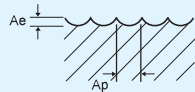


[DA412 series] ▶ 고속 가공

피삭재	열처리강					
	HRc45 ~ HRc50		HRc50 ~ HRc55		HRc55 ~ HRc60	
경도	1500 ~ 1750N/mm ²		1750 ~ 2000N/mm ²		2000 ~ 2080N/mm ²	
외경(inch)	RPM	FEED	RPM	FEED	RPM	FEED
R1/16 X 1/8	12,700	68.90	12,300	65.70	11,800	39.90
R3/32 X 3/16	9,400	65.00	9,050	61.80	8,600	29.50
R1/8 X 1/4	8,600	68.90	8,250	65.70	7,850	27.60
R5/32 X 5/16	7,000	61.00	6,700	57.50	6,350	25.60
R3/16 X 3/8	6,050	57.10	5,800	53.50	5,450	24.40
R1/4 X 1/2	5,450	55.90	5,200	52.40	4,900	24.00
R5/16 X 5/8	4,350	48.40	4,150	44.50	3,900	10.40
R3/8 X 3/4	3,500	39.40	3,300	35.40	3,150	8.70
R1/2 X 1	2,800	39.40	2,640	35.40	2,520	8.70

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

Ae: D1/8=,006
D3/16~D5/16=,010
D3/8~D1=,012
Ap: 0,05 X D

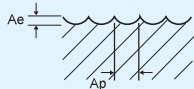


[DA512, DA302 series] ▶ 일반 가공

피삭재	비합금강 합금강, 주철		합금강 내열강		열처리강	
	~ HRc30		HRc30 ~ HRc40		HRc45 ~ HRc65	
경도	~ 1000N/mm ²		1000 ~ 1250N/mm ²		1500N/mm ²	
외경(inch)	RPM	FEED	RPM	FEED	RPM	FEED
R1/64 X 1/32	15,760	9.80	12,720	7.80	5,800	3.80
R1/32 X 1/16	15,760	13.80	12,140	1.60	5,320	4.70
R3/64 X 3/32	14,400	29.50	10,700	19.30	4,680	5.90
R1/16 X 1/8	13,100	26.70	10,000	18.10	4,520	5.90
R3/32 X 3/16	9,140	32.30	7,300	22.80	3,680	7.10
R1/8 X 1/4	7,780	33.00	6,300	24.80	3,160	7.50
R5/32 X 5/16	5,260	37.50	4,420	26.00	2,100	7.50
R3/16 X 3/8	4,620	40.10	3,780	28.00	1,780	7.50
R1/4 X 1/2	3,780	35.40	2,940	26.00	1,360	7.50
R5/16 X 5/8	2,740	36.20	2,320	26.00	1,160	7.50
R3/8 X 3/4	2,100	33.00	1,900	25.00	840	7.50

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

Ae: D1/32~D1/4=,008inch
D5/16~D3/4=,012inch
Ap: 0,2 X D



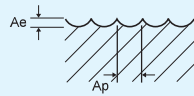
Ae: D1/32~D1/4=,008inch
D5/16~D3/4=,012inch
Ap: 0,1 X D

[DA512, DA302 series] ▶ 고속 가공

피삭재	비합금강 합금강, 주철		열처리강	
경도	~ HRC45		HRc45 ~ HRc65	
강도	~ 1500N/mm ²		1500N/mm ²	
외경(inch)	RPM	FEED	RPM	FEED
R1/64 X 1/32	25,000	25.60	12,720	15.70
R1/32 X 1/16	23,000	27.50	12,140	16.90
R3/64 X 3/32	21,000	34.60	10,700	19.30
R1/16 X 1/8	21,000	39.40	10,000	20.50
R3/32 X 3/16	21,000	70.90	7,300	23.60
R1/8 X 1/4	21,000	90.90	6,300	24.80
R5/32 X 5/16	15,760	111.80	4,420	29.10
R3/16 X 3/8	13,660	120.00	3,780	33.00
R1/4 X 1/2	10,500	103.50	2,940	33.00
R5/16 X 5/8	8,200	103.50	2,320	28.00
R3/8 X 3/4	6,300	99.00	1,900	20.80

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

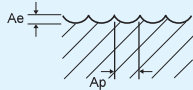
Ae: D1/32~D1/4=.008 inch
D5/16~D3/4=.012 inch
Ap: 0.05 X D


[DA514 series] ▶ 일반 가공

피삭재	비합금강 합금강, 주철		합금강 내열강		열처리강	
경도	~ HRC30		HRc30 ~ HRc40		HRc45 ~ HRc65	
강도	~ 1000N/mm ²		1000 ~ 1250N/mm ²		1500N/mm ²	
외경(inch)	RPM	FEED	RPM	FEED	RPM	FEED
R1/16 X 1/8	13,100	40.10	10,000	27.00	4,520	8.85
R3/32 X 3/16	9,140	48.50	7,300	34.00	3,680	10.50
R1/8 X 1/4	7,780	49.50	6,300	37.00	3,160	11.25
R5/32 X 5/16	5,260	56.00	4,420	39.00	2,100	11.25
R3/16 X 3/8	4,620	60.00	3,780	42.00	1,780	11.25
R1/4 X 1/2	3,780	53.00	2,940	39.00	1,360	11.25
R5/16 X 5/8	2,740	54.50	2,320	38.50	1,160	11.25

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

Ae: D1/8~D1/4=.008 inch
D5/16~D5/8=.012 inch
Ap: 0.02 X D



Ae: D1/8~D1/4=.008 inch
D5/16~D5/8=.012 inch
Ap: 0.1 X D