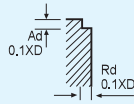


[ X-STAR series, Fractional ] ▶ 고속 가공

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.

