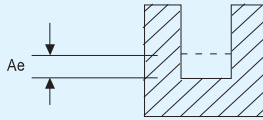


[ZSLNS20, ZSLNS40 series]

피삭재	합금강, 내열강			열처리강			열처리강			동, 동합금		
경도	HRc30 ~ HRc45			HRc45 ~ HRc55			HRc55 ~ HRc65					
외경(mm)	RPM	FEED	Ae(mm)	RPM	FEED	Ae(mm)	RPM	FEED	Ae(mm)	RPM	FEED	Ae(mm)
0.4	34,100-50,000	350-590	0.005-0.028	30,500-35,200	295-340	0.003-0.020	18,300-24,600	120-200	0.002-0.012	48,000-50,000	790-920	0.008-0.048
0.5	25,650-33,000	370-470	0.006-0.035	23,750-26,000	285-315	0.004-0.025	14,200-18,000	115-130	0.003-0.015	44,000-50,000	800-1,150	0.010-0.060
0.6	20,900-35,200	330-560	0.007-0.030	19,900-22,000	260-290	0.005-0.021	11,900-15,500	100-120	0.003-0.013	37,500-50,000	770-1,250	0.011-0.051
0.8	16,150-26,400	360-590	0.009-0.040	15,200-16,700	280-310	0.006-0.028	9,000-11,700	110-125	0.004-0.017	28,500-47,000	770-1,300	0.015-0.068
1.0	12,300-18,700	350-540	0.011-0.028	10,500-11,500	250-280	0.008-0.020	6,300-8,050	100-115	0.005-0.012	22,500-34,000	810-1,300	0.018-0.048
1.2	10,450-17,600	350-590	0.025-0.070	9,100-10,000	250-280	0.015-0.042	5,400-7,000	100-115	0.009-0.026	22,500-31,500	950-1,350	0.036-0.101
1.5	9,100-17,600	430-830	0.017-0.077	7,000-8,000	250-280	0.012-0.055	4,300-5,500	100-115	0.007-0.033	14,500-25,000	770-1,320	0.028-0.132
2.0	6,350-10,550	340-570	0.021-0.140	6,100-6,700	270-300	0.015-0.100	3,600-4,700	100-120	0.009-0.060	11,500-18,500	770-1,250	0.036-0.240
3.0	4,300-7,050	550-900	0.056-0.210	3,990-4,600	445-515	0.040-0.150	2,400-3,200	105-310	0.024-0.090	9,000-13,000	1,400-2,110	0.096-0.360
4.0	3,200-5,300	400-675	0.074-0.280	3,000-3,400	335-380	0.053-0.200	1,800-2,400	75-230	0.032-0.120	6,750-9,750	1,050-1,575	0.128-0.480

RPM = rev. / min.
FEED = mm / min.



[DB412 series]

피삭재	열처리강							
경도	HRc45 ~ HRc50		HRc50 ~ HRc55		HRc55 ~ HRc60		HRc60 ~ HRc70	
강도	1500 ~ 1750N/mm ²		1750 ~ 2000N/mm ²		2000 ~ 2080N/mm ²		2080N/mm ²	
외경(mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1	20,000	460	20,000	400	20,000	350	20,000	240
1.5	16,300	640	16,100	580	16,000	570	14,200	360
2	14,500	800	14,200	740	13,850	760	11,300	465
2.5	13,400	950	13,000	890	12,600	920	9,600	560
3	12,700	1,100	12,300	1,050	11,800	1,000	8,400	660
4	10,600	1,100	10,300	1,050	9,800	1,000	6,650	650
5	9,400	1,100	9,050	1,050	8,600	950	5,600	680
6	8,600	1,150	8,250	1,100	7,850	950	4,850	700
8	7,000	1,050	6,700	1,000	6,350	950	3,800	650
10	6,050	1,000	5,800	960	5,450	900	3,200	620
12	5,450	1,000	5,200	960	4,900	900	2,750	610

RPM = rev. / min.
FEED = mm / min.

Ae: D1~D4=0.05XD
D5~D8=0.025mm
D10~D20=0.30mm
Ap: D1~D20=0.1 X D

