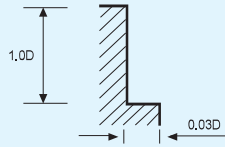


[ZE712A series] ▶ Side 가공

피삭재	열처리강, 내열강		열처리강									
	경도		HRc40~ HRc50		HRc50~ HRc55		HRc55~ HRc60		HRc60~ HRc65		HRc65~ HRc70	
외경(mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1	48,000	1,050	38,000	820	25,500	510	20,500	310	16,000	190	12,500	125
2(1/16)	33,300	1,200	26,000	970	17,500	600	14,500	370	11,000	230	9,500	165
3(1/8)	21,800	1,200	17,300	970	11,500	600	9,500	370	7,500	230	6,400	165
4	16,700	1,250	13,200	1000	8,800	625	7,200	385	5,600	240	4,750	170
5(3/16)	15,700	1,450	12,500	1,150	8,300	710	6,400	410	5,100	260	4,450	190
6(1/4)	13,100	1,350	10,350	1,100	6,900	690	5,300	400	4,200	255	3,700	185
8(5/16)	9,880	1,320	7,800	1,030	5,200	635	4,000	365	3,200	235	2,800	170
10(3/8)	7,800	1,200	6,150	970	4,100	590	3,200	340	2,550	220	2,200	160
12(1/2)	6,650	1,200	5,250	970	3,500	590	2,650	340	2,100	220	1,860	160
16	4,900	1,050	3,900	840	2,600	520	2,000	300	1,600	190	1,400	140
20	3,900	950	3,100	750	2,050	475	1,600	275	1,300	175	1,100	125

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



[ZE712A series] ▶ 슬로팅 가공

피삭재	열처리강, 내열강		열처리강									
	경도		HRc40~ HRc50		HRc50~ HRc55		HRc55~ HRc60		HRc60~ HRc65		HRc65~ HRc70	
외경(mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
0.2	50,000	130	45,000	115	40,000	95	33,000	310	16,000	190	12,500	125
0.3	50,000	190	45,000	140	40,000	115	33,000	370	11,000	230	9,500	165
0.4	50,000	235	45,000	180	40,000	140	33,000	370	7,500	230	6,400	165
0.5	50,000	370	45,000	280	40,000	220	33,000	385	5,600	240	4,750	170
0.6	50,000	470	45,000	360	40,000	285	30,000	410	5,100	260	4,450	190
0.8	50,000	600	40,000	440	30,000	295	25,000	400	4,200	255	3,700	185
0.9	49,000	655	39,000	520	27,800	330	22,700	365	3,200	235	2,800	170
1	48,000	750	38,000	570	25,500	360	20,500	340	2,550	220	2,200	160
2(1/16)	33,300	850	26,000	680	17,500	420	14,500	340	2,100	220	1,860	160
3(1/8)	21,800	850	17,300	680	11,500	420	9,500	300	1,600	190	1,400	140
4	16,700	880	13,200	700	8,800	440	7,200	275	1,300	175	1,100	125
5(3/16)	15,700	1,000	12,500	805	8,300	500	6,400	0	0	0	0	0
6(1/4)	13,100	950	10,350	770	6,900	480	5,300	0	0	0	0	0
8(5/16)	9,880	930	7,800	720	5,200	445	4,000	0	0	0	0	0
10(3/8)	7,800	850	6,150	680	4,100	415	3,200	0	0	0	0	0
12(1/2)	6,650	850	5,250	680	3,500	415	2,650	0	0	0	0	0
16	4,900	730	3,900	580	2,600	365	2,000	0	0	0	0	0
20	3,900	660	3,100	525	2,050	335	1,600	0	0	0	0	0

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

