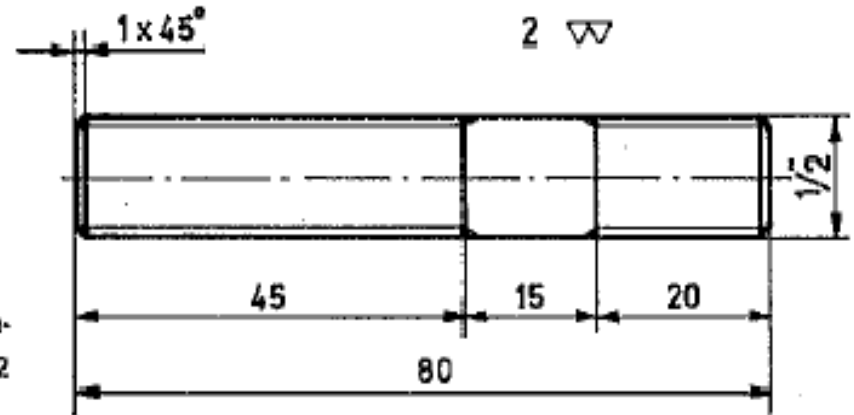
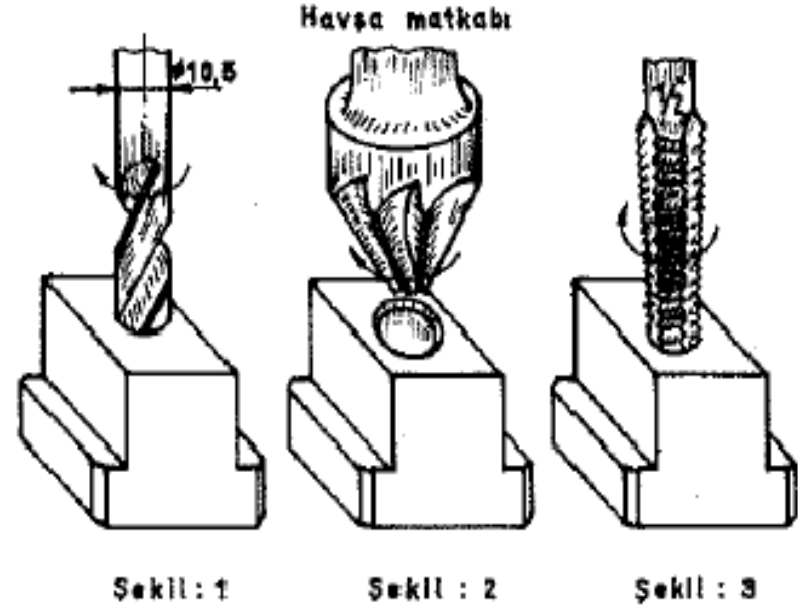
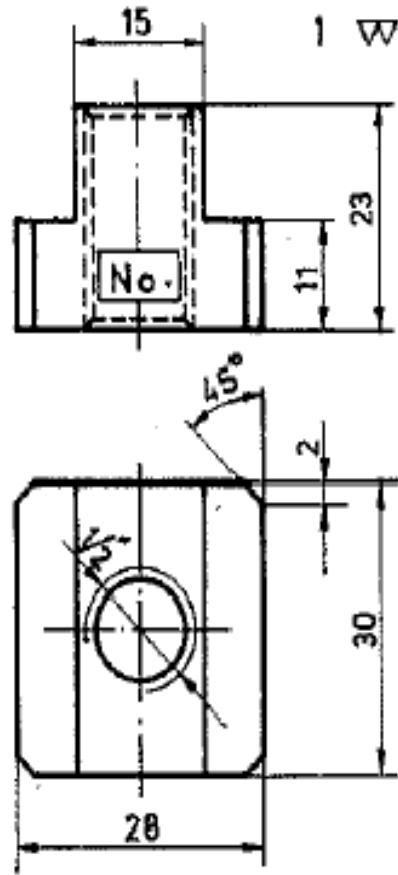
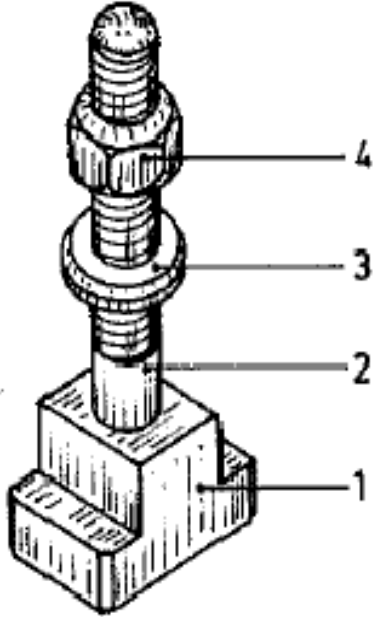


# Vidalama İş Akışı



## Kullanılacak takımlar :

Mengene, kaba, orta, ince yassı eğeler, markacı aletleri, testere kolu, kumpas, 90° ve 120° gönye,  $\varnothing$  10,5 ve  $\varnothing$  13,5 mm. matkap, havşa matkabı,  $\frac{1}{2}$  kılavuz ve pafta lokması, buji kolu, pafta kolu, yağdanlık.

# Klavuz ve Pafta ile Diş Açma

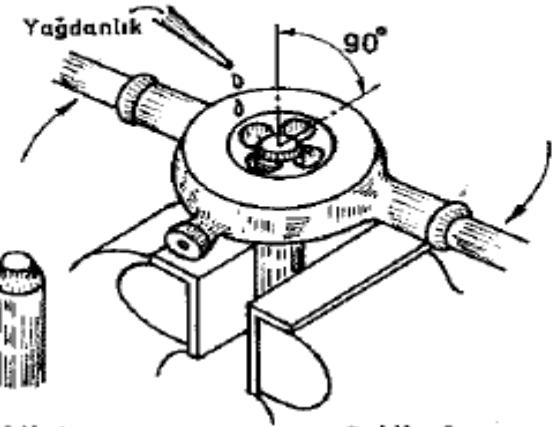
Beceri :

- a — Kılavuz havşası açmak.
- b — Kılavuzla elde diş vida açmak.
- c — Pafta ile elde erkek vida açmak.

- d — Elde rondelâ yapmak.
- e — Altıköşe marka etmek ve eğilemek.
- f —  $120^\circ$  gönye ile kontrol etmek.

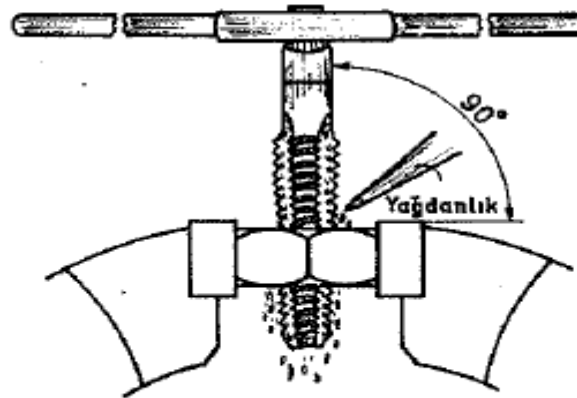
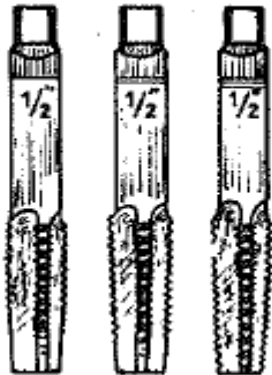
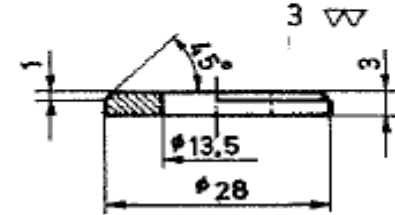
İŞLEM SIRASI :

- 1 — 1 numaralı parçayı resme göre ölçüsünde ve gönyesinde eğileyiniz, merkezine  $\varnothing 10,5$  mm. matkapla delik deliniz ve 1 inçden başlayarak  $1/2$  kılavuz çekiniz.
- 2 — 12,5 mm. çapındaki çubuğun uç kısımlarını Şekil : 4 teki gibi elde konik olarak eğileyiniz ve resimdeki ölçülere göre her iki tarafına  $1/2$  pafta lokması ile elde diş çekiniz.
- 3 — Size rondelâ için verilen malzemenin iki geniş yüzeyini, ölçüsüne de dikkat ederek temizledikten sonra, bir yüzeyine 28 mm. çapında bir dalre çiziniz ve merkezine  $\varnothing 13,5$  mm. matkapla delik delerek, pahlarını resimdeki ölçülerine göre eğileyiniz.
- 4 — Somun malzemesini 12 mm. yüksekliğinde eğileyiniz. Altıköşeyi marka ederek  $120^\circ$  gönyesinde eğileyiniz. Merkezini  $\varnothing 10,5$  mm. matkapla delerek  $1/2$  kılavuz çekiniz ve pahları kırınız.
- 5 — İşaretili yere numaranızı vurunuz.

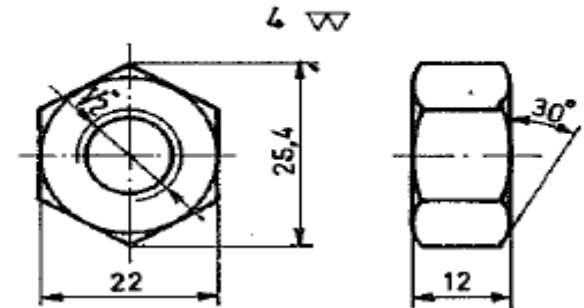


Şekil : 4

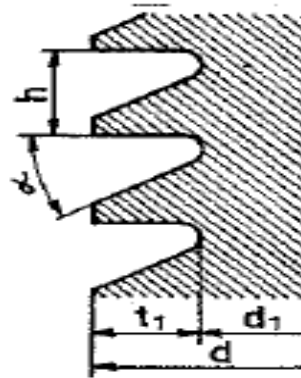
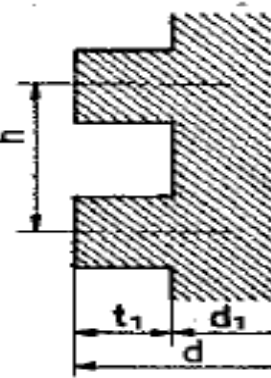
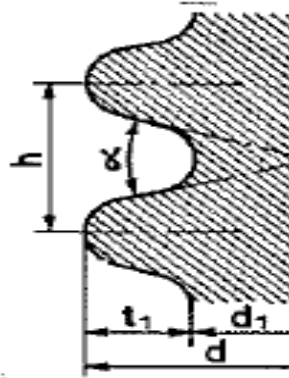
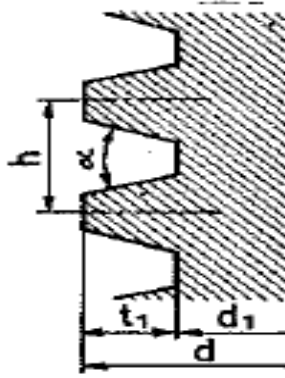
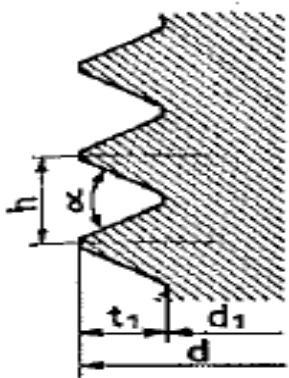
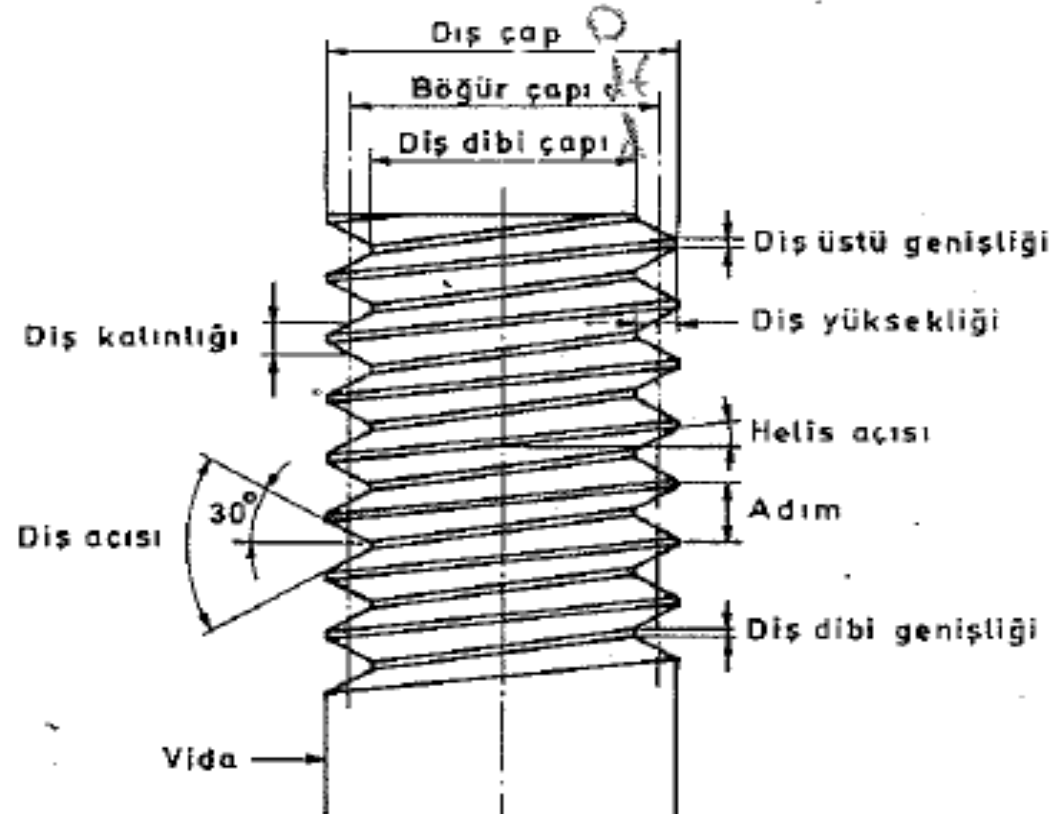
Şekil : 5



Şekil : 6

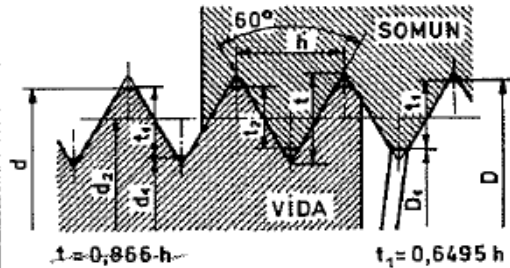


# Vidalar

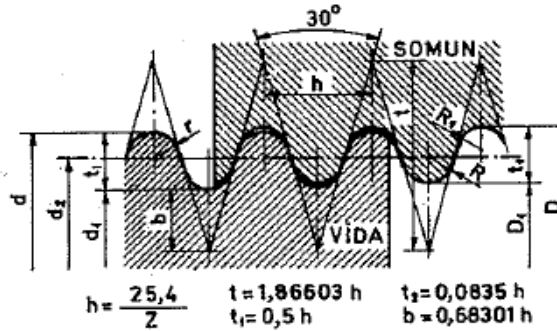


# Vida Profilleri

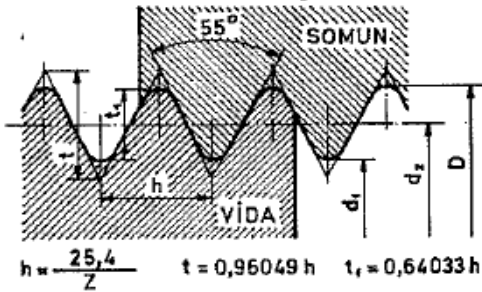
Metrik vida dişi



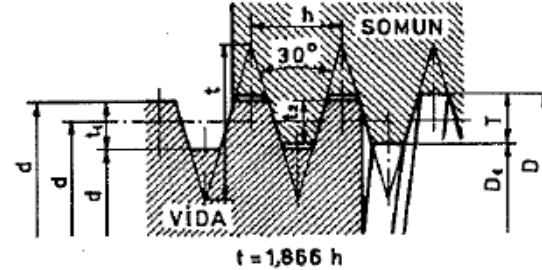
Yuvarlak vida dişi



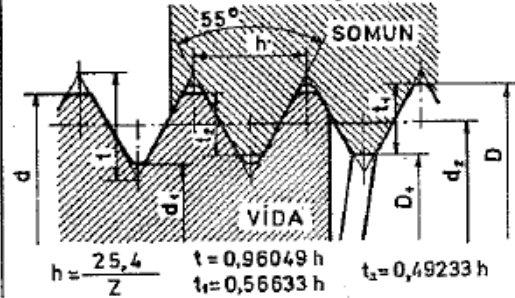
Whitworth vida dişi



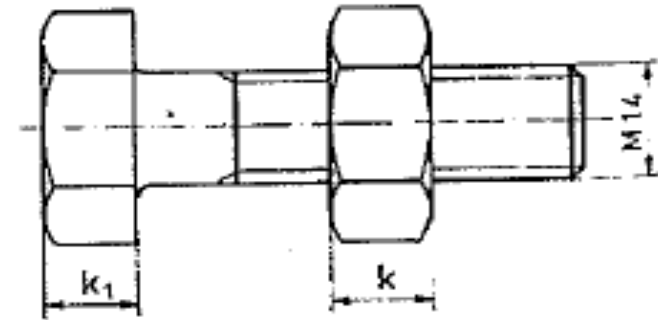
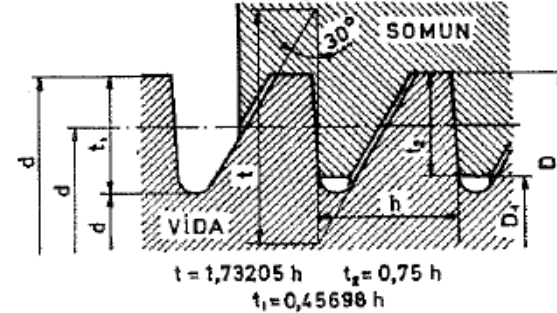
Trapez vida dişi



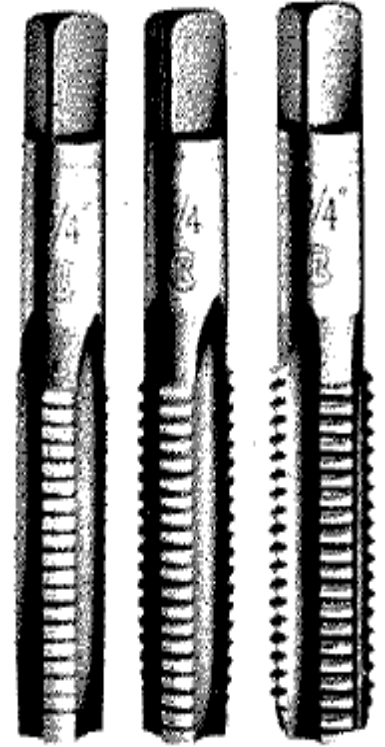
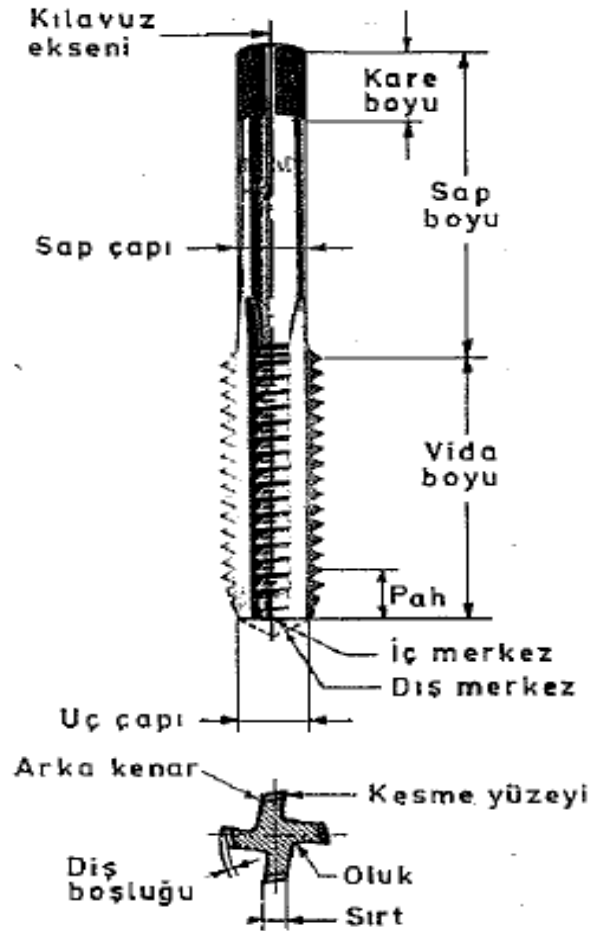
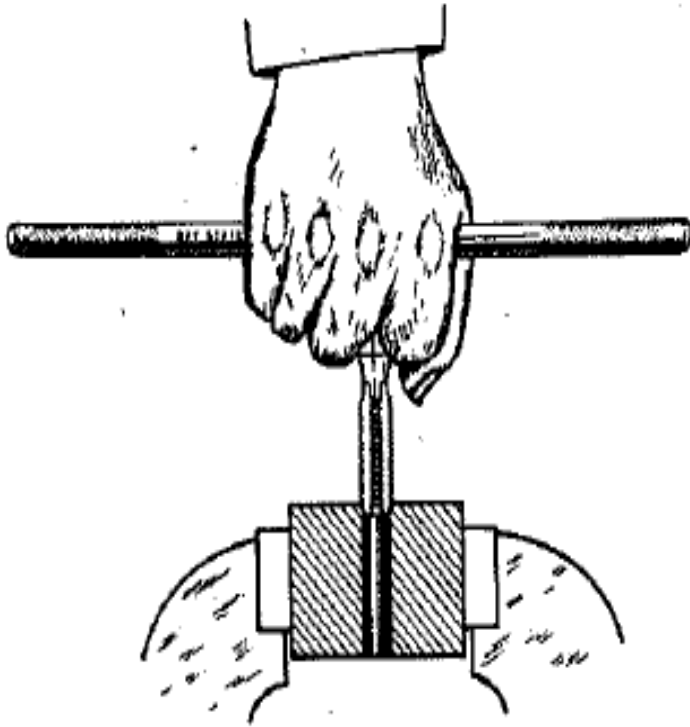
Whitworth ince diş



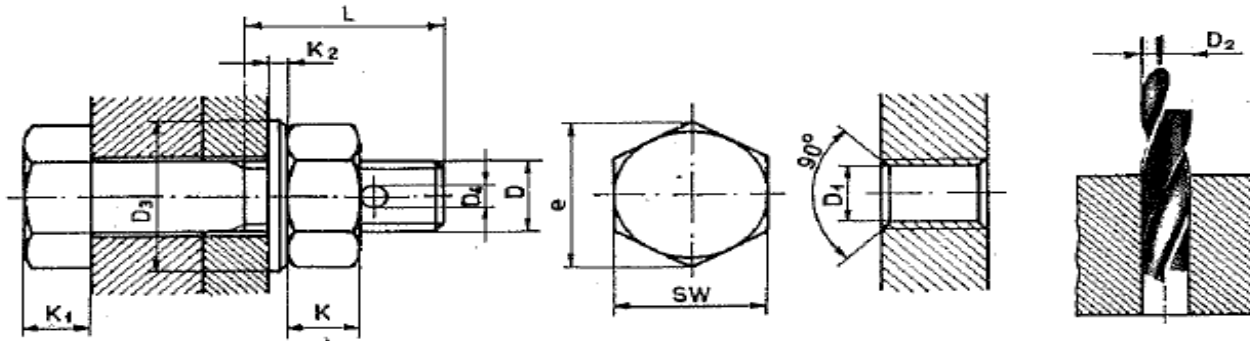
Testere vida dişi



# Klavuz Bölümleri ve Diş Açma



# Metrik Vida Tablosu



D Anma çapı		D <sub>1</sub> mm.	Z	h Adım mm.	e mm.	SW mm.	K mm.	K <sub>1</sub> mm.	K <sub>2</sub> mm.	D <sub>3</sub> mm.	D <sub>4</sub> mm.	D <sub>2</sub> mm.
Parmak	mm.											
1/16	1,588	1,25	60	0,4234	5,6	4	1,5	1,5	0,5	6	—	1,2
3/32	2,381	1,8	48	0,5292	5,8	5	2	2	0,75	7	—	1,9
1/8	3,17	2,36	40	0,635	6,9	6	3	3	1	8	—	2,6
5/32	3,969	3,05	32	0,7938	8,1	7	3,5	3,5	1	10	—	3,2
3/16	4,76	3,4	26	0,9035	9,2	8	3,5	3,5	1	11	—	3,7
7/32	5,560	4,2	24	1,0584	11,5	10	5,5	5	1,5	12,5	—	4,5
1/4	6,350	4,724	20	1,2701	12,7	11	5,5	5	2	14	—	5
5/16	7,94	6,131	18	1,411	16,2	14	6,5	6	2,5	18	2,5	6,5
3/8	9,525	7,492	16	1,588	19,6	17	8	7	3	23	2,5	7,9
7/16	11,118	8,798	14	1,814	21,9	19	8,8	7,7	3	25	2,5	9,25
1/2	12,7	9,99	12	2,117	25,4	22	11	9	3,5	27	3,5	10,5
5/8	15,876	12,92	11	2,309	31,2	27	13	11	4	34	3,5	13,5
3/4	19,051	15,798	10	2,540	36,9	32	16	13	5	40	4,5	16,4
7/8	22,226	18,611	9	2,822	41,6	36	18	16	5	48	5,5	19,25
1	25,401	21,335	8	3,175	47,3	41	20	18	6	50	6,5	22
1 1/8	28,576	23,929	7	3,629	53,1	46	22	20	6	56	6,5	24,7
1 1/4	31,751	27,104	7	3,629	57,7	50	25	22	7	60	7,5	28
1 3/8	34,926	29,505	6	4,233	63,5	55	28	24	7	66	7,5	30,5
1 1/2	38,101	32,680	6	4,233	69,3	60	30	27	8	75	7,5	33,5
1 5/8	41,277	34,771	5	5,080	75	65	32	30	9	80	8,5	36
1 3/4	44,452	37,946	5	5,080	80,8	70	35	32	9	86	8,5	39
1 7/8	47,627	40,398	4,5	5,645	86,6	75	38	34	10	91	9,5	41,5
2	50,802	43,573	4,5	5,645	92,4	80	40	36	10	100	10,5	45

Çizelgede :

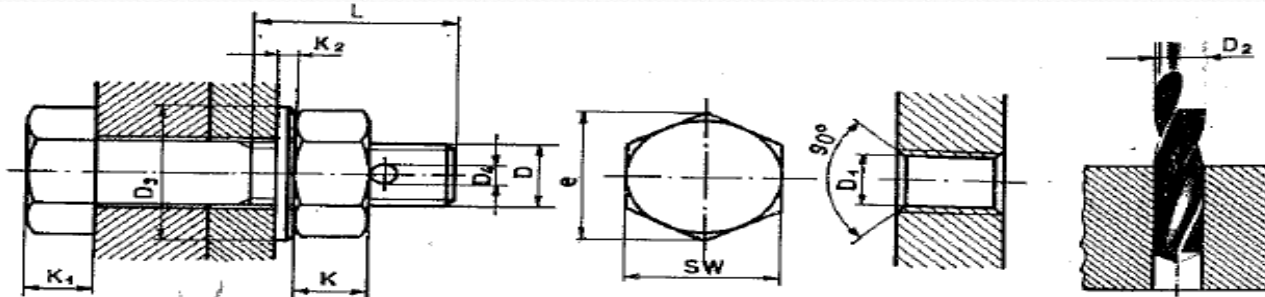
D<sub>1</sub> = Diş dibi çapı,

D<sub>2</sub> = Matkap çapı,

D<sub>3</sub> = Rondelâ çapı,

Z = Parmaktaki diş sayısıdır.

# Withworth Vida Tablosu



D mm.	D <sub>1</sub> mm.	h Adım mm.	e mm.	SW mm.	K mm.	K <sub>1</sub> mm.	K <sub>2</sub> mm.	D <sub>3</sub> mm.	D <sub>4</sub> mm.	D <sub>2</sub> mm.
M 1,7	1,214	0,35	4,6	4	1,7	1,2	0,3	5	—	1,35
M 2	1,444	0,4	5,2	4,5	2	1,4	0,35	6	—	1,6
M 2,6	1,974	0,45	5,8	5	2,3	1,5	0,4	7	—	2,15
M 3	2,35	0,5	6,4	5,5	3	2	0,5	8	1	2,5
M 3,5	2,72	0,6	7	6	3,5	2,4	0,6	9	1	2,8
M 4	3,09	0,7	8,1	7	4	2,8	0,8	10	1,5	3,25
M 4,5	3,52	0,75	8,1	7	4,5	3,15	0,8	10	1,5	3,75
M 5	3,96	0,8	10,4	8	5	3,5	1	12	1,5	4,1
M 5,5	4,15	0,9	11	9	5,5	3,85	1	12	1,6	4,3
M 6	4,7	1	11,5	10	6	4,5	1,5	12,5	2	4,8
M 7	5,7	1	13,9	12	7	4,9	2	15	2	5,8
M 8	6,37	1,25	16,2	14	8	5,5	2	17,5	2	6,5
M 9	7,38	1,25	17,5	15	9	7	2	19	2	7,5
M 10	8,52	1,5	19,6	17	9	7	2,5	22	3	8,25
M 11	9,05	1,5	20,5	18	9,5	7,5	3	23	3	9,5
M 12	9,72	1,75	21,9	19	9,5	8	3	24	3	10
M 14	11,4	2	25,4	22	11	9	3	28	4	11,5
M 16	13,4	2	27,7	24	13	10,5	3	30	4	13,5
M 18	14,75	2,5	31,2	27	15	12	4	34	5	15
M 20	16,75	2,5	34,6	30	16	13	4	37	5	17
M 22	18,75	2,5	36,9	32	17	14	4	40	5	19
M 24	20,1	3	41,6	36	18	15	4	44	6	20,5
M 27	23,1	3	47,3	41	20	17	5	50	6	23,5
M 30	25,45	3,5	53,1	46	22	19	5	56	7	26
M 33	28,45	3,5	57,7	50	25	21	5	60	7	29
M 36	30,8	4	63,5	55	28	23	6	68	8	31,5
M 39	33,8	4	69,3	60	30	25	6	72	8	34,5
M 42	36,15	4,5	75	65	32	26	7	78	9	37
M 45	39,15	4,5	80,8	70	35	28	7	85	9	40

Çizelgele :

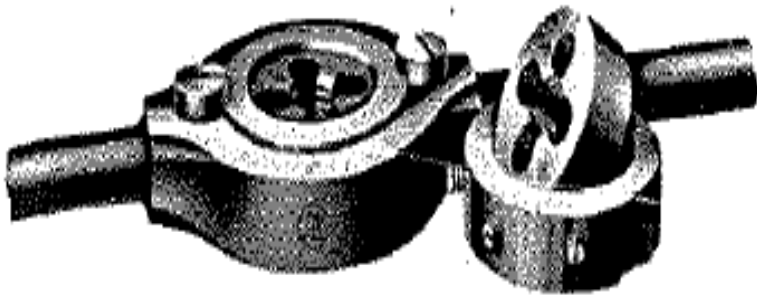
D = Anma çapı,

D<sub>1</sub> = Diş dibi çapı,

D<sub>2</sub> = Matkap çapı

D<sub>3</sub> = Rondelâ çapıdır.

# Pafta ve Kolları

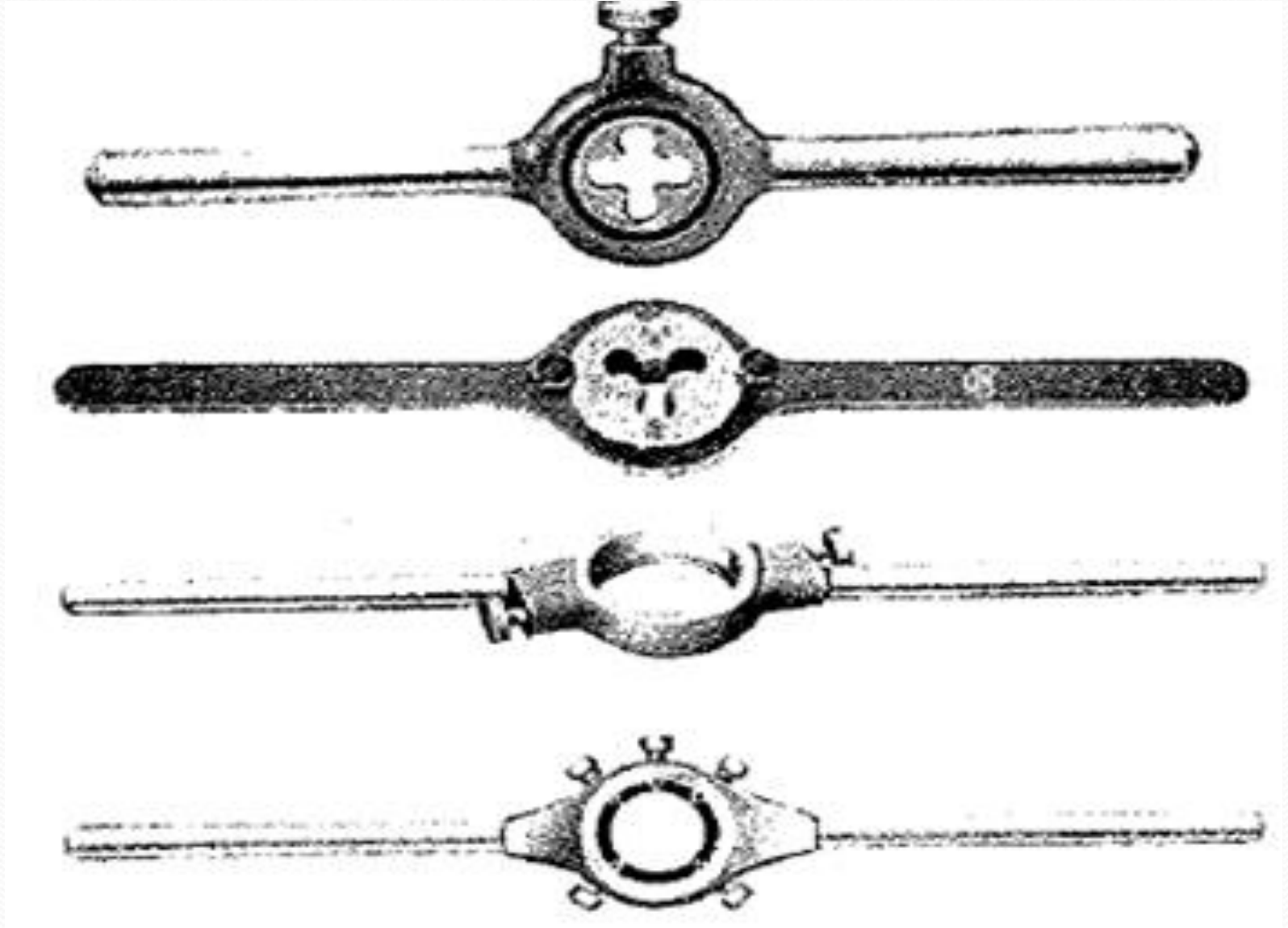


HAYŞA





# Çeşitli Pafta Kolları



# Çeşitli Klavuz Kolları

