

## [ DA552 series ] ▶ 일반 가공

피삭재	합금강, 내열강		열처리강			
	HRc30 ~ HRc40		HRc45 ~ HRc50		HRc50 ~ HRc55	
경도	1000 ~ 1250N/mm <sup>2</sup>		1250 ~ 1750N/mm <sup>2</sup>		1750N/mm <sup>2</sup> ~ 2000N/mm <sup>2</sup>	
외경(inch)	RPM	FEED	RPM	FEED	RPM	FEED
R3/32 X 3/16	4670	14.50	6000	27.70	5760	26.80
R1/8 X 1/4	4030	15.80	5520	29.00	5200	27.70
R5/32 X 5/16	2830	16.70	4480	26.50	4240	25.20
R3/16 X 3/8	2420	17.90	3880	25.20	3720	24.20
R1/4 X 1/2	1880	16.70	3480	25.20	3320	24.20

  

RPM = rev. / min. FEED = inch / min. Ae: D3/16~D1/4=.008 D5/16~D1/2=.012 Ap: 0.2 X D		Ae: D3/16~D5/16=.010 D3/8~D1/2=.012 Ap: 0.1 X D
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## [ DA552 series ] ▶ 고속 가공

피삭재	합금강, 내열강		열처리강			
	~ HRc45		HRc45 ~ HRc50		HRc50 ~ HRc55	
경도	~ 1500N/mm <sup>2</sup>		1250 ~ 1750N/mm <sup>2</sup>		1750N/mm <sup>2</sup> ~ 2000N/mm <sup>2</sup>	
외경(inch)	RPM	FEED	RPM	FEED	RPM	FEED
R3/32 X 3/16	13,440	45.40	6,000	41.60	5,760	39.40
R1/8 X 1/4	13,440	58.20	5,520	44.10	5,200	42.50
R5/32 X 5/16	10,080	71.50	4,480	39.40	4,240	36.20
R3/16 X 3/8	8,740	76.90	3,880	36.30	3,720	34.60
R1/4 X 1/2	6,720	66.20	3,480	35.60	3,320	33.00

  

RPM = rev. / min. FEED = inch / min. Ae: D3/16~D1/4=.008 D5/16~D1/2=.012 Ap: 0.5 X D		Ae: D3/16~D5/16=.010 D3/8~D1/2=.012 Ap: 0.05 X D
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