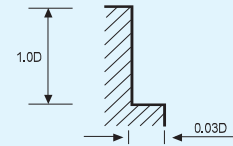
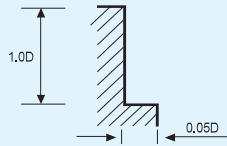


[ZE714A series] ▶ Side 가공

피삭재	열처리강, 내열강		열처리강									
	HRc30~ HRc40		HRc40~ HRc50		HRc50~ HRc55		HRc55~ HRc60		HRc60~ HRc65		HRc65~ HRc70	
경도	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1	48,000	1,480	38,000	1,050	25,500	710	20,500	430	16,000	270	12,500	175
2(1/16)	33,300	1,750	26,000	1,250	17,500	840	14,500	520	11,000	320	9,500	230
3(1/8)	21,800	1,750	17,300	1,250	11,500	840	9,500	520	7,500	320	6,400	230
4	16,700	1,800	13,200	1,300	8,800	880	7,200	540	5,600	335	4,750	240
5(3/16)	15,700	2,000	12,500	1,500	8,300	1,000	6,400	580	5,100	370	4,450	270
6(1/4)	13,100	1,950	10,350	1,400	6,900	950	5,300	560	4,200	350	3,700	260
8(5/16)	9,880	1,880	7,800	1,350	5,200	900	4,000	520	3,200	330	2,800	240
10(3/8)	7,800	1,750	6,150	1,260	4,100	840	3,200	480	2,550	310	2,200	220
12(1/2)	6,650	1,750	5,250	1,260	3,500	840	2,650	480	2,100	300	1,860	220
16	4,900	1,500	3,900	1,100	2,600	730	2,000	420	1,600	270	1,400	200
20	3,900	1,300	3,100	970	2,050	650	1,600	380	1,300	250	1,100	180

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

[ZS204A series] ▶ Side 가공

피삭재	열처리강									
	HRc40~ HRc50		HRc50~ HRc55		HRc55~ HRc60		HRc60~ HRc65		HRc65~ HRc70	
경도	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
4(3/16)	17,200	1,690	11,440	1,140	9,360	700	7,280	430	6,170	310
6(1/4)	13,450	1,820	8,970	1,230	6,890	720	5,460	450	4,810	330
8(5/16)	9,100	1,750	6,760	1,170	5,200	670	4,160	420	3,640	310
10(3/8)	8,000	1,630	5,330	1,090	4,160	620	3,320	400	2,860	280
12(1/2)	6,830	1,630	4,550	1,010	3,450	580	2,730	370	2,420	260

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