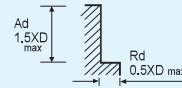
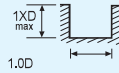


## [ X-STAR series, Fractional ]

피삭재	저탄소강				의료용합금강		금형강		회주철		주철 덕타일	
	~HB175		~HB275		~HB275		~HB275		~HB200		~HB300	
D(Fractional)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1/8	15,585	12	12,835	10	10,695	8	5,500	4	14,515	11	7,335	5
3/16	10,360	20	8,560	17	7,150	14	3,670	8	9,690	19	4,880	9
1/4	7,795	24	6,420	20	5,350	17	2,750	8	7,260	23	3,665	11
5/16	6,235	29	5,135	24	4,280	20	2,200	10	5,805	27	2,935	14
3/8	5,195	39	4,280	32	3,565	27	1,835	13	4,840	36	2,445	18
7/16	4,455	38	3,665	31	3,055	26	1,570	13	4,145	35	2,095	18
1/2	3,895	37	3,210	30	2,675	25	1,375	13	3,630	34	1,835	17
9/16	3,465	35	2,850	29	2,375	24	1,220	12	3,225	32	1,630	16
5/8	3,115	33	2,565	27	2,140	23	1,100	11	2,905	31	1,465	15
3/4	2,600	31	2,140	25	1,785	21	915	11	2,420	29	1,220	14
1	1,950	25	1,605	21	1,335	17	690	9	1,815	24	915	12

RPM = rev. / min.  
FEED = inch / min.

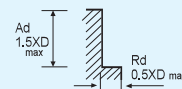
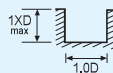


- ※ 단단하고 정확한 장비 및 홀더를 사용하십시오.
- ※ 적절한 절단 오일을 사용하십시오.

## [ X-STAR series, Fractional ]

피삭재	구상흑연주철		스테인리스 300계열		스테인리스 400계열		스테인리스 PH계열		티타늄합금		내열강	
	~HB300		~HB275		~HB185		~HB325		~HB295		~HB300	
D(Fractional)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1/8	4,585	4	9,170	7	12,835	10	7,640	5	9,170	9	2,445	2
3/16	3,070	6	6,080	12	8,550	17	5,080	10	6,080	14	1,600	3
1/4	2,290	7	4,585	14	6,420	22	3,820	12	4,585	16	1,220	3
5/16	1,835	8	3,665	16	5,135	25	3,055	14	3,665	18	980	4
3/8	1,530	11	3,055	16	4,280	25	2,545	14	3,055	18	815	4
7/16	1,310	11	2,620	16	3,665	25	2,185	14	2,620	18	700	4
1/2	1,145	11	2,290	16	3,210	25	1,910	14	2,290	18	610	4
9/16	1,020	10	2,035	20	2,850	29	1,700	17	2,035	20	545	6
5/8	915	9	1,835	16	2,565	25	1,530	14	1,835	18	490	4
3/4	765	9	1,520	15	2,410	22	1,275	12	1,520	16	400	4
1	575	7	1,145	15	1,605	22	955	12	1,145	16	305	3

RPM = rev. / min.  
FEED = inch / min.

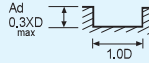


- ※ 단단하고 정확한 장비 및 홀더를 사용하십시오.
- ※ 적절한 절단 오일을 사용하십시오.

## [ X-STAR series, Fractional ] ▶ 슬로팅 가공

피삭재	열처리강		
경도	HRc30~45		
D(Fractional)	RPM	FEED	
1/8	6,573	16	
3/16	4,382	16	
1/4	3,287	17	
5/16	2,629	17	
3/8	2,191	17	
7/16	1,878	17	
1/2	1,643	16	
9/16	1,461	16	
5/8	1,315	16	
3/4	1,096	17	
1	822	16	

RPM = rev. / min.  
FEED = inch / min.

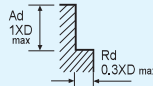


- ※ 단단하고 정확한 장비 및 홀더를 사용하십시오.
- ※ 적절한 절단 오일을 사용하십시오.

## [ X-STAR series, Fractional ] ▶ Side 가공

피삭재	열처리강		
경도	HRc30~45		
D(Fractional)	RPM	FEED	
1/8	6,573	16	
3/16	4,382	16	
1/4	3,287	17	
5/16	2,629	17	
3/8	2,191	17	
7/16	1,878	17	
1/2	1,643	16	
9/16	1,461	16	
5/8	1,315	16	
3/4	1,096	17	
1	822	16	

RPM = rev. / min.  
FEED = inch / min.

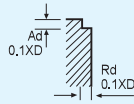


- ※ 단단하고 정확한 장비 및 홀더를 사용하십시오.
- ※ 적절한 절단 오일을 사용하십시오.

[ X-STAR series, Fractional ] ▶ 고속 가공

피삭재	열처리강	
경도	HRc30~45	
D(Fractional)	RPM	FEED
1/8	17,121	75
3/16	11,414	78
1/4	8,561	75
5/16	6,848	77
3/8	5,707	75
7/16	4,892	76
1/2	4,280	75
9/16	3,805	75
5/8	3,424	75
3/4	2,854	75
1	2,140	73

RPM = rev. / min.  
FEED = inch / min.



- ※ 단단하고 정확한 장비 및 홀더를 사용하십시오.
- ※ 적절한 절단 오일을 사용하십시오.

[ ZE716A, ZR706A series ]

피삭재	열처리강, 내열강		열처리강									
	HRc30~ HRc40		HRc40~ HRc50		HRc50~ HRc55		HRc55~ HRc60		HRc60~ HRc65		HRc65~ HRc70	
외경(mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
6(1/4)	24,800	5,350	23,500	4,900	16,000	4,900	13,500	3,300	10,500	2,100	8,000	1,450
8(5/16)	20,000	5,500	19,000	5,000	12,000	4,600	10,000	3,100	8,000	2,000	6,000	1,400
10(3/8)	16,000	4,900	15,500	4,500	9,500	4,100	8,000	2,900	6,400	1,800	4,800	1,300
12(1/2)	13,000	4,500	12,500	4,100	8,000	3,800	6,600	2,500	5,300	1,600	4,000	1,150
16(5/8)	10,000	4,000	9,700	3,700	6,000	3,400	5,000	2,300	4,000	1,250	3,000	870
20(3/4)	8,000	3,350	7,800	3,400	4,800	3,200	4,000	2,100	3,200	1,020	2,400	690

RPM = rev. / min.  
FEED = inch / min.

