 | 18,640 | 18,640 | 18,640 | 18,340 | | | |
| 17 | 18,880 | 18,880 | 18,880 | 18,600 | 18,730 | 18,730 | 18,730 | 18,430 | | | |
| 18 | 18,870 | 18,880 | 18,880 | 18,590 | 18,710 | 18,710 | 18,710 | 18,410 | 19,960 | 19,970 | 19,980 |
| 19 | 18,920 | 18,930 | 18,940 | 18,630 | 18,800 | 18,800 | 18,800 | 18,500 | | | |
| 20 | | | | 18,780 | 18,780 | 18,780 | 18,780 | 18,480 | 19,980 | 19,990 | 20,010 |

Диаметр стержней D_1 , мм

Легированная сталь 45, никелевая

Продолжение табл. 2

| Диаметр отверстия | Размеры в мм | | | | | | | | | |
|----------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|
| | 19H7 | 19H8 | 19H9 | 18,72H7 | 19H7 | 19H8 | 19H9 | 18,72H7 | 20H7 | 20H8 |
| Образование прорезей | 2400-0135; 2400-0134 | 2400-0125; 2400-0126 | 2000-0135; 2400-0136 | 2400-0137; 2400-0135 | 2500-0129; 2400-0140 | 2400-1027; 2400-1028 | 2400-0141; 2400-0142 | 2400-0145; 2400-0144 | 2400-0145; 2400-0146 | 2400-0145; 2400-0146 |
| | | | | | | | | | | |
| 21 | 18,960 | 18,970 | 18,980 | 18,680 | 18,870 | 18,870 | 18,870 | 18,570 | 20,000 | 20,010 |
| 22 | | | | | 18,850 | 18,850 | 18,850 | 18,560 | | 20,030 |
| 23 | 18,980 | 18,990 | 19,010 | 18,700 | 18,910 | 18,920 | 18,920 | 18,620 | 20,011 | 20,023 |
| 24 | | | | | | | | | | 20,042 |
| 25 | 19,010 | 19,030 | 18,720 | 18,950 | 18,960 | 18,960 | 18,960 | 18,650 | 20,021 | 20,033 |
| 26 | | | | | | | | | | 20,052 |
| 27 | 19,011 | 19,023 | 19,042 | 18,731 | 18,980 | 18,990 | 18,990 | 18,700 | | |
| 28 | | | | | | | | | | |
| 29 | 19,021 | 19,033 | 19,052 | 18,741 | 19,000 | 19,010 | 19,010 | 18,720 | 20,021 | 20,033 |
| 30 | | | | | | | | | | 20,052 |
| 31 | | | | | | 19,013 | 19,023 | 19,042 | 18,733 | |
| 32 | | | | | | | | | | |
| 33 | 19,021 | 19,033 | 19,052 | 18,741 | 19,023 | 19,033 | 19,052 | 18,743 | | |
| 34 | | | | | | | | | | |
| 35 | | | | | | | | | | |
| 36 | | | | | | | | | | |
| 37 | | | | | | | | | | |
| 38 | | | | | | | | | | |
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Продолжение табл. 2

| Размеры в мм | | | | | | | | | |
|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|
| Обозначение противех | 2400-0149; 2400-0150 | 2400-0151; 2400-0152 | 2400-0160; 2400-0163 | 2400-0163; 2400-0164 | 2400-0165; 2400-0165 | 2400-0167; 2400-0168 | 2400-1034; 2400-1035 | 2400-0159; 2400-0160 | 2400-0161; 2400-0162 |
| Диаметр отверстий | 19,72H7 | 20H7 | 20H8 | 20H9 | 19,73H7 | 21H7 | 21H8 | 21H9 | 20,72H7 |
| 1 | 18,920 | 19,170 | 19,170 | 19,170 | 18,870 | 20,020 | 20,020 | 20,020 | 19,720 |
| 2 | 18,890 | 19,140 | 19,140 | 19,140 | 18,840 | 19,990 | 19,990 | 19,990 | 19,990 |
| 3 | 19,040 | 19,240 | 19,240 | 19,240 | 18,940 | 20,140 | 20,140 | 20,140 | 19,950 |
| 4 | 19,010 | 19,210 | 19,210 | 19,210 | 18,910 | 20,110 | 20,110 | 20,110 | 19,840 |
| 5 | 19,160 | 19,310 | 19,310 | 19,310 | 19,010 | 20,260 | 20,260 | 20,260 | 19,840 |
| 6 | 19,130 | 19,280 | 19,280 | 19,280 | 18,980 | 20,230 | 20,230 | 20,230 | 19,950 |
| 7 | 19,280 | 19,380 | 19,380 | 19,380 | 19,080 | 20,380 | 20,380 | 20,380 | 20,080 |
| 8 | 19,250 | 19,350 | 19,350 | 19,350 | 19,050 | 20,350 | 20,350 | 20,350 | 20,050 |
| 9 | 19,400 | 19,450 | 19,450 | 19,450 | 19,150 | 20,500 | 20,500 | 20,500 | 20,140 |
| 10 | 19,370 | 19,420 | 19,420 | 19,420 | 19,120 | 20,470 | 20,470 | 20,470 | 20,260 |
| 11 | 19,520 | 19,520 | 19,520 | 19,520 | 19,220 | 20,620 | 20,620 | 20,620 | 20,230 |
| 12 | 19,490 | 19,490 | 19,490 | 19,490 | 19,190 | 20,590 | 20,590 | 20,590 | 20,350 |
| 13 | 19,600 | 19,590 | 19,590 | 19,590 | 19,290 | 20,740 | 20,740 | 20,740 | 20,320 |
| 14 | 19,580 | 19,560 | 19,560 | 19,560 | 19,260 | 20,710 | 20,710 | 20,710 | 20,440 |
| 15 | 19,660 | 19,660 | 19,660 | 19,660 | 19,360 | 20,830 | 20,830 | 20,830 | 20,620 |
| 16 | 19,640 | 19,630 | 19,630 | 19,630 | 19,330 | 20,810 | 20,810 | 20,810 | 20,590 |
| 17 | 19,680 | 19,720 | 19,720 | 19,720 | 19,430 | 21,880 | 21,880 | 21,880 | 20,710 |
| 18 | 19,700 | 19,700 | 19,700 | 19,700 | 19,400 | | | | 20,680 |
| 19 | 19,800 | 19,800 | 19,800 | 19,800 | 19,500 | | | | 20,680 |
| 20 | 19,770 | 19,770 | 19,770 | 19,770 | 19,470 | | | | 20,770 |

Измерение 3566е D₁ нонеопенИзмерение 3566е D₂ нонеопен

Продолжение табл. 2

| Размеры в мм | | | | | | | | | |
|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|------------|-------------------------|-------------------------|-------------------------|---------------------------------|
| Обозначение протяжек | 2400-0149; 2400-0159 | 2400-0151; 2400-0152 | 2400-0155; 2400-0156 | 2400-0153; 2400-0154 | 2400-0155; | 2400-0157; 2400-0153 | 2400-0159; 2400-0160 | 2400-0161; 2400-0162 | 2400- 0163; 2400- 0164 |
| Диаметр отверстия | 19,7347 | 20,047 | 20,493 | 19,7,17 | 21,177 | 21,478 | 21,19 | 20,7,217 | 21,177 |
| 21 | 19,720 | 19,870 | 19,870 | 19,570 | 20,950 | 20,970 | 20,980 | 20,680 | 20,870 |
| 22 | 19,850 | 19,850 | 19,850 | 19,550 | — | — | — | 20,850 | 20,850 |
| 23 | 19,731 | 19,910 | 19,920 | 19,620 | 20,980 | 20,990 | 21,010 | 20,700 | 20,920 |
| 24 | — | — | — | — | — | — | — | — | — |
| 25 | 19,741 | 19,950 | 19,960 | 19,961 | 19,660 | 21,000 | 21,010 | 21,030 | 20,720 |
| 26 | — | — | — | — | — | — | — | — | 20,950 |
| 27 | — | — | — | — | — | — | — | — | — |
| 28 | 19,980 | 19,990 | 20,000 | 19,700 | 21,111 | 21,023 | 21,042 | 20,731 | 20,980 |
| 29 | 19,741 | 20,000 | 20,010 | 20,025 | 19,720 | 21,021 | 21,033 | 21,052 | 21,010 |
| 30 | — | — | — | — | — | — | — | — | — |
| 31 | — | 20,011 | 20,023 | 20,042 | 19,731 | — | — | — | — |
| 32 | — | — | — | — | — | — | — | — | — |
| 33 | — | 20,021 | 20,033 | 20,052 | 19,741 | 21,021 | 21,033 | 21,052 | 21,023 |
| 34 | — | — | — | — | — | — | — | — | — |
| 35 | — | — | — | — | — | — | — | — | — |
| 36 | — | — | — | — | — | — | — | — | — |
| 37 | — | — | — | — | — | — | — | — | — |
| 38 | — | — | — | — | — | — | — | — | — |
| 39 | — | — | — | — | — | — | — | — | — |
| 40 | — | — | — | — | — | — | — | — | — |

Диаметры щебея D_1 , D_2 , D_3

Каналы приемных

и сброса

Продолжение табл. 2

Размеры в мм

| Диаметр отверстия | размеры в мм | | | | | | 24H7 |
|-------------------|--------------|---------|--------|--------|--------|---------|--------|
| | 21H9 | 20,72H7 | 22H7 | 22H8 | 22H9 | 21,72H7 | |
| 1 | 19,990 | 19,880 | 21,020 | 21,020 | 20,720 | 21,020 | 21,020 |
| 2 | 19,960 | 19,660 | 20,920 | 20,920 | 20,690 | 20,920 | 20,920 |
| 3 | 20,080 | 19,780 | 21,140 | 21,140 | 20,840 | 21,140 | 21,140 |
| 4 | 20,050 | 19,750 | 21,110 | 21,110 | 20,810 | 21,110 | 21,110 |
| 5 | 20,170 | 19,870 | 21,260 | 21,260 | 20,960 | 21,260 | 21,260 |
| 6 | 20,140 | 19,840 | 21,230 | 21,230 | 20,930 | 21,230 | 21,230 |
| 7 | 20,260 | 19,960 | 21,380 | 21,380 | 21,080 | 21,380 | 21,380 |
| 8 | 20,230 | 19,930 | 21,350 | 21,350 | 21,050 | 21,350 | 21,350 |
| 9 | 20,350 | 20,050 | 21,500 | 21,500 | 21,200 | 21,500 | 21,500 |
| 10 | 20,320 | 20,020 | 21,470 | 21,470 | 21,170 | 21,470 | 21,470 |
| 11 | 20,440 | 20,140 | 21,620 | 21,620 | 21,320 | 21,620 | 21,620 |
| 12 | 20,410 | 20,110 | 21,590 | 21,590 | 21,290 | 21,590 | 21,590 |
| 13 | 20,530 | 20,230 | 21,740 | 21,740 | 21,440 | 21,740 | 21,740 |
| 14 | 20,530 | 20,200 | 21,710 | 21,710 | 21,410 | 21,710 | 21,710 |
| 15 | 20,620 | 20,320 | 21,830 | 21,840 | 21,850 | 21,830 | 21,840 |
| 16 | 20,590 | 20,290 | 21,810 | 21,820 | 21,830 | 21,830 | 21,820 |
| 17 | 20,710 | 20,410 | 21,880 | 21,880 | 21,900 | 21,880 | 21,890 |
| 18 | 20,680 | 20,380 | | | | | |
| 19 | 20,800 | 20,500 | 21,920 | 21,930 | 21,940 | 21,920 | 21,930 |
| 20 | 20,770 | 20,470 | | | | | |

размеры в мм

Продолжение табл. 2

Размеры в мм

| Диаметр отверстия | 21НР | 20,72Н7 | 22Н7 | 22Н8 | 22Н9 | 21,72Н7 | 22Н7 | 22Н8 | 22Н9 | 21,72Н7 | 24Н7 |
|----------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|
| Обозначение профилей | 2400-0165; 2400-0166 | 2400-0167; 2400-0168 | 2400-0168; 2400-0170 | 2400-0188; 2400-0189 | 2400-0171; 2400-0172 | 2400-0173; 2400-0174 | 2400-0175; 2400-0176 | 2400-0177; 2400-0178 | 2400-0177; 2400-0178 | 2400-0177; 2400-0178 | 2400-0181; 2400-0182 |
| Номера профилей | 21 | 20,880 | 20,580 | 21,960 | 21,970 | 21,980 | 21,680 | 21,960 | 21,970 | 21,980 | 21,680 |
| Номера профилей | 22 | 20,880 | 20,560 | 21,980 | 21,990 | 22,010 | 21,700 | 21,980 | 21,990 | 22,010 | 21,700 |
| Номера профилей | 23 | 20,930 | 20,630 | 21,980 | 21,990 | 22,010 | 22,030 | 21,720 | 22,000 | 22,010 | 22,030 |
| Номера профилей | 24 | 20,970 | 20,670 | 22,000 | 22,010 | 22,030 | 22,040 | 21,731 | 22,011 | 22,023 | 22,042 |
| Номера профилей | 25 | 21,000 | 20,700 | 22,011 | 22,023 | 22,042 | 22,052 | 21,741 | 22,021 | 22,033 | 22,052 |
| Номера профилей | 26 | 21,025 | 20,720 | 22,021 | 22,033 | 22,052 | 22,062 | 21,741 | 22,021 | 22,033 | 22,052 |
| Номера профилей | 27 | 21,042 | 20,731 | — | — | — | — | — | — | — | — |
| Номера профилей | 28 | 21,052 | 20,741 | 22,021 | 22,033 | 22,052 | 21,741 | 22,021 | 22,033 | 22,052 | 21,741 |
| Номера профилей | 29 | 21,052 | 20,741 | — | — | — | — | — | — | — | — |
| Номера профилей | 30 | 21,052 | 20,741 | — | — | — | — | — | — | — | — |
| Номера профилей | 31 | 21,052 | 20,741 | — | — | — | — | — | — | — | — |
| Номера профилей | 32 | 21,052 | 20,741 | — | — | — | — | — | — | — | — |
| Номера профилей | 33 | 21,052 | 20,741 | — | — | — | — | — | — | — | — |
| Номера профилей | 34 | 21,052 | 20,741 | — | — | — | — | — | — | — | — |
| Номера профилей | 35 | — | — | — | — | — | — | — | — | — | — |
| Номера профилей | 36 | — | — | — | — | — | — | — | — | — | — |
| Номера профилей | 37 | 21,052 | 20,741 | — | — | — | — | — | — | — | — |
| Номера профилей | 38 | — | — | — | — | — | — | — | — | — | — |
| Номера профилей | 39 | — | — | — | — | — | — | — | — | — | — |
| Номера профилей | 40 | — | — | — | — | — | — | — | — | — | — |

Аналогичные размеры D₁ заменяются

Приложение к табл. 2

Размеры в мм

| Обозначение протяжек | | 2400-103; 2400-1044 | 2400-0183; 2400-0184 | 2400-0185; 2400-0186 | 2400-0187; 2400-0188 | 2400-1045; 2400-1045 | 2400-0189; 2400-0190 | 2400-0191; 2400-0192 | 2400-0193; 2400-0194 | 2400-1047; 2400-1048 | 2400- -0195; -0196 | 2400- -0197; -0198 |
|-------------------------|--------|------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|--------------------------|--------------------------|
| Диаметр отверстия | 24H8 | 24H9 | 23,72H7 | 24H7 | 24H8 | 24H9 | 23,77H7 | 25H7 | 25H8 | 25H9 | 24,72H7 | |
| 1 | 23,070 | 23,070 | 22,770 | 23,070 | 23,070 | 23,070 | 22,770 | 24,050 | 24,050 | 24,050 | 23,750 | |
| 2 | 23,040 | 23,040 | 22,740 | 23,040 | 23,040 | 23,040 | 22,740 | 24,020 | 24,020 | 24,020 | 23,720 | |
| 3 | 23,240 | 23,240 | 22,940 | 23,240 | 23,240 | 23,240 | 22,940 | 24,200 | 24,200 | 24,200 | 23,900 | |
| 4 | 23,210 | 23,210 | 22,910 | 23,210 | 23,210 | 23,210 | 22,910 | 24,170 | 24,170 | 24,170 | 23,870 | |
| 5 | 23,410 | 23,410 | 23,110 | 23,410 | 23,410 | 23,410 | 23,110 | 24,350 | 24,350 | 24,350 | 24,050 | |
| 6 | 23,380 | 23,380 | 23,080 | 23,380 | 23,380 | 23,380 | 23,080 | 24,320 | 24,320 | 24,320 | 24,020 | |
| 7 | 23,580 | 23,580 | 23,280 | 23,580 | 23,580 | 23,580 | 23,280 | 24,500 | 24,500 | 24,500 | 24,200 | |
| 8 | 23,560 | 23,560 | 23,260 | 23,560 | 23,560 | 23,560 | 23,260 | 24,470 | 24,470 | 24,470 | 24,170 | |
| 9 | 23,760 | 23,760 | 23,450 | 23,750 | 23,750 | 23,750 | 23,450 | 24,650 | 24,650 | 24,650 | 24,350 | |
| 10 | 23,730 | 23,730 | 23,430 | 23,730 | 23,730 | 23,730 | 23,430 | 24,620 | 24,620 | 24,620 | 24,320 | |
| 11 | 23,830 | 23,840 | 23,540 | 23,830 | 23,830 | 23,840 | 23,540 | 24,780 | 24,790 | 24,800 | 24,500 | |
| 12 | | | | | | | | 24,760 | 24,770 | 24,780 | 24,480 | |
| 13 | 23,890 | 23,900 | 23,600 | 23,890 | 23,890 | 23,900 | 23,600 | 24,860 | 24,870 | 24,880 | 24,580 | |
| 14 | | | | | | | | | | | | |
| 15 | 23,930 | 23,940 | 23,640 | 23,930 | 23,930 | 23,940 | 23,640 | 24,920 | 24,930 | 24,940 | 24,640 | |
| 16 | | | | | | | | | | | | |
| 17 | 23,970 | 23,980 | 23,680 | 23,960 | 23,970 | 23,980 | 23,680 | 24,960 | 24,970 | 24,980 | 24,680 | |
| 18 | | | | | | | | | | | | |
| 19 | 23,990 | 24,010 | 23,700 | 23,980 | 23,990 | 24,010 | 23,700 | 24,980 | 24,990 | 25,010 | 24,700 | |
| 20 | | | | | | | | | | | | |

Диаметры отверстий D_1 , D_2 , D_3

Приложение табл. 2

| | | Размеры в мм | | | | | | | | | | |
|-------------------|------|--------------|-----------|------------|------------|------------|------------|------------|------------|------------|------------|------------|
| Обозначение | | 2400-0148; | 240-0188; | 2400-0185; | 2400-0197; | 2400-1045; | 2400-0186; | 2400-0198; | 2400-0191; | 2400-0153; | 2400-1042; | 2400-0195; |
| протяжек | | 2400 1048 | 2400 0184 | 2400 0186 | 2400 0185 | 2400 0196 | 2400 0188 | 2400 0199 | 2400 0192 | 2400 0194 | 2400 0188 | 2400 0196 |
| Диаметр отверстия | 24H8 | 24H9 | 23,72H7 | 24H7 | 24H8 | 24H9 | 23,72H7 | 23,72H7 | 23,72H7 | 23,72H8 | 23,72H7 | 24,72H7 |
| | 21 | 24,010 | 24,030 | 23,720 | 24,000 | 24,010 | 24,030 | 23,720 | 23,720 | 25,000 | 25,010 | 25,030 |
| | 22 | | | | | | | | | | | |
| | 23 | 24,023 | 24,042 | 23,731 | 24,011 | 24,023 | 24,042 | 23,731 | 23,731 | 25,011 | 25,023 | 25,042 |
| | 24 | | | | | | | | | | | |
| | 25 | 24,033 | 24,052 | 23,741 | 24,021 | 24,033 | 24,052 | 23,741 | 23,741 | 25,021 | 25,033 | 25,052 |
| | 26 | | | | | | | | | | | |
| | 27 | | | | | | | | | | | |
| | 18 | | | | | | | | | | | |
| | 28 | | | | | | | | | | | |
| | 29 | 24,033 | 24,052 | 23,741 | 24,021 | 24,033 | 24,052 | 23,741 | 23,741 | 25,021 | 25,033 | 25,052 |
| | 30 | | | | | | | | | | | |
| | 31 | | | | | | | | | | | |
| | 32 | | | | | | | | | | | |
| | 33 | | | | | | | | | | | |
| | 34 | | | | | | | | | | | |
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| | 36 | | | | | | | | | | | |
| | 37 | | | | | | | | | | | |
| | 38 | | | | | | | | | | | |
| | 39 | | | | | | | | | | | |
| | 40 | | | | | | | | | | | |

Размеры в миллиметрах

Продолжение табл. 2

| Размеры в мм | | | | | | | | | |
|-------------------|--------|--------|--------|----------|--------|--------|--------|----------|--------|
| Диаметр отверстия | 25/47 | 25/48 | 25/49 | 24,72/47 | 25/47 | 26/48 | 26/49 | 25,72/47 | 26/47 |
| 1 | 24,010 | 24,010 | 24,010 | 23,710 | 25,050 | 25,050 | 24,750 | 25,010 | 25,010 |
| 2 | 23,980 | 23,980 | 23,980 | 23,680 | 25,020 | 25,020 | 24,720 | 24,980 | 24,980 |
| 3 | 24,120 | 24,120 | 24,120 | 23,820 | 25,200 | 25,200 | 24,900 | 25,120 | 25,120 |
| 4 | 24,090 | 24,090 | 24,090 | 23,790 | 25,170 | 25,170 | 24,870 | 25,090 | 25,090 |
| 5 | 24,230 | 24,230 | 24,230 | 23,930 | 25,350 | 25,350 | 25,050 | 25,230 | 25,230 |
| 6 | 24,200 | 24,200 | 24,200 | 23,900 | 25,320 | 25,320 | 25,020 | 25,200 | 25,200 |
| 7 | 24,340 | 24,340 | 24,340 | 24,040 | 25,500 | 25,500 | 25,200 | 25,340 | 25,340 |
| 8 | 24,310 | 24,310 | 24,310 | 24,010 | 25,470 | 25,470 | 25,170 | 25,310 | 25,310 |
| 9 | 24,450 | 24,450 | 24,450 | 24,150 | 25,650 | 25,650 | 25,350 | 25,450 | 25,450 |
| 10 | 24,420 | 24,420 | 24,420 | 24,120 | 25,620 | 25,620 | 25,320 | 25,420 | 25,420 |
| 11 | 24,560 | 24,560 | 24,560 | 24,260 | 25,780 | 25,790 | 25,500 | 25,660 | 25,660 |
| 12 | 24,530 | 24,530 | 24,530 | 24,230 | 25,760 | 25,770 | 25,470 | 25,530 | 25,530 |
| 13 | 24,670 | 24,670 | 24,670 | 24,370 | 25,860 | 25,870 | 25,680 | 25,670 | 25,670 |
| 14 | 24,640 | 24,640 | 24,640 | 24,340 | | | | 25,640 | 25,640 |
| 15 | 24,780 | 24,780 | 24,780 | 24,480 | | | | 25,780 | 25,780 |
| 16 | 24,750 | 24,750 | 24,750 | 24,450 | | | | 25,750 | 25,750 |
| 17 | 24,870 | 24,870 | 24,870 | 24,580 | | | | 25,870 | 25,880 |
| 18 | 24,850 | 24,860 | 24,860 | 24,560 | | | | 25,850 | 25,870 |
| 19 | 24,920 | 24,930 | 24,930 | 24,630 | | | | 25,920 | 25,940 |
| 20 | | | | | | | | | |

Диаметр зygобе D₁ нонспецифический
Легированная нержавеющая

Продолжение табл. 2

| Размеры в мм | | | | | | | | | |
|-------------------------|--------|-------------------------|--------|-------------------------|--------|-------------------------|--------|-------------------------|--------|
| Обозначение протяжек | | 2400-0196; 2400-0206 | | 2400-1049; 2400-1081 | | 2400-0201; 2400-0202 | | 2400-0205; 2400-0206 | |
| Диаметр отверстия | | 25,67 | 25,98 | 25,99 | 26,47 | 26,48 | 26,59 | 25,72 | 26,47 |
| 21 | 24,960 | 24,970 | 24,970 | 24,670 | 26,000 | 26,010 | 26,030 | 25,720 | 25,960 |
| 22 | | | | | | | | | 25,970 |
| 23 | 24,980 | 24,990 | 25,000 | 24,700 | 26,011 | 26,023 | 26,042 | 25,731 | 25,980 |
| 24 | | | | | | | | | 25,990 |
| 25 | 25,000 | 25,010 | 25,025 | 24,720 | 26,021 | 26,033 | 26,052 | 25,741 | 26,000 |
| 26 | | | | | | | | | 26,010 |
| 27 | 25,011 | 25,023 | 25,042 | 24,731 | | | | | 26,030 |
| 28 | | | | | | | | | |
| 29 | 25,021 | 25,033 | 25,052 | 24,741 | 26,021 | 26,033 | 26,052 | 25,741 | 26,011 |
| 30 | | | | | | | | | 26,023 |
| 31 | | | | | | | | | 26,042 |
| 32 | | | | | | | | | 26,052 |
| 33 | 25,021 | 25,033 | 25,052 | 24,741 | | | | | 26,033 |
| 34 | | | | | | | | | 26,052 |
| 35 | | | | | | | | | |
| 36 | | | | | | | | | |
| 37 | | | | | | | | | |
| 38 | | | | | | | | | |
| 39 | | | | | | | | | |
| 40 | | | | | | | | | |

Продолжение табл. 2

| Размеры в мм | | | | | | | | | | | |
|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|---------------------------------|--------|--------|
| Обозначение протяжек | 2400-0215; 2400-0216 | 2400-0217; 2400-0218 | 2400-0219; 2400-0220 | 2400-0221; 2400-0222 | 2400-0223; 2400-0224 | 2400-1065; 2400-1069 | 2400-0225; 2400-0226 | 2400-0227; 2400-0228 | 2400- 1061; 2400- 1062 | | |
| Диаметр протяжки | 25,72Н7 | 27Н7 | 27Н8 | 27Н9 | 26,73Н7 | 27Н7 | 27Н8 | 27Н9 | 26,72Н7 | 28Н7 | 28Н8 |
| 1 | 24,710 | 26,080 | 26,080 | 25,780 | 26,010 | 26,010 | 26,010 | 26,010 | 25,710 | 27,080 | 27,080 |
| 2 | 24,680 | 26,050 | 26,050 | 25,750 | 25,980 | 25,980 | 25,980 | 25,980 | 25,680 | 27,050 | 27,050 |
| 3 | 24,820 | 26,260 | 26,260 | 25,960 | 26,120 | 26,120 | 26,120 | 26,120 | 25,820 | 27,260 | 27,260 |
| 4 | 24,790 | 26,230 | 26,230 | 25,930 | 26,090 | 26,090 | 26,090 | 26,090 | 25,790 | 27,230 | 27,230 |
| 5 | 24,830 | 26,440 | 26,440 | 26,140 | 26,230 | 26,230 | 26,230 | 26,230 | 25,930 | 27,440 | 27,440 |
| 6 | 24,900 | 26,410 | 26,410 | 26,110 | 26,200 | 26,200 | 26,200 | 26,200 | 25,900 | 27,410 | 27,410 |
| 7 | 25,040 | 26,620 | 26,620 | 26,320 | 26,340 | 26,340 | 26,340 | 26,340 | 26,040 | 27,620 | 27,620 |
| 8 | 25,010 | 26,590 | 26,590 | 26,290 | 26,310 | 26,310 | 26,310 | 26,310 | 26,010 | 27,590 | 27,590 |
| 9 | 25,150 | 26,780 | 26,780 | 26,490 | 26,450 | 26,450 | 26,450 | 26,450 | 26,150 | 27,780 | 27,780 |
| 10 | 25,120 | 26,760 | 26,770 | 26,470 | 26,420 | 26,420 | 26,420 | 26,420 | 26,120 | 27,760 | 27,760 |
| 11 | 25,260 | 26,860 | 26,870 | 26,880 | 26,580 | 26,560 | 26,560 | 26,560 | 26,260 | 27,860 | 27,870 |
| 12 | 25,230 | 26,920 | 26,930 | 26,940 | 26,640 | 26,610 | 26,640 | 26,530 | 26,230 | 27,860 | 27,870 |
| 13 | 25,370 | 26,940 | 26,950 | 26,960 | 26,670 | 26,640 | 26,640 | 26,530 | 26,230 | 27,920 | 27,930 |
| 14 | 25,340 | 26,960 | 26,970 | 26,980 | 26,780 | 26,750 | 26,750 | 26,670 | 26,370 | 27,980 | 27,990 |
| 15 | 25,480 | 26,990 | 26,990 | 26,990 | 26,880 | 26,880 | 26,880 | 26,880 | 26,590 | 27,980 | 27,990 |
| 16 | 25,450 | 27,000 | 27,010 | 27,010 | 26,700 | 26,700 | 26,700 | 26,700 | 26,570 | 27,980 | 27,990 |
| 17 | 25,590 | 26,980 | 26,990 | 27,010 | 26,700 | 26,660 | 26,860 | 26,870 | 26,640 | 27,980 | 27,990 |
| 18 | 25,570 | 27,000 | 27,010 | 27,030 | 26,720 | 26,920 | 26,930 | 26,940 | 26,640 | 28,000 | 28,010 |
| 19 | 25,640 | 27,000 | 27,010 | 27,030 | 26,720 | 26,920 | 26,930 | 26,940 | 26,640 | 28,000 | 28,010 |
| 20 | | | | | | | | | | | |

Диаметры заготовок D₁ и неподвижных

Продолжение табл. 2

| О皎нажение протяжек | Размеры и им | | | | | | | | | | |
|-----------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|--------|
| | 2400-0215; 2400-0216 | 2400-0217; 2400-0218 | 2400-0218; 2400-0219 | 2400-0219; 2400-0220 | 2400-0221; 2400-0222 | 2400-0223; 2400-0224 | 2400-0224; 2400-0225 | 2400-0225; 2400-0226 | 2400-0226; 2400-0228 | 2400-0229; 2400-0230 | |
| Диаметр отверстия | 25,72Н7 | 27Н7 | 27Н8 | 27Н9 | 26,72Н7 | 27Н7 | 27Н8 | 27Н9 | 26,72Н7 | 28Н7 | 28Н8 |
| 21 | 25,680 | 27,011 | 27,023 | 27,042 | 26,731 | 26,960 | 26,970 | 26,980 | 26,680 | 28,011 | 28,023 |
| 22 | | | | | | | | | | | |
| 23 | 25,700 | 27,021 | 27,033 | 27,052 | 26,741 | 26,980 | 26,990 | 27,010 | 26,700 | 28,021 | 28,033 |
| 24 | | | | | | | | | | | |
| 25 | 25,720 | | | | | 27,000 | 27,010 | 27,030 | 26,720 | | |
| 26 | | | | | | | | | | | |
| 27 | 25,731 | 27,021 | 27,033 | 27,052 | 26,741 | 27,011 | 27,023 | 27,042 | 26,731 | 28,021 | 28,033 |
| 28 | | | | | | | | | | | |
| 29 | 25,741 | | | | | 27,021 | 27,033 | 27,052 | 26,741 | | |
| 30 | | | | | | | | | | | |
| 31 | | | | | | | | | | | |
| 32 | | | | | | | | | | | |
| 33 | 25,741 | | | | | 27,021 | 27,033 | 27,052 | 26,741 | | |
| 34 | | | | | | | | | | | |
| 35 | | | | | | | | | | | |
| 36 | | | | | | | | | | | |
| 37 | | | | | | | | | | | |
| 38 | | | | | | | | | | | |
| 39 | | | | | | | | | | | |
| 40 | | | | | | | | | | | |

Измерение D_1 , мм

Продолжение табл. 2

| Размеры в мм | | Диаметр отверстия | |
|--------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|
| Односторонне протяжки | 2400-0231; 2400-0232 | 2400-0233; 2400-0234 | 2400-0235; 2400-0235 | 2400-0236; 2400-0236 | 2400-0237; 2400-0237 | 2400-0238; 2400-0238 | 2400-0239; 2400-0239 | 2400-0241; 2400-0241 | 2400-0245; 2400-0245 | 2400-0246; 2400-0246 | 2400-0247; 2400-0247 | 2400-0248; 2400-0248 | 2400-0249; 2400-0249 | 2400-0250; 2400-0250 | 2400-0251; 2400-0251 | 2400-0252; 2400-0252 | 2400-0253; 2400-0253 | 2400-0254; 2400-0254 | 2400-0255; 2400-0255 |
| Диаметр отверстия | 26,19 | 27,72 | 27,77 | 28,17 | 28,68 | 28,93 | 29,19 | 29,27 | 29,37 | 29,48 | 30,49 | 30,77 | 30,97 | 30,97 | 30,97 | 30,97 | 30,97 | 30,97 | 30,97 |
| 1 | 27,080 | 26,780 | 27,050 | 27,050 | 27,750 | 29,080 | 29,080 | 29,080 | 29,080 | 29,080 | 28,780 | 29,050 | 29,050 | 29,050 | 29,050 | 29,050 | 29,050 | 29,050 | 29,050 |
| 2 | 27,050 | 26,750 | 27,020 | 27,020 | 26,720 | 29,050 | 29,050 | 29,050 | 29,050 | 29,050 | 28,750 | 29,020 | 29,020 | 29,020 | 29,020 | 29,020 | 29,020 | 29,020 | 29,020 |
| 3 | 27,260 | 26,960 | 27,200 | 27,200 | 27,200 | 26,900 | 29,260 | 29,260 | 29,260 | 29,260 | 28,960 | 29,200 | 29,200 | 29,200 | 29,200 | 29,200 | 29,200 | 29,200 | 29,200 |
| 4 | 27,230 | 26,930 | 27,170 | 27,170 | 27,170 | 26,870 | 29,230 | 29,230 | 29,230 | 29,230 | 28,930 | 29,170 | 29,170 | 29,170 | 29,170 | 29,170 | 29,170 | 29,170 | 29,170 |
| 5 | 27,440 | 27,140 | 27,350 | 27,350 | 27,350 | 27,050 | 29,440 | 29,440 | 29,440 | 29,440 | 29,140 | 29,350 | 29,350 | 29,350 | 29,350 | 29,350 | 29,350 | 29,350 | 29,350 |
| 6 | 27,410 | 27,110 | 27,320 | 27,320 | 27,320 | 27,020 | 29,410 | 29,410 | 29,410 | 29,410 | 29,110 | 29,320 | 29,320 | 29,320 | 29,320 | 29,320 | 29,320 | 29,320 | 29,320 |
| 7 | 27,620 | 27,320 | 27,500 | 27,500 | 27,500 | 27,200 | 29,620 | 29,620 | 29,620 | 29,620 | 29,320 | 29,500 | 29,500 | 29,500 | 29,500 | 29,500 | 29,500 | 29,500 | 29,500 |
| 8 | 27,590 | 27,290 | 27,470 | 27,470 | 27,470 | 27,170 | 29,590 | 29,590 | 29,590 | 29,590 | 29,290 | 29,470 | 29,470 | 29,470 | 29,470 | 29,470 | 29,470 | 29,470 | 29,470 |
| 9 | 27,790 | 27,490 | 27,650 | 27,650 | 27,650 | 27,350 | 29,770 | 29,770 | 29,770 | 29,770 | 29,490 | 29,650 | 29,650 | 29,650 | 29,650 | 29,650 | 29,650 | 29,650 | 29,650 |
| 10 | 27,770 | 27,470 | 27,620 | 27,620 | 27,620 | 27,320 | 29,750 | 29,750 | 29,750 | 29,750 | 29,470 | 29,620 | 29,620 | 29,620 | 29,620 | 29,620 | 29,620 | 29,620 | 29,620 |
| 11 | 27,380 | 27,580 | 27,780 | 27,780 | 27,780 | 27,800 | 27,500 | 27,500 | 27,500 | 27,500 | 29,580 | 29,780 | 29,780 | 29,780 | 29,780 | 29,780 | 29,780 | 29,780 | 29,780 |
| 12 | 27,940 | 27,640 | 27,860 | 27,870 | 27,880 | 27,580 | 29,920 | 29,920 | 29,920 | 29,920 | 29,860 | 29,980 | 29,980 | 29,980 | 29,980 | 29,980 | 29,980 | 29,980 | 29,980 |
| 13 | 27,940 | 27,640 | 27,860 | 27,870 | 27,880 | 27,580 | 29,920 | 29,920 | 29,920 | 29,920 | 29,860 | 29,980 | 29,980 | 29,980 | 29,980 | 29,980 | 29,980 | 29,980 | 29,980 |
| 14 | | | | | | | | | | | | | | | | | | | |
| 15 | 27,980 | 27,680 | 27,920 | 27,930 | 27,940 | 27,640 | 29,960 | 29,970 | 29,970 | 29,970 | 29,680 | 29,920 | 29,920 | 29,920 | 29,920 | 29,920 | 29,920 | 29,920 | 29,920 |
| 16 | | | | | | | | | | | | | | | | | | | |
| 17 | 28,010 | 27,700 | 27,950 | 27,970 | 27,980 | 27,680 | 29,980 | 29,990 | 29,990 | 29,990 | 30,010 | 29,700 | 29,960 | 29,960 | 29,960 | 29,960 | 29,960 | 29,960 | 29,960 |
| 18 | | | | | | | | | | | | | | | | | | | |
| 19 | 28,030 | 27,720 | 27,980 | 27,990 | 28,010 | 27,700 | 30,000 | 30,010 | 30,010 | 30,010 | 30,030 | 29,720 | 29,980 | 29,980 | 29,980 | 29,980 | 29,980 | 29,980 | 29,980 |
| 20 | | | | | | | | | | | | | | | | | | | |

Измерения в миллиметрах D₁ и D₂

Продолжение табл. 2

| | | Размеры в мм | | | | | | | | | |
|-------------------------|--------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|---------------------------------|--------|
| Обозначение протяжек | | 2400-0231; 2400-0232 | 2400-0233; 2400-0234 | 2400-1063; 2400-1064 | 2400-0235; 2400-0236 | 2400-0237; 2400-0238 | 2400-0239; 2400-0240 | 2400-0241; 2400-0242 | 2400-0243; 2400-0244 | 2400- 0245; 2400- 0246 | |
| Диаметр стяжки | 26479 | 27,72H7 | 28H7 | 29H8 | 28H9 | 27,72H7 | 27,72H7 | 30H7 | 30H9 | 29,72H7 | 30H7 |
| 21 | 28,042 | 27,731 | 28,000 | 28,010 | 28,030 | 27,720 | 30,011 | 30,023 | 30,042 | 29,731 | 30,000 |
| 22 | 28,052 | 27,741 | 28,011 | 28,023 | 28,042 | 27,731 | 30,021 | 30,033 | 30,052 | 29,741 | 30,011 |
| 23 | 28,052 | 27,741 | 28,021 | 28,033 | 28,052 | 27,741 | | | | | 30,021 |
| 24 | | | | | | | | | | | |
| 25 | | | | | | | | | | | |
| 26 | | | | | | | | | | | |
| 27 | 28,052 | 27,741 | | | | | | | | | |
| 28 | | | | | | | | | | | |
| 29 | | | | | | | | | | | |
| 30 | | | | | 28,021 | 28,033 | 28,052 | 27,741 | | | 30,021 |
| 31 | | | | | | | | | | | |
| 32 | | | | | | | | | | | |
| 33 | | | | | | | | | | | |
| 34 | | | | | | | | | | | |
| 35 | | | | | | | | | | | |
| 36 | | | | | | | | | | | |
| 37 | | | | | | | | | | | |
| 38 | | | | | | | | | | | |
| 39 | | | | | | | | | | | |
| 40 | | | | | | | | | | | |

Измерения в градусах D , градусные

Продолжение табл. 2

| Размеры в мм | | Номинальные размеры | | Номинальные размеры | | Номинальные размеры | |
|--------------|--------|---------------------|---------|---------------------|--------|---------------------|--------|
| Номер | стенки | 30H9 | 29,72H7 | 32H7 | 31H9 | 31,56H7 | 32H9 |
| 1 | 29,050 | 29,050 | 28,750 | 30,990 | 30,990 | 30,970 | 30,970 |
| 2 | 29,020 | 29,020 | 28,720 | 30,960 | 30,960 | 30,940 | 30,940 |
| 3 | 29,200 | 29,200 | 28,900 | 31,180 | 31,180 | 31,140 | 31,140 |
| 4 | 29,170 | 29,170 | 28,870 | 31,150 | 31,150 | 30,850 | 31,110 |
| 5 | 29,350 | 29,350 | 29,050 | 31,370 | 31,370 | 31,070 | 31,310 |
| 6 | 39,320 | 39,320 | 39,020 | 31,340 | 31,340 | 31,040 | 31,280 |
| 7 | 29,500 | 29,500 | 29,200 | 31,560 | 31,560 | 31,260 | 31,480 |
| 8 | 29,470 | 29,470 | 29,170 | 31,530 | 31,530 | 31,230 | 31,450 |
| 9 | 29,550 | 29,550 | 29,350 | 31,750 | 31,750 | 31,420 | 31,650 |
| 10 | 29,620 | 29,620 | 29,320 | 31,730 | 31,730 | 31,400 | 31,620 |
| 11 | 29,790 | 29,790 | 29,500 | 31,860 | 31,860 | 31,520 | 31,780 |
| 12 | 29,770 | 29,770 | 29,480 | 31,920 | 31,920 | 31,580 | 31,760 |
| 13 | 29,870 | 29,880 | 29,580 | 31,920 | 31,920 | 31,860 | 31,870 |
| 14 | | | | | | | |
| 15 | 29,930 | 29,940 | 29,640 | 31,990 | 31,990 | 31,620 | 31,930 |
| 16 | | | | | | | |
| 17 | 29,970 | 29,980 | 29,680 | 31,980 | 32,000 | 31,640 | 31,960 |
| 18 | | | | | | | |
| 19 | 29,990 | 30,010 | 29,700 | 32,000 | 32,020 | 31,660 | 31,980 |
| 20 | | | | | | | |

Измерения в дюймах, номинальные

Продолжение табл. 2

| Обозначение профиля | | Размеры в мм | | | | | | Обозначение профиля | | Размеры в мм | | | | | |
|---------------------|--------|--------------|--------|--------|--------|--------|--------|---------------------|--------|--------------|--------|------|--------|------|--------|
| Диаметр отверстия | 20H8 | 30H9 | 25,7H7 | 32H7 | 31,6H7 | 30H9 | 31,6H7 | 32H7 | 31,6H7 | 32H5 | 31,6H7 | 32H9 | 31,6H7 | 32H5 | 31,6H7 |
| 21 | 30,010 | 30,030 | 29,720 | 32,015 | 32,030 | 32,032 | 31,675 | 32,000 | 32,020 | 32,035 | 31,600 | | | | |
| 22 | | | | | | | | | | | | | | | |
| 23 | 30,023 | 30,042 | 29,731 | 32,025 | 32,039 | 32,062 | 31,685 | 32,015 | 32,030 | 32,052 | 31,675 | | | | |
| 24 | | | | | | | | | | | | | | | |
| 25 | 30,033 | 30,052 | 29,741 | | | | | 32,025 | 32,039 | 32,062 | 31,685 | | | | |
| 26 | | | | | | | | | | | | | | | |
| 27 | | | | | | | | | | | | | | | |
| 28 | 30,033 | 30,052 | 29,741 | | | | | | | | | | | | |
| 29 | | | | | | | | | | | | | | | |
| 30 | | | | | | | | | | | | | | | |
| 31 | | | | | | | | | | | | | | | |
| 32 | | | | | | | | | | | | | | | |
| 33 | | | | | | | | | | | | | | | |
| 34 | | | | | | | | | | | | | | | |
| 35 | | | | | | | | | | | | | | | |
| 36 | | | | | | | | | | | | | | | |
| 37 | | | | | | | | | | | | | | | |
| 38 | | | | | | | | | | | | | | | |
| 39 | | | | | | | | | | | | | | | |
| 40 | | | | | | | | | | | | | | | |

Минимальные размеры D_1 , мм

Продолжение табл. 2

| Размеры в мм | | | | | | | | | |
|-------------------------|--------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|
| Обозначение протяжек | | 2400-0365; 2400-0366 | 2400-1074; 2400-1075 | 2400-0367; 2400-0368 | 2400-0369; 2400-0370 | 2400-0371; 2400-0372 | 2400-0373; 2400-0374 | 2400-0375; 2400-0376 | 2400-0377; 2400-0378 |
| Диаметр стяжки | | 34H7 | 34H8 | 34H9 | 34H10 | 34H11 | 34H12 | 34H13 | 34H14 |
| 1 | 32,990 | 32,990 | 32,990 | 32,970 | 32,970 | 32,980 | 32,670 | 33,990 | 33,990 |
| 2 | 32,960 | 32,960 | 32,960 | 32,940 | 32,940 | 32,940 | 32,640 | 33,960 | 33,960 |
| 3 | 33,180 | 33,180 | 33,180 | 32,830 | 33,140 | 33,140 | 32,840 | 34,180 | 34,180 |
| 4 | 33,150 | 33,150 | 33,150 | 32,850 | 33,110 | 33,110 | 32,810 | 34,150 | 34,150 |
| 5 | 33,370 | 33,370 | 33,370 | 33,970 | 33,310 | 33,310 | 33,310 | 34,370 | 34,370 |
| 6 | 33,340 | 33,340 | 33,340 | 33,040 | 33,280 | 33,280 | 32,980 | 34,340 | 34,340 |
| 7 | 33,560 | 33,560 | 33,560 | 33,260 | 33,480 | 33,480 | 33,480 | 34,560 | 34,560 |
| 8 | 33,530 | 33,530 | 33,530 | 33,230 | 33,450 | 33,450 | 33,450 | 34,530 | 34,530 |
| 9 | 33,750 | 33,750 | 33,750 | 33,420 | 33,650 | 33,650 | 33,650 | 34,750 | 34,750 |
| 10 | 33,730 | 33,730 | 33,730 | 33,400 | 33,620 | 33,620 | 33,620 | 34,730 | 34,730 |
| 11 | 33,860 | 33,860 | 33,860 | 33,520 | 33,780 | 33,780 | 33,790 | 34,850 | 34,850 |
| 12 | 33,920 | 33,920 | 33,920 | 33,580 | 33,830 | 33,830 | 33,830 | 34,920 | 34,920 |
| 13 | 33,960 | 33,960 | 33,960 | 33,620 | 33,920 | 33,920 | 33,940 | 34,960 | 34,960 |
| 14 | 34,000 | 34,000 | 34,000 | 33,660 | 33,960 | 33,960 | 33,980 | 34,980 | 35,000 |
| 15 | 34,020 | 34,030 | 34,030 | 33,660 | 33,980 | 34,000 | 34,010 | 33,640 | 35,020 |
| 16 | 34,000 | 34,020 | 34,030 | 33,660 | 33,980 | 34,000 | 34,010 | 33,640 | 35,030 |

Продолжение табл. 2

| | | Размеры в мм | | | | | |
|-------------------|--------|--------------|------------|------------|------------|------------|------------|
| Обозначение | | 2400-1074; | 2400-0267; | 2400-1078; | 2400-0275; | 2400-1078; | 2400-0275; |
| протяжек | | 2400-0266; | 2400-0272; | 2400-1077; | 2400-0274; | 2400-0278; | 2400-0280; |
| Диаметр отверстия | 34Н7 | 34Н8 | 34Н9 | 33,68Н7 | 34Н7 | 34Н9 | 33,68Н7 |
| 21 | 34,015 | 34,030 | 34,052 | 33,675 | 34,000 | 34,020 | 34,035 |
| 22 | | | | | | | |
| 23 | 34,025 | 34,039 | 34,062 | 33,685 | 34,015 | 34,030 | 34,052 |
| 24 | | | | | | | |
| 25 | | | | | | | |
| 26 | | | | | 34,025 | 34,039 | 34,062 |
| 27 | 34,025 | 34,039 | 34,062 | 33,685 | | | |
| 28 | | | | | | | |
| 29 | | | | | | | |
| 30 | | | | | | | |
| 31 | | | | | | | |
| 32 | | | | | | | |
| 33 | | | | | | | |
| 34 | | | | | | | |
| 35 | | | | | | | |
| 36 | | | | | | | |
| 37 | | | | | | | |
| 38 | | | | | | | |
| 39 | | | | | | | |
| 40 | | | | | | | |

Минимальные зазоры D_1 , мм

Продолжение табл. 2

| Размеры в мм | | | | | | | | | |
|-------------------------|--------|-------------------------|--------|-------------------------|--------|-------------------------|--------|-------------------------|--------|
| Обозначение протяжек | | 2400-0361: 2400-0382 | | 2400-0285: 2400-0289 | | 2400-0267: 2400-0288 | | 2400-0289: 2400-0290 | |
| Диаметр отверстий | | 34,56H7 | | 35H8 | | 34,65H7 | | 35H8 | |
| 1 | 33,690 | 33,970 | 33,970 | 33,670 | 33,970 | 34,990 | 34,990 | 34,690 | 34,970 |
| 2 | 33,660 | 33,940 | 33,940 | 33,640 | 33,940 | 34,960 | 34,960 | 34,660 | 34,940 |
| 3 | 33,880 | 34,140 | 34,140 | 33,840 | 34,140 | 35,180 | 35,180 | 34,880 | 35,140 |
| 4 | 33,850 | 34,110 | 34,110 | 33,810 | 34,110 | 35,150 | 35,150 | 34,850 | 35,110 |
| 5 | 34,070 | 34,310 | 34,310 | 34,010 | 34,310 | 35,370 | 35,370 | 35,070 | 35,310 |
| 6 | 34,040 | 34,280 | 34,280 | 33,980 | 34,280 | 35,340 | 35,340 | 35,040 | 35,280 |
| 7 | 34,250 | 34,480 | 34,480 | 34,180 | 34,480 | 35,560 | 35,560 | 35,260 | 35,480 |
| 8 | 34,230 | 34,450 | 34,450 | 34,150 | 34,450 | 35,530 | 35,530 | 35,230 | 35,450 |
| 9 | 34,420 | 34,650 | 34,650 | 34,350 | 34,650 | 35,750 | 35,750 | 35,420 | 35,650 |
| 10 | 34,400 | 34,620 | 34,620 | 34,320 | 34,620 | 35,730 | 35,730 | 35,400 | 35,620 |
| 11 | 34,520 | 34,780 | 34,780 | 34,450 | 34,780 | 35,860 | 35,860 | 35,520 | 35,790 |
| 12 | 34,580 | 34,860 | 34,880 | 34,520 | 34,860 | 35,920 | 35,920 | 35,580 | 35,880 |
| 13 | 34,660 | 34,960 | 34,980 | 34,580 | 34,960 | 35,960 | 35,960 | 35,620 | 35,940 |
| 14 | 34,620 | 34,920 | 34,940 | 34,580 | 34,920 | 35,920 | 35,920 | 35,580 | 35,880 |
| 15 | 34,620 | 34,920 | 34,940 | 34,580 | 34,920 | 35,920 | 35,920 | 35,580 | 35,880 |
| 16 | 34,640 | 34,960 | 34,980 | 34,620 | 34,960 | 35,980 | 35,980 | 35,640 | 35,980 |
| 17 | 34,660 | 35,000 | 35,010 | 34,640 | 35,000 | 36,020 | 36,020 | 35,660 | 35,980 |
| 18 | 34,660 | 34,960 | 34,980 | 34,620 | 34,960 | 35,980 | 35,980 | 35,660 | 35,980 |
| 19 | 34,660 | 34,960 | 34,980 | 34,620 | 34,960 | 35,980 | 35,980 | 35,660 | 35,980 |
| 20 | 34,660 | 34,960 | 34,980 | 34,620 | 34,960 | 35,980 | 35,980 | 35,660 | 35,980 |

Измерение Σ геометрическое D_1 , номинальное

Продолжение табл. 2

| Размеры в мм | | Карбиды титана | | Карбиды циркония | | Карбиды титана | |
|--------------------|-------------|----------------|-------------|------------------|-------------|----------------|-------------|
| О.0394-0.016 | 2400-0.061; | 2400-0.076; | 2400-1.061; | 2400-0.085; | 2400-0.098; | 2400-1.073; | 2400-0.031; |
| п.0914-0.008 | 2400-0.022; | 2400-0.084 | 2400-1.032 | 2400-0.026; | 2400-0.088 | 2400-1.094 | 2400-0.032; |
| Диаметр свертки | 34,6347 | 35,077 | 35,418 | 35,49 | 34,6647 | 35,117 | 35,148 |
| Числовых | 21 | 34,675 | 35,000 | 35,020 | 35,035 | 34,660 | 36,030 |
| 22 | | | | | | | |
| 23 | 34,685 | 35,015 | 35,030 | 35,052 | 34,675 | 36,039 | 36,062 |
| 24 | | | | | | | |
| 25 | 35,025 | 35,039 | 35,062 | 35,085 | | | |
| 26 | | | | | | | |
| 27 | 34,685 | | | | 36,025 | 36,039 | 36,062 |
| 28 | | | | | | | |
| 29 | 35,025 | 35,039 | 35,062 | 34,685 | | | |
| 30 | | | | | | | |
| 31 | | | | | | | |
| 32 | | | | | | | |
| 33 | | | | | | | |
| 34 | | | | | | | |
| 35 | | | | | | | |
| 36 | | | | | | | |
| 37 | | | | | | | |
| 38 | | | | | | | |
| 39 | | | | | | | |
| 40 | | | | | | | |

Продолжение табл. 2

| | | Размеры в мм | | | | | | | |
|---------------------|--------------------|--------------|------------|------------|------------|------------|------------|------------|------------|
| Обозначение профиля | Диаметр спиральной | 2400-0399: | 2400-1037: | 2400-1089: | 2400-1091: | 2400-1095: | 2400-0301: | 2400-1091: | 2400-0303: |
| | | 2400-0388 | 2400-0302 | 2400-1088 | 2400-1093 | 2400-1095 | 2400-0370 | 2400-1097 | 2400-0364 |
| 1 | 34,970 | 34,670 | 35,990 | 35,990 | 35,970 | 35,970 | 36,990 | 36,990 | 36,990 |
| 2 | 34,940 | 34,640 | 35,960 | 35,960 | 35,940 | 35,940 | 36,960 | 36,960 | 36,960 |
| 3 | 35,140 | 34,840 | 36,180 | 36,180 | 36,140 | 36,140 | 37,180 | 37,180 | 36,880 |
| 4 | 35,110 | 34,810 | 36,150 | 36,150 | 36,110 | 36,110 | 37,150 | 37,150 | 36,850 |
| 5 | 35,310 | 35,010 | 36,370 | 36,370 | 36,310 | 36,310 | 37,370 | 37,370 | 37,110 |
| 6 | 35,280 | 34,980 | 36,340 | 36,340 | 36,280 | 36,280 | 37,340 | 37,340 | 37,310 |
| 7 | 35,480 | 35,180 | 36,560 | 36,560 | 36,480 | 36,480 | 37,560 | 37,560 | 37,280 |
| 8 | 35,450 | 35,150 | 36,530 | 36,530 | 36,450 | 36,450 | 37,530 | 37,530 | 37,040 |
| 9 | 35,650 | 35,350 | 36,750 | 36,750 | 36,650 | 36,650 | 37,750 | 37,750 | 37,420 |
| 10 | 35,620 | 35,320 | 36,730 | 36,730 | 36,620 | 36,620 | 37,730 | 37,730 | 37,400 |
| 11 | 35,790 | 35,450 | 36,860 | 36,860 | 36,780 | 36,780 | 37,860 | 37,860 | 37,620 |
| 12 | 35,770 | 35,430 | 36,860 | 36,860 | 36,770 | 36,770 | 37,860 | 37,860 | 37,590 |
| 13 | 35,880 | 35,520 | 36,920 | 36,920 | 36,880 | 36,880 | 37,920 | 37,920 | 37,590 |
| 14 | | | | | | | | | |
| 15 | 35,940 | 35,580 | 36,960 | 36,960 | 36,920 | 36,920 | 37,960 | 37,960 | 37,960 |
| 16 | | | | | | | | | |
| 17 | 35,980 | 35,620 | 36,980 | 37,000 | 36,960 | 36,980 | 37,980 | 38,000 | 38,000 |
| 18 | | | | | | | | | |
| 19 | 36,010 | 35,640 | 37,000 | 37,030 | 36,980 | 37,010 | 38,000 | 38,020 | 38,020 |
| 20 | | | | | | | | | |

Измерение в дюймах, дюймы в миллиметрах

Продолжение табл. 2

| | | Размеры в мм | | | | | | | | | |
|----------------------|---------------------|---------------------|-----------|---------------------|-----------|---------------------|-----------|---------------------|-----------|---------------------|-----------|
| Обозначение профилей | 2400-0091-2460-0236 | 2400-1067-2400-1088 | | 2400-1092-2400-1093 | | 2400-1094-2400-1095 | | 2400-1096-2400-1097 | | 2400-0103-2400-0304 | |
| | | 2400-0091 | 2460-0236 | 2400-1067 | 2400-1088 | 2400-1092 | 2400-1093 | 2400-1094 | 2400-1095 | 2400-1096 | 2400-1097 |
| Диаметр отверстия | 36,079 | 35,697 | 37,177 | 37,199 | 37,177 | 37,179 | 37,179 | 38,077 | 38,078 | 38,079 | 37,6647 |
| Номер | 21 | 36,035 | 35,660 | 37,015 | 37,052 | 37,000 | 37,035 | 38,015 | 38,030 | 38,052 | 37,675 |
| | 22 | | | | | | | | | | 38,000 |
| | 23 | 36,052 | 35,675 | 37,025 | 37,062 | 37,015 | 37,052 | 38,025 | 38,039 | 38,062 | 37,695 |
| | 24 | | | | | | | | | | 38,015 |
| | 25 | 36,062 | 35,685 | | | 37,025 | 37,062 | | | | 38,025 |
| | 26 | | | | | | | | | | |
| | 27 | | | | | | | | | | |
| | 28 | | | | | | | | | | |
| | 29 | 36,062 | 35,685 | | | 37,025 | 37,062 | | | | 38,025 |
| | 30 | | | | | | | | | | |
| | 31 | | | | | | | | | | |
| | 32 | | | | | | | | | | |
| | 33 | | | | | | | | | | |
| | 34 | | | | | | | | | | |
| | 35 | | | | | | | | | | |
| | 36 | | | | | | | | | | |
| | 37 | | | | | | | | | | |
| | 38 | | | | | | | | | | |
| | 39 | | | | | | | | | | |
| | 40 | | | | | | | | | | |

Диаметр отверстия D, мм

Продолжение табл. 2

| Размеры в мм | | | | | | | | | |
|---------------------|--------|-------------------------|----------|-------------------------|--------|-------------------------|---------|-------------------------|---------|
| Основные размеры | | 2400-1098; 2400-1059 | | 2400-0308; 2400-0310 | | 2400-0311; 2400-0312 | | 2400-1110; 2400-1114 | |
| Диаметр стопорки | 38,498 | 38,679 | 37,664H7 | 40H7 | 40f8 | 40H9 | 39,66H7 | 40H7 | 39,66H9 |
| 1 | 36,970 | 37,970 | 35,670 | 35,670 | 39,000 | 39,000 | 38,700 | 38,940 | 38,940 |
| 2 | 36,940 | 36,940 | 36,640 | 36,640 | 38,970 | 38,970 | 38,670 | 38,910 | 38,910 |
| 3 | 37,140 | 37,140 | 36,840 | 36,840 | 39,200 | 39,200 | 38,900 | 39,080 | 39,080 |
| 4 | 37,110 | 37,110 | 36,810 | 36,810 | 39,170 | 39,170 | 38,870 | 39,050 | 39,050 |
| 5 | 37,310 | 37,310 | 37,010 | 37,010 | 39,400 | 39,400 | 39,100 | 39,220 | 39,220 |
| 6 | 37,280 | 37,280 | 36,980 | 36,980 | 39,370 | 39,370 | 39,070 | 39,190 | 39,190 |
| 7 | 37,480 | 37,480 | 37,180 | 37,180 | 36,600 | 36,600 | 39,600 | 39,360 | 39,360 |
| 8 | 37,450 | 37,450 | 37,150 | 37,150 | 39,570 | 39,570 | 39,270 | 39,330 | 39,330 |
| 9 | 37,650 | 37,650 | 37,350 | 37,350 | 39,770 | 39,780 | 39,440 | 39,500 | 39,500 |
| 10 | 37,620 | 37,620 | 37,320 | 37,320 | 39,750 | 39,760 | 39,420 | 39,470 | 39,470 |
| 11 | 37,790 | 37,790 | 37,450 | 37,450 | 39,860 | 39,870 | 39,520 | 39,640 | 39,640 |
| 12 | 37,770 | 37,770 | 37,430 | 37,430 | 39,880 | 39,880 | 39,520 | 39,610 | 39,610 |
| 13 | 37,880 | 37,880 | 37,520 | 37,520 | 39,920 | 39,930 | 39,580 | 39,780 | 39,780 |
| 14 | | | | | | | | 39,760 | 39,760 |
| 15 | 37,940 | 37,940 | 37,580 | 37,580 | 39,960 | 39,970 | 39,620 | 39,860 | 39,860 |
| 16 | | | | | | | | 39,870 | 39,870 |
| 17 | 37,980 | 37,980 | 37,620 | 37,620 | 39,980 | 40,000 | 40,010 | 39,920 | 39,920 |
| 18 | | | | | | | | 39,930 | 39,930 |
| 19 | 38,000 | 38,010 | 37,640 | 40,000 | 40,020 | 40,035 | 39,660 | 39,970 | 39,970 |
| 20 | | | | | | | | 39,960 | 39,960 |

Диаметр с翼ка D1, мм

Продолжение табл. 2

| | | Размеры в мм | | | | | | | | | | | |
|-------------------|-------------------|--------------|------------|------------|------------|------------|------------|------------|------------|------------|------------|------------|------------|
| | | Канавки | | | | | Гнезда | | | | | | |
| | | Канавки | | Гнезда | | | Канавки | | Гнезда | | | | |
| Обозначение | Единица измерения | 2400-1095; | 2400-0308; | 2400-0311; | 2400-0314; | 2400-1101; | 2400-0315; | 2400-0317; | 2400-0319; | 2400-1103; | 2400-1104; | 2400-0321; | 2400-0323; |
| | | 2400-1099 | 2400-0310 | 2400-0312 | 2400-0314 | 2400-1102 | 2400-0316 | 2400-0318 | 2400-0320 | 2400-1104 | 2400-0322 | 2400-0324 | |
| Диаметр отверстия | мм | 38,078 | 38,049 | 37,657 | 40,077 | 40,078 | 40,079 | 39,5677 | 40,077 | 40,078 | 40,079 | 39,5677 | |
| 21 | 38,020 | 38,035 | 37,660 | 40,015 | 40,030 | 40,052 | 39,675 | 39,580 | 40,000 | 40,000 | 40,000 | 39,640 | |
| 22 | | | | | | | | | | | | | |
| 23 | 38,030 | 38,052 | 37,675 | 40,025 | 40,039 | 40,062 | 39,685 | 40,000 | 40,020 | 40,030 | 40,030 | 39,660 | |
| 24 | | | | | | | | | | | | | |
| 25 | 38,039 | 38,062 | 37,685 | | | | | | 40,015 | 40,030 | 40,052 | 39,675 | |
| 26 | | | | | | | | | | | | | |
| 27 | | | | | | | | | | | | | |
| 28 | | | | | | | | | | | | | |
| 29 | 38,039 | 38,062 | 38,685 | | | | | | 40,025 | 40,039 | 40,062 | 39,685 | |
| 30 | | | | | | | | | | | | | |
| 31 | | | | | | | | | | | | | |
| 32 | | | | | | | | | | | | | |
| 33 | | | | | | | | | | | | | |
| 34 | | | | | | | | | | | | | |
| 35 | | | | | | | | | | | | | |
| 36 | | | | | | | | | | | | | |
| 37 | | | | | | | | | | | | | |
| 38 | | | | | | | | | | | | | |
| 39 | | | | | | | | | | | | | |
| 40 | | | | | | | | | | | | | |

Диаметр отверстия D, мм

Продолжение табл. 2

| Диаметр отверстия | Размеры в мм | | | | | | | | | |
|-------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|
| | 4200-0325; 2400-0326 | 2400-1165; 2400-1105 | 2400-0327; 2400-0328 | 2400-0329; 2400-0330 | 2400-0331; 2400-0332 | 2400-1107; 2400-1108 | 2400-0333; 2400-0334 | 2400-0335; 2400-0336 | 2400-0337; 2400-0338 | 2400-0339; 2400-0340 |
| 1 | 40,880 | 40,880 | 40,880 | 40,880 | 40,910 | 40,910 | 40,910 | 40,910 | 43,880 | 43,880 |
| 2 | 40,850 | 40,850 | 40,850 | 40,850 | 40,880 | 40,880 | 40,880 | 40,880 | 43,850 | 43,850 |
| 3 | 41,060 | 41,060 | 41,060 | 41,060 | 41,120 | 41,120 | 41,120 | 41,120 | 44,060 | 44,060 |
| 4 | 41,030 | 41,030 | 41,030 | 41,030 | 41,090 | 41,090 | 41,090 | 41,090 | 44,030 | 44,030 |
| 5 | 41,240 | 41,240 | 41,240 | 41,240 | 40,940 | 41,330 | 41,330 | 41,330 | 44,240 | 44,240 |
| 6 | 41,210 | 41,210 | 41,210 | 41,210 | 40,910 | 41,300 | 41,300 | 41,300 | 44,210 | 44,210 |
| 7 | 41,420 | 41,420 | 41,420 | 41,420 | 41,120 | 41,540 | 41,540 | 41,540 | 44,420 | 44,420 |
| 8 | 41,390 | 41,390 | 41,390 | 41,390 | 41,090 | 41,510 | 41,510 | 41,510 | 44,390 | 44,390 |
| 9 | 41,600 | 41,600 | 41,600 ¹³ | 41,600 ¹³ | 41,300 | 41,750 | 41,750 | 41,750 | 44,600 | 44,600 |
| 10 | 41,570 | 41,570 | 41,570 | 41,570 | 41,270 | 41,730 | 41,730 | 41,730 | 44,570 | 44,570 |
| 11 | 41,770 | 41,770 | 41,780 | 41,780 | 41,440 | 41,850 | 41,850 | 41,850 | 44,770 | 44,780 |
| 12 | 41,750 | 41,750 | 41,750 | 41,750 | 41,420 | 41,910 | 41,910 | 41,910 | 44,750 | 44,760 |
| 13 | 41,860 | 41,870 | 41,880 | 41,880 | 41,520 | 41,910 | 41,910 | 41,910 | 44,870 | 44,880 |
| 14 | | | | | | | | | | |
| 15 | 41,920 | 41,930 | 41,940 | 41,940 | 41,580 | 41,950 | 41,950 | 41,950 | 44,940 | 44,940 |
| 16 | | | | | | | | | | |
| 17 | 41,960 | 41,970 | 41,980 | 41,980 | 41,620 | 41,990 | 41,990 | 41,990 | 44,970 | 44,980 |
| 18 | | | | | | | | | | |
| 19 | 41,980 | 42,000 | 42,010 | 42,010 | 42,000 | 42,010 | 42,030 | 41,660 | 44,980 | 45,010 |
| 20 | | | | | | | | | | |

Диаметр отверстия D_1 , номинальный

Продолжение табл. 2

| | | Размеры в мм | | | | | | | |
|---------------------------|--------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|
| Одностороннее протяжка | | 2400-1108; 2400-0336 | 2400-0327; 2400-0338 | 2400-0329; 2400-0330 | 2400-1107; 2400-1108 | 2400-0338; 2400-0334 | 2400-0335; 2400-0331 | 2400-1108; 2400-0336 | 2400-0337; 2400-0340 |
| Диаметр стержня | | 42Н7 | 42Н6 | 41,69Н7 | 42Н7 | 42Н8 | 42Н9 | 41,69Н7 | 45Н7 |
| 21 | 42,000 | 42,020 | 42,035 | 41,660 | 42,015 | 42,030 | 42,052 | 41,675 | 45,000 |
| 22 | | | | | | | | | 45,020 |
| 23 | 42,015 | 42,030 | 42,052 | 41,675 | 42,025 | 42,039 | 42,062 | 41,685 | 45,015 |
| 24 | | | | | | | | | 45,030 |
| 25 | 42,025 | 42,039 | 42,052 | 41,685 | | | | | 45,052 |
| 26 | | | | | | | | | |
| 27 | | | | | 42,025 | 42,039 | 42,062 | 41,685 | |
| 28 | | | | | | | | | |
| 29 | 42,025 | 42,039 | 42,052 | 41,685 | | | | | |
| 30 | | | | | | | | | |
| 31 | | | | | | | | | |
| 32 | | | | | | | | | |
| 33 | | | | | | | | | |
| 34 | | | | | | | | | |
| 35 | | | | | | | | | |
| 36 | | | | | | | | | |
| 37 | | | | | | | | | |
| 38 | | | | | | | | | |
| 39 | | | | | | | | | |
| 40 | | | | | | | | | |

Продолжение табл. 2

| Размеры в мм | | | | | | | | | |
|-------------------------|--------|--------------------------|--------|--------------------------|---------|--------------------------|--------|--------------------------|--------|
| Обозначение протяжек | | 2400-0341; 2400-0342; | | 2400-0345; 2400-0346; | | 2400-0347; 2400-0348; | | 2400-1114; 2400-1115; | |
| Диаметр стяжек | | 44,68H7 | 45H8 | 45/19 | 44,68H7 | 47H7 | 47H9 | 47H7 | 48H7 |
| 1 | 43,580 | 43,910 | 43,910 | 43,610 | 45,880 | 45,880 | 45,910 | 45,910 | 46,880 |
| 2 | 43,550 | 43,880 | 43,880 | 43,580 | 45,850 | 45,850 | 45,880 | 45,880 | 46,850 |
| 3 | 43,760 | 44,120 | 44,120 | 44,120 | 46,060 | 46,060 | 46,120 | 46,120 | 47,060 |
| 4 | 43,730 | 44,090 | 44,090 | 44,090 | 46,030 | 46,030 | 46,090 | 46,090 | 47,030 |
| 5 | 43,940 | 44,330 | 44,330 | 44,330 | 46,240 | 46,240 | 46,330 | 46,330 | 47,240 |
| 6 | 43,910 | 44,300 | 44,300 | 44,300 | 46,210 | 46,210 | 46,300 | 46,300 | 47,210 |
| 7 | 44,120 | 44,540 | 44,540 | 44,540 | 46,420 | 46,420 | 46,540 | 46,540 | 47,420 |
| 8 | 44,090 | 44,510 | 44,510 | 44,510 | 46,390 | 46,390 | 46,510 | 46,510 | 47,390 |
| 9 | 44,300 | 44,750 | 44,750 | 44,750 | 46,600 | 46,600 | 46,750 | 46,750 | 47,600 |
| 10 | 44,270 | 44,730 | 44,730 | 44,730 | 46,570 | 46,570 | 46,730 | 46,730 | 47,570 |
| 11 | 44,440 | 44,850 | 44,850 | 44,850 | 46,770 | 46,770 | 46,850 | 46,850 | 47,770 |
| 12 | 44,420 | | | | 45,750 | 45,750 | 46,780 | 46,780 | 47,750 |
| 13 | 44,520 | 44,910 | 44,910 | 44,910 | 46,880 | 46,880 | 46,910 | 46,910 | 47,860 |
| 14 | | | | | | | | | |
| 15 | 44,580 | 44,950 | 44,950 | 44,950 | 44,620 | 44,620 | 46,940 | 46,940 | 47,920 |
| 16 | | | | | | | | | |
| 17 | 44,620 | 44,980 | 44,980 | 44,980 | 44,640 | 44,640 | 46,980 | 46,980 | 47,960 |
| 18 | | | | | | | | | |
| 19 | 44,640 | 45,000 | 45,010 | 45,030 | 44,680 | 44,680 | 47,010 | 47,010 | 47,980 |
| 20 | | | | | | | | | |

Продолжение табл. 2

| | | Размеры в мм | | | | | | | |
|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|
| Обозначение протяжек | 2400-0341; 2400-0342 | 2400-0332; 2400-0344 | 2400-1112; 2400-1113 | 2400-0345; 2400-0345 | 2400-1114; 2400-1115 | 2400-1116; 2400-1117 | 2400-1118; 2400-1119 | 2400-1121; 2400-1122 | 2400-1123; 2400-1124 |
| Диаметр стержня | 44,6617 | 45,677 | 45,678 | 45,679 | 44,6617 | 47,677 | 47,679 | 47,677 | 48,678 |
| 21 | 44,660 | 45,015 | 45,030 | 45,052 | 44,675 | 47,000 | 47,035 | 47,015 | 47,052 |
| 22 | | | | | | | | | 48,020 |
| 23 | 44,675 | 45,025 | 45,039 | 45,062 | 44,685 | 47,015 | 47,052 | 47,025 | 48,030 |
| 24 | | | | | | | | | |
| 25 | 44,685 | | | | | 47,025 | 47,062 | | |
| 26 | | 45,025 | 45,039 | 45,062 | 44,685 | | | | |
| 27 | | | | | | | | 47,025 | 48,039 |
| 28 | | | | | | | | | |
| 29 | 44,685 | | | | | 47,025 | 47,062 | | |
| 30 | | | | | | | | | |
| 31 | | | | | | | | | |
| 32 | | | | | | | | | |
| 33 | | | | | | | | | |
| 34 | | | | | | | | | |
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| 40 | | | | | | | | | |

Диаметр стержня D_1 в миллиметрах

Продолжение табл. 2

Размеры в мм

| Обозначение прогрежек | 2400-0351; | | 2400-0353; | | 2400-0355; | | 2400-0357; | | 2400-0359; | | 2400-0361; | | 2400-0363; | | 2400-0365; | | |
|--------------------------|------------|-----------|------------|-----------|------------|-----------|------------|-----------|------------|-----------|------------|-----------|------------|-----------|------------|-----------|-------|
| | 2400-0352 | 2400-0354 | 2400-0356 | 2400-0358 | 2400-0360 | 2400-0362 | 2400-0364 | 2400-0366 | 2400-0368 | 2400-0370 | 2400-0372 | 2400-0374 | 2400-0376 | 2400-0378 | 2400-0380 | 2400-0382 | |
| Диаметр отверстия | 43H9 | 41 | 47,66H7 | 48H7 | 48H9 | 49H9 | 47,56H7 | 50H7 | 50H9 | 50H10 | 50H11 | 50H12 | 50H13 | 50H14 | 50H15 | 50H16 | 50H17 |
| 1 | 46,880 | 46,580 | 46,910 | 46,910 | 46,910 | 46,610 | 46,610 | 46,880 | 46,880 | 46,880 | 46,880 | 46,880 | 46,880 | 46,880 | 46,880 | 46,880 | |
| 2 | 46,850 | 46,550 | 46,880 | 46,880 | 46,880 | 46,580 | 46,580 | 46,840 | 46,840 | 46,840 | 46,840 | 46,840 | 46,840 | 46,840 | 46,840 | 46,840 | |
| 3 | 47,060 | 46,760 | 47,120 | 47,120 | 47,120 | 46,820 | 46,820 | 49,060 | 49,060 | 49,060 | 49,060 | 49,060 | 49,060 | 49,060 | 49,060 | 49,060 | |
| 4 | 47,030 | 46,730 | 47,090 | 47,090 | 47,090 | 46,790 | 46,790 | 49,020 | 49,020 | 49,020 | 49,020 | 49,020 | 49,020 | 49,020 | 49,020 | 49,020 | |
| 5 | 47,240 | 46,940 | 47,330 | 47,330 | 47,330 | 47,330 | 47,330 | 49,240 | 49,240 | 49,240 | 49,240 | 49,240 | 49,240 | 49,240 | 49,240 | 49,240 | |
| 6 | 47,210 | 46,910 | 47,300 | 47,300 | 47,300 | 47,300 | 47,300 | 49,200 | 49,200 | 49,200 | 49,200 | 49,200 | 49,200 | 49,200 | 49,200 | 49,200 | |
| 7 | 47,420 | 47,120 | 47,540 | 47,540 | 47,540 | 47,240 | 47,240 | 49,420 | 49,420 | 49,420 | 49,420 | 49,420 | 49,420 | 49,420 | 49,420 | 49,420 | |
| 8 | 47,350 | 47,090 | 47,510 | 47,510 | 47,510 | 47,210 | 47,210 | 49,380 | 49,380 | 49,380 | 49,380 | 49,380 | 49,380 | 49,380 | 49,380 | 49,380 | |
| 9 | 47,600 | 47,300 | 47,750 | 47,750 | 47,750 | 47,420 | 47,420 | 49,600 | 49,600 | 49,600 | 49,600 | 49,600 | 49,600 | 49,600 | 49,600 | 49,600 | |
| 10 | 47,570 | 47,270 | 47,730 | 47,730 | 47,730 | 47,400 | 47,400 | 49,560 | 49,560 | 49,560 | 49,560 | 49,560 | 49,560 | 49,560 | 49,560 | 49,560 | |
| 11 | 47,780 | 47,420 | 47,850 | 47,850 | 47,850 | 47,520 | 47,520 | 49,770 | 49,770 | 49,770 | 49,770 | 49,770 | 49,770 | 49,770 | 49,770 | 49,770 | |
| 12 | 47,760 | 47,400 | 47,910 | 47,910 | 47,910 | 47,580 | 47,580 | 49,860 | 49,860 | 49,860 | 49,860 | 49,860 | 49,860 | 49,860 | 49,860 | 49,860 | |
| 13 | 47,880 | 47,520 | 47,910 | 47,910 | 47,910 | 47,910 | 47,910 | 49,870 | 49,870 | 49,870 | 49,870 | 49,870 | 49,870 | 49,870 | 49,870 | 49,870 | |
| 14 | | | | | | | | | | | | | | | | | |
| 15 | | | | | | | | | | | | | | | | | |
| 16 | 47,940 | 47,580 | 47,950 | 47,950 | 47,950 | 47,620 | 47,620 | 49,920 | 49,920 | 49,920 | 49,920 | 49,920 | 49,920 | 49,920 | 49,920 | 49,920 | |
| 17 | | | | | | | | | | | | | | | | | |
| 18 | | | | | | | | | | | | | | | | | |
| 19 | | | | | | | | | | | | | | | | | |
| 20 | 48,010 | 47,640 | 48,000 | 48,010 | 48,030 | 47,660 | 47,660 | 49,960 | 49,960 | 49,960 | 49,960 | 49,960 | 49,960 | 49,960 | 49,960 | 49,960 | |

Диаметр зигзагов D_1 , мм

Продолжение табл. 2

| Размеры в мм | | | | | | | | | |
|----------------------|---------|------------|------------|------------|------------|------------|------------|------------|------------|
| Обозначение проекции | | 2400-0351; | 2400-0353; | 2400-0355; | 2400-0356; | 2400-0357; | 2400-0359; | 2400-0361; | 2400-0363; |
| диаметр отверстия | | 2400-1125; | 2400-1126; | 2400-1127; | 2400-1128; | 2400-1129; | 2400-1130; | 2400-1131; | 2400-1132; |
| 48/19 | 47,66H7 | 48H8 | 48/19 | 47,66H7 | 48H8 | 47,66H7 | 48H8 | 50H9 | 49,66H7 |
| 21 | 48,035 | 47,660 | 48,015 | 48,030 | 48,052 | 47,675 | 50,000 | 50,020 | 50,035 |
| 22 | | | | | | | | | |
| 23 | 48,052 | 47,675 | 48,025 | 48,039 | 48,062 | 47,685 | 50,015 | 50,030 | 50,052 |
| 24 | | | | | | | | | |
| 25 | 48,062 | 47,685 | | | | | 50,025 | 50,039 | 50,062 |
| 26 | | | | | | | | | |
| 27 | | | | 48,025 | 48,039 | 48,062 | 47,685 | | |
| 28 | | | | | | | | | |
| 29 | 48,062 | 47,685 | | | | | | | |
| 30 | | | | | | | | | |
| 31 | | | | | | | | | |
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| 38 | | | | | | | | | |
| 39 | | | | | | | | | |
| 40 | | | | | | | | | |

Продолжение табл. 2

| Размеры в мм | | | | | | | | | | |
|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|--------|
| Обозначение протяжек | 2400-1129; 2400-1131 | 2400-0369; 2400-0370 | 2400-0371; 2400-0372 | 2400-1132; 2400-1133 | 2400-0375; 2400-0376 | 2400-0377; 2400-0378 | 2400-0379; 2400-0380 | 2400-1134; 2400-1135 | 2400-0381; 2400-0384 | |
| | 50 H8 | 50 H9 | 49,66 H7 | 52 H7 | 52 H8 | 52 H9 | 51,61 H7 | 52 H7 | 52 H8 | 52 H9 |
| Диаметр отверстия | | | | | | | | | | |
| 1 | 48,910 | 48,910 | 48,610 | 50,800 | 50,800 | 50,400 | 50,810 | 50,810 | 50,810 | 50,410 |
| 2 | 48,870 | 48,870 | 48,570 | 50,760 | 50,760 | 50,360 | 50,770 | 50,770 | 50,770 | 50,370 |
| 3 | 49,120 | 49,120 | 48,820 | 51,000 | 51,000 | 50,600 | 51,020 | 51,020 | 51,020 | 50,620 |
| 4 | 49,080 | 49,080 | 48,780 | 50,960 | 50,960 | 50,560 | 50,980 | 50,980 | 50,980 | 50,580 |
| 5 | 49,330 | 49,330 | 49,030 | 51,200 | 51,200 | 50,800 | 51,230 | 51,230 | 51,230 | 50,830 |
| 6 | 49,290 | 49,290 | 48,990 | 51,160 | 51,160 | 50,760 | 51,190 | 51,190 | 51,190 | 50,790 |
| 7 | 49,540 | 49,540 | 49,240 | 51,400 | 51,400 | 51,000 | 51,440 | 51,440 | 51,440 | 51,040 |
| 8 | 49,500 | 49,500 | 49,200 | 51,360 | 51,360 | 50,960 | 51,400 | 51,400 | 51,400 | 51,000 |
| 9 | 49,750 | 49,750 | 49,430 | 51,600 | 51,600 | 51,200 | 51,650 | 51,650 | 51,650 | 51,250 |
| 10 | 49,730 | 49,730 | 49,410 | 51,560 | 51,560 | 51,160 | 51,610 | 51,610 | 51,610 | 51,210 |
| 11 | 49,850 | 49,850 | 49,520 | 51,780 | 51,780 | 51,380 | 51,790 | 51,790 | 51,790 | 51,390 |
| 12 | 49,910 | 49,910 | 49,580 | 51,870 | 51,870 | 51,470 | 51,870 | 51,880 | 51,890 | 51,470 |
| 13 | 49,910 | 49,910 | 49,620 | 51,760 | 51,760 | 51,360 | 51,770 | 51,780 | 51,780 | 51,370 |
| 14 | 49,950 | 49,950 | 49,660 | 51,930 | 51,930 | 51,340 | 51,530 | 51,530 | 51,530 | 51,530 |
| 15 | 49,950 | 49,950 | 49,660 | 51,970 | 51,970 | 51,980 | 51,570 | 51,570 | 51,570 | 51,570 |
| 16 | 49,990 | 49,990 | 49,640 | 51,970 | 51,970 | 51,980 | 51,970 | 51,980 | 51,990 | 51,590 |
| 17 | 50,010 | 50,030 | 49,660 | 51,990 | 52,000 | 52,010 | 51,590 | 51,590 | 52,000 | 51,590 |

Продолжение табл. 2

| | | Размеры в мм | | | | | | | |
|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-----------|
| Обозначение протяжек | 2400-1129; 2403-1131 | 2400-0371; 2403-0372 | 2400-0373; 2403-0374 | 2400-1122; 2400-1133 | 2400-0375; 2400-0376 | 2400-0379; 2400-0378 | 2400-1134; 2400-1135 | 2400-0383; 2400-0394 | 2400-0382 |
| | | 50/76 | 50/79 | 49,6/77 | 52/77 | 52/78 | 51,6/77 | 52/77 | 52/78 |
| Диаметр шпильки | | | | | | | | | |
| 21 | 50,030 | 50,052 | 49,675 | 52,010 | 52,020 | 52,040 | 51,610 | 52,010 | 52,045 |
| 22 | | | | | | | | | |
| 23 | 50,039 | 50,062 | 49,685 | 52,020 | 52,036 | 52,064 | 51,620 | 52,020 | 52,064 |
| 24 | | | | | | | | | |
| 25 | | | | 52,030 | 52,046 | 52,074 | 51,630 | 52,030 | 52,046 |
| 26 | | | | | | | | | |
| 27 | 50,039 | 50,062 | 49,685 | | | | | | |
| 28 | | | | | | | | | |
| 29 | | | | | 52,030 | 52,046 | 52,074 | 51,630 | 52,030 |
| 30 | | | | | | | | | |
| 31 | | | | | | | | | |
| 32 | | | | | | | | | |
| 33 | | | | | | | | | |
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| 40 | | | | | | | | | |

Продолжение табл. 2

| Обозначение протяжек | | Размеры в мм | | | | | |
|-------------------------|-------|--------------|-------|-------|-------|--------|-------|
| Диаметр стопорки | 53H7 | 53H8 | 53H9 | 53H7 | 53H8 | 53H9 | 53H7 |
| 1 | 51,80 | 51,800 | 51,80 | 51,40 | 51,81 | 51,810 | 51,41 |
| 2 | 51,76 | 51,760 | 51,76 | 51,36 | 51,77 | 51,770 | 51,37 |
| 3 | 52,00 | 52,000 | 52,00 | 51,60 | 52,02 | 52,020 | 51,62 |
| 4 | 51,96 | 51,960 | 51,96 | 51,56 | 51,98 | 51,980 | 51,58 |
| 5 | 52,20 | 52,200 | 52,20 | 51,80 | 52,23 | 52,230 | 51,83 |
| 6 | 52,16 | 52,160 | 52,16 | 51,76 | 52,19 | 52,190 | 51,79 |
| 7 | 52,40 | 52,400 | 52,40 | 52,00 | 52,41 | 52,440 | 52,04 |
| 8 | 52,36 | 52,360 | 52,36 | 51,96 | 52,40 | 52,400 | 52,00 |
| 9 | 52,60 | 52,600 | 52,60 | 52,20 | 52,65 | 52,650 | 52,25 |
| 10 | 52,56 | 52,560 | 52,56 | 52,17 | 52,61 | 52,610 | 52,21 |
| 11 | 52,78 | 52,780 | 52,78 | 52,38 | 52,79 | 52,800 | 52,39 |
| 12 | 52,76 | 52,760 | 52,76 | 52,36 | 52,77 | 52,780 | 52,37 |
| 13 | 52,87 | 52,870 | 52,88 | 52,47 | 52,87 | 52,880 | 52,47 |
| 14 | | | | | | | |
| 15 | | | | | | | |
| 16 | 52,93 | 52,930 | 52,94 | 52,63 | 52,93 | 52,940 | 52,65 |
| 17 | 52,97 | 52,970 | 52,98 | 52,57 | 52,97 | 52,980 | 52,57 |
| 18 | 52,99 | 53,000 | 53,01 | 52,59 | 52,99 | 53,000 | 53,02 |
| 19 | | | | | | | |
| 20 | | | | | | | |

Диаметры залегающих D_1 и D_2 отверстий

Продолжение табл. 2

| Обозначение протяжек | | 2400-1135; 2400-1137 | | 2400-1145; 2400-1139 | | 2400-1145; 2400-1142 | | 2400-1145; 2400-1144 | | 2400-1145; 2400-1148 | | 2400-1149; 2400-1151 | | 2400-1152; 2400-1153 | | 2400-1155; | | |
|-------------------------|-------|-------------------------|--------|-------------------------|-------|-------------------------|--------|-------------------------|-------|-------------------------|--------|-------------------------|-------|-------------------------|--------|------------|-------|--------|
| Диаметр отверстия | | 53H7 | | 53H9 | | 53H7 | | 53H7 | | 53H8 | | 53H9 | | 53H7 | | 53H8 | | |
| 21 | 53,01 | 53,020 | 53,04 | 52,61 | 53,01 | 53,020 | 53,045 | 52,61 | 53,01 | 53,020 | 53,045 | 52,61 | 53,01 | 53,020 | 53,045 | 52,61 | 53,01 | |
| 22 | | | | | | | | | | | | | | | | | | |
| 23 | 53,02 | 53,036 | 53,064 | 52,62 | 53,02 | 53,036 | 53,064 | 52,62 | 53,02 | 53,036 | 53,064 | 52,62 | 53,02 | 53,036 | 53,064 | 52,62 | 53,02 | 53,036 |
| 24 | | | | | | | | | | | | | | | | | | |
| 25 | 53,03 | 53,046 | 53,074 | 52,63 | 53,03 | 53,046 | 53,074 | 52,63 | 53,03 | 53,046 | 53,074 | 52,63 | 53,03 | 53,046 | 53,074 | 52,63 | 53,03 | 53,046 |
| 26 | | | | | | | | | | | | | | | | | | |
| 27 | | | | | | | | | | | | | | | | | | |
| 28 | | | | | | | | | | | | | | | | | | |
| 29 | 53,03 | 53,046 | 53,074 | 52,63 | 53,03 | 53,046 | 53,074 | 52,63 | 53,03 | 53,046 | 53,074 | 52,63 | 53,03 | 53,046 | 53,074 | 52,63 | 53,03 | 53,046 |
| 30 | | | | | | | | | | | | | | | | | | |
| 31 | | | | | | | | | | | | | | | | | | |
| 32 | | | | | | | | | | | | | | | | | | |
| 33 | | | | | | | | | | | | | | | | | | |
| 34 | | | | | | | | | | | | | | | | | | |
| 35 | | | | | | | | | | | | | | | | | | |
| 36 | — | — | — | — | — | — | — | — | — | — | — | — | — | — | — | — | — | — |
| 37 | | | | | | | | | | | | | | | | | | |
| 38 | | | | | | | | | | | | | | | | | | |
| 39 | | | | | | | | | | | | | | | | | | |
| 40 | | | | | | | | | | | | | | | | | | |

Продолжение табл. 2

| Размеры в мм | | | | | | | | | | |
|-----------------------------------|-------------------------|--------|-------------------------|--------|-------------------------|--------|-------------------------|--------|-------------------------|--------|
| Обозначение протяжек | 2400-0389; 2400-0390 | | 2400-0391; 2400-0392 | | 2400-0395; 2400-0394 | | 2400-0396; 2400-0395 | | 2400-0397; 2400-0396 | |
| | 54,5H7 | 55,5H8 | 54,6H7 | 55,6H8 | 53,5H7 | 54,5H8 | 53,5H7 | 54,5H8 | 53,5H7 | 54,5H8 |
| Глубина ямки в неподвижных опорах | | | | | | | | | | |
| 1 | 53,40 | 53,81 | 53,810 | 53,81 | 53,41 | 54,80 | 54,800 | 54,80 | 54,40 | 54,81 |
| 2 | 53,36 | 53,77 | 53,770 | 53,77 | 53,37 | 54,76 | 54,760 | 54,76 | 54,36 | 54,77 |
| 3 | 53,60 | 54,02 | 54,020 | 54,02 | 53,62 | 55,00 | 55,000 | 55,00 | 54,60 | 55,02 |
| 4 | 53,56 | 53,98 | 54,980 | 53,98 | 53,58 | 54,96 | 54,960 | 54,96 | 54,56 | 54,98 |
| 5 | 53,80 | 54,23 | 54,230 | 54,23 | 53,83 | 55,20 | 55,200 | 55,20 | 54,80 | 55,23 |
| 6 | 53,76 | 54,19 | 54,190 | 54,19 | 53,79 | 55,16 | 55,160 | 55,16 | 54,76 | 55,19 |
| 7 | 54,00 | 54,44 | 54,440 | 54,44 | 54,04 | 55,40 | 55,400 | 55,40 | 55,00 | 55,44 |
| 8 | 53,96 | 54,40 | 54,400 | 54,40 | 54,00 | 55,36 | 55,360 | 55,36 | 54,96 | 55,40 |
| 9 | 54,20 | 54,65 | 54,650 | 54,65 | 54,65 | 55,60 | 55,600 | 55,60 | 55,20 | 55,65 |
| 10 | 54,16 | 54,61 | 54,610 | 54,61 | 54,21 | 55,57 | 55,570 | 55,57 | 55,16 | 55,61 |
| 11 | 54,38 | 54,78 | 54,800 | 54,80 | 54,38 | 55,78 | 55,780 | 55,78 | 55,38 | 55,79 |
| 12 | 54,36 | 54,76 | 54,780 | 54,78 | 54,36 | 55,76 | 55,760 | 55,76 | 55,36 | 55,77 |
| 13 | 54,47 | 54,87 | 54,880 | 54,89 | 54,47 | 55,87 | 55,870 | 55,88 | 55,47 | 55,88 |
| 14 | | | | | | | | | | |
| 15 | 54,53 | 54,93 | 53,940 | 54,95 | 54,53 | 55,93 | 55,930 | 55,94 | 55,53 | 55,93 |
| 16 | | | | | | | | | | |
| 17 | 54,57 | 54,97 | 54,980 | 54,98 | 54,57 | 55,97 | 55,970 | 55,98 | 55,57 | 55,97 |
| 18 | 54,59 | 54,99 | 55,000 | 55,02 | 54,59 | 55,99 | 56,000 | 56,01 | 55,59 | 55,99 |
| 19 | | | | | | | | | | |
| 20 | | | | | | | | | | |

Продолжение табл. 2

| | | Размеры в мм | | | | | | | | | | | |
|--------------------------|-------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|--|--|
| Обозначение проставок | | 2400-0899; 2400-0380 | 2400-1156; 2400-0382 | 2400-0390; 2400-0394 | 2400-1157; 2400-0386 | 2400-1158; 2400-1169 | 2400-1161; 2400-1162 | 2400-1163; 2400-1164 | 2400-1165; 2400-1166 | 2400-1167; 2400-1171 | 2400-1168; 2400-1171 | | |
| Диаметр шестерни | | 54,6Н7 | 55Н7 | 55Н8 | 55Н9 | 55Н17 | 55Н8 | 55Н9 | 55Н7 | 55Н7 | 55Н8 | | |
| 21 | 54,61 | 55,01 | 55,020 | 55,045 | 54,61 | 55,01 | 56,020 | 56,040 | 55,61 | 56,01 | 56,020 | | |
| 22 | | | | | | | | | | | | | |
| 23 | 54,62 | 55,02 | 55,036 | 55,064 | 54,62 | 55,02 | 56,036 | 56,064 | 55,62 | 56,02 | 56,036 | | |
| 24 | | | | | | | | | | | | | |
| 25 | 54,63 | 55,03 | 55,046 | 55,074 | 54,63 | 55,03 | 56,046 | 56,074 | 55,63 | 56,03 | 56,046 | | |
| 26 | | | | | | | | | | | | | |
| 27 | | | | | | | | | | | | | |
| 28 | | | | | | | | | | | | | |
| 29 | 54,63 | 55,03 | 55,046 | 55,074 | 54,63 | 55,03 | 56,046 | 56,074 | 55,63 | 56,03 | 56,046 | | |
| 30 | | | | | | | | | | | | | |
| 31 | | | | | | | | | | | | | |
| 32 | | | | | | | | | | | | | |
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| 40 | | | | | | | | | | | | | |

Кангирии зигбре D, мм/пог

Продолжение табл. 2

Размеры в мм

| Обозначение протяжек | 2400-1172; 2400-1175 | 2400-1174; 2400-1176 | 2400-0397; 2400-1177 | 2400-0399; 2400-0400 | 2400-0401; 2400-0402 | 2400-0403; 2400-0404 | 2400-1178; 2400-1179 | 2400-0405; 2400-0406 | 2400- 0407; 2400-0410 |
|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-----------------------------|
| | 56,179 | 56,617 | 55,517 | 58,179 | 57,917 | 58,177 | 58,178 | 57,617 | 57,417 |
| Диаметр стяжек | | | | | | | | | |
| 1 | 54,41 | 54,41 | 56,80 | 56,800 | 56,40 | 56,81 | 56,810 | 56,41 | 58,80 |
| 2 | 54,77 | 54,37 | 56,76 | 56,760 | 56,76 | 56,36 | 56,77 | 56,770 | 56,37 |
| 3 | 55,02 | 54,62 | 57,00 | 57,000 | 57,00 | 56,60 | 57,02 | 57,020 | 56,62 |
| 4 | 54,98 | 54,58 | 56,96 | 56,960 | 56,96 | 56,56 | 56,98 | 56,980 | 56,58 |
| 5 | 55,23 | 54,83 | 57,20 | 57,200 | 57,20 | 56,80 | 57,23 | 57,230 | 56,83 |
| 6 | 55,19 | 54,79 | 57,16 | 57,160 | 57,16 | 56,76 | 57,19 | 57,190 | 56,79 |
| 7 | 55,44 | 55,04 | 57,40 | 57,400 | 57,40 | 57,00 | 57,44 | 57,440 | 57,04 |
| 8 | 55,40 | 55,00 | 57,36 | 57,360 | 57,36 | 56,96 | 57,40 | 57,400 | 57,00 |
| 9 | 55,65 | 55,25 | 57,60 | 57,600 | 57,60 | 57,20 | 57,65 | 57,650 | 57,25 |
| 10 | 55,61 | 55,21 | 57,57 | 57,570 | 57,57 | 57,16 | 57,61 | 57,610 | 57,21 |
| 11 | 55,80 | 55,39 | 57,78 | 57,780 | 57,78 | 57,38 | 57,79 | 57,800 | 57,39 |
| 12 | 55,78 | 55,37 | 57,76 | 57,760 | 57,76 | 57,36 | 57,77 | 57,780 | 57,37 |
| 13 | 55,89 | 55,47 | 57,87 | 57,880 | 57,88 | 57,47 | 57,87 | 57,880 | 57,47 |
| 14 | 55,95 | 55,53 | 57,93 | 57,940 | 57,94 | 57,53 | 57,93 | 57,940 | 57,53 |
| 15 | 55,99 | 55,57 | 57,97 | 57,980 | 57,98 | 57,57 | 57,97 | 57,980 | 57,57 |
| 16 | 56,02 | 55,59 | 57,99 | 58,000 | 58,01 | 57,59 | 57,99 | 58,000 | 57,59 |
| 17 | 55,99 | 55,57 | 57,97 | 57,980 | 57,98 | 57,57 | 57,97 | 57,980 | 57,57 |
| 18 | 56,02 | 55,59 | 57,99 | 58,000 | 58,01 | 57,59 | 57,99 | 58,000 | 57,59 |
| 19 | 56,02 | 55,59 | 57,99 | 58,000 | 58,01 | 57,59 | 57,99 | 58,000 | 57,59 |
| 20 | 56,02 | 55,59 | 57,99 | 58,000 | 58,01 | 57,59 | 57,99 | 58,000 | 57,59 |

Приложение табл. 2

| | | Размеры в мм | | | | | | | | | |
|--------------------------|--------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-----------------------------|-----------------------------|
| Однотактные двигатели | | 2400-1172; 2400-1173 | 2400-1174; 2400-1175 | 2400-1087; 2400-0398 | 2400-0389; 2400-0400 | 2400-0401; 2400-0402 | 2400-0403; 2400-0404 | 2400-1178; 2400-1179 | 2400-0405; 2400-0406 | 2400- 0407; 2400-0408 | 2400- 0409; 2400-0410 |
| Двухтактные двигатели | | 55H9 | 56,6H7 | 55,5H7 | 58H8 | 58H9 | 57,6H7 | 59H7 | 58H9 | 57,6H7 | 60H7 |
| 21 | 56,045 | 55,61 | 58,01 | 58,020 | 58,040 | 57,61 | 58,01 | 58,020 | 58,045 | 57,61 | 60,01 |
| 22 | | | | | | | | | | | |
| 23 | 56,064 | 55,62 | 58,02 | 58,036 | 58,064 | 57,62 | 58,02 | 58,036 | 58,064 | 57,62 | 60,02 |
| 24 | | | | | | | | | | | |
| 25 | 56,074 | 55,63 | 58,03 | 58,046 | 58,074 | 57,63 | 58,03 | 58,046 | 58,074 | 57,63 | 60,03 |
| 26 | | | | | | | | | | | |
| 27 | | | | | | | | | | | |
| 28 | | | | | | | | | | | |
| 29 | 56,074 | 55,63 | 58,03 | 58,046 | 58,074 | 57,63 | 58,03 | 58,046 | 58,074 | 57,63 | 60,03 |
| 30 | | | | | | | | | | | |
| 31 | | | | | | | | | | | |
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| 39 | | | | | | | | | | | |
| 40 | | | | | | | | | | | |

диаметра зygбеса D₂ номиналь

Продолжение табл. 2

| Размеры в мм | | | | | | | | | |
|-------------------------|--------|-------------------------|-------|-------------------------|--------|-------------------------|-------|-------------------------|--------|
| Обозначение протяжек | | 2400-1181; 2400-1182 | | 2400-0411; 2400-0412 | | 2400-0413; 2400-0414 | | 2400-0415; 2400-0416 | |
| Диаметр стяжки | | 63/68 | | 60/69 | | 60/68 | | 60/67 | |
| 1 | 59,800 | 58,80 | 58,40 | 58,81 | 58,810 | 58,81 | 58,41 | 61,80 | 61,800 |
| 2 | 58,760 | 58,76 | 58,36 | 58,77 | 58,770 | 58,77 | 58,37 | 61,76 | 61,760 |
| 3 | 59,000 | 59,00 | 58,60 | 59,02 | 59,020 | 59,02 | 58,62 | 62,00 | 62,000 |
| 4 | 58,960 | 58,96 | 58,56 | 58,98 | 58,980 | 58,98 | 58,58 | 61,96 | 61,960 |
| 5 | 59,200 | 59,20 | 58,80 | 59,23 | 59,230 | 59,23 | 58,83 | 62,20 | 62,200 |
| 6 | 59,160 | 59,16 | 58,76 | 59,19 | 59,190 | 59,19 | 58,79 | 62,16 | 62,160 |
| 7 | 59,400 | 59,40 | 59,00 | 59,44 | 59,440 | 59,44 | 59,04 | 62,40 | 62,400 |
| 8 | 59,360 | 59,36 | 58,96 | 59,40 | 59,400 | 59,40 | 59,00 | 62,36 | 62,360 |
| 9 | 59,600 | 59,60 | 59,20 | 59,65 | 59,650 | 59,65 | 59,25 | 62,60 | 62,600 |
| 10 | 59,560 | 59,56 | 59,16 | 59,61 | 59,610 | 59,61 | 59,21 | 62,56 | 62,560 |
| 11 | 59,780 | 59,78 | 59,38 | 59,79 | 59,800 | 59,80 | 59,39 | 62,78 | 62,780 |
| 12 | 59,760 | 59,76 | 59,36 | 59,77 | 59,780 | 59,78 | 59,37 | 62,76 | 62,760 |
| 13 | 59,870 | 59,88 | 59,47 | 59,87 | 59,880 | 59,88 | 59,47 | 62,87 | 62,870 |
| 14 | | | | | | | | | |
| 15 | 59,920 | 59,94 | 59,53 | 59,93 | 59,940 | 59,95 | 59,53 | 62,93 | 62,930 |
| 16 | | | | | | | | | |
| 17 | 59,970 | 59,98 | 59,57 | 59,97 | 59,980 | 59,99 | 59,57 | 62,97 | 62,970 |
| 18 | | | | | | | | | |
| 19 | 60,000 | 60,01 | 59,59 | 59,99 | 60,000 | 60,02 | 59,59 | 62,99 | 63,000 |
| 20 | | | | | | | | | 63,01 |

Продолжение табл. 2

| | | Размеры в мм | | | | | | | | | |
|----------------------|--------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|
| Обозначение проекции | | 2400-1181; 2400-1182 | 2400-0411; 2400-0412 | 2400-0413; 2400-0414 | 2400-0415; 2400-0416 | 2400-1183; 2400-1184 | 2400-0417; 2400-0418 | 2400-0419; 2400-0420 | 2400-0421; 2400-0422 | 2400-1185; 2400-1186 | 2400-0425; 2400-0426 |
| Диаметр отверстий | 60H8 | 60H9 | 58,6H7 | 60H7 | 59H8 | 60H9 | 59,6H7 | 60H7 | 63H8 | 63H9 | 62,6H7 |
| 21 | 60,020 | 60,04 | 59,61 | 60,01 | 60,020 | 60,045 | 59,61 | 63,01 | 63,020 | 63,04 | 62,61 |
| 22 | | | | | | | | | | | |
| 23 | 60,036 | 60,064 | 59,62 | 60,02 | 60,036 | 60,064 | 59,62 | 63,02 | 63,036 | 63,064 | 62,62 |
| 24 | | | | | | | | | | | |
| 25 | 60,046 | 60,074 | 56,63 | 60,03 | 60,046 | 60,074 | 59,63 | 63,03 | 63,046 | 63,074 | 62,63 |
| 26 | | | | | | | | | | | |
| 27 | | | | | | | | | | | |
| 28 | | | | | | | | | | | |
| 29 | 60,046 | 60,074 | 59,63 | 60,03 | 60,046 | 60,074 | 59,63 | 63,03 | 63,046 | 63,074 | 62,63 |
| 30 | | | | | | | | | | | |
| 31 | | | | | | | | | | | |
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| 40 | | | | | | | | | | | |

Продолжение табл. 2

| Обозначение профилей | | Размеры в мм | | | | | |
|----------------------|----------------|--------------|-------|-------|--------|--------|-------|
| Линейр | стеклопластика | 63Н7 | 63Н8 | 63Н9 | 63Н7 | 63Н8 | 63Н9 |
| 1 | 61,81 | 61,810 | 61,81 | 61,41 | 63,80 | 63,80 | 63,81 |
| 2 | 61,77 | 61,770 | 61,77 | 61,37 | 63,760 | 63,76 | 63,77 |
| 3 | 62,02 | 62,020 | 62,02 | 61,62 | 64,000 | 63,60 | 64,02 |
| 4 | 61,98 | 61,980 | 61,98 | 61,58 | 63,960 | 63,56 | 63,98 |
| 5 | 62,23 | 62,230 | 62,23 | 61,83 | 64,200 | 63,80 | 64,23 |
| 6 | 62,19 | 62,190 | 62,19 | 61,79 | 64,16 | 63,76 | 64,19 |
| 7 | 62,44 | 62,440 | 62,44 | 62,04 | 64,400 | 64,40 | 64,44 |
| 8 | 62,40 | 62,400 | 62,40 | 62,00 | 64,36 | 63,96 | 64,40 |
| 9 | 62,65 | 62,650 | 62,65 | 62,25 | 64,60 | 64,60 | 64,65 |
| 10 | 62,61 | 62,610 | 62,61 | 62,21 | 64,56 | 64,56 | 64,61 |
| 11 | 62,79 | 62,800 | 62,80 | 62,39 | 64,780 | 64,78 | 64,79 |
| 12 | 62,77 | 62,780 | 62,78 | 62,37 | 64,76 | 64,76 | 64,77 |
| 13 | 62,87 | 62,880 | 62,89 | 62,47 | 64,87 | 64,88 | 64,87 |
| 14 | | | | | | | |
| 15 | 62,93 | 62,940 | 62,95 | 62,53 | 64,93 | 64,94 | 64,93 |
| 16 | | | | | | | |
| 17 | 62,97 | 62,980 | 62,99 | 62,57 | 64,97 | 64,970 | 64,97 |
| 18 | | | | | | | |
| 19 | 62,99 | 63,000 | 63,02 | 62,59 | 64,99 | 65,000 | 64,99 |
| 20 | | | | | | | |

Продолжение табл. 2

| Размеры в мм | | | | | | | | | |
|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|
| Обозначение протяжек | 2400-0427; 2400-0423 | 2400-1987; 2400-1988 | 2400-0429; 2400-0430 | 2400-0431; 2400-0432 | 2400-0432; 2400-0434 | 2400-1189; 2400-1191 | 2400-0435; 2400-0433 | 2400-0437; 2400-0440 | 2400-0438; 2400-0442 |
| Диаметр отверстия | 63H7 | 63H8 | 63H9 | 62,6H7 | 65H7 | 65H8 | 65H9 | 64,6H7 | 65H7 |
| 21 | 63,01 | 63,020 | 63,045 | 62,61 | 65,01 | 65,020 | 65,04 | 64,61 | 65,01 |
| 22 | | | | | | | | | |
| 23 | 63,02 | 63,036 | 63,064 | 62,62 | 65,02 | 65,036 | 65,064 | 64,62 | 65,02 |
| 24 | | | | | | | | | |
| 25 | 63,03 | 63,046 | 63,074 | 62,63 | 65,03 | 65,046 | 65,074 | 64,63 | 65,03 |
| 26 | | | | | | | | | |
| 27 | | | | | | | | | |
| 28 | | | | | | | | | |
| 29 | 63,03 | 63,046 | 63,074 | 62,63 | 65,03 | 65,046 | 65,074 | 64,63 | 65,03 |
| 30 | | | | | | | | | |
| 31 | | | | | | | | | |
| 32 | | | | | | | | | |
| 33 | | | | | | | | | |
| 34 | | | | | | | | | |
| 35 | | | | | | | | | |
| 36 | | | | | | | | | |
| 37 | | | | | | | | | |
| 38 | | | | | | | | | |
| 39 | | | | | | | | | |
| 40 | | | | | | | | | |

Продолжение табл. 2

Размеры в мм

| О обозначение размеров | 2400-0445: | | 2400-1194: | | 2400-0446: | | 2400-0447: | | 2400-0448: | | 2400-0449: | | 2400-0451: | | 2400-0452: | | 2400-1196: | | 2400-1197: | | 2400-0453: | | 2400-0454: | | 2400-0455: | | 2400-0456: | | 2400-1201: | |
|---------------------------|------------|-----------|------------|-----------|------------|-----------|------------|-----------|------------|-----------|------------|-----------|------------|-----------|------------|-----------|------------|-----------|------------|-----------|------------|-----------|------------|-----------|------------|-----------|------------|------------|------------|------------|
| | 2400-0444 | 2400-0446 | 2400-1195 | 2400-1196 | 2400-0446 | 2400-0448 | 2400-0450 | 2400-0451 | 2400-0452 | 2400-1197 | 2400-0453 | 2400-0454 | 2400-0455 | 2400-0456 | 2400-0457 | 2400-0458 | 2400-0459 | 2400-0460 | 2400-0461 | 2400-0462 | 2400-1197 | 2400-0463 | 2400-0464 | 2400-0465 | 2400-0466 | 2400-0467 | 2400-1202: | 2400-1203: | 2400-1204: | 2400-1205: |
| Диаметр стержня | 64,6Н7 | 70Н7 | 70Н8 | 70Н9 | 69,6Н7 | 70Н7 | 70Н8 | 70Н9 | 70Н10 | 70Н11 | 70Н12 | 70Н13 | 70Н14 | 70Н15 | 70Н16 | 70Н17 | 70Н18 | 69,6Н7 | 70Н7 | 70Н8 | 70Н9 | 70Н10 | 70Н11 | 70Н12 | 70Н13 | 70Н14 | 70Н15 | 70Н16 | 70Н17 | 71Н8 |
| 1 | 63,41 | 68,80 | 68,80 | 68,80 | 68,80 | 68,40 | 68,60 | 68,60 | 68,60 | 68,60 | 68,80 | 68,80 | 68,40 | 68,40 | 68,40 | 68,40 | 69,80 | 69,80 | 69,80 | 69,80 | 69,80 | 69,80 | 69,80 | 69,80 | 69,80 | 69,80 | 69,80 | 69,80 | 69,80 | |
| 2 | 63,37 | 68,76 | 68,76 | 68,76 | 68,76 | 68,36 | 68,76 | 68,76 | 68,76 | 68,76 | 68,76 | 68,76 | 68,36 | 68,36 | 68,36 | 68,36 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | |
| 3 | 63,62 | 69,00 | 69,00 | 69,00 | 69,00 | 68,60 | 69,00 | 69,00 | 69,00 | 69,00 | 69,00 | 69,00 | 68,60 | 68,60 | 68,60 | 68,60 | 70,00 | 70,00 | 70,00 | 70,00 | 70,00 | 70,00 | 70,00 | 70,00 | 70,00 | 70,00 | 70,00 | 70,00 | 70,00 | |
| 4 | 63,58 | 68,96 | 68,96 | 68,96 | 68,96 | 68,56 | 68,96 | 68,96 | 68,96 | 68,96 | 68,96 | 68,96 | 68,56 | 68,56 | 68,56 | 68,56 | 69,96 | 69,96 | 69,96 | 69,96 | 69,96 | 69,96 | 69,96 | 69,96 | 69,96 | 69,96 | 69,96 | 69,96 | 69,96 | |
| 5 | 63,83 | 69,20 | 69,20 | 69,20 | 69,20 | 69,20 | 69,20 | 69,20 | 69,20 | 69,20 | 69,20 | 69,20 | 69,20 | 69,20 | 69,20 | 69,20 | 69,20 | 69,20 | 69,20 | 69,20 | 69,20 | 69,20 | 69,20 | 69,20 | 69,20 | 69,20 | 69,20 | 69,20 | | |
| 6 | 63,79 | 69,16 | 69,16 | 69,16 | 69,16 | 69,16 | 69,16 | 69,16 | 69,16 | 69,16 | 69,16 | 69,16 | 69,16 | 69,16 | 69,16 | 69,16 | 69,16 | 69,16 | 69,16 | 69,16 | 69,16 | 69,16 | 69,16 | 69,16 | 69,16 | 69,16 | 69,16 | 69,16 | | |
| 7 | 64,04 | 69,40 | 69,40 | 69,40 | 69,40 | 69,40 | 69,40 | 69,40 | 69,40 | 69,40 | 69,40 | 69,40 | 69,40 | 69,40 | 69,40 | 69,40 | 69,40 | 69,40 | 69,40 | 69,40 | 69,40 | 69,40 | 69,40 | 69,40 | 69,40 | 69,40 | 69,40 | 69,40 | | |
| 8 | 64,00 | 69,36 | 69,36 | 69,36 | 69,36 | 69,36 | 69,36 | 69,36 | 69,36 | 69,36 | 69,36 | 69,36 | 69,36 | 69,36 | 69,36 | 69,36 | 69,36 | 69,36 | 69,36 | 69,36 | 69,36 | 69,36 | 69,36 | 69,36 | 69,36 | 69,36 | 69,36 | 69,36 | | |
| 9 | 64,25 | 69,60 | 69,60 | 69,60 | 69,60 | 69,60 | 69,60 | 69,60 | 69,60 | 69,60 | 69,60 | 69,60 | 69,60 | 69,60 | 69,60 | 69,60 | 69,60 | 69,60 | 69,60 | 69,60 | 69,60 | 69,60 | 69,60 | 69,60 | 69,60 | 69,60 | 69,60 | 69,60 | | |
| 10 | 64,21 | 69,56 | 69,56 | 69,56 | 69,56 | 69,56 | 69,56 | 69,56 | 69,56 | 69,56 | 69,56 | 69,56 | 69,56 | 69,56 | 69,56 | 69,56 | 69,56 | 69,56 | 69,56 | 69,56 | 69,56 | 69,56 | 69,56 | 69,56 | 69,56 | 69,56 | 69,56 | 69,56 | | |
| 11 | 64,39 | 69,78 | 69,78 | 69,78 | 69,78 | 69,78 | 69,78 | 69,78 | 69,78 | 69,78 | 69,78 | 69,78 | 69,78 | 69,78 | 69,78 | 69,78 | 69,78 | 69,78 | 69,78 | 69,78 | 69,78 | 69,78 | 69,78 | 69,78 | 69,78 | 69,78 | 69,78 | 69,78 | | |
| 12 | 64,37 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | 69,76 | | |
| 13 | 64,48 | 69,87 | 69,87 | 69,87 | 69,87 | 69,88 | 69,88 | 69,88 | 69,88 | 69,88 | 69,88 | 69,88 | 69,88 | 69,88 | 69,88 | 69,88 | 69,88 | 69,88 | 69,88 | 69,88 | 69,88 | 69,88 | 69,88 | 69,88 | 69,88 | 69,88 | 69,88 | 69,88 | | |
| 14 | 64,48 | 69,87 | 69,87 | 69,87 | 69,87 | 69,87 | 69,87 | 69,87 | 69,87 | 69,87 | 69,87 | 69,87 | 69,87 | 69,87 | 69,87 | 69,87 | 69,87 | 69,87 | 69,87 | 69,87 | 69,87 | 69,87 | 69,87 | 69,87 | 69,87 | 69,87 | 69,87 | 69,87 | | |
| 15 | 64,53 | 69,93 | 69,93 | 69,93 | 69,93 | 69,93 | 69,93 | 69,93 | 69,93 | 69,93 | 69,93 | 69,93 | 69,93 | 69,93 | 69,93 | 69,93 | 69,93 | 69,93 | 69,93 | 69,93 | 69,93 | 69,93 | 69,93 | 69,93 | 69,93 | 69,93 | 69,93 | 69,93 | | |
| 16 | 64,57 | 69,97 | 69,97 | 69,97 | 69,97 | 69,98 | 69,98 | 69,98 | 69,98 | 69,98 | 69,98 | 69,98 | 69,98 | 69,98 | 69,98 | 69,98 | 69,98 | 69,98 | 69,98 | 69,98 | 69,98 | 69,98 | 69,98 | 69,98 | 69,98 | 69,98 | 69,98 | 69,98 | | |
| 17 | 64,59 | 69,99 | 69,99 | 69,99 | 69,99 | 70,00 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | |
| 18 | 64,59 | 69,99 | 69,99 | 69,99 | 69,99 | 70,00 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | |
| 19 | 64,59 | 69,99 | 69,99 | 69,99 | 69,99 | 70,00 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | |
| 20 | 64,59 | 69,99 | 69,99 | 69,99 | 69,99 | 70,00 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | 70,01 | |

Измерение 356 базы D₁ нониусом

Продолжение табл. 2

| | | Размеры в мм | | | | | | | | |
|----------------------|-------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-----------------------------------|-------|--------|
| Обозначение проекций | | 2400-0445; 2400-0446 | 2400-1194; 2400-1195 | 2400-0451; 2400-0452 | 2400-1196; 2400-1197 | 2400-0453; 2400-0454 | 2400-0455; 2400-0456 | 2400-1200; 2400-1202; -1199 | | |
| Диаметр отверстия | | 64,5H7 | 70H7 | 70H9 | 70H17 | 70H18 | 70H2 | 69,6H7 | 71H7 | 71H8 |
| 21 | 64,61 | 70,01 | 70,020 | 70,04 | 69,61 | 70,01 | 70,020 | 70,045 | 69,61 | 71,01 |
| 22 | | | | | | | | | | 71,020 |
| 23 | 64,62 | 70,02 | 70,036 | 70,064 | 69,62 | 70,02 | 70,036 | 70,064 | 69,62 | 71,02 |
| 24 | | | | | | | | | | 71,036 |
| 25 | 64,63 | 70,03 | 70,046 | 70,074 | 69,63 | 70,03 | 70,046 | 70,074 | 69,63 | 71,03 |
| 26 | | | | | | | | | | 71,046 |
| 27 | | | | | | | | | | |
| 28 | | | | | | | | | | |
| 29 | 64,63 | 70,03 | 70,046 | 70,074 | 69,63 | 70,03 | 70,046 | 70,074 | 69,63 | 71,03 |
| 30 | | | | | | | | | | 71,046 |
| 31 | | | | | | | | | | |
| 32 | | | | | | | | | | |
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Продолжение табл. 2

| Размеры в мм | | | | | | | | | |
|----------------------|-------|------------|-------|------------|-------|------------|-------|------------|--------|
| Обозначение проекции | | 2400-1200; | | 2400-1205; | | 2400-1207; | | 2400-1209; | |
| 2400-1204 | | 2400-1206; | | 2400-1211; | | 2400-1212; | | 2400-1214; | |
| диаметр отверстия | | 71H9 | | 70,5H7 | | 71H5 | | 70,6H7 | |
| 1 | 69,80 | 69,40 | 69,80 | 69,800 | 69,80 | 69,40 | 73,70 | 73,700 | 73,70 |
| 2 | 69,76 | 69,36 | 69,76 | 69,760 | 69,76 | 69,36 | 73,66 | 73,660 | 73,66 |
| 3 | 70,00 | 69,60 | 70,00 | 70,000 | 70,00 | 69,60 | 73,90 | 73,900 | 73,90 |
| 4 | 69,96 | 69,56 | 69,96 | 69,960 | 69,96 | 69,56 | 73,86 | 73,860 | 73,86 |
| 5 | 70,20 | 69,80 | 70,20 | 70,200 | 70,20 | 69,80 | 74,10 | 74,100 | 74,10 |
| 6 | 70,16 | 69,76 | 70,16 | 70,160 | 70,16 | 69,76 | 74,06 | 74,060 | 74,06 |
| 7 | 70,40 | 70,00 | 70,40 | 70,400 | 70,40 | 70,00 | 74,30 | 74,300 | 74,30 |
| 8 | 70,36 | 69,96 | 70,36 | 70,360 | 70,36 | 69,96 | 74,26 | 74,260 | 74,26 |
| 9 | 70,80 | 70,20 | 70,60 | 70,600 | 70,60 | 70,20 | 74,50 | 74,500 | 74,50 |
| 10 | 70,56 | 70,16 | 70,56 | 70,560 | 70,56 | 70,16 | 74,46 | 74,460 | 74,46 |
| 11 | 70,78 | 70,38 | 70,78 | 70,780 | 70,78 | 70,38 | 74,68 | 74,680 | 74,68 |
| 12 | 70,76 | 70,36 | 70,76 | 70,760 | 70,76 | 70,36 | 74,64 | 74,640 | 74,64 |
| 13 | 70,88 | 70,47 | 70,87 | 70,870 | 70,88 | 70,47 | 74,80 | 74,810 | 74,80 |
| 14 | | | | | | | 74,78 | 74,790 | 74,78 |
| 15 | 70,94 | 70,53 | 70,93 | 70,930 | 70,94 | 70,53 | 74,87 | 74,880 | 74,880 |
| 16 | | | | | | | 74,93 | 74,940 | 74,940 |
| 17 | 70,98 | 70,57 | 70,97 | 70,970 | 70,98 | 70,57 | 74,97 | 74,980 | 74,980 |
| 18 | | | | | | | 74,99 | 74,990 | 74,990 |
| 19 | 71,01 | 70,59 | 70,99 | 71,000 | 71,02 | 70,59 | 74,97 | 74,980 | 74,980 |
| 20 | | | | | | | 75,00 | 74,99 | 74,99 |

Измерения в ненормированных единицах

Измерения в дюймах D_1 и D_2 нормированные

Продолжение табл. 2

| Размеры в мм | | | | | | | | | | |
|----------------------|------------|-----------|------------|-----------|------------|-----------|------------|-----------|------------|------------|
| Обозначение профилей | 2400-1208; | | 2400-1208; | | 2400-1212; | | 2400-1214; | | 2400-1216; | |
| | 2400-1204 | 2400-1208 | 2400-1208 | 2400-1211 | 2400-1213 | 2400-1215 | 2400-0459 | 2400-1217 | 2400-0458; | 2400-0461; |
| Диаметр отверстий | 71,49 | 70,617 | 71,47 | 71,48 | 71,49 | 70,617 | 73,47 | 75,48 | 74,517 | 75,01 |
| 21 | 71,04 | 70,61 | 71,01 | 71,020 | 71,045 | 70,61 | 74,99 | 75,000 | 75,03 | 74,59 |
| 22 | | | | | | | | | | |
| 23 | 71,064 | 70,62 | 71,02 | 71,036 | 71,064 | 70,62 | 75,01 | 75,020 | 75,05 | 74,61 |
| 24 | | | | | | | | | | 75,02 |
| 25 | 71,074 | 70,63 | 71,03 | 71,046 | 71,074 | 70,63 | 75,02 | 75,036 | 75,064 | 74,62 |
| 26 | | | | | | | | | | 75,03 |
| 27 | | | | | | | 75,03 | 75,016 | 75,074 | 74,63 |
| 28 | | | | | | | | | | 75,03 |
| 29 | 71,074 | 70,63 | 71,03 | 71,046 | 71,074 | 70,63 | | | | |
| 30 | | | | | | | | | | |
| 31 | | | | | | | | | | |
| 32 | | | | | | | | | | |
| 33 | | | | | | | | | | |
| 34 | | | | | | | | | | |
| 35 | | | | | | | | | | |
| 36 | | | | | | | | | | |
| 37 | | | | | | | | | | |
| 38 | | | | | | | | | | |
| 39 | | | | | | | | | | |
| 40 | | | | | | | | | | |

Диаметр з格外е D_1 , мм

Продолжение табл. 2

| Размеры в мм | | | | | | | | | |
|---------------------|----------------------|----------------------|----------------------|----------------------|----------------------|----------------------|----------------------|-----------------|-----------------|
| Обозначение профиля | 2400-1218; 2400-1219 | 2400-0465; 2400-0466 | 2400-0467; 2400-0468 | 2400-0471; 2400-0472 | 2400-0473; 2400-0475 | 2400-0474; 2400-0476 | 2400-1223; 2400-1224 | 2400-0477; 0478 | 2400-0479; 0476 |
| Диаметр отверстия | 75,93 | 75,93 | 74,6H7 | 80H7 | 80f8 | 80H9 | 79,6H7 | 80H8 | 79,6H7 |
| 1 | 73,720 | 73,72 | 73,32 | 78,70 | 78,700 | 78,30 | 78,70 | 78,700 | 78,70 |
| 2 | 73,680 | 73,68 | 73,28 | 78,66 | 78,660 | 78,66 | 78,66 | 78,660 | 78,66 |
| 3 | 73,940 | 73,94 | 73,54 | 78,90 | 78,900 | 78,90 | 78,50 | 78,90 | 78,50 |
| 4 | 73,900 | 73,90 | 73,50 | 78,86 | 78,860 | 78,86 | 78,46 | 78,860 | 78,86 |
| 5 | 74,160 | 74,16 | 73,76 | 79,10 | 79,100 | 79,10 | 78,70 | 79,100 | 79,10 |
| 6 | 74,120 | 74,12 | 73,72 | 79,06 | 79,060 | 79,06 | 78,66 | 79,060 | 79,06 |
| 7 | 74,380 | 74,38 | 73,98 | 79,30 | 79,300 | 79,30 | 78,90 | 79,300 | 79,30 |
| 8 | 74,340 | 74,34 | 73,94 | 79,26 | 79,260 | 79,26 | 78,86 | 79,260 | 79,26 |
| 9 | 74,600 | 74,60 | 74,20 | 79,50 | 79,500 | 79,50 | 79,10 | 79,500 | 79,50 |
| 10 | 74,560 | 74,56 | 74,16 | 79,46 | 79,460 | 79,46 | 79,06 | 79,460 | 79,46 |
| 11 | 74,790 | 74,79 | 74,37 | 79,68 | 79,680 | 79,68 | 79,28 | 79,680 | 79,68 |
| 12 | 74,770 | 74,77 | 74,35 | 79,64 | 79,640 | 79,64 | 79,24 | 79,640 | 79,64 |
| 13 | 74,880 | 74,89 | 74,46 | 79,80 | 79,800 | 79,82 | 79,40 | 79,800 | 79,82 |
| 14 | | | | 79,78 | 79,780 | 79,80 | 79,38 | 79,780 | 79,80 |
| 15 | 74,940 | 74,95 | 74,52 | 79,87 | 79,880 | 79,90 | 79,47 | 79,880 | 79,90 |
| 16 | 74,980 | 74,99 | 74,56 | 79,93 | 79,940 | 79,96 | 79,53 | 79,940 | 79,96 |
| 17 | 75,000 | 75,02 | 74,59 | 79,97 | 79,980 | 80,00 | 79,57 | 79,980 | 80,00 |
| 18 | | | | | | | | | |
| 19 | | | | | | | | | |
| 20 | | | | | | | | | |

Диаметр зигзага D, мм

Продолжение табл. 2

| Размеры в мм | | | | | | | | | |
|----------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|---------------------------------|
| Сбои износов при работе | 2400-1218; 2400-1219 | 2400-0465; 2400-0465 | 2400-0467; 2400-0465 | 2400-0469; 2400-0470 | 2400-1221; 2400-1222 | 2400-0470; 2400-0472 | 2400-0475; 2400-0476 | 2400-1223; 2400-1224 | 2400- 0477; 2400- 0478 |
| Диаметр отверстия | 75,043 | 75,049 | 74,647 | 80,077 | 80,078 | 80,079 | 79,647 | 80,078 | 80,079 |
| | 21 | 75,020 | 75,045 | 74,61 | 79,99 | 80,000 | 80,03 | 79,59 | 79,59 |
| | 22 | | | | | | | | |
| | 23 | 75,036 | 75,054 | 74,62 | 80,01 | 80,020 | 80,05 | 79,61 | 80,01 |
| | 24 | | | | | | | | |
| | 25 | 75,046 | 75,074 | 74,63 | 80,02 | 80,036 | 80,064 | 79,62 | 80,02 |
| | 26 | | | | | | | | |
| | 27 | | | | | 80,03 | 80,046 | 80,074 | 80,036 |
| | 28 | | | | | | | 80,63 | 80,036 |
| | 29 | | | | | | | | 80,064 |
| | 30 | 75,046 | 75,074 | 74,63 | | | | | 79,62 |
| | 31 | | | | | | | | |
| | 32 | | | | | | | | |
| | 33 | | | | | | | | |
| | 34 | | | | | | | | |
| | 35 | | | | | | | | |
| | 36 | | | | | | | | |
| | 37 | | | | | | | | |
| | 38 | | | | | | | | |
| | 39 | | | | | | | | |
| | 40 | | | | | | | | |

Диаметры сфер D₁ номинальные

Продолжение табл. 2

Размеры в мм

| Обозначение проекции | 2400-0481: | | 2400-0483: | | 2400-0485: | | 2400-0487: | | 2400-1227: | | 2400-0489: | | 2400-0491: | | 2400-0493: | | 2400-1229: | | 2400-0495: | | 2400-0497: | | 2400-0499: | | 2400-0501: | | 2400-0503: | | | | | | | |
|----------------------|------------|--------|------------|--------|------------|---------|------------|--------|------------|---------|------------|--------|------------|--------|------------|--------|------------|--------|------------|--------|------------|--------|------------|--------|------------|--------|------------|--------|--------|--------|--------|--|--|--|
| | 2400-0482: | | 2400-1225: | | 2400-0484: | | 2400-0486: | | 2400-1226: | | 2400-0488: | | 2400-0489: | | 2400-0490: | | 2400-0492: | | 2400-0494: | | 2400-0496: | | 2400-0498: | | 2400-0499: | | 2400-0500: | | | | | | | |
| Диаметр отверстия | 85,477 | 85,488 | 85,499 | 85,510 | 84,5417 | 84,5477 | 85,468 | 85,479 | 84,5477 | 84,5499 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | | | | |
| 1 | 83,720 | 83,720 | 83,72 | 83,72 | 83,220 | 83,690 | 83,690 | 83,69 | 83,69 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | 83,690 | | | | | |
| 2 | 83,680 | 83,680 | 83,68 | 83,68 | 83,180 | 83,650 | 83,650 | 83,65 | 83,65 | 83,650 | 83,650 | 83,650 | 83,650 | 83,650 | 83,650 | 83,650 | 83,650 | 83,650 | 83,650 | 83,650 | 83,650 | 83,650 | 83,650 | 83,650 | 83,650 | 83,650 | 83,650 | 83,650 | 83,650 | 83,650 | | | | |
| 3 | 83,940 | 83,940 | 83,94 | 83,94 | 83,440 | 83,880 | 83,880 | 83,88 | 83,88 | 83,880 | 83,880 | 83,880 | 83,880 | 83,880 | 83,880 | 83,880 | 83,880 | 83,880 | 83,880 | 83,880 | 83,880 | 83,880 | 83,880 | 83,880 | 83,880 | 83,880 | 83,880 | 83,880 | 83,880 | 83,880 | | | | |
| 4 | 83,900 | 83,900 | 83,90 | 83,90 | 83,400 | 83,840 | 83,840 | 83,84 | 83,84 | 83,840 | 83,840 | 83,840 | 83,840 | 83,840 | 83,840 | 83,840 | 83,840 | 83,840 | 83,840 | 83,840 | 83,840 | 83,840 | 83,840 | 83,840 | 83,840 | 83,840 | 83,840 | 83,840 | 83,840 | | | | | |
| 5 | 84,160 | 84,160 | 84,16 | 84,16 | 83,660 | 84,070 | 84,070 | 84,07 | 84,07 | 84,070 | 84,070 | 84,070 | 84,070 | 84,070 | 84,070 | 84,070 | 84,070 | 84,070 | 84,070 | 84,070 | 84,070 | 84,070 | 84,070 | 84,070 | 84,070 | 84,070 | 84,070 | 84,070 | 84,070 | 84,070 | | | | |
| 6 | 84,120 | 84,120 | 84,12 | 84,12 | 83,620 | 84,030 | 84,030 | 84,03 | 84,03 | 84,030 | 84,030 | 84,030 | 84,030 | 84,030 | 84,030 | 84,030 | 84,030 | 84,030 | 84,030 | 84,030 | 84,030 | 84,030 | 84,030 | 84,030 | 84,030 | 84,030 | 84,030 | 84,030 | 84,030 | 84,030 | | | | |
| 7 | 84,380 | 84,380 | 84,38 | 84,38 | 83,880 | 84,260 | 84,260 | 84,26 | 84,26 | 84,260 | 84,260 | 84,260 | 84,260 | 84,260 | 84,260 | 84,260 | 84,260 | 84,260 | 84,260 | 84,260 | 84,260 | 84,260 | 84,260 | 84,260 | 84,260 | 84,260 | 84,260 | 84,260 | 84,260 | 84,260 | | | | |
| 8 | 84,340 | 84,340 | 84,34 | 84,34 | 83,840 | 84,220 | 84,220 | 84,22 | 84,22 | 84,220 | 84,220 | 84,220 | 84,220 | 84,220 | 84,220 | 84,220 | 84,220 | 84,220 | 84,220 | 84,220 | 84,220 | 84,220 | 84,220 | 84,220 | 84,220 | 84,220 | 84,220 | 84,220 | 84,220 | 84,220 | | | | |
| 9 | 84,600 | 84,600 | 84,60 | 84,60 | 84,100 | 84,450 | 84,450 | 84,45 | 84,45 | 84,450 | 84,450 | 84,450 | 84,450 | 84,450 | 84,450 | 84,450 | 84,450 | 84,450 | 84,450 | 84,450 | 84,450 | 84,450 | 84,450 | 84,450 | 84,450 | 84,450 | 84,450 | 84,450 | 84,450 | 84,450 | | | | |
| 10 | 84,560 | 84,560 | 84,56 | 84,56 | 84,050 | 84,410 | 84,410 | 84,41 | 84,41 | 84,410 | 84,410 | 84,410 | 84,410 | 84,410 | 84,410 | 84,410 | 84,410 | 84,410 | 84,410 | 84,410 | 84,410 | 84,410 | 84,410 | 84,410 | 84,410 | 84,410 | 84,410 | 84,410 | 84,410 | 84,410 | | | | |
| 11 | 84,770 | 84,780 | 84,78 | 84,78 | 84,300 | 84,640 | 84,640 | 84,64 | 84,64 | 84,640 | 84,640 | 84,640 | 84,640 | 84,640 | 84,640 | 84,640 | 84,640 | 84,640 | 84,640 | 84,640 | 84,640 | 84,640 | 84,640 | 84,640 | 84,640 | 84,640 | 84,640 | 84,640 | 84,640 | 84,640 | | | | |
| 12 | 84,750 | 84,760 | 84,76 | 84,76 | 84,280 | 84,600 | 84,600 | 84,60 | 84,60 | 84,600 | 84,600 | 84,600 | 84,600 | 84,600 | 84,600 | 84,600 | 84,600 | 84,600 | 84,600 | 84,600 | 84,600 | 84,600 | 84,600 | 84,600 | 84,600 | 84,600 | 84,600 | 84,600 | 84,600 | 84,600 | | | | |
| 13 | 84,860 | 84,880 | 84,88 | 84,88 | 84,400 | 84,780 | 84,780 | 84,78 | 84,78 | 84,780 | 84,780 | 84,780 | 84,780 | 84,780 | 84,780 | 84,780 | 84,780 | 84,780 | 84,780 | 84,780 | 84,780 | 84,780 | 84,780 | 84,780 | 84,780 | 84,780 | 84,780 | 84,780 | 84,780 | 84,780 | | | | |
| 14 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 15 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 16 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 17 | 84,950 | 84,980 | 84,98 | 84,98 | 84,500 | 84,930 | 84,930 | 84,93 | 84,93 | 84,930 | 84,930 | 84,930 | 84,930 | 84,930 | 84,930 | 84,930 | 84,930 | 84,930 | 84,930 | 84,930 | 84,930 | 84,930 | 84,930 | 84,930 | 84,930 | 84,930 | 84,930 | 84,930 | 84,930 | 84,930 | 84,930 | | | |
| 18 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 19 | 84,930 | 85,020 | 85,02 | 85,02 | 84,530 | 84,970 | 84,970 | 84,97 | 84,97 | 84,970 | 84,970 | 84,970 | 84,970 | 84,970 | 84,970 | 84,970 | 84,970 | 84,970 | 84,970 | 84,970 | 84,970 | 84,970 | 84,970 | 84,970 | 84,970 | 84,970 | 84,970 | 84,970 | 84,970 | 84,970 | 84,970 | | | |
| 20 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

Диаметр отверстия D, мм

Продолжение табл. 2

| Размеры в мм | | | | | | | | | |
|--------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|-------------------------|---------------------------------|
| Образование прогибов | 2400-0481- 2400-0482 | 2400-1225- 2400-1226 | 2400-0482- 2400-0484 | 2400-0482- 2400-0486 | 2400-0482- 2400-0488 | 2400-0482- 2400-0490 | 2400-0482- 2400-0492 | 2400-0482- 2400-0494 | 2400- 1226- 2400- 1231 |
| Планетарный отверстия | 85H7 | 85H8 | 85H9 | 85H7 | 85H7 | 85H8 | 85H9 | 84,5H7 | 90H8 |
| Числовые значения | | | | | | | | | |
| 21 | 85,010 | 85,030 | 85,055 | 84,550 | 84,990 | 85,010 | 85,03 | 84,530 | 90,010 |
| 22 | | | | | | | | | 90,030 |
| 23 | 85,025 | 85,044 | 85,077 | 84,565 | 85,010 | 85,030 | 85,06 | 84,550 | 90,025 |
| 24 | | | | | | | | | 90,044 |
| 25 | 85,035 | 85,054 | 85,087 | 84,575 | 85,025 | 85,044 | 85,077 | 84,565 | 90,035 |
| 26 | | | | | | | | | 90,054 |
| 27 | | | | | 85,035 | 85,054 | 85,087 | 84,575 | |
| 28 | | | | | | | | | |
| 29 | 85,035 | 85,054 | 85,087 | 84,575 | | | | | 90,035 |
| 30 | | | | | | | | | 90,054 |
| 31 | | | | | | | | | |
| 32 | | | | | | | | | |
| 33 | | | | | | | | | |
| 34 | | | | | | | | | |
| 35 | | | | | | | | | |
| 36 | | | | | | | | | |
| 37 | | | | | | | | | |
| 38 | | | | | | | | | |
| 39 | | | | | | | | | |
| 40 | | | | | | | | | |

Измерение 35 базы D₁ номинальное

Продолжение табл. 2

| | | Размеры в мм | | | | |
|-------------------------|----------------------|----------------------|----------------------|----------------------|----------------------|--|
| Обозначение протяжек | 2400-0497; 2400-0498 | 2400-0499; 2400-0500 | 2400-1222; 2400-1223 | 2400-0511; 2400-0502 | 2400-0503; 2400-0504 | |
| Диаметр стержней | 89,54Н7 | 90Н7 | 90Н8 | 90Н9 | 89,54Н7 | |
| 1 | 88,220 | 88,690 | 88,690 | 88,69 | 88,190 | |
| 2 | 88,180 | 88,650 | 88,650 | 88,65 | 87,150 | |
| 3 | 88,440 | 88,880 | 88,880 | 88,88 | 88,380 | |
| 4 | 88,400 | 88,840 | 88,840 | 88,84 | 88,340 | |
| 5 | 88,660 | 89,070 | 89,070 | 89,07 | 88,570 | |
| 6 | 88,620 | 89,030 | 89,030 | 89,03 | 88,530 | |
| 7 | 88,680 | 89,260 | 89,260 | 89,26 | 88,760 | |
| 8 | 88,840 | 89,220 | 89,220 | 89,22 | 88,720 | |
| 9 | 89,100 | 89,450 | 89,450 | 89,45 | 88,950 | |
| 10 | 89,060 | 89,410 | 89,410 | 89,41 | 88,910 | |
| 11 | 89,300 | 89,640 | 89,640 | 89,64 | 89,140 | |
| 12 | 89,280 | 89,600 | 89,600 | 89,60 | 89,100 | |
| 13 | 89,400 | 89,780 | 89,790 | 89,80 | 89,310 | |
| 14 | | 89,760 | 89,770 | 89,78 | 89,290 | |
| 15 | 89,450 | 89,870 | 89,890 | 89,89 | 89,410 | |
| 16 | | | | | | |
| 17 | 89,500 | 89,930 | 89,940 | 89,95 | 89,470 | |
| 18 | | | | | | |
| 19 | 89,530 | 89,970 | 89,980 | 89,99 | 89,510 | |
| 20 | | | | | | |

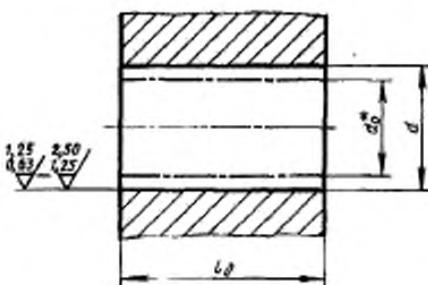
Линейные размеры D₁ и D₂ в миллиметрах

| Размеры в мм | | Приложение табл. 2 | |
|-------------------------|----------------------|----------------------|----------------------|
| Обозначение протяжки | 2400-0197; 2400-0298 | 2400-0199; 2400-0390 | 2400-1222; 2400-1223 |
| Лицевая сторона | 89,54H7 | 89H7 | 90H8 |
| 21 | 89,550 | 89,990 | 90,010 |
| 22 | | | 90,03 |
| 23 | 89,565 | 90,010 | 90,030 |
| 24 | | | 90,06 |
| 25 | 89,575 | 90,025 | 90,044 |
| 26 | | | 90,077 |
| 27 | | 90,035 | 90,054 |
| 28 | | | 90,087 |
| 29 | 89,575 | | |
| 30 | | 90,035 | |
| 31 | | | 90,054 |
| 32 | | | 90,087 |
| 33 | | | 89,575 |
| 34 | | | |
| 35 | | | |
| 36 | | | |
| 37 | | | |
| 38 | | | |
| 39 | | | |
| 40 | | | |

Диаметр язьбес D_1 нонесен

(Измененная редакция, Изд. № 2, Изд. № 3).

3. Размеры протягиваемого отверстия и усилие протягивания должны соответствовать указанным на черт. 2 и в табл. 3.



*Размер для справок.

Черт. 2

Таблица 3

Размеры в мм

| Обозначение протяжек | Номинальный диаметр отверстия | | Длина протягивания l_d | Усилие протягивания P , Н (кгс) при переднем угле γ | | | |
|----------------------|-------------------------------|-----------------------|-----------------------------|---|-----------------------------|-----------------|-----------------|
| | После протягивания d | до протягивания d_0 | | Сталь и изомагни- евые сплавы | Чугун, бронза, латунь | 20° | 15° |
| 2400-0061 | | | | | | | |
| 2400-0062 | | | | | | | |
| 2400-1001 | 14,00 | 13,4 | | | | | |
| 2400-1002 | | | | 15—34 | 15—34 | 10000 (1020) | 11200 (1140) |
| 2400-0063 | | | | | | | 13420 (1365) |
| 2400-0064 | | | | | | | |
| 2400-0065 | 13,76 | 13,1 | | | | | |
| 2400-0066 | | | | | | | |
| 2400-0067 | | | | | | | |
| 2400-0068 | | | | | | | |
| 2400-1003 | 14,00 | 13,4 | | | | | |
| 2400-1004 | | | | 26—44 | 26—44 | 10300 (1050) | 11600 (1180) |
| 2400-0069 | | | | | | | 13450 (1370) |
| 2400-0070 | | | | | | | |
| 2400-0071 | 13,76 | 13,1 | | | | | |
| 2400-0072 | | | | | | | |

Продолжение табл. 3

Размеры в мм

| Обозначение протяжек | Номинальный диаметр отверстия | | Длина протягиваний δ | | Усилие протягивания P , Н (кгс) при переднем угле γ | | |
|----------------------|-------------------------------|-----------------------|-----------------------------|-----------------------|--|-----------------|-----------------|
| | После протягивания d | до протягивания d_0 | Сталь и алюминиевые сплавы | Чугун, бронза, латунь | 20° | 15° | 10° |
| | | | Номин. | После дозпроц. | | | |
| 2400-0073 | | | | | | | |
| 2400-0074 | | | | | | | |
| 2400-1005 | 15,00 | 14,4 | | | | | |
| 2400-1006 | | | 15 - 34 | 15 - 34 | 11000 (1120) | 12300 (1250) | 14400 (1470) |
| 2400-0075 | | | | | | | |
| 2400-0076 | | | | | | | |
| 2400-0077 | 14,76 | 14,1 | | | | | |
| 2400-0078 | | | | | | | |
| 2400-0079 | | | | | | | |
| 2400-0080 | | | | | | | |
| 2400-1007 | 15,00 | 14,4 | | | | | |
| 2400-1008 | | | 22 - 53 | 22 - 53 | 9300 (950) | 10600 (1080) | 12850 (1310) |
| 2400-0081 | | | H11 | | | | |
| 2400-0082 | | | | | | | |
| 2400-0083 | 14,76 | 14,1 | | | | | |
| 2400-0084 | | | | | | | |
| 2400-0085 | | | | | | | |
| 2400-0086 | | | | | | | |
| 2400-1009 | | | | | | | |
| 2400-1011 | 16,00 | 15,4 | | | | | |
| 2400-0087 | | | 15 - 40 | 15 - 48 | 11300 (1150) | 12700 (1300) | 15300 (1560) |
| 2400-0088 | | | | | | | |
| 2400-0089 | 15,76 | 15,1 | | | | | |
| 2400-0090 | | | | | | | |
| 2400-0091 | | | | | | | |
| 2400-0092 | | | | | | | |
| 2400-1012 | 16,00 | 15,4 | 22 - 63 | 22 - 75 | 15200 (1550) | 17200 (1750) | 20400 (2080) |
| 2400-1013 | | | | | | | |

Продолжение табл. 3

Размеры в мм

| Обозначение протяжек | Номинальный диаметр отверстия | | Длина протягивания l_d | | Усилие протягивания $P, \text{Н} (\text{kgc})$ при переднем угле γ | | |
|----------------------|-------------------------------|-----------------------|--------------------------|----------------------------|---|-----------------|-----------------|
| | Посадка протяжек d | до протягивания d_p | | Сталь и алюминиевые сплавы | Чугун, бронза, латунь | | |
| | | Номин. | Поме- жные | | 20° | 15° | |
| 2400-0093 | 16,00 | 15,4 | | | | | |
| 2400-0094 | | | | 22—63 | 22—75 | 15200 (1550) | 17200 (1750) |
| 2400-0095 | 15,76 | 15,1 | | | | | 20100 (2080) |
| 2400-0096 | | | | | | | |
| 2400-0097 | | | | | | | |
| 2400-0098 | | | | | | | |
| 2400-1014 | 17,00 | 16,4 | | | | | |
| 2400-1015 | | | | 15—40 | 15—48 | 12050 (1230) | 13550 (1380) |
| 2400-0099 | | | | | | | 16250 (1655) |
| 2400-0100 | | | | | | | |
| 2400-0101 | 16,76 | 16,1 | | | | | |
| 2400-0102 | | | | | | | |
| 2400-0103 | | | | H11 | | | |
| 2400-0104 | | | | | | | |
| 2400-1016 | 17,00 | 16,4 | | | | | |
| 2400-1017 | | | | 22—63 | 22—75 | 16100 (1640) | 18150 (1850) |
| 2400-0105 | | | | | | | 21600 (2210) |
| 2400-0106 | | | | | | | |
| 2400-0107 | 16,76 | 16,1 | | | | | |
| 2400-0108 | | | | | | | |
| 2400-0109 | | | | | | | |
| 2400-0110 | | | | | | | |
| 2400-1018 | 18,00 | 17,4 | | | | | |
| 2400-1019 | | | | 15—40 | 15—40 | 14360 (1460) | 16100 (1640) |
| 2400-0111 | | | | | | | 19050 (1940) |
| 2400-0112 | | | | | | | |
| 2400-0113 | 17,76 | 17,1 | | | | | |
| 2400-0114 | | | | | | | |

Продолжение табл. 3

Размеры в мм

| Обозначение протяжек | Номинальный диаметр отверстия | | Длина протягивания l_d | | Усилие протягивания P , Н (кгс) при переносе угла γ | | |
|----------------------|-------------------------------|------------------------------|----------------------------|-----------------------|--|-----------------|-----------------|
| | После протягивания d | Номин. до протягивания d_0 | Сталь и алюминиевые сплавы | Чугун, бронза, латунь | | | |
| | | | | 20° | 15° | 10° | |
| 2400-0115 | | | | | | | |
| 2400-0116 | | | | | | | |
| 2400-1021 | | | | | | | |
| 2400-1022 | 18,00 | 17,4 | | | 14950 (1520) | 16900 (1720) | 20100 (2050) |
| 2400-0117 | | | | | | | |
| 2400-0118 | | | | | | | |
| 2400-0119 | 17,76 | 17,1 | | | | | |
| 2400-0120 | | | | | | | |
| 2400-0127 | | | | | | | |
| 2400-0128 | | | | | | | |
| 2400-1023 | 19,00 | 18,1 | | | | | |
| 2400-1024 | | | | | | | |
| 2400-0129 | | | | | | | |
| 2400-0130 | | | | | | | |
| 2400-0131 | | | | | | | |
| 2400-0132 | 18,72 | 17,8 | | | | | |
| 2400-0133 | | | | | | | |
| 2400-0134 | | | | | | | |
| 2400-1025 | | | | | | | |
| 2400-1026 | (19,00) | 18,1 | | | | | |
| 2400-0135 | | | | | | | |
| 2400-0136 | | | | | | | |
| 2400-0137 | | | | | | | |
| 2400-0138 | 18,72 | 17,8 | | | | | |
| 2400-0139 | | | | | | | |
| 2400-0140 | (19,00) | 18,1 | | | | | |
| 2400-1027 | | | | | | | |
| 2400-1028 | | | | | | | |

Продолжение табл. 3

Размеры в мм

| Обозначение протяжек | Номинальный диаметр отверстия | | Длина протягивания l_0 | | Усилие протягивания $P, \text{Н} (\text{кг})$ при переднем угле γ | | |
|----------------------|-------------------------------|-----------------------|----------------------------|-----------------------|--|-----------------|-----------------|
| | После протягивания d | до протягивания d_0 | Сталь и алюминиевые сплавы | Чугун, бронза, латунь | 10° | | 15° |
| | | | | | 10° | 15° | 10° |
| 2400-0141 | 19,00 | 18,1 | | | | | |
| 2400-0142 | | | 50—85 | 50—100 | 19900 (2030) | 22700 (2320) | 27300 (2780) |
| 2400-0143 | 18,72 | 17,8 | | | | | |
| 2400-0144 | | | | | | | |
| 2400-0145 | | | | | | | |
| 2400-0146 | | | | | | | |
| 2400-1029 | 20,00 | 19,1 | | | | | |
| 2400-1031 | | | 19—53 | 19—63 | 23000 (2340) | 25600 (2600) | 29000 (2950) |
| 2400-0147 | | | | | | | |
| 2400-0148 | | | | | | | |
| 2400-0149 | 19,72 | 18,8 | | | | | |
| 2400-0150 | | | | | | | |
| 2400-0151 | | | H11 | | | | |
| 2400-0152 | | | | | | | |
| 2400-1032 | 20,00 | 19,1 | | | | | |
| 2400-1033 | | | 30—90 | 30—100 | 21300 (2170) | 24100 (2460) | 28700 (2920) |
| 2400-0153 | | | | | | | |
| 2400-0154 | | | | | | | |
| 2400-0155 | 19,72 | 18,8 | | | | | |
| 2400-0156 | | | | | | | |
| 2400-0157 | | | | | | | |
| 2400-0158 | | | | | | | |
| 2400-1034 | (21,00) | 19,9 | | | | | |
| 2400-1035 | | | 19—53 | 19—63 | 24100 (2460) | 26500 (2700) | 30500 (3100) |
| 2400-0159 | | | | | | | |
| 2400-0160 | | | | | | | |
| 2400-0161 | 20,72 | 19,6 | | | | | |
| 2400-0162 | | | | | | | |

Продолжение табл. 3

Размеры в мм

| Обозначение протяжек | Номинальный диаметр отверстия | | Длина протягивания l_3 | | Усилие протягивания P, N (кгс) при переносном угле γ | | |
|----------------------|-------------------------------|-----------------------|----------------------------|-----------------------|---|--------------|------------------------|
| | После протягивания d | до протягивания d_0 | Сталь и алюминиевые сплавы | Чугун, бронза, латунь | | | |
| Номин. | После протягивания d | Номин. | После протягивания d | Номин. | После протягивания d | Номин. | После протягивания d |
| 2400-0163 | | | | | | | |
| 2400-0164 | | | | | | | |
| 2400-1036 | (21,00) | 19,9 | | | | | |
| 2400-1037 | | | | | | | |
| 2400-0165 | | | 40—90 | 40—100 | 24500 (2500) | 27400 (2810) | 32400 (3290) |
| 2400-0166 | | | | | | | |
| 2400-0167 | 20,72 | 19,6 | | | | | |
| 2400-0168 | | | | | | | |
| 2400-0169 | | | | | | | |
| 2400-0170 | | | | | | | |
| 2400-1038 | 22,00 | 20,9 | | | | | |
| 2400-1039 | | | | | | | |
| 2400-0171 | | | 19—53 | 19—63 | 25300 (2580) | 27700 (2820) | 32000 (3250) |
| 2400-0172 | | | | | | | |
| 2400-0173 | | | | | | | |
| 2400-0174 | 21,72 | 20,6 | | | | | |
| 2400-0175 | | | | | | | |
| 2400-0176 | | | | | | | |
| 2400-1041 | | | | | | | |
| 2400-1042 | 22,00 | 20,9 | | | | | |
| 2400-0177 | | | | | | | |
| 2400-0178 | | | 40—85 | 40—100 | 29500 (3000) | 32500 (3300) | 37400 (3790) |
| 2400-0179 | | | | | | | |
| 2400-0180 | 21,72 | 20,6 | | | | | |
| 2400-0181 | | | | | | | |
| 2400-0182 | | | | | | | |
| 2400-1043 | 24,00 | 22,9 | 21—53 | 21—68 | 37600 (3810) | 41400 (4200) | 46800 (4740) |
| 2400-1044 | | | | | | | |

Продолжение табл. 3

Размеры в мм

| Обозначение протяжки | Номинальный диаметр отверстия | | Длина протягивания l_d | Усилие протягивания P, H (кгс) при переднем угле γ | | | |
|----------------------|-------------------------------|----------------------------|-----------------------------|--|-----------------------------|-----------------|--|
| | После протя- гивания d | до протяги- вания d_0 | | Сталь и алюмини- евые сплавы | Чугун, бронза, латунь | 20° | |
| | | | | | | 15° | |
| 2400-0183 | 24,00 | 22,9 | | | | | |
| 2400-0184 | | | | | | | |
| 2400-0185 | 23,72 | 22,6 | | 21 - 53 | 21 - 63 | 37600 (3810) | |
| 2400-0186 | | | | | | 41400 (4200) | |
| 2400-0187 | | | | | | 46800 (4740) | |
| 2400-0188 | | | | | | | |
| 2400-1045 | 24,00 | 22,9 | | | | | |
| 2400-1046 | | | | | | | |
| 2400-0189 | | | | | | | |
| 2400-0190 | | | | | | | |
| 2400-0191 | 23,72 | 22,6 | | | | | |
| 2400-0192 | | | | | | | |
| 2400-0193 | | | H11 | | | | |
| 2400-0194 | | | | | | | |
| 2400-1047 | 25,00 | 23,9 | | | | | |
| 2400-1048 | | | | | | | |
| 2400-0195 | | | | 21 - 53 | 21 - 63 | 34900 (3540) | |
| 2400-0196 | | | | | | 38700 (3920) | |
| 2400-0197 | 24,72 | 23,6 | | | | 4370 (4430) | |
| 2400-0198 | | | | | | | |
| 2400-0199 | | | | | | | |
| 2400-0200 | | | | | | | |
| 2400-1049 | 25,00 | 23,9 | | | | | |
| 2400-1051 | | | | | | | |
| 2400-0201 | | | | | | | |
| 2400-0202 | | | | | | | |
| 2400-0203 | 24,72 | 23,6 | | | | | |
| 2400-0204 | | | | | | | |

Продолжение табл. 3

Размеры в мм

| Обозначение протяжек | Номинальный диаметр отверстия | | Длина протягивания l_d | | Усилие протягивания P, N (кгс) при переднем угле γ | | |
|----------------------|-------------------------------|-----------------------|----------------------------|-----------------------|---|-----------------|-----------------|
| | Полосы протягивания P | до протягивания d_0 | Сталь и алюминиевые сплавы | Чугун, бронза, латунь | 20° | 15° | 10° |
| | | | | | Норм. | Повыс. допуск | |
| 2400-0205 | | | | | | | |
| 2400-0206 | | | | | | | |
| 2400-1052 | 26,00 | 24,9 | | | | | |
| 2400-1053 | | | | | | | |
| 2400-0207 | | | 21—53 | 21—63 | 36500 (3700) | 40000 (4060) | 45400 (4610) |
| 2400-0208 | | | | | | | |
| 2400-0209 | 25,72 | 24,6 | | | | | |
| 2400-0210 | | | | | | | |
| 2400-0211 | | | | | | | |
| 2400-0212 | | | | | | | |
| 2400-1054 | 26,00 | 24,9 | | | | | |
| 2400-1055 | | | | | | | |
| 2400-0213 | | | 40—110 | 40—135 | 41200 (4180) | 46800 (4740) | 52800 (5360) |
| 2400-0214 | | | | | | | |
| 2400-0215 | 25,72 | 24,6 | | | | | |
| 2400-0216 | | | | | | | |
| 2400-0217 | | | | | | | |
| 2400-0218 | | | | | | | |
| 2400-1056 | (27,00) | 25,9 | | | | | |
| 2400-1057 | | | | | | | |
| 2400-0219 | | | 21—46 | 21—63 | 37500 (3800) | 40900 (4150) | 46200 (4680) |
| 2400-0200 | | | | | | | |
| 2400-0221 | 26,72 | 25,6 | | | | | |
| 2400-0222 | | | | | | | |
| 2400-0223 | | | | | | | |
| 2400-0224 | (27,00) | 25,9 | 40—120 | 40—135 | 52700 (5350) | 58100 (5900) | 66800 (6800) |
| 2400-1058 | | | | | | | |
| 2400-1059 | | | | | | | |

Продолжение табл. 3

Размеры в мм

| Обозначение протяжки | Номинальный диаметр отверстия | | Длина протягивания l_d | | Усилие протягивания P, H (кгс) при переднем угле γ | | |
|----------------------|-------------------------------|-----------------------|--------------------------|----------------------------|---|-----------------|-----------------|
| | Последний диаметр d | до протягивания d_0 | | Сталь и алюминиевые сплавы | Чугун, бронза, латунь | 20° | 15° |
| | | Номин. | Последн. | | | | |
| 2400-0225 | (27,00) | 25,9 | | | | | |
| 2400-0226 | | | | 40—120 | 40—135 | 52700 (5350) | 58100 (5900) |
| 2400-0227 | 26,72 | 25,6 | | | | | 66800 (6800) |
| 2400-0228 | | | | | | | |
| 2400-0229 | | | | | | | |
| 2400-0230 | | | | | | | |
| 2400-1061 | 28,00 | 26,9 | | | | | |
| 2400-1062 | | | | 21—46 | 21—63 | 38800 (3940) | 42400 (4300) |
| 2400-0231 | | | | | | | 47800 (4850) |
| 2400-0232 | | | | | | | |
| 2400-0233 | 27,72 | 26,6 | | | | | |
| 2400-0234 | | | | | | | |
| 2400-0235 | | | H11 | | | | |
| 2400-0236 | | | | | | | |
| 2400-1063 | 28,00 | 26,9 | | | | | |
| 2400-1064 | | | | 40—120 | 40—135 | 58100 (5900) | 64500 (6550) |
| 2400-0237 | | | | | | | 73000 (7440) |
| 2400-0238 | | | | | | | |
| 2400-0239 | 27,72 | 26,6 | | | | | |
| 2400-0240 | | | | | | | |
| 2400-0241 | | | | | | | |
| 2400-0242 | | | | | | | |
| 2400-1065 | 30,0 | 28,9 | | | | | |
| 2400-1066 | | | | 21—46 | 21—63 | 41500 (4220) | 45200 (4600) |
| 2400-0243 | | | | | | | 51100 (5200) |
| 2400-0244 | | | | | | | |
| 2400-0245 | 29,72 | 28,6 | | | | | |
| 2400-0246 | | | | | | | |

Продолжение табл. 3

Размеры в мм

| Обозначение протяжек | Номинальный диаметр отверстия | | Длина протягивания l_d | | Усиление протягивания P_{II} (кгс) при переднем угле γ | | |
|----------------------|-------------------------------|-----------------------|----------------------------|-----------------------|---|--------------|--------------|
| | После протягивания d | до протягивания d_0 | Сталь и алюминиевые сплавы | Чугун, бронза, латунь | 20° | | 15° |
| | | | | | 10° | | |
| 2400-0247 | | | | | | | |
| 2400-0248 | | | | | | | |
| 2400-1067 | 30,00 | 28,9 | | | | | |
| 2400-1068 | | | H11 | 40-95 | 40-135 | 56200 (5610) | 61300 (6230) |
| 2400-0249 | | | | | | | 68800 (7050) |
| 2400-0250 | | | | | | | |
| 2400-0251 | 29,72 | 28,6 | | | | | |
| 2400-0252 | | | | | | | |
| 2400-0253 | | | | | | | |
| 2400-0254 | | | | | | | |
| 2400-1069 | 32,00 | 30,8 | | | | | |
| 2400-1071 | | | | 21-46 | 21-63 | 56000 (5700) | 60700 (6170) |
| 2400-0255 | | | | | | | 68400 (6950) |
| 2400-0256 | | | | | | | |
| 2400-0257 | 31,66 | 30,5 | | | | | |
| 2400-0258 | | | | | | | |
| 2400-0259 | | | | | | | |
| 2400-0260 | | | H12 | | | | |
| 2400-1072 | 32,00 | 30,8 | | | | | |
| 2400-1073 | | | | 40-105 | 40-135 | 67300 (6850) | 73000 (7450) |
| 2400-0261 | | | | | | | 83000 (8420) |
| 2400-0262 | | | | | | | |
| 2400-0263 | 31,66 | 30,5 | | | | | |
| 2400-0264 | | | | | | | |
| 2400-0265 | | | | | | | |
| 2400-0266 | 34,00 | 32,8 | | 21-46 | 21-63 | 59600 (6050) | 64600 (6570) |
| 2400-1074 | | | | | | | 72400 (7390) |
| 2400-1075 | | | | | | | |

Продолжение табл. 3

Размеры в мм

| Обозначение протяжек | Номинальный диаметр отверстия | | Длина протягивания l_0 | | Усилие протягивания P , Н (кгс) при переднем угле γ | | |
|----------------------|-------------------------------|------------------------|----------------------------|-----------------------|--|-----------------|-------------------|
| | Посадка протяжек d | Ход протягивания d_0 | Сталь и алюминиевые сплавы | Чугун, бронза, латунь | | | |
| | | | | 20° | 15° | 10° | |
| 2400-0267 | 34,00 | 32,8 | | | | | |
| 2400-0268 | | | 21—46 | 21—63 | 59000 (6050) | 64500 (6570) | 72300 (7390) |
| 2400-0269 | 33,66 | 32,5 | | | | | |
| 2400-0270 | | | | | | | |
| 2400-0271 | | | | | | | |
| 2400-0272 | | | | | | | |
| 2400-1076 | 34,00 | 32,8 | | | | | |
| 2400-1077 | | | 40—115 | 40—135 | 80000 (8150) | 87500 (8900) | 98500 (10070) |
| 2400-0273 | | | | | | | |
| 2400-0274 | | | | | | | |
| 2400-0275 | 33,66 | 32,5 | | | | | |
| 2400-0276 | | | | | | | |
| 2400-0277 | | | H12 | | | | |
| 2400-0278 | | | | | | | |
| 2400-1078 | (35,00) | 33,8 | | | | | |
| 2400-1079 | | | 21—46 | 21—63 | 51000 (6220) | 66800 (6800) | 75000 (7610) |
| 2400-0279 | | | | | | | |
| 2400-0280 | | | | | | | |
| 2400-0281 | 34,66 | 33,5 | | | | | |
| 2400-0282 | | | | | | | |
| 2400-0283 | | | | | | | |
| 2400-0284 | | | | | | | |
| 2400-1081 | (35,00) | 33,8 | | | | | |
| 2400-1082 | | | 40—115 | 40—135 | 82600 (8410) | 90000 (9200) | 101000 (10360) |
| 2400-0285 | | | | | | | |
| 2400-0286 | | | | | | | |
| 2400-0287 | 34,66 | 33,5 | | | | | |
| 2400-0288 | | | | | | | |

Продолжение табл. 3

Размеры в мм

| Обозначение протяжки | Номинальный диаметр отверстия | | Длина протягивания l_d | | Усиление протягивания P , Н (кгс) при переднем угле γ | | |
|----------------------|-------------------------------|-----------------------|----------------------------|-----------------------|--|-----------------|-------------------|
| | После протягивания d | до протягивания d_0 | Сталь и алюминиевые сплавы | Чугун, бронза, латунь | 20° | 15° | 10° |
| | | Номин. | | | | | |
| 2400-0289 | | | | | | | |
| 2400-0290 | | | | | | | |
| 2400-1083 | 36,00 | 34,8 | | | | | |
| 2400-1084 | | | 21—46 | 21—63 | 63000 (6420) | 68400 (6960) | 77000 (7830) |
| 2400-0291 | | | | | | | |
| 2400-0292 | | | | | | | |
| 2400-0293 | 35,66 | 34,5 | | | | | |
| 2400-0294 | | | | | | | |
| 2400-0295 | | | | | | | |
| 2400-0296 | | | | | | | |
| 2400-1085 | 36,00 | 34,8 | | | | | |
| 2400-1086 | | | 40—115 | 40—145 | 84000 (8600) | 92500 (9450) | 104000 (10660) |
| 2400-0297 | | | H12 | | | | |
| 2400-0298 | | | | | | | |
| 2400-0299 | 35,66 | 34,5 | | | | | |
| 2400-0300 | | | | | | | |
| 2400-1087 | | | | | | | |
| 2400-1088 | 37,00 | 35,8 | 21—46 | 21—63 | 65000 (6600) | 70000 (7150) | 78700 (8040) |
| 2400-1089 | | | | | | | |
| 2400-1091 | | | | | | | |
| 2400-1092 | | | | | | | |
| 2400-1093 | 37,00 | 35,8 | 40—100 | 40—145 | 81700 (8330) | 88500 (9060) | 100000 (10260) |
| 2400-1094 | | | | | | | |
| 2400-1095 | | | | | | | |
| 2400-0301 | | | | | | | |
| 2400-0302 | 38,00 | 36,8 | 21—46 | 21—63 | 66000 (6750) | 72000 (7350) | 81000 (8260) |
| 2400-1096 | | | | | | | |
| 2400-1097 | | | | | | | |

Продолжение табл. 3

Размеры в мм

| Обозначение протяжек | Номинальный диаметр отверстия | | Длина протягивания l_d | | Усилие протягивания P , Н (кгс) при переднем угле γ | | |
|----------------------|-------------------------------|-----------------------|----------------------------|-----------------------|--|-----------------|-------------------|
| | После протягивания d | до протягивания d_0 | Сталь и алюминиевые сплавы | Чугун, бронза, латунь | | | |
| | | | | 20° | 15° | 10° | |
| 2400-0303 | 38,00 | 36,8 | | | | | |
| 2400-0304 | | | 21-46 | 21-63 | 66000 (6750) | 72000 (7350) | 81000 (8260) |
| 2400-0305 | 37,66 | 36,5 | | | | | |
| 2400-0306 | | | | | | | |
| 2400-0307 | | | | | | | |
| 2400-0308 | | | | | | | |
| 2400-1098 | | | | | | | |
| 2400-1099 | 38,00 | 36,8 | | | | | |
| 2400-0309 | | | 40-100 | 40-145 | 84000 (8560) | 90600 (9300) | 103000 (10540) |
| 2400-0310 | | | | | | | |
| 2400-0311 | 37,66 | 36,5 | | | | | |
| 2400-0312 | | | | | | | |
| 2400-0313 | | | <i>H12</i> | | | | |
| 2400-0314 | | | | | | | |
| 2400-1101 | 40,00 | 38,8 | | | | | |
| 2400-1102 | | | 24-58 | 24-85 | 73200 (7500) | 79000 (8100) | 88500 (9080) |
| 2400-0315 | | | | | | | |
| 2400-0316 | | | | | | | |
| 2400-0317 | 39,66 | 38,5 | | | | | |
| 2400-0318 | | | | | | | |
| 2400-0319 | | | | | | | |
| 2400-0320 | | | | | | | |
| 2400-1103 | 40,00 | 38,8 | | | | | |
| 2400-1104 | | | 40-130 | 40-160 | 87000 (8900) | 96000 (9800) | 109000 (11160) |
| 2400-0321 | | | | | | | |
| 2400-0322 | | | | | | | |
| 2400-0323 | 39,66 | 38,5 | | | | | |
| 2400-0324 | | | | | | | |

Продолжение табл. 3

Размеры в мм

| Обозначение протяжек | Номинальный диаметр отверстия | | Длина протягивания l_d | | Усиление протягивания P , Н (кгс) при переднем угле γ | | |
|----------------------|-------------------------------|-----------------------|----------------------------|-----------------------|--|-------------------|-------------------|
| | После протягивания d | до протягивания d_0 | Сталь и алюминиевые сплавы | Чугун, бронза, латунь | | | |
| Номинал, мм | Поле допуска, мм | | | | 20° | 15° | 10° |
| 2400-0325 | | | | | | | |
| 2400-0326 | | | | | | | |
| 2400-1105 | 42,00 | 40,7 | | | | | |
| 2400-1106 | | | 24-58 | 24-85 | 70000 (7150) | 75800 (7750) | 85000 (8731) |
| 2400-0327 | | | | | | | |
| 2400-0328 | | | | | | | |
| 2400-0329 | 41,66 | 40,4 | | | | | |
| 2400-0330 | | | | | | | |
| 2400-0331 | | | | | | | |
| 2400-0332 | | | | | | | |
| 2400-1107 | 42,00 | 40,7 | | | | | |
| 2400-1108 | | | 40-118 | 40-160 | 108000 (11000) | 116000 (11820) | 131000 (13370) |
| 2400-0333 | | | | | | | |
| 2400-0334 | | | | | | | |
| 2400-0335 | 41,66 | 40,4 | | | | | |
| 2400-0336 | | | | | | | |
| 2400-0337 | | | | | | | |
| 2400-0338 | | | | | | | |
| 2400-1109 | 45,00 | 43,7 | | | | | |
| 2400-1111 | | | 24-58 | 24-85 | 75000 (7670) | 82000 (8340) | 88000 (9000) |
| 2400-0339 | | | | | | | |
| 2400-0340 | | | | | | | |
| 2400-0341 | 44,66 | 43,4 | | | | | |
| 2400-0342 | | | | | | | |
| 2400-0343 | | | | | | | |
| 2400-0344 | 45,00 | 43,70 | 40-118 | 40-160 | 115000 (11700) | 124500 (12700) | 140000 (14260) |
| 2400-1112 | | | | | | | |
| 2400-1113 | | | | | | | |

Продолжение табл. 3

Размеры в мм

| Обозначение протяжек | Номинальный диаметр отверстия | | Длина протягивания l_d | | Усиление протягивания P_h Н (кгс) при переднем угле γ | | | |
|----------------------|-------------------------------|-----------------------|----------------------------|-----------------------|--|-------------------|-------------------|-------------------|
| | После протягивания d | до протягивания d_0 | Сталь и алюминиевые сплавы | Чугун, бронза, латунь | 20° | | 15° | |
| | | | | | 10° | | | |
| 2400-0345 | 45,00 | 43,7 | | | | | | |
| 2400-0346 | | | 40—118 | 40—160 | 115000 (11700) | 124500 (12700) | 110000 (14260) | |
| 2400-0347 | 44,66 | 43,4 | | | | | | |
| 2400-0348 | | | | | | | | |
| 2400-1114 | | | | | | | | |
| 2400-1115 | (47,00) | 45,7 | | 24—58 | 24—85 | 78000 (7950) | 85000 (8660) | 96000 (9770) |
| 2400-1116 | | | | | | | | |
| 2400-1117 | | | | | | | | |
| 2400-1118 | | | | | | | | |
| 2400-1119 | 47,00 | 45,7 | H12 | 40—118 | 40—160 | 119000 (12120) | 130000 (13200) | 145600 (14800) |
| 2400-1121 | | | | | | | | |
| 2400-1122 | | | | | | | | |
| 2400-0349 | | | | | | | | |
| 2400-0350 | | | | | | | | |
| 2400-1123 | 48,00 | 46,7 | | | | | | |
| 2400-1124 | | | | | | | | |
| 2400-0351 | | | | | | | | |
| 2400-0352 | | | | | | | | |
| 2400-0353 | 47,66 | 46,4 | | | | | | |
| 2400-0354 | | | | | | | | |
| 2400-0355 | | | | | | | | |
| 2400-0356 | | | | | | | | |
| 2400-1125 | 48,00 | 46,7 | | | | | | |
| 2400-1126 | | | | | | | | |
| 2400-0357 | | | | | | | | |
| 2400-0358 | | | | | | | | |
| 2400-0359 | 47,66 | 46,4 | | | | | | |
| 2400-0360 | | | | | | | | |

Продолжение табл. 3

| Обозначение протяжки | Размеры в мм | | | | Усилие протягивания P , Н (кгс) при переднем угле γ | | |
|----------------------|-------------------------------|-----------------------|---|-----------------------------|--|-------------------|-------------------|
| | Номинальный диаметр отверстия | | Длина протягивания l_d | | | | |
| | После протягивания d | до протягивания d_1 | Сталь и алюмини- ческие сплавы | Чугун, бронза, латунь | 20° | 15° | 10° |
| 2400-0361 | | | | | | | |
| 2400-0362 | | | | | | | |
| 2400-1127 | 50,00 | 48,7 | | | | | |
| 2400-1128 | | | 24—58 | 24—85 | 83000 (8450) | 90600 (9220) | 102000 (10400) |
| 2400-0363 | | | | | | | |
| 2400-0364 | | | | | | | |
| 2400-0365 | 49,66 | 48,4 | | | | | |
| 2400-0366 | | | | | | | |
| 2400-0367 | | | | | | | |
| 2400-0368 | | | | | | | |
| 2400-1129 | 50,00 | 48,7 | | | | | |
| 2400-1131 | | | 40—118 | 40—160 | 127000 (12950) | 138500 (14100) | 155500 (15780) |
| 2400-0369 | | | | | | | |
| 2400-0370 | | | | | | | |
| 2400-0371 | 49,66 | 48,4 | | | | | |
| 2400-0372 | | | | | | | |
| 2400-0373 | | | | | | | |
| 2400-0374 | | | | | | | |
| 2400-1132 | 52,00 | 50,6 | | | | | |
| 2400-1133 | | | 24—58 | 24—85 | 95000 (9700) | 103000 (10500) | 115500 (11800) |
| 2400-0375 | | | | | | | |
| 2400-0376 | | | | | | | |
| 2400-0377 | 51,60 | 50,2 | | | | | |
| 2400-0378 | | | | | | | |
| 2400-0379 | | | | | | | |
| 2400-0380 | 52,00 | 50,6 | 40—118 | 40—160 | 132300 (13600) | 144400 (14700) | 162000 (16500) |
| 2400-1134 | | | | | | | |
| 2400-1135 | | | | | | | |

Продолжение табл. 3

Размеры в мм

| Обозначение протяжек | Номинальный диаметр отверстия | | Длина протягивания l_d | | Усилие протягивания P , Н (кгс) при переднем угле γ | | |
|----------------------|-------------------------------|-----------------------|----------------------------|-----------------------|--|-------------------|-------------------|
| | Посадка протягивания d | до протягивания d_0 | Сталь и алюминиевые сплавы | Чугун, бронза, латунь | | | |
| | | | | 20° | 15° | 10° | |
| 2400-0381 | 52,00 | 50,6 | | | | | |
| 2400-0382 | | | | | | | |
| 2400-0383 | 51,60 | 50,2 | 40—118 | 40—160 | 132300 (13500) | 144000 (14700) | 162000 (16500) |
| 2400-0384 | | | | | | | |
| 2400-1136 | | | | | | | |
| 2400-1137 | | | | | | | |
| 2400-1138 | 53,00 | 51,6 | | | | | |
| 2400-1139 | | | | | | | |
| 2400-1141 | | | | | | | |
| 2400-1142 | | | | | | | |
| 2400-1143 | 52,60 | 51,2 | | | | | |
| 2400-1144 | | | | | | | |
| 2400-1145 | | | H12 | | | | |
| 2400-1146 | | | | | | | |
| 2400-1147 | 53,00 | 51,6 | | | | | |
| 2400-1148 | | | | | | | |
| 2400-1149 | | | | | | | |
| 2400-1151 | | | | | | | |
| 2400-1152 | 52,60 | 51,2 | | | | | |
| 2400-1153 | | | | | | | |
| 2400-0385 | | | | | | | |
| 2400-0386 | | | | | | | |
| 2400-1154 | 55,00 | 53,6 | | | | | |
| 2400-1155 | | | | | | | |
| 2400-0387 | | | | | | | |
| 2400-0388 | | | | | | | |
| 2400-0389 | 54,60 | 53,2 | 24—58 | 24—85 | 101000 (10300) | 109000 (11140) | 122000 (12480) |
| 2400-0390 | | | | | | | |

Продолжение табл. 3

Размеры в мм

| Обозначение протяжек | Nominalnyy diametr otverstija | | Dlinna protygnivaniya r ₃ | | Usilie protygnivaniya P _H (kgc) pri peredljenii ugla Ψ | | |
|----------------------|-------------------------------|----------------------|--------------------------------------|--------------------------------|--|----------------|----------------|
| | Posle protygnivaniya d | do protygnivaniya do | | Stal' i aluminijevye spalivnye | Chugun, bronza, latuza | | |
| | | Nominal | Posle protygnivaniya d | | 20° | 15° | |
| 2400-0391 | | | | | | | |
| 2400-0392 | | | | | | | |
| 2400-1156 | 55,0 | 53,6 | | | | | |
| 2400-1157 | | | 40—118 | 40—160 | 140000 (14240) | 152000 (15500) | 172000 (17500) |
| 2400-0393 | | | | | | | |
| 2400-0394 | | | | | | | |
| 2400-0395 | 51,6 | 53,2 | | | | | |
| 2400-0396 | | | | | | | |
| 2400-1158 | | | | | | | |
| 2400-1159 | | | | | | | |
| 2400-1161 | 56,0 | 54,6 | | | | | |
| 2400-1162 | | | 24—58 | 24 | 102500 (10450) | 111000 (11350) | 125000 (12700) |
| 2400-1163 | | | | | | | |
| 2400-1164 | | | | | | | |
| 2400-1165 | | | | | | | |
| 2400-1166 | 55,6 | 51,2 | | | | | |
| 2400-1167 | | | | | | | |
| 2400-1168 | | | | | | | |
| 2400-1169 | | | | | | | |
| 2400-1171 | 56,0 | 54,6 | | | | | |
| 2400-1172 | | | 40—118 | 40—160 | 142500 (14500) | 155000 (15800) | 173500 (17650) |
| 2400-1173 | | | | | | | |
| 2400-1174 | | | | | | | |
| 2400-1175 | 55,6 | 51,2 | | | | | |
| 2400-0397 | | | | | | | |
| 2400-0398 | (58,0) | 56,6 | 24—58 | 21—85 | 106000 (10800) | 115500 (11750) | 129000 (13160) |
| 2400-1176 | | | | | | | |
| 2400-1177 | | | | | | | |

Продолжение табл. 3

Размеры в мм

| Обозначение протяжек | Номинальный диаметр отверстия | | Длина протягивания | | Усилие протягивания Р, Н (кгс) при переднем угле γ | | |
|----------------------|-------------------------------|--------------------------------|--------------------------|-----------------------|--|-------------------|-------------------|
| | Посадка протяжек d | до протягивания d ₀ | Сталь и алюминий, сплавы | Чугун, бронза, латунь | 20° | 15° | 10° |
| | | | Номин. | Посл. допуск | | | |
| 2400-0399 | (58,0) | 56,6 | | | | | |
| 2400-0400 | | | | | 106000 (10800) | 115500 (11750) | 129000 (13160) |
| 2400-0401 | 57,6 | 56,2 | | | | | |
| 2400-0402 | | | | | | | |
| 2400-0403 | | | | | | | |
| 2400-0404 | | | | | | | |
| 2400-1178 | (58,0) | 56,6 | | | | | |
| 2400-1179 | | | | | 147000 (15000) | 160000 (16340) | 180000 (18380) |
| 2400-0405 | | | | | | | |
| 2400-0406 | | | | | | | |
| 2400-0407 | 57,6 | 56,2 | | | | | |
| 2400-0408 | | | | | | | |
| 2400-0409 | | | | | | | |
| 2400-0410 | | | | | | | |
| 2400-1181 | 60,0 | 58,6 | H12 | | | | |
| 2400-1182 | | | | | | | |
| 2400-0411 | | | | | 110000 (11200) | 119000 (12150) | 133900 (13610) |
| 2400-0412 | | | | | | | |
| 2400-0413 | 59,6 | 58,2 | | | | | |
| 2400-0414 | | | | | | | |
| 2400-0415 | | | | | | | |
| 2400-0416 | | | | | | | |
| 2400-1183 | 60,0 | 58,6 | | | | | |
| 2400-1184 | | | | | 152500 (15550) | 166000 (16900) | 187000 (19000) |
| 2400-0417 | | | | | | | |
| 2400-0418 | | | | | | | |
| 2400-0419 | 59,6 | 58,2 | | | | | |
| 2400-0420 | | | | | | | |

Продолжение табл. 3

Размеры в мм

| Обозначение протяжек | Номинальный диаметр отверстия | | | Длина протягивания l_d | | Усилие протягивания P , Н (кгс) при переднем угле γ | | |
|----------------------|-------------------------------|-----------------------|---------------|----------------------------|-----------------------|--|-------------------|-------------------|
| | После протягивания d | до протягивания d_0 | | Сталь и алюминиевые сплавы | Чугун, бронза, латунь | | | |
| | | Ном.к. | Посл. допуска | | | 20° | 15° | 10° |
| 2400-0421 | | | | | | | | |
| 2400-0422 | | | | | | | | |
| 2400-1185 | 63,0 | 61,6 | | 24—58 | 24—85 | 115000 (11760) | 125000 (12750) | 140000 (14290) |
| 2400-1186 | | | | | | | | |
| 2400-0423 | | | | | | | | |
| 2400-0424 | | | | | | | | |
| 2400-0425 | 62,6 | 61,2 | | | | | | |
| 2400-0426 | | | | | | | | |
| 2400-0427 | | | | | | | | |
| 2400-0428 | | | | | | | | |
| 2400-1187 | | | | | | | | |
| 2400-1188 | 63,0 | 61,6 | | 40—125 | 40—170 | 161500 (16400) | 172000 (17500) | 196000 (20000) |
| 2400-0429 | | | | | | | | |
| 2400-0430 | | | | | | | | |
| 2400-0431 | 62,6 | 61,2 | H12 | | | | | |
| 2400-0432 | | | | | | | | |
| 2400-0433 | | | | | | | | |
| 2400-0434 | | | | | | | | |
| 2400-1189 | 65,0 | 63,6 | | 24—58 | 24—85 | 118800 (12100) | 129000 (13180) | 145000 (14750) |
| 2400-1191 | | | | | | | | |
| 2400-0435 | | | | | | | | |
| 2400-0436 | | | | | | | | |
| 2400-0437 | 64,6 | 63,2 | | | | | | |
| 2400-0438 | | | | | | | | |
| 2400-0439 | | | | | | | | |
| 2400-0440 | 65,0 | 63,6 | | 40—130 | 40—185 | 186600 (19000) | 197500 (20100) | 226000 (23100) |
| 2400-1192 | | | | | | | | |
| 2400-1193 | | | | | | | | |

Продолжение табл. 3

Размеры в мм

| Обозначение протяжек | Номинальный диаметр отверстия | | Длина протягивания l_d | | Усилие протягивания P , Н (кгс) при переднем угле γ | | | | |
|----------------------|-------------------------------|----------|--------------------------|----------------|--|-----------------------|-------------------|-------------------|-------------------|
| | После протягивания d | Номинал. | до протягивания d_0 | | Сталь и алюминиевые сплавы | Чугун, бронза, латунь | 20° | 15° | 10° |
| | | | Номинал. | После подрезки | | | | | |
| 2400-0441 | 65,0 | 63,6 | | | | | | | |
| 2400-0442 | | | | | 40—130 | 40—185 | 186500 (19000) | 197000 (20100) | 227000 (23100) |
| 2400-0443 | 64,6 | 63,2 | | | | | | | |
| 2400-0444 | | | | | | | | | |
| 2400-0445 | | | | | | | | | |
| 2400-0446 | | | | | | | | | |
| 2400-1194 | 70,0 | 68,6 | | | | | | | |
| 2400-1195 | | | | | | | | | |
| 2400-0447 | | | | | 26—63 | 26—95 | 128500 (13100) | 139000 (14200) | 156000 (15880) |
| 2400-0448 | | | | | | | | | |
| 2400-0449 | 69,6 | 68,2 | | | | | | | |
| 2400-0450 | | | | | | | | | |
| 2400-0451 | | | | | | | | | |
| 2400-0452 | | | | | | | | | |
| 2400-1196 | 70,0 | 68,6 | <i>H12</i> | | | | | | |
| 2400-1197 | | | | | | | | | |
| 2400-0453 | | | | | 42—170 | 42—215 | 214000 (21800) | 231000 (23600) | 260000 (26470) |
| 2400-0454 | | | | | | | | | |
| 2400-0455 | 69,6 | 68,2 | | | | | | | |
| 2400-0466 | | | | | | | | | |
| 2400-1198 | | | | | | | | | |
| 2400-1199 | | | | | | | | | |
| 2400-1201 | 71,0 | 69,6 | | | | | | | |
| 2400-1202 | | | | | | | | | |
| 2400-1203 | | | | | 26—63 | 26—95 | 131000 (13350) | 141500 (14400) | 158000 (16120) |
| 2400-1204 | | | | | | | | | |
| 2400-1205 | | | | | | | | | |
| 2400-1206 | 70,6 | 69,2 | | | | | | | |

Продолжение табл. 3

Размеры в мм

| Означение протяжек | Номинальный диаметр отверстия | | Длина протягивания l_d | | Усилие протягивания P , Н (кгс) при переднем угле γ | | |
|--------------------|-------------------------------|-----------------------|----------------------------|-----------------------|--|-------------------|-------------------|
| | после протяжки d | до протягивания d_0 | Сталь и алюминиевые сплавы | Чугун, бронза, латунь | 20° | 15° | 10° |
| 2400-1207 | | | | | | | |
| 2400-1208 | | | | | | | |
| 2400-1209 | | | | | | | |
| 2400-1211 | 71,0 | 69,6 | | | | | |
| 2400-1212 | | | 42-170 | 42-215 | 217000 (22100) | 236000 (24000) | 263000 (26860) |
| 2400-1213 | | | | | | | |
| 2400-1214 | 70,6 | 69,2 | | | | | |
| 2400-1215 | | | | | | | |
| 2400-0457 | | | | | | | |
| 2400-0458 | | | | | | | |
| 2400-1216 | 75,0 | 73,5 | | | | | |
| 2400-1217 | | | 26-63 | 26-95 | 137000 (14050) | 149000 (15200) | 167000 (17020) |
| 2400-0459 | | | | | | | |
| 2400-0460 | | | | | | | |
| 2400-0461 | 74,6 | 73,1 | H12 | | | | |
| 2400-0462 | | | | | | | |
| 2400-0463 | | | | | | | |
| 2400-0464 | | | | | | | |
| 2400-1218 | 75,0 | 73,5 | | | | | |
| 2400-1219 | | | 42-150 | 42-215 | 224000 (22900) | 244000 (24900) | 274000 (27870) |
| 2400-0465 | | | | | | | |
| 2400-0466 | | | | | | | |
| 2400-0467 | 74,6 | 73,1 | | | | | |
| 2400-0468 | | | | | | | |
| 2400-0469 | | | | | | | |
| 2400-0470 | | | | | | | |
| 2400-1221 | 80,0 | 78,5 | 26-63 | 26-95 | 148000 (15100) | 159000 (16200) | 178000 (18160) |
| 2400-1222 | | | | | | | |

Продолжение табл. 3

Размеры в мм

| Обозначение протяжек | Номинальный диаметр отверстия | | Диаметр протягивания d_g | | Усилие протягивания P , Н (кгс) при переднем угле γ | | |
|----------------------|-------------------------------|----------------------------|----------------------------------|-----------------------------|--|-------------------|-------------------|
| | после протя- гивания d | до протя- гивания d_g | Сталь и алюминиевые сплавы | Чугун, бронза, латунь | | | |
| | Номин. | После вспуска | | | 20° | 15° | 10° |
| 2400-0471 | 80,00 | 78,5 | | | | | |
| 2400-0472 | | | 26-63 | 26-95 | 148000 (15100) | 159000 (16200) | 178000 (18160) |
| 2400-0473 | | | | | | | |
| 2400-0474 | 79,60 | 78,1 | | | | | |
| 2400-0475 | | | | | | | |
| 2400-0476 | | | | | | | |
| 2400-1223 | | | | | | | |
| 2400-1224 | 80,00 | 78,5 | | | | | |
| 2400-0477 | | | 42-160 | 42-215 | 246000 (25000) | 265000 (27000) | 297000 (30260) |
| 2400-0478 | | | | | | | |
| 2400-0479 | | | | | | | |
| 2400-0480 | 79,60 | 78,1 | | | | | |
| 2400-0481 | | | | | | | |
| 2400-0482 | | | | | | | |
| 2400-1225 | | | <i>H12</i> | | | | |
| 2400-1226 | 85,00 | 83,5 | | | | | |
| 2400-0483 | | | | | | | |
| 2400-0484 | | | | | | | |
| 2400-0485 | 84,54 | 83,0 | | | | | |
| 2400-0486 | | | | | | | |
| 2400-0487 | | | | | | | |
| 2400-0488 | | | | | | | |
| 2400-1227 | 85,00 | 83,5 | | | | | |
| 2400-1228 | | | | | | | |
| 2400-0489 | | | 42-190 | 42-230 | 274000 (28000) | 296000 (30100) | 333000 (34000) |
| 2400-0490 | | | | | | | |
| 2400-0491 | | | | | | | |
| 2400-0492 | 84,54 | 83,0 | | | | | |

Размеры в мм

Продолжение табл. 3

| Обозначение протяжек | Номинальный диаметр отверстия | | Длина протягивания l_d | | Усилие протягивания P , Н (кгс) при переднем угле γ | | | | |
|----------------------|-------------------------------|--------|----------------------------|--|--|-----------------------------|-------------------|-------------------|-------------------|
| | После проя- гивания d | Номин. | до протя- гивания d_0 | | Сталь и алюмини- евые сплавы | Чугун, бронза, латунь | 20° | 15° | 10° |
| | | | После ану- са | | | | | | |
| 2400-0493 | | | | | | | | | |
| 2400-0494 | | | | | | | | | |
| 2400-1229 | 90,00 | 88,5 | | | | | | | |
| 2400-1231 | | | | | 40—120 | 40—175 | 240900 (24600) | 259000 (26400) | 290200 (29730) |
| 2400-0495 | | | | | | | | | |
| 2400-0496 | | | | | | | | | |
| 2400-0497 | 89,54 | 88,00 | | | | | | | |
| 2400-0498 | | | | | H12 | | | | |
| 2400-0499 | | | | | | | | | |
| 2400-0500 | | | | | | | | | |
| 2400-1232 | 90,00 | 88,5 | | | | | | | |
| 2400-1233 | | | | | 45—220 | 45—250 | 288000 (29400) | 313000 (31900) | 350800 (35880) |
| 2400-0501 | | | | | | | | | |
| 2400-0502 | | | | | | | | | |
| 2400-0503 | | | | | | | | | |
| 2400-0504 | 89,54 | 88,0 | | | | | | | |

Примечание. Размеры, заключенные в скобки, по возможности не применять.

4. Наибольшая расчетная сила протягивания P указана для обработки деталей из стали I—V групп обрабатываемости (по приложению 3). Для определения усилия протягивания для закаленных сталей и других материалов величину P следует умножить на коэффициент K , указанный в табл. 4.

| Обрабатываемый материал | Твердость НВ | K |
|---|--------------|-----|
| Стали I—V групп обрабатываемости в закаленном состоянии | <285 | 1,2 |
| | 285...336 | 1,3 |
| | 336...375 | 1,4 |
| Инструментальные легированные, быстрорежущие стали и сталь марки ШХ15 | 204...229 | 1,4 |
| Чугуны VI и VII групп обрабатываемости | <229 | 0,5 |
| | ≥229 | 0,7 |
| Бронзы, латуни VIII и IX групп обрабатываемости | <110 | 0,4 |
| Алюминиевые сплавы X группы обрабатываемости | <100 | 0,4 |

3, 4. (Измененная редакция, Изм. № 1).

5. Центровые отверстия — по ГОСТ 14034—74.
 6. Хвостовики протяжек типа 2 исполнения 1 или 3 — по ГОСТ 4044—70.

(Измененная редакция, Изм. № 3).

7. Неуказанные предельные отклонения размеров: валов — $h14$; остальных $\pm \frac{IT14}{2}$.

(Измененная редакция, Изм. № 1).

8. Группы заточки, форма передней грани зубьев протяжек указаны в приложении 1.

9. Форма и размеры профиля зубьев протяжек указаны в приложении 2 (рекомендуемом).

10. Задний угол зубьев протяжек должен быть:

| | |
|---------------------------------|-----|
| черновых и переходных | 3°; |
| чистовых | 2°; |
| калибрующих | 1°. |

11. Выкружки на переходных и чистовых зубьях следует располагать в шахматном порядке друг к другу и к первому зубу последней черновой секции.

12. По заказу потребителя допускается изготавливать протяжки с узкими стружкоразделительными канавками на чистовых зубьях.

13. По заказу потребителя допускается изменять общую длину протяжки за счет изменения длины до первого зуба l_1 и за счет изменения длины заднего хвостовика для протяжек исполнения 2.

14. Группы обрабатываемости протягиваемых материалов указаны в приложении 3 (справочном).

15. Для протягивания отверстий в деталях из стали V группы обрабатываемости протяжки с подачей более 0,05 мм на сторону применять не рекомендуется.

16. Показатели надежности протяжек из стали марки Р18 и стали марки Р6М6 указаны в справочном приложении 4.

17. Типовой чертеж протяжки указан в справочном приложении 5.

18. Остальные технические требования — по ГОСТ 9126—76.

ПРИЛОЖЕНИЕ I

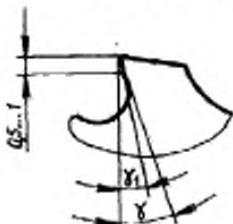
ГРУППЫ ЗАТОЧКИ И ФОРМА ПЕРЕДНЕЙ ГРАННИ ЗУБЬЕВ ПРОТЯЖЕК

1. Группы заточки, форма передней грани и величина переднего угла черновых, переходных, чистовых и калибрующих зубьев протяжек должны соответствовать указанным на чертеже и в таблице.

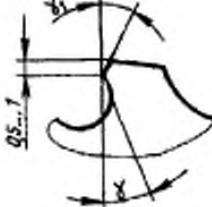
Форма А



Форма Б



Форма В



| Группа заточки | Передний угол | | | | | | Рекомендуемые материалы по группам обрабатываемости | |
|----------------|------------------------------|----------|-------------------------------|----------|------------|--|---|--|
| | черновых и переходных зубьев | | чистовых и калибрующих зубьев | | | | | |
| | форма | γ | форма | γ | γ_1 | | | |
| I | | 20°* | | 20°* | — | Стали I групп обрабатываемости, алюминиевые сплавы X групп обрабатываемости | | |
| II | A | 15°* | A | 18°* | — | Стали II и III групп обрабатываемости | | |
| III | | 10° | | 10° | — | Стали IV и V групп обрабатываемости | | |
| IV | | 10° | B | 10° | 0-5° | Чугун ковкий VI и VII групп обрабатываемости | | |
| V | | 10° | B | 10° | 0-5° | Чугун серый VI и VII групп обрабатываемости, бронза, латунь VIII и IX групп обрабатываемости | | |

* Для протяжек диаметром до 20 мм допускается передний угол $\gamma = 10^\circ$.

2. Группы обрабатываемости материалов указаны в справочном приложении 3.

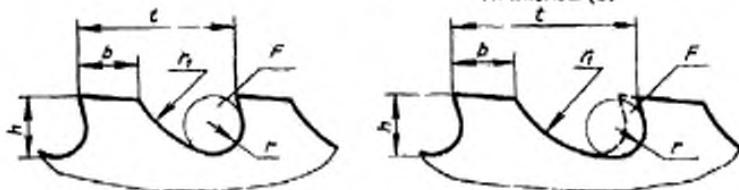
(Измененная редакция, Изм. № 1).

ПРИЛОЖЕНИЕ 2
Рекомендуемое

ФОРМА И РАЗМЕРЫ ПРОФИЛЯ ЗУБЬЕВ ПРОТЯЖЕК

1. Форма и размеры профиля зубьев протяжек указаны на черт. 1 и в табл. 1.

Профиль с удлиненной стружечной канавкой (У)



Черт. 1

Таблица 1

Размеры в мм

| Номер профиля | t | b | r | b | r_1 | Активная пасечка P , мм | Номер профиля | t | b | r | b | r_1 | Активная пасечка P , мм |
|---------------|-----|-----|-----|-----|-------|---------------------------|---------------|-----|-----|-----|-----|-------|---------------------------|
| 1 | 4,0 | 1,6 | 0,8 | 1,5 | 2,5 | 1,77 | 2У | | 1,8 | 0,9 | 2,7 | 2,8 | 2,54 |
| 2 | | 1,8 | 0,9 | 1,2 | 2,8 | 2,54 | 3 | 6,0 | 2,0 | 1,0 | 3,0 | 3,0 | 3,14 |
| 1 | | 1,6 | 0,8 | 2,0 | 2,5 | 1,77 | 4 | | 2,5 | 1,3 | 2,0 | 4,0 | 4,90 |
| 2 | 4,5 | 1,8 | 0,9 | 1,7 | 2,8 | 2,54 | 3У | 2,0 | 1,0 | 3,5 | 3,0 | 3,14 | |
| 3 | | 2,0 | 1,0 | 1,5 | 3,0 | 3,14 | 4 | 7,0 | 2,5 | 1,3 | 3,0 | 4,0 | 4,90 |
| 1У | | 1,6 | 0,8 | | 2,2 | 1,77 | 5 | | 3,0 | 1,5 | 2,3 | 5,0 | 7,10 |
| 2 | 5,0 | 1,8 | 0,9 | | 2,8 | 2,54 | 4 | | 2,5 | 1,3 | 4,0 | 4,0 | 4,90 |
| 3 | | 2,0 | 1,0 | 2,0 | 3,0 | 3,14 | 5 | 8,0 | 3,0 | 1,5 | 3,3 | 5,0 | 7,10 |
| 1У | | 1,6 | 0,8 | 2,5 | 2,5 | 1,77 | 6 | | 3,6 | 1,8 | 2,5 | 5,5 | 9,60 |
| 2 | 5,5 | 1,8 | 0,9 | 2,7 | 2,8 | 2,54 | | | | | | | |
| 3 | | 2,0 | 1,0 | 2,5 | 3,0 | 3,14 | | | | | | | |

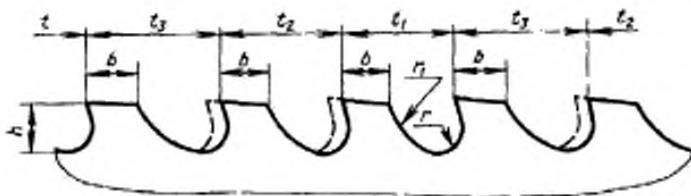
Продолжение табл. I

Размеры в мм

| Номер профиля | <i>t</i> | <i>h</i> | <i>r</i> | <i>b</i> | <i>r₁</i> | Активная защемка <i>F₁</i> , мм ² | Номер профиля | <i>t</i> | <i>h</i> | <i>r</i> | <i>b</i> | <i>r₁</i> | Активная защемка <i>F₁</i> , мм ² |
|---------------|----------|----------|----------|----------|----------------------|---|---------------|----------|----------|----------|----------|----------------------|---|
| 4У | 9 | 2,5 | 1,3 | 4,0 | 4,0 | 4,9 | 10У | 6 | 3,0 | 8,5 | 10 | 28,3 | |
| 5 | | 3,0 | 1,5 | 4,3 | 5,0 | 7,1 | 11 | 7 | 3,5 | 8,0 | 11 | 38,5 | |
| 6 | | 3,6 | 1,8 | 3,5 | 5,5 | 6,6 | 12 | 8 | 4,0 | 7,0 | 12 | 50,3 | |
| 5У | | 3,0 | 1,5 | 4,3 | 5,0 | 7,1 | 11 | 7 | 3,5 | 9,0 | 11 | 38,5 | |
| 6 | 10 | 3,6 | 1,8 | 4,5 | 5,5 | 9,6 | 12 | 8 | 4,0 | 8,0 | 12 | 50,3 | |
| 7 | | 4,0 | 2,0 | 3,5 | 6,0 | 12,6 | 13 | 9 | 4,5 | 6,0 | 14 | 63,6 | |
| 6У | | 3,6 | 1,8 | 4,5 | 5,5 | 9,6 | 11У | 7 | 3,5 | 9,0 | 11 | 38,5 | |
| 7 | 11 | 4,0 | 2,0 | 4,5 | 6,0 | 12,6 | 12 | 8 | 4,0 | 9,0 | 12 | 50,3 | |
| 8 | | 4,5 | 2,3 | 4,0 | 7,0 | 15,9 | 13 | 9 | 4,5 | 7,0 | 14 | 63,6 | |
| 7 | | 4,0 | 2,0 | 5,5 | 6,0 | 12,6 | 11У | 7 | 3,5 | 9,0 | 11 | 38,5 | |
| 8 | 12 | 4,5 | 2,3 | 5,0 | 7,0 | 15,9 | 12У | 8 | 4,0 | 9,0 | 12 | 50,3 | |
| 9 | | 5,0 | 2,5 | 4,0 | 8,0 | 19,6 | 13 | 9 | 4,5 | 8,0 | 14 | 63,6 | |
| 7У | | 4,0 | 2,0 | 5,5 | 6,0 | 12,6 | 12У | 8 | 4,0 | 9,0 | 12 | 50,3 | |
| 8 | 13 | 4,5 | 2,3 | 6,0 | 7,0 | 15,9 | 13 | 9 | 4,5 | 10,0 | 14 | 63,6 | |
| 9 | | 5,0 | 2,5 | 5,0 | 8,0 | 19,6 | 14 | 10 | 5,0 | 8,5 | 16 | 78,5 | |
| 8У | | 4,5 | 2,3 | 6,0 | 7,0 | 15,9 | 12У | 8 | 4,0 | 10,0 | 12 | 50,3 | |
| 9 | 14 | 5,0 | 2,5 | 6,0 | 8,0 | 19,6 | 13У | 9 | 4,5 | 10,0 | 14 | 63,6 | |
| 10 | | 6,0 | 3,0 | 4,5 | 10,0 | 28,3 | 14 | 10 | 5,0 | 9,5 | 16 | 78,5 | |
| 8У | | 4,5 | 2,3 | 6,0 | 7,0 | 15,9 | 12У | 8 | 4,0 | 10,5 | 12 | 50,3 | |
| 9 | 15 | 5,0 | 2,5 | 7,0 | 8,0 | 19,6 | 13У | 9 | 4,5 | 10,0 | 14 | 63,6 | |
| 10 | | 6,0 | 3,0 | 5,5 | 10,0 | 28,3 | 14 | 10 | 5,0 | 10,5 | 16 | 78,5 | |
| 9У | | 5,0 | 2,5 | 7,0 | 8,0 | 19,6 | 13У | 9 | 4,5 | 10,5 | 14 | 63,6 | |
| 10 | 16 | 6,0 | 3,0 | 6,5 | 10,0 | 28,3 | 14У | 10 | 5,0 | 10,5 | 16 | 78,5 | |
| 11 | | 7,0 | 3,5 | 5,0 | 11,0 | 38,5 | 15 | 12 | 6,0 | 9,5 | 20 | 113,1 | |
| 9У | | 5,0 | 2,5 | 7,0 | 8,0 | 19,6 | 13У | 9 | 4,5 | 12 | 14 | 63,6 | |
| 10 | 17 | 6,0 | 3,0 | 7,5 | 10,0 | 28,3 | 14У | 10 | 5,0 | 12 | 16 | 78,5 | |
| 11 | | 7,0 | 3,5 | 6,0 | 11,0 | 38,5 | 15 | 12 | 6,0 | 11,5 | 20 | 113,1 | |
| 10 | | 6,0 | 3,0 | 8,5 | 10,0 | 28,3 | 13У | 9 | 4,5 | 14 | 16 | 63,6 | |
| 11 | 18 | 7,0 | 3,5 | 7,0 | 11,0 | 38,5 | 14У | 10 | 5,0 | 12,0 | 16 | 78,5 | |
| 12 | | 8,0 | 4,0 | 6,0 | 12,0 | 50,3 | 15У | 12 | 6,0 | 20 | 113,1 | | |

Примечание. Удлиненная форма профиля У выполняется тем же размером при его продольном перемещении.

2. Шаги чистовых и калибрующих зубьев (t_1 ; t_2 ; t_3) неравномерные и устанавливаются в соответствие с черт. 2 и табл. 2.



Черт. 2

Таблица 2

мм

| t | t_1 | t_2 | t_3 | t_1 | t | t_3 | t_2 | t_1 |
|------|---------|-----------|-------|-------|-----|---------|---------|-------|
| 4,0 | — | — | — | 4,0 | 16 | — | — | 11 |
| 4,5 | — | — | — | 4,0 | 17 | — | — | 12 |
| 5,0 | — | — | — | 4,0 | 18 | — | — | 13 |
| 5,5 | — | — | — | 4,0 | 19 | — | — | 14 |
| 6,0 | t_1+1 | $t_1+0,5$ | — | 4,5 | 20 | t_1+2 | t_1+1 | — |
| 7,0 | | | — | 5,0 | 21 | | | 15 |
| 8,0 | — | — | — | 5,5 | 22 | — | — | 16 |
| 9,0 | — | — | — | 6,0 | 24 | — | — | 17 |
| 10,0 | — | — | — | 7,0 | 25 | — | — | 18 |
| 11,0 | — | — | — | 7,0 | 26 | — | — | 19 |
| 12,0 | t_1+2 | t_1+1 | — | 8,0 | 28 | t_1+4 | t_1+2 | — |
| 13,0 | | | — | 9,0 | 30 | | | 20 |
| 14,0 | — | — | — | 10,0 | 32 | — | — | 22 |
| 15,0 | — | — | — | 11,0 | — | — | — | — |

Примечание. Размеры профиля чистовых и калибрующих зубьев h ; b ; r ; r_1 устанавливаются в зависимости от шага t_1 для всех трех шагов одинаковыми. Форма профиля зубьев протяжек для шагов t_2 и t_3 удлиненная.

(Измененная редакция, Изд. № 1).

ПРИЛОЖЕНИЕ 5
Справочное

ГРУППЫ ОБРАБАТЫВАЕМОСТИ ПРОТЯГИВАЕМЫХ МАТЕРИАЛОВ

Группы обрабатываемости сталей указаны в табл. 1.

Таблица 1

| Материал | Группы обрабатываемости | | | | Твердость НВ |
|---|-------------------------|-----------|-----------|-----------|--------------|
| | I | II | III | IV | |
| A12, A20, A30 по ГОСТ 1414—75 | <229 | — | — | — | — |
| 10, 15, 20, 25 по ГОСТ 1050—74 | <229 | — | — | — | — |
| 30, 35, 40, 45, 50 по ГОСТ 1050—74 | <255 | 255...285 | 285...321 | 321...364 | — |
| 65, 70, 80 по ГОСТ 14859—79 | <229 | 229...255 | 255...285 | 285...321 | 321...364 |
| 15Г, 20Г, 30Г по ГОСТ 4543—71 | <241 | 241...269 | 269...302 | — | — |
| 40Г, 45Г, 50Г, 35Г2, 45Г2, 50Г2 по ГОСТ 4543—71 | <229 | 229...255 | 255...285 | 285...321 | 321...364 |
| 60Г, 65Г, 70Г по ГОСТ 14959—79 | — | <241 | 241...269 | 269...321 | 321...340 |
| 15Х, 15ХА, 20Х, 30Х по ГОСТ 4543—71 | <255 | 255...302 | — | — | — |
| 35Х, 30ХР4, 38ХА, 40Х, 45Х, 50Х по ГОСТ 4543—71 | <229 | 229...269 | 269...302 | 302...340 | 340...364 |
| 33ХС, 38ХС, 40ХС по ГОСТ 4543—71 | — | <229 | 229...269 | 269...302 | 302...340 |

Продолжение табл. I

| Материал | Марка | Группы обрабатываемости | | | | |
|--|-----------|-------------------------|-----------|-----------|-----------|---|
| | | I | II | III | IV | V |
| Твердость НВ | | | | | | |
| 18ХГ, 20ХГП, 40ХГТР по ГОСТ 4543-71 | <229 | 229...269 | 269...321 | 321...340 | 340...364 | |
| 12ХН3А, 12Х2Н4А, 20ХН1, 20ХНР, 20ХН3А, 20Х2Н4А, 30ХН3А, 40ХН, 45ХН, 50ХН по ГОСТ 4543-71 | <241 | 241...269 | 269...302 | 302...321 | 321...364 | |
| 15ХФ по ГОСТ 4543-71 | <229 | 229...269 | 269...302 | 302...321 | 321...364 | |
| 40ХФА по ГОСТ 4543-71 | — | <255 | 255...285 | 285...321 | 321...340 | |
| 15ХМ по ГОСТ 4543-71 | <229 | 229...269 | 269...302 | 302...340 | — | |
| 30ХМА, 35ХМ по ГОСТ 4543-71 | — | <229 | 229...269 | 269...321 | 321...340 | |
| 20ХГНР, 38ХГН по ГОСТ 4543-71 | <241 | 241...269 | 269...302 | 302...321 | 321...364 | |
| 229...255 | 255...285 | 285...302 | 302...321 | | | |
| 20ХГСА, 25ХГСА, 30ХГС, 35ХГС по ГОСТ 4543-71 | — | <229 | 229...269 | 269...321 | 321...340 | |
| 20ХН4ФА по ГОСТ 4543-71 | — | — | <255 | 255...285 | 285...321 | |
| 25Х2Н4МА, 18Х2Н4МА по ГОСТ 4543-71 | — | — | <255 | 255...285 | 285...321 | |
| 40Х2Н2МА, 38Х2Н2МА по ГОСТ 4543-71 | — | <229 | 229...269 | 269...302 | 302...340 | |

Продолжение табл. 1

| Материал | Марка | Группы обрабатываемости | | | | | |
|-------------------------------------|-------|-------------------------|-----------|-----------|-----------|-----------|-----------|
| | | I | II | III | IV | V | V |
| 14Х2Н3МА, 20ХН2М по ГОСТ 4543—71 | — | — | — | ≤255 | 255...269 | 269...321 | 269...321 |
| 40ХН2МА по ГОСТ 4543—71 | — | — | — | ≤269 | 269...321 | 321...340 | 321...340 |
| 38Х2МЮА, 38Х2Ю по ГОСТ 4543—71 | — | — | — | ≤269 | 269...302 | 302...340 | 302...340 |
| 18ХТ по ГОСТ 4543—71 | ≤255 | 255...302 | 302...321 | — | — | — | — |
| 30ХТ, 35ХГФ, 40ХТТР по ГОСТ 4543—71 | ≤229 | 229...269 | 269...302 | 302...321 | 302...321 | 321...340 | 321...340 |
| 15ХГН2ТА по ГОСТ 4543—71 | ≤229 | 229...269 | 269...302 | 302...321 | 302...321 | — | — |
| ЦХ15 по ГОСТ 801—78 | — | — | — | — | ≤229 | — | — |
| Р9, Р18 по ГОСТ 19265—73 | — | — | — | — | — | 207...255 | 207...255 |

2. Группы обрабатываемости чугуна, стальных и цветных металлов указанны в табл. 2.

Таблица 2

| Наименование | Материал | Группы обрабатываемости | | | | | |
|---|--|-------------------------|-----------|------|----|---|---|
| | | VI | VII | VIII | IX | X | |
| Твердость HB | | | | | | | |
| Чугун серый | СЧ15, СЧ18, СЧ21—40, СЧ40 по ГОСТ 1412—79 | ≤197 | 197...269 | — | — | — | — |
| Чугун ковкий (ферритный) | КЧ30—6, КЧ33—8, КЧ35—10, КЧ37—12 по ГОСТ 1215—79 | ≤163 | — | — | — | — | — |
| Чугун ковкий (со структурой зернистого перлита) | КЧ45—7 по ГОСТ 1215—79 | ≤217 | — | — | — | — | — |
| Чугун ковкий | КЧ50—5, КЧ55—4 по ГОСТ 1215—79 | — | 179...269 | — | — | — | — |
| Чугун серый антифрикционный | АЧС1, АЧС2 по ГОСТ 1585—79 | 160...229 | — | — | — | — | — |
| Чугун ковкий антифрикционный | АЧК1, АЧК2 по ГОСТ 1585—79 | 167...217 | — | — | — | — | — |

Продолжение табл. 2

| Наименование | Материал | Группы обрабатываемости | | | | | Твердость НВ |
|---------------------|---|-------------------------|-----|------|------------------|---|--------------|
| | | V1 | VII | VIII | IX | X | |
| Бронзы безоловянные | БРА5, БРА7, БРАЖ9-4, БРАЖМ1-10-3-15, Бр.КМ13-1, Бр.КН1-3 по ГОСТ 18175-78, БрА9Ж3Л, БрА10Ж4Н4Л по ГОСТ 493-79 | - | - | - | 65..140 140..200 | - | |
| Бронзы оловянные | БрО5И5С5, БрОЗЧ1:2С5, БрОЗЛ7СН1 по ГОСТ 613-79; Бр.ОЛС4-4-2,5; по ГОСТ 5017-74 | - | - | - | <70 | - | - |
| | Бр.ОФ6,5-0,15, Бр.ОФ4-0,25 по ГОСТ 5017-74 | - | - | - | <130 130..200 | - | |
| Латунь | ЛЛ16К4, ЛЛ140С, ЛЛ38Ми2С2 по ГОСТ 17711-80 Л63, Л68, Л70, ЛА77-2 ЛМи58-2, ЛМПА57-3-1, ПО62-1, ЛС59-1, ЛАЖ60-1-1 по ГОСТ 15827-70 | - | - | - | <160 | - | |

Продолжение табл. 2

| Нанесение | Материя | Группы обрабатываемости | | | |
|--------------|---------|--|------|----|---|
| | | VII | VIII | IX | X |
| Твердость HB | | | | | |
| Литенование | Марка | АЛ1, АЛ2, АЛ3, АЛ4, АЛ5, АЛ6, АЛ7, АЛ8, АЛ9, АЛ10В, АЛ11, АЛ13, АЛ14В, АЛ15В, АЛ16В, АЛ17В, АЛ18В по ГОСТ 2835—65; Д1, Д16, АВ, АП, АД1, АМ2, В95, АК4, АК6, АК8 по ГОСТ 4784—74 | — | — | — |

(Измененная редакция, Изд. № 1).

ПРИЛОЖЕНИЕ 4
Справочное

Показатели надежности протяжек по ГОСТ 13377—75, и режимы протягивания при обработке деталей из стали I, II, III групп обрабатываемости, чугуна VI, VII групп обрабатываемости не должны быть менее приведенных в таблице.

| Группа обрабатываемости | Класс шероховатости обработанной поверхности по ГОСТ 2789—73 | Скорость протягивания, м/мин | Тип инструментального производства | | | | | |
|-------------------------|--|------------------------------|--|----------|----------|----------|---------------------------|----------|
| | | | Крупносерийное | | Серийное | | Мелкосерийное и единичное | |
| | | | Девяностопятипроцентная T_{50} и медианная T_{50} наработка протяжки, метры протянутой поверхности | | | | | |
| | | | T_{50} | T_{50} | T_{50} | T_{50} | T_{50} | T_{50} |
| I | 7 | 6 | 69 | 79 | 59 | 78 | 54 | 76 |
| | 6 | 8 | 59 | 68 | 50 | 66 | 44 | 66 |
| II | 7 | 6 | 56 | 65 | 48 | 64 | 42 | 60 |
| | 6 | 7 | 52 | 60 | 44 | 59 | 40 | 58 |
| III | 7 | 5 | 50 | 59 | 43 | 58 | 38 | 56 |
| | 6 | 6 | 46 | 54 | 39 | 54 | 36 | 50 |
| VI | 7 | 7 | 76 | 86 | 64 | 82 | 56 | 78 |
| | 6 | 9 | 68 | 77 | 56 | 72 | 50 | 69 |
| VII | 7 | 5 | 61 | 70 | 50 | 66 | 46 | 63 |
| | 6 | 6 | 56 | 65 | 46 | 60 | 42 | 58 |

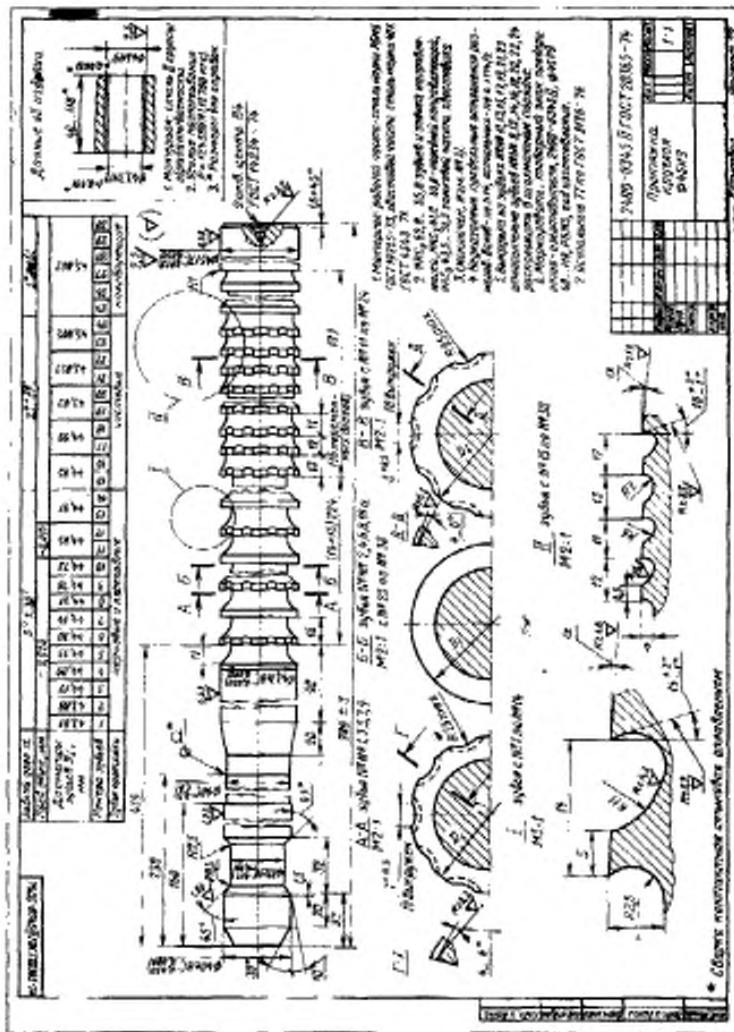
Примечание: 1. T_{50} — медианная наработка соответствует величине средней стойкости протяжки между переточками и используется предприятием потребителем при планировании потребности в протяжном инструменте.

2. T_{50} — девяностопятипроцентная наработка является периодом планово-принудительной переточки или замены, обеспечивающим условия рациональной эксплуатации протяжного инструмента: стабильность величины шероховатости формы и размеров обрабатываемых поверхностей в пределах оговоренных требований, отсутствие интенсивного изнашивания рабочих поверхностей и излипания на них стружки.

ПРИЛОЖЕНИЕ 5

Справочное

ТИПОВОЕ ОФОРМЛЕНИЕ ЧЕРТЕЖА ПРОТЯЖКИ



(Измененная редакция, Изм. № 1, Изм. № 3).

Изменение № 4 ГОСТ 20365-74 Протяжки круглые переменного резания диаметром от 14 до 90 мм. Конструкция и размеры

Утверждено и введено в действие Постановлением Государственного комитета СССР по стандартам от 23.09.87 № 3624

Дата введения 01.02.88

Пункт 2. Чертеж 1. Размеры l_2 , l_3 дополнить знаком сноски *;

чертеж дополнить сноской *: «* Размеры для справок»;

таблица 1. Графа D_4 . Заменить значение: 60 на 63;

графа 1. Заменить значения: 5,5 на 6,5 (для протяжек 2400-0181—2400-0186); 8,0 на 7,0 (для протяжек 2400-0187—2400-0192); 6,5 на 9,5 (для протяжек 2400-1092—2400-1095).

графа «Зубья протяжек. Чистовые и калибрующие. Число зубьев». Для протяжек 2400-0187—2400-0192 заменить значение: 16 на 18;

таблица 2. Для протяжек 2400-1043—2400-0198 и номеров зубьев 15—20 в наименованиях графы «Диаметры черновых зубьев D_1 » заменить слово: «черновых» на «чистовых»;

для протяжек 2400-0189—2400-0192 жирную линию между зубьями 16 и 17 заменить светлой линией; светлую линию между зубьями 14 и 15 заменить на жирную;

для протяжек 2400-0201, 2400-0202 заменить значения: 24,780 на 24,750 (номер зуба 16), 24,870 на 24,880 (номер зуба 17); для протяжек 2400-0273,

(Продолжение изменения к ГОСТ 20365—74)

2400-0274 и номера зуба 1 заменить значение: 32,980 на 32,970; для протяжек 2400-0313, 2400-0314 и номера зуба 7 заменить значение: 36,600 на 39,600; для протяжек 2400-0385, 2400-0386 и номеров зубьев 17 и 18 заменить значение: 94,97 на 54,97.

Пункт 7, приложение 5 (пункт 4). Заменить обозначения: $h14$ на $h16$, $\pm \frac{IT14}{2}$ на $\pm \frac{IT16}{2}$.

Пункт 16 исключить.

Приложение 1. Сноsku * изложить в новой редакции:

* Для протяжек диаметром до 20 мм, а также любого диаметра при высоте профиля зубьев $h < 2,5$ мм, допускается передний угол $\gamma = 10^\circ$; для протяжек диаметром свыше 20 до 30 мм — $\gamma = 12^\circ$.

Приложение 3. Заменить ссылки и марки: ГОСТ 1412—79 на ГОСТ 1412—85, ГОСТ 1585—79 на ГОСТ 1585—85, ГОСТ 2685—65 на ГОСТ 2685—75, АЛ10В на АК5М7, АЛ14В на АК7М2, АЛ15В на АК4М4, АЛ17В на АК4М2Ц6.

Приложение 4 исключить.

Приложение 5. Пункт 6. Заменить обозначение: 2400—0345II на 0345II;

чертеж. Размеры 224 и 193 дополнить знаком сноски **;

чертеж дополнить сноской **: ** Размеры для справок;

заменить размер: 415 на 415±5.

(ИУС № 1 1988 г.)

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