

Voorboordiameter voor inwendig draadsnijden

MF Metrisch ISO – fijne draad

Afmeting M-fijn	Voorboor Ø mm
3 x 0.35	2.65
3.5 x 0.35	3.2
4 x 0.5	3.5
5 x 0.5	4.5
5.5 x 0.5	5.0
6 x 0.75	5.3
7 x 0.75	6.3
8 x 0.75	7.3
8 x 1	7.0
9 x 1	8.0
10 x 0.75	9.3
10 x 1	9.0
10 x 1.25	8.8
11 x 1	10.0
12 x 1	11.0
12 x 1.25	10.8
12 x 1.5	10.5
14 x 1	13.0
14 x 1.25	12.8
14 x 1.5	12.5
15 x 1	14.0
15 x 1.5	13.5
16 x 1	15.0
16 x 1.5	14.5
18 x 1	17.0
18 x 1.5	16.5
18 x 2	16.0
20 x 1	19.0
20 x 1.5	18.5
20 x 2	18.0
22 x 1	21.0
22 x 1.5	20.5
22 x 2	20.0
24 x 1	23.0
24 x 1.5	22.5
24 x 2	22.0
25 x 1	24.0
25 x 1.5	23.5
25 x 2	23.0
26 x 1.5	24.5
27 x 1.5	25.5
27 x 2	25.0
28 x 1.5	26.5
28 x 2	26.0
30 x 1.5	28.5
30 x 2	28.0
32 x 1.5	30.5
32 x 2	30.0
33 x 2	31.0
35 x 1.5	33.5
36 x 1.5	34.5
36 x 2	34.0
36 x 3	33.0
38 x 1.5	36.5
39 x 3	36.0
40 x 1.5	38.5
40 x 2	38.0
40 x 3	37.0
42 x 1.5	40.5
42 x 2	40.0
42 x 3	39.0
45 x 1.5	43.5
45 x 2	43.0
45 x 3	42.0
48 x 1.5	46.5
48 x 2	46.0
48 x 3	45.0
50 x 1.5	48.2
50 x 2	48.0
50 x 3	47.0

M Metrisch ISO – schroefdraad

Afmeting M	Spoed mm	Voorboor Ø mm
1.6	0.35	1.25
1.8	0.35	1.45
2	0.4	1.6
2.2	0.45	1.75
2.5	0.45	2.05
3	0.5	2.5
3.5	0.6	2.9
4	0.7	3.3
4.5	0.75	3.8
5	0.8	4.2
6	1	5.0
7	1	6.0
8	1.25	6.8
9	1.25	7.8
10	1.5	8.5
11	1.5	9.5
12	1.75	10.3
14	2	12.0
16	2	14.0
18	2.5	15.5
20	2.5	17.5
22	2.5	19.5
24	3	21.0
27	3	24.0
30	3.5	26.5
33	3.5	29.5
36	4	32.0
39	4	35.0
42	4.5	37.5
45	4.5	40.5
48	5	43.0
52	5	47.0

BSW British Standard-Whitworth

Afmeting BSW	Gangen per inch.	Voorboor Ø mm
3/32	48	1.8
1/8	40	2.55
5/32	32	3.2
3/16	24	3.7
7/32	24	4.5
1/4	20	5.1
5/16	18	6.5
3/8	16	7.9
7/16	14	9.2
1/2	12	10.5
9/16	12	12.0
5/8	11	13.5
3/4	10	16.5
7/8	9	19.25
1	8	22.0
1.1/8	7	24.75
1.1/4	7	28.0
1.3/8	6	30.5
1.1/2	6	33.5
1.5/8	5	35.5
1.3/4	5	39.0
1.7/8	4.1/2	41.5
2	4.1/2	44.5

UNC ISO Unified – grove draad

Afmeting UNC	Gangen per inch.	Voorboor Ø mm
No.2	56	1.8
No.3	48	2.0
No.4	40	2.35
No.5	40	2.65
No.6	32	2.85
No.8	32	3.5
No.10	24	3.9
No.12	24	4.5
1/4	20	5.1
5/16	18	6.6
3/8	16	8.0
7/16	14	9.4
1/2	13	10.8
9/16	12	12.2
5/8	11	13.5
3/4	10	16.5
7/8	9	19.5
1	8	22.25
1.1/8	7	25.0
1.1/4	7	28.0
1.3/8	6	30.5
1.1/2	6	34.0
1.3/4	5	39.5
2	4.1/2	45.0

UNF ISO Unified – fijne draad

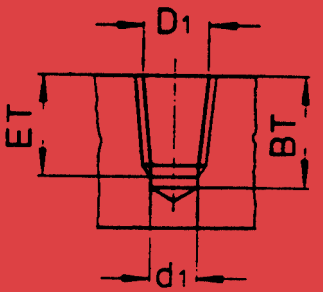
Afmeting UNF	Gangen per inch.	Voorboor Ø mm
No.2	64	1.8
No.3	56	2.1
No.4	48	2.4
No.5	44	2.7
No.6	40	2.95
No.8	36	3.5
No.10	32	4.1
No.12	28	4.7
1/4	28	5.5
5/16	24	6.9
3/8	24	8.5
7/16	20	9.9
1/2	20	11.5
9/16	18	12.9
5/8	18	14.5
3/4	16	17.5
7/8	14	20.5
1	12	23.25
1.1/8	12	26.5
1.1/4	12	29.5
1.3/8	12	33.0
1.1/2	12	36.0

BSF British Standard-Fine

Afmeting BSF	Gangen per inch.	Voorboor Ø mm
3/16	32	4.0
7/32	28	4.5
1/4	26	5.2
9/32	26	6.0
5/16	22	6.6
3/8	20	8.1
7/16	18	9.5
1/2	16	11.0
9/16	16	12.5
5/8	14	14.0
11/16	14	15.5
3/4	12	16.5
13/16	12	18.25
7/8	11	19.5
1	10	22.5
1.1/8	9	25.5
1.1/4	9	28.5
1.3/8	8	31.5
1.1/2	8	34.5
1.5/8	8	37.5

BSPT (Rc) Conische Whitworth Gasdraad (1:16)

Afmeting Rc	Gangen per inch.	Voorboor Ø d1 mm cilindrisch	Voorboor Ø D1 mm conisch	Draad-diepte ET mm	Boor-diepte BT mm
1/16	28	6.3	6.49	9.31	10.1
1/8	28	8.3	8.5	9.31	10.1
1/4	19	11.0	11.35	12.37	15.0
3/8	19	14.5	14.85	12.77	15.4
1/2	14	18.1	18.49	16.83	20.5
3/4	14	23.5	23.98	18.13	21.8
1	11	29.6	30.11	21.42	26.0
1.1/4	11	38.1	38.78	23.72	28.3
1.1/2	11	44.0	44.67	23.72	28.3
2	11	55.6	56.48	28.02	32.6
2.1/2	11	71.1	72.0	31.32	37.1
3	11	83.6	84.71	34.42	40.2



NPS Cilindrische Amerikaanse gasdraad

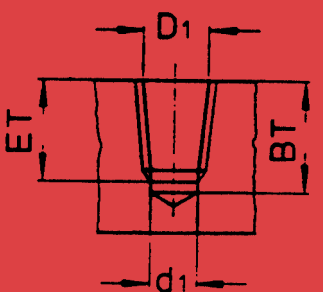
Afmeting NPS	Gangen per inch.	Voorboor Ø mm
1/8	27	9.1
1/4	18	12.0
3/8	18	15.5
1/2	14	19.0
3/4	14	24.5
1	11.1/2	30.5
1.1/4	11.1/2	39.5
1.1/2	11.1/2	45.5
2	11.1/2	57.5
2.1/2	11.1/2	69.0
3	11.1/2	85.0

BSPF (G) Cilindrische Whitworth Gasdraad

Afmeting G	Gangen per inch.	Voorboor Ø mm
1/8	28	8.8
1/4	19	11.8
3/8	19	15.25
1/2	14	19.0
5/8	14	21.0
3/4	14	24.5
7/8	14	28.0
1	11	30.5
1.1/4	11	39.5
1.1/2	11	45.0
1.3/4	11	51.0
2	11	57.0
2.1/4	11	63.0
2.1/2	11	72.5
2.3/4	11	79.0
3	11	85.5

NPT Conische Amerikaanse Gasdraad (1:16)

Afmeting NPT	Gangen per inch.	Voorboor Ø d1 mm cilindrisch	Voorboor Ø D1 mm conisch	Draad-diepte ET mm	Boor-diepte BT mm
1/16	27	6.25	6.4	9.29	10.7
1/8	27	8.4	8.7	9.32	10.8
1/4	18	11.1	11.4	13.52	15.6
3/8	18	14.3	14.7	13.83	16.0
1/2	14	17.9	18.3	18.07	20.8
3/4	14	23.0	23.7	18.55	21.3
1	11.1/2	29.0	29.7	22.29	25.6
1.1/4	11.1/2	37.7	38.4	22.8	26.1
1.1/2	11.1/2	44.0	44.5	22.8	26.1
2	11.1/2	56.0	56.6	23.2	26.5
2.1/2	8	66.7	67.6	34.57	36.3



PG Panzerrohrdraad DIN 40430

Afmeting PG	Gangen per inch.	Voorboor Ø mm
7	20	11.4
9	18	13.9
11	18	17.25
13.5	18	19.0
16	18	21.25
21	16	27.0
29	16	35.5
36	16	45.5
42	16	52.5
48	16	58.0

NPTF Conische Amerikaanse Gasdraad (droge dichtheid) (1:16)

Afmeting NPTF	Gangen per inch.	Voorboor Ø d1 mm cilindrisch	Voorboor Ø D1 mm conisch	Draad-diepte ET mm	Boor-diepte BT mm
1/16	27	6.25	6.4	9.29	10.3
1/8	27	8.6	8.7	9.32	10.3
1/4	18	11.1	11.4	13.52	15.0
3/8	18	14.7	14.8	13.83	15.3
1/2	14	17.9	18.3	18.07	19.9
3/4	14	23.4	23.6	18.55	20.4
1	11.1/2	29.4	29.7	22.29	24.5
1.1/4	11.1/2	38.1	38.4	22.8	25.0
1.1/2	11.1/2	44.0	44.5	22.8	25.0
2	11.1/2	56.4	56.5	23.2	25.4
2.1/2	8	67.0	67.6	34.75	38.0
3	8	83.0	83.5	36.88	40.0

