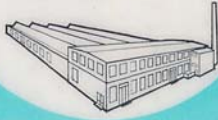




PROFILSLEBET
GEVINDVÆRKTØJ



| Materialer | Skærehastighed V (m/min.) | | Spånvinkel grader | Smøremiddel |
|---------------------------------|---------------------------|----|-------------------|--------------------------|
| | VS | HS | | |
| Aluminium, sandstøbt | 15 | 45 | 15° | Emulsion eller sprit |
| trukkert og trykstøbt | 15 | 45 | 25° | — |
| Bakelit | 6 | 18 | 0-5° | Tørt eller petroleum |
| Bladstøbegods | 6 | 18 | 6-10° | Emulsion |
| Bronce | 10 | 30 | 8° | — |
| Duralumin | 10 | 30 | 15° | — |
| Kobber | 10 | 30 | 20-30° | — eller skæreoile |
| Magniumlegeringer (elektron) | 15 | 45 | 15-20° | Tert |
| Messing, trukket og varmpresset | 15 | 45 | 10-15° | Emulsion |
| støbt | 15 | 45 | 0-5° | — |
| Rødgods | 15 | 45 | 0-5° | — |
| Silumin | 10 | 30 | 20-25° | — |
| Zink | 10 | 30 | 15-25° | — |
| Støbejern, blødt | 6 | 20 | 4-6° | Skæreoile eller emulsion |
| hårdt | 8 | 20 | 4-6° | — |
| Smødejern | 8 | 20 | 15° | — |
| Automatjern | 10 | 30 | 20° | — |
| Komp-akselstål | 8 | 25 | 10-15° | — |
| Stål til 45 kp/mm² | 8 | 25 | 12-15° | — |
| — 75 — | 6 | 20 | 10-12° | — |
| — over 75 — | 4 | 15 | 8-10° | — |
| Værktøjstål | 4 | 15 | 6-10° | — |
| Stålstøbegods | 4 | 15 | 8-12° | — |
| Kromnickelstål | 10 | 30 | 10-12° | — |
| Rustfrit stål | 8 | 25 | 15° | — |

De angivne skærehastigheder gælder for mellemtappe
Ved skæring med bakker må skærehastigheden formindskes ca. 50 %

| Rør-gev. | Gevinddia. | | Omdrejninger pr. minut | | | | | | | | | |
|----------|------------|-------|---|-----|-----|------|------|------|------|------|------|------|
| | WG | ISO-M | Når skærehastigheden V (m/min.) fra tabel I er: | | | | | | | | | |
| | | | 4 | 6 | 8 | 10 | 12 | 15 | 20 | 25 | 30 | 45 |
| R 1/8 | 1/8 | 3 | 420 | 636 | 850 | 1060 | 1270 | 1590 | 2120 | 2750 | 3180 | 4770 |
| | 5/32 | 4 | 320 | 478 | 638 | 800 | 955 | 1195 | 1600 | 2000 | 2390 | 3585 |
| | 3/16 | 5 | 230 | 382 | 510 | 635 | 764 | 955 | 1270 | 1590 | 1910 | 2865 |
| | 1/4 | 6 | 212 | 318 | 425 | 535 | 636 | 800 | 1070 | 1335 | 1600 | 2400 |
| | 5/16 | 8 | 150 | 240 | 318 | 400 | 478 | 600 | 800 | 1000 | 1200 | 1800 |
| R 1/4 | 3/8 | 10 | 128 | 190 | 255 | 320 | 382 | 480 | 640 | 800 | 960 | 1440 |
| | 1/2 | 12 | 105 | 158 | 212 | 265 | 318 | 400 | 530 | 665 | 800 | 1200 |
| | 9/16 | 14 | 90 | 135 | 182 | 230 | 274 | 340 | 460 | 570 | 680 | 1020 |
| R 3/8 | 5/8 | 16 | 80 | 120 | 160 | 200 | 240 | 300 | 400 | 500 | 600 | 900 |
| | 1 1/2 | 18 | 72 | 106 | 142 | 175 | 212 | 265 | 350 | 430 | 530 | 795 |
| R 1/2 | 3/4 | 20 | 54 | 96 | 128 | 160 | 190 | 240 | 320 | 400 | 480 | 720 |
| | 7/8 | 22 | 50 | 88 | 116 | 145 | 174 | 220 | 290 | 365 | 440 | 660 |
| R 3/4 | 1 | 24 | 52 | 80 | 106 | 134 | 160 | 200 | 268 | 335 | 400 | 600 |
| | 1 1/8 | 26 | 48 | 74 | 98 | 124 | 146 | 185 | 248 | 310 | 370 | 555 |
| | 1 1/4 | 28 | 46 | 68 | 90 | 114 | 138 | 170 | 228 | 285 | 340 | 510 |
| R 1 | 1 1/4 | 30 | 44 | 64 | 85 | 106 | 128 | 160 | 212 | 270 | 320 | 480 |
| | 1 3/8 | 32 | 40 | 60 | 80 | 100 | 120 | 150 | 200 | 250 | 300 | 450 |
| | 1 1/2 | 35 | 36 | 54 | 72 | 90 | 110 | 135 | 180 | 225 | 270 | 405 |
| R 1 1/4 | 1 1/2 | 40 | 32 | 48 | 64 | 80 | 96 | 120 | 160 | 200 | 240 | 360 |
| | 1 3/4 | 45 | 28 | 42 | 56 | 70 | 85 | 105 | 140 | 175 | 210 | 315 |
| R 1 1/2 | 2 | 50 | 26 | 38 | 50 | 64 | 76 | 95 | 128 | 160 | 190 | 285 |
| | 2 1/4 | 55 | 24 | 34 | 45 | 57 | 71 | 89 | 118 | 147 | 176 | 265 |

BRUG ALDRIG MINDRE **GEVIND-BOR** END NEDENSTÅENDE

| Metrisk gevind | | | UNC-gevind | | | UNF-gevind | | | Whitworth-rørgevind | | | Whitworth-gevind | | | Whitworth-fingevind | | | | | | | |
|----------------|-----------|----------|------------|--------------|-------------|------------|---------|--------------|---------------------|----------|--------|------------------|-------------|----------|---------------------|--------------|-------------|----------|--------|--------|----|------|
| Udv. dia. mm | Stign. mm | Gev.-bor | Gevind | Udv. dia. mm | Gev. pr. 1" | Gev.-bor | Gevind | Udv. dia. mm | Gev. pr. 1" | Gev.-bor | Gevind | Udv. dia. mm | Gev. pr. 1" | Gev.-bor | Gevind | Udv. dia. mm | Gev. pr. 1" | Gev.-bor | | | | |
| 2,0 | 0,4 | 1,6 | 2-56 | 2,184 | 56 | 1,8 | 3-56 | 2,515 | 56 | 2,1 | 1/8" | 9,728 | 28 | 8,7 | 3/32" | 2,381 | 48 | 1,9 | 3/16" | 4,762 | 32 | 4,0 |
| 2,2 | 0,45 | 1,7 | 3-48 | 2,515 | 48 | 2,0 | 4-48 | 2,845 | 48 | 2,35 | 1/4" | 13,157 | 19 | 11,75 | 1/8" | 3,175 | 40 | 2,6 | 7/32" | 5,556 | 28 | 4,7 |
| 2,3 | 0,4 | 1,9 | 4-40 | 2,845 | 40 | 2,3 | 5-44 | 3,175 | 44 | 2,65 | 3/8" | 16,662 | 19 | 15,3 | 5/32" | 3,969 | 32 | 3,2 | 1/4" | 6,35 | 26 | 5,4 |
| 2,5 | 0,45 | 2,0 | 5-40 | 3,175 | 40 | 2,6 | 6-40 | 3,505 | 40 | 2,9 | 1/2" | 20,955 | 14 | 19,0 | 3/16" | 4,762 | 24 | 3,8 | 5/16" | 7,938 | 22 | 6,8 |
| 2,6 | 0,45 | 2,15 | 6-32 | 3,505 | 32 | 2,8 | 8-36 | 4,166 | 36 | 3,5 | 5/8" | 22,911 | 14 | 21,0 | 7/32" | 5,556 | 24 | 4,6 | 3/8" | 9,525 | 20 | 8,3 |
| 3,0 | 0,5 | 2,5 | 8-32 | 4,166 | 32 | 3,4 | 10-32 | 4,826 | 32 | 4,1 | 3/4" | 26,441 | 14 | 24,5 | 1/4" | 6,35 | 20 | 5,2 | 7/16" | 11,112 | 18 | 9,8 |
| 3,5 | 0,6 | 2,9 | 10-24 | 4,826 | 24 | 3,8 | 12-28 | 5,486 | 28 | 4,6 | 7/8" | 30,201 | 14 | 28,3 | 5/16" | 7,938 | 18 | 6,6 | 1/2" | 12,70 | 16 | 11,0 |
| 4,0 | 0,7 | 3,3 | 12-24 | 5,486 | 24 | 4,5 | 1/4" | 6,35 | 28 | 5,5 | 1" | 33,249 | 11 | 30,5 | 3/8" | 9,525 | 16 | 8,0 | 9/16" | 14,288 | 16 | 12,5 |
| 4,5 | 0,75 | 3,8 | 1/4" | 6,35 | 20 | 5,1 | 5/16" | 7,938 | 24 | 6,9 | 1 1/8" | 37,897 | 11 | 35,5 | 7/16" | 11,112 | 14 | 9,4 | 5/8" | 15,875 | 14 | 14,0 |
| 5,0 | 0,8 | 4,2 | 5/16" | 7,938 | 18 | 6,6 | 3/8" | 9,525 | 24 | 8,5 | 1 1/4" | 41,91 | 11 | 39,5 | 1/2" | 12,70 | 12 | 10,5 | 3/4" | 19,05 | 12 | 17,0 |
| 5,5 | 0,9 | 4,6 | 3/8" | 9,525 | 16 | 8,0 | 7/16" | 11,112 | 20 | 9,8 | 1 3/8" | 44,323 | 11 | 41,5 | 9/16" | 14,288 | 12 | 12,0 | 7/8" | 22,225 | 11 | 20,0 |
| 6,0 | 1,0 | 5,0 | 7/16" | 11,112 | 14 | 9,4 | 1/2" | 12,70 | 20 | 11,4 | 1 1/2" | 47,80 | 11 | 45,0 | 5/8" | 15,875 | 11 | 13,5 | 1" | 25,40 | 10 | 23,0 |
| 7,0 | 1,0 | 6,0 | 1/2" | 12,70 | 13 | 10,7 | 9/16" | 14,288 | 18 | 12,8 | 1 5/8" | 51,988 | 11 | 49,2 | 3/4" | 19,05 | 10 | 16,5 | 1 1/8" | 28,575 | 9 | 26,0 |
| 8,0 | 1,25 | 6,8 | 5/16" | 14,288 | 12 | 12,0 | 5/8" | 15,875 | 18 | 14,5 | 1 3/4" | 53,746 | 11 | 51,0 | 7/8" | 22,225 | 9 | 19,5 | 1 1/4" | 31,75 | 9 | 29,0 |
| 9,0 | 1,25 | 7,8 | 5/8" | 15,875 | 11 | 13,5 | 1 1/16" | 17,462 | 16 | 15,8 | 2" | 59,614 | 11 | 57,0 | 1" | 25,40 | 8 | 22,5 | 1 3/8" | 34,925 | 8 | 32,0 |
| 10,0 | 1,5 | 8,5 | 3/4" | 19,05 | 10 | 16,5 | 3/4" | 19,05 | 16 | 17,5 | 2 1/4" | 65,71 | 11 | 63,0 | 1 1/8" | 28,575 | 7 | 25,0 | 1 1/2" | 38,10 | 8 | 35,0 |
| 11,0 | 1,5 | 9,5 | 7/8" | 22,225 | 9 | 19,5 | 7/8" | 22,225 | 14 | 20,5 | 2 1/2" | 75,184 | 11 | 72,5 | 1 1/4" | 31,75 | 7 | 28,0 | 1 5/8" | 41,275 | 8 | 38,0 |
| 12,0 | 1,75 | 10,3 | 1" | 25,40 | 8 | 22,2 | 1"NF | 25,40 | 14 | 23,5 | 2 3/4" | 81,534 | 11 | 79,0 | 1 3/8" | 34,925 | 6 | 31,0 | 1 3/4" | 44,45 | 7 | 41,0 |
| 14,0 | 2,0 | 12,0 | 1 1/8" | 28,575 | 7 | 25,0 | 1"UNF | 25,40 | 12 | 23,2 | 3" | 87,884 | 11 | 85,5 | 1 1/2" | 38,10 | 6 | 34,0 | 1 7/8" | 47,625 | 7 | 44,0 |
| 16,0 | 2,0 | 14,0 | 1 1/4" | 31,75 | 7 | 28,1 | 1 1/8" | 28,575 | 12 | 26,5 | 3 1/4" | 93,98 | 11 | 91,5 | 1 5/8" | 41,275 | 5 | 36,5 | 2" | 50,80 | 7 | 47,5 |
| 18,0 | 2,5 | 15,5 | 1 3/8" | 34,925 | 6 | 30,7 | 1 1/4" | 31,75 | 12 | 29,6 | 3 1/2" | 100,33 | 11 | 97,5 | 1 3/4" | 44,45 | 5 | 39,5 | 2 1/4" | 57,15 | 6 | 53,0 |
| 20,0 | 2,5 | 17,5 | 1 1/2" | 38,10 | 6 | 34,0 | 1 3/8" | 34,925 | 12 | 32,7 | 3 3/4" | 106,68 | 11 | 104,0 | 1 7/8" | 47,625 | 4 1/2 | 42,0 | 2 1/2" | 63,50 | 6 | 59,5 |
| 22,0 | 2,5 | 19,5 | | | | | 1 1/2" | 38,10 | 12 | 36,0 | 4" | 113,03 | 11 | 110,5 | 2" | 50,80 | 4 1/2 | 45,5 | 2 3/4" | 69,85 | 6 | 66,0 |
| 24,0 | 3,0 | 21,0 | | | | | | | | | | | | | 2 1/4" | 57,15 | 4 | 51,0 | 3" | 76,20 | 5 | 71,5 |
| 27,0 | 3,0 | 24,0 | | | | | | | | | | | | | 2 1/2" | 63,50 | 4 | 57,5 | | | | |
| 30,0 | 3,5 | 26,5 | | | | | | | | | | | | | 2 3/4" | 69,85 | 3 1/2 | 63,0 | | | | |
| | | | | | | | | | | | | | | | 3" | 76,20 | 3 1/2 | 69,5 | | | | |

Ved alle M og M-Fin gevind udregnes gevindboret ved at trække stigningen fra den udvendige diameter.