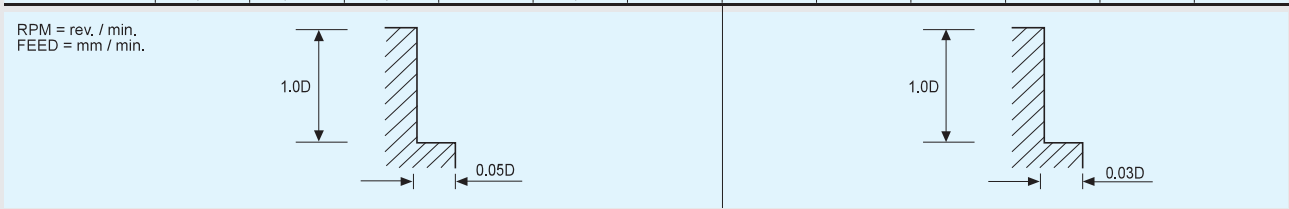


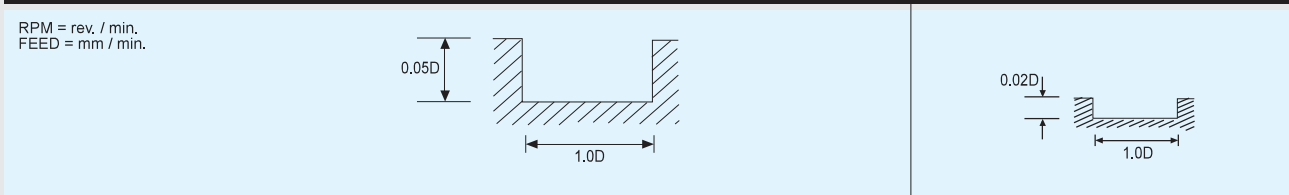
[ZE704, ZE714, ZE724 series] ▶ 측면 절삭 가공

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
외경(mm)												
1	48,000	1,480	38,000	1,050	25,500	710	20,500	430	16,000	270	12,500	175
2	33,300	1,750	26,000	1,250	17,500	840	14,500	520	11,000	320	9,500	230
3	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	15,700	2,000	12,500	1,500	8,300	1,000	6,400	580	5,100	370	4,450	270
6	13,100	1,950	10,350	1,400	6,900	950	5,300	560	4,200	350	3,700	260
8	9,880	1,880	7,800	1,350	5,200	900	4,000	520	3,200	330	2,800	240
10	7,800	1,750	6,150	1,260	4,100	840	3,200	480	2,550	310	2,200	220
12	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



[ZR702, ZR732 series] ▶ 슬로팅 가공

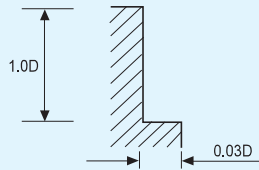
피삭재	열처리강 내열강		열처리강									
	HRc30 ~ HRc40		HRc40 ~ HRc50		HRc50 ~ HRc55		HRc55 ~ HRc60		HRc60 ~ HRc65		HRc65 ~ HRc70	
경도	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
외경(mm)												
2	33,300	680	26,000	544	17,500	336	14,500	208	11,000	128	9,500	92
3	21,800	680	17,300	544	11,500	336	9,500	208	7,500	128	6,400	92
4	16,700	704	13,200	560	8,800	352	7,200	216	5,600	136	4,750	94
5	15,700	800	12,500	644	8,300	400	6,400	228	5,100	144	4,450	106
6	13,100	760	10,350	616	6,900	384	5,300	224	4,200	144	3,700	104
8	9,880	744	7,800	576	5,200	356	4,000	204	3,200	132	2,800	96
10	7,800	680	6,150	544	4,100	332	3,200	192	2,550	124	2,200	90
12	6,650	680	5,250	544	3,500	332	2,650	192	2,100	124	1,860	90
16	4,900	584	3,900	464	2,600	292	2,000	168	1,600	108	1,400	78
20	3,900	528	3,100	420	2,050	268	1,600	168	1,300	100	1,100	70



[ZR702, ZR732 series] ▶ 측면 절삭 가공

피삭재	열처리강, 내열강		열처리강									
	열처리강, 내열강		HRc40 ~ HRc50		HRc50 ~ HRc55		HRc55 ~ HRc60		HRc60 ~ HRc65		HRc65 ~ HRc70	
경도	HRc30 ~ HRc40		RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
외경(mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2	33,300	960	26,000	776	17,500	480	14,500	296	11,000	184	9,500	132
3	21,800	960	17,300	776	11,500	480	9,500	296	7,500	184	6,400	132
4	16,700	1,000	13,200	800	8,800	500	7,200	308	5,600	192	4,750	136
5	15,700	1,160	12,500	920	8,300	568	6,400	328	5,100	208	4,450	152
6	13,100	1,080	10,350	880	6,900	552	5,300	320	4,200	204	3,700	148
8	9,880	1,056	7,800	824	5,200	508	4,000	292	3,200	188	2,800	136
10	7,800	960	6,150	776	4,100	472	3,200	272	2,550	176	2,200	128
12	6,650	960	5,250	776	3,500	472	2,650	272	2,100	176	1,860	128
16	4,900	840	3,900	672	2,600	416	2,000	240	1,600	152	1,400	112
20	3,900	760	3,100	600	2,050	380	1,600	220	1,300	140	1,100	100

RPM = rev. / min.
FEED = mm / min.



[ZR704, ZR714, ZR724, ZR734 series]

피삭재	열처리강, 내열강		열처리강									
	열처리강, 내열강		HRc40 ~ HRc50		HRc50 ~ HRc55		HRc55 ~ HRc60		HRc60 ~ HRc65		HRc65 ~ HRc70	
경도	HRc30 ~ HRc40		RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
외경(mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
3	21,800	1,400	17,300	1,000	11,500	672	9,500	416	7,500	256	6,400	184
4	16,700	1,440	13,200	1,040	8,800	704	7,200	432	5,600	268	4,750	192
5	15,700	1,600	12,500	1,200	8,300	800	6,400	464	5,100	296	4,450	216
6	13,100	1,560	10,350	1,120	6,900	760	5,300	448	4,200	280	3,700	208
8	9,880	1,504	7,800	1,080	5,200	720	4,000	416	3,200	264	2,800	192
10	7,800	1,400	6,150	1,008	4,100	672	3,200	384	2,550	248	2,200	176
12	6,650	1,400	5,250	1,008	3,500	672	2,650	384	2,100	240	1,860	176
16	4,900	1,200	3,900	880	2,600	584	2,000	336	1,600	216	1,400	160
20	3,900	1,040	3,100	776	2,050	520	1,600	304	1,300	200	1,100	144

RPM = rev. / min.
FEED = mm / min.

