TABELA DOBORU / *SELECTION TABLE / SELEKTION TABELLE*

	DIN-371 / DIN-376 DIN-371 / DIN-374			DIN-352							DIN-371 / DIN-376 DIN-371 / DIN-374 DIN-5156				**Norma** *Norm* *Norma*
15 / 17	21 / 24	27 / 31	27 / 32	44	40 / 41	15 / 17	15 / 17	16 / 18	15 / 17	16 / 18	16	16 / 18	21 / 24	28 / 32	**M**
50 / 52	59	62 / 66	50 / 52			50 / 52	50 / 52	50 / 52	50 / 52	51 / 54		51		62 / 66	**MF**
															UNC
															UNF
						92									**G**
															Rp/Rc
															BSW
															BSF
															NPT
															EG
															Pg
															Tr
1400	**1400**	**1400**	**1400**	**HRC50**	**HRC60**	**GG**	**GG**	**GG**	**GG**	**GG**	**GAL**	**GAL**	**GAL**	**GAL**	**Nazwa** *Name* *Bezeichnung*
	B	R15	R15 IK		IK			IK	IK	IKR	IK	IKR	B	R15	**Wykonanie** *Execution* *Ausfuhrung*
PM/HSSE	PM/HSSE	PM/HSSE	PM/HSSE	HSSE-PM	VHM	PM/HSSE	PM/HSSE	PM/HSSE	PM/HSSE	PM/HSSE	PM/HSSE	PM/HSSE	PM/HSSE	PM/HSSE	**Materiał** *Material* *Werkstoff*
TiCN	TiCN	TiCN	TiCN	TiCN	TiCN	TiCN	TiCN	TiCN	TiCN	TiCN	TiCN	TiCN	TiCN	TiCN	**Rodzaj powłoki** *Coating* *Beschichtung*
C / 2-3P	B / 4-5P	C / 2-3P	C / 2-3P	D / 4-5P	D / 4-5P	C / 2-3P	E / 1,5-2P	E / 1,5-2P	C / 2-3P	E / 1,5-2P	E / 1,5-2P	E / 1,5-2P	B / 4-5P	C / 2-3P	**Nakrój** *Chamfer* *Anschnitt*
<1,5d	<2,5d	<1,5d	<1,5d	<1,5d	<1,5d	<1,5d	<1,5d	<2d	<2d	<2,5d	<2d	<2d	<3d	<2d	**Typ otworu** *Hole type* *Lochform*
E/O	E/O/P	E/O/P	E/O	O/P.	E/O	E/O	E/O	E/O	E/O	E/O	E/O	E/O	E/O/P	E/O/P	**Chłodziwo** *Coolant* *Kühlmittel*
						Vc [m/min]									
															P
															1.1
															1.2
															1.3
															1.4
5-15	5-15	5-15	5-15												1.5
1-5	1-5	1-5	1-5												1.6
															M
															2.1
															2.2
															2.3
															K
10-20	10-20	10-20	10-20			20-60	20-60	20-60	20-60	20-60	15-30	15-30	10-25	10-25	3.1
10-20	10-20	10-20	10-20			15-25	15-25	15-25	15-25	15-25					3.2
10-20	10-20	10-20	10-20			15-25	15-25	15-25	15-25	15-25					3.3
															N
															4.1
						15-35	15-35	15-35	15-35	15-35	15-35	15-35	10-25	10-25	4.2
						10-30	10-30	10-30	10-30	10-30	10-30	10-30	10-25	10-25	4.3
															4.4
															4.5
10-20	10-20	10-20	10-20												4.6
															4.7
10-20	10-20	10-20	10-20												4.8
															4.9
						25-35	25-35	25-35	25-35	25-35					4.10
						5-15	5-15	5-15	5-15	5-15					4.11
															4.12
						5-15	5-15	5-15	5-15	5-15					4.13
															S
															5.1
															5.2
															5.3
															5.4
															H
1-4	1-4	1-4	1-4	1-4	1-4										6.1
				1-4	1-4										6.2
					1-4										6.3
															6.4

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