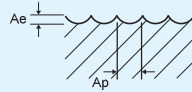


[DA514 series] ▶ 고속 가공

피삭재	비합금강, 합금강, 주철		합금강, 내열강	
경도	~ HRc45		HRc45 ~ HRc65	
강도	~ 1500N/mm ²		~ 1500N/mm ²	
외경(inch)	RPM	FEED	RPM	FEED
R1/16 X 1/8	21,000	59.00	17,000	30.50
R3/32 X 3/16	21,000	106.25	12,000	35.50
R1/8 X 1/4	21,000	136.50	10,500	37.00
R5/32 X 5/16	15,760	167.50	7,800	43.50
R3/16 X 3/8	13,660	180.00	6,300	49.50
R1/4 X 1/2	10,500	155.50	5,260	49.50
R5/16 X 5/8	8,200	155.50	3,780	42.00

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

Ae: D1/8~D1/4=.008 inch
D5/16~D5/8=.012 inch
Ap: 0.05 X D

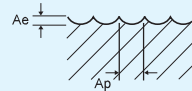


[DA522 series] ▶ 일반 가공

피삭재	합금강, 내열강		열처리강			
경도	HRc30 ~ HRc40		HRc45 ~ HRc50		HRc50 ~ HRc55	
강도	1000 ~ 1250N/mm ²		1500 ~ 1750N/mm ²		1750N/mm ² ~ 2000N/mm ²	
외경(inch)	RPM	FEED	RPM	FEED	RPM	FEED
R1/16 X 1/8	10,000	18.10	12,700	43.30	12,300	41.30
R3/32 X 3/16	7,300	22.80	9,400	43.30	9,050	41.30
R1/8 X 1/4	6,300	24.80	8,600	45.30	8,250	43.30
R5/32 X 5/16	4,420	26.00	7,000	41.30	6,700	39.40
R3/16 X 3/8	3,780	28.00	6,050	39.40	5,800	37.80
R1/4 X 1/2	2,940	26.00	5,450	39.40	5,200	37.80
R5/16 X 5/8	2,320	26.00	4,350	34.30	4,150	32.70
R3/8 X 3/4	1,900	25.00	3,500	27.20	3,300	25.60
R1/2 X 1	1,520	25.00	2,800	27.20	2,650	25.60

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

Ae: D1/8~D1/4=.008
D5/16~D1=.012
Ap: 0.2 X D



Ae: D1/8=.006
D3/16~D5/16=.010
D3/8~D1=.012
Ap: 0.1 X D

[DA522 series] ▶ 고속 가공

피삭재	합금강, 내열강		열처리강			
	HRc30 ~ HRc40		HRc45 ~ HRc50		HRc50 ~ HRc55	
경도	1000 ~ 1250N/mm ²		1500 ~ 1750N/mm ²		1750N/mm ² ~ 2000N/mm ²	
강도	1000 ~ 1250N/mm ²		1500 ~ 1750N/mm ²		1750N/mm ² ~ 2000N/mm ²	
외경(inch)	RPM	FEED	RPM	FEED	RPM	FEED
R1/16 X 1/8	21,000	39.40	12,700	68.90	12,300	65.70
R3/32 X3/16	21,000	70.90	9,400	65.00	9,050	61.80
R1/8 X 1/4	21,000	90.90	8,600	69.00	8,250	65.70
R5/32 X 5/16	15,760	111.80	7,000	61.00	6,700	57.50
R3/16 X 3/8	13,660	120.10	6,050	57.10	5,800	53.50
R1/4 X 1/2	10,500	103.50	5,450	55.90	5,200	52.40
R5/16 X 5/8	8,200	103.50	4,350	48.40	4,150	44.50
R3/8 X 3/4	6,300	99.20	3,500	39.40	3,300	35.40
R1/2 X 1	5,040	99.20	2,800	39.40	2,650	35.40

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

Ae: D1/8~D1/4=.008
D5/16~D1=.012
Ap: 0.05 X D

Ae: D1/8=.006
D3/16~D5/16=.010
D3/8~D1=.012
Ap: 0.05 X D

[MD502 series] ▶ 고속 가공

피삭재	비합금강, 합금강, 주철		합금강, 내열강	
	HRc30 ~ HRc45		HRc45 ~ HRc55	
경도	1000 ~ 1500N/mm ²		1500 ~ 2000N/mm ²	
강도	1000 ~ 1500N/mm ²		1500 ~ 2000N/mm ²	
외경(inch)	RPM	FEED	RPM	FEED
R.012X.024	30,000	23.60	30,000	11.80
R.0155X.031	27,000	25.60	27,000	15.00
R.020X.040	25,000	25.60	25,000	15.70
R.0235X.047	24,000	26.40	24,000	16.50
R.031X.062	23,000	27.60	23,000	16.90

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

D < .040
Ae: 0.05 X D
Ap: 0.15 X D
D ≥ .040
Ae: 0.075 X D
Ap: 0.15 X D