

## ZALECANE PARAMETRY SKRAWANIA

Materiał przedmiotu obrabianego	Średnica wiertła DC (mm)	L/D	Stal konstrukcyjna ( $\leq 180\text{HB}$ )		Stal węglowa Stal stopowa (180–280HB)		Stal węglowa Stal stopowa (280–350HB)	
			Obroty ( $\text{min}^{-1}$ )	Posuw (min.–maks.) (mm/obr.)	Obroty ( $\text{min}^{-1}$ )	Posuw (min.–maks.) (mm/obr.)	Obroty ( $\text{min}^{-1}$ )	Posuw (min.–maks.) (mm/obr.)
<b>1.0</b>	<b>2*,7DC</b>		15900	0.04 (0.02–0.05)	15900	0.04 (0.02–0.05)	12700	0.04 (0.02–0.05)
	$\geq 12\text{DC}$		15900	0.02 (0.01–0.03)	12700	0.02 (0.01–0.03)	9500	0.02 (0.01–0.03)
<b>1.5</b>	<b>2*,7DC</b>		10600	0.05 (0.03–0.08)	10600	0.05 (0.03–0.08)	8400	0.05 (0.03–0.08)
	$\geq 12\text{DC}$		10600	0.05 (0.02–0.08)	8400	0.05 (0.03–0.08)	6300	0.05 (0.02–0.08)
<b>2.0</b>	<b>2*,7DC</b>		7900	0.07 (0.04–0.10)	7900	0.07 (0.04–0.10)	6300	0.07 (0.04–0.10)
	$\geq 12\text{DC}$		7900	0.07 (0.04–0.10)	7900	0.07 (0.04–0.10)	7900	0.07 (0.04–0.10)
<b>2.5</b>	<b>2*,7DC</b>		7600	0.09 (0.05–0.13)	7600	0.09 (0.05–0.13)	6300	0.09 (0.05–0.13)
	$\geq 12\text{DC}$		7600	0.09 (0.06–0.13)	6300	0.09 (0.06–0.13)	6300	0.08 (0.05–0.13)

Materiał przedmiotu obrabianego	Średnica wiertła DC (mm)	L/D	Austenityczna stal nierdzewna ( $\leq 200\text{HB}$ )		Żeliwo szare ( $\leq 350\text{MPa}$ )		Żeliwo sferoidalne (GGG) ( $\leq 450\text{MPa}$ )	
			Obroty ( $\text{min}^{-1}$ )	Posuw (min.–maks.) (mm/obr.)	Obroty ( $\text{min}^{-1}$ )	Posuw (min.–maks.) (mm/obr.)	Obroty ( $\text{min}^{-1}$ )	Posuw (min.–maks.) (mm/obr.)
<b>1.0</b>	<b>2*,7DC</b>		9500	0.03 (0.02–0.05)	15900	0.04 (0.02–0.05)	12700	0.04 (0.02–0.05)
	$\geq 12\text{DC}$		9500	0.02 (0.01–0.03)	12700	0.02 (0.01–0.03)	9500	0.02 (0.01–0.03)
<b>1.5</b>	<b>2*,7DC</b>		6300	0.05 (0.03–0.07)	10600	0.05 (0.03–0.08)	8400	0.05 (0.03–0.08)
	$\geq 12\text{DC}$		6300	0.05 (0.02–0.08)	8400	0.05 (0.03–0.08)	6300	0.05 (0.02–0.08)
<b>2.0</b>	<b>2*,7DC</b>		4700	0.06 (0.04–0.08)	7900	0.07 (0.04–0.10)	6300	0.07 (0.04–0.10)
	$\geq 12\text{DC}$		4700	0.07 (0.04–0.10)	7900	0.07 (0.04–0.10)	7900	0.07 (0.04–0.10)
<b>2.5</b>	<b>2*,7DC</b>		5000	0.08 (0.05–0.10)	7600	0.09 (0.05–0.13)	6300	0.09 (0.05–0.13)
	$\geq 12\text{DC}$		3800	0.08 (0.05–0.12)	6300	0.09 (0.06–0.13)	6300	0.08 (0.05–0.12)

Materiał przedmiotu obrabianego	Średnica wiertła DC (mm)	L/D	Stopy aluminium (Si<5%)		Stopy żaroodporne	
			Obroty ( $\text{min}^{-1}$ )	Posuw (min.–maks.) (mm/obr.)	Obroty ( $\text{min}^{-1}$ )	Posuw (min.–maks.) (mm/obr.)
<b>1.0</b>	<b>2*,7DC</b>		19000	0.05 (0.03–0.08)	3100	0.02 (0.01–0.03)
	$\geq 12\text{DC}$		15900	0.05 (0.03–0.08)	3100	0.02 (0.01–0.03)
<b>1.5</b>	<b>2*,7DC</b>		16900	0.07 (0.05–0.12)	2100	0.03 (0.02–0.04)
	$\geq 12\text{DC}$		14800	0.08 (0.05–0.12)	2100	0.03 (0.02–0.04)
<b>2.0</b>	<b>2*,7DC</b>		14300	0.1 (0.06–0.15)	2300	0.04 (0.03–0.05)
	$\geq 12\text{DC}$		12700	0.11 (0.06–0.15)	2300	0.04 (0.03–0.05)
<b>2.5</b>	<b>2*,7DC</b>		12700	0.13 (0.08–0.20)	1900	0.05 (0.04–0.06)
	$\geq 12\text{DC}$		11400	0.14 (0.08–0.20)	1900	0.05 (0.04–0.06)

\*2=Wiertło pilotowe. Głębokość otworu 2DC.