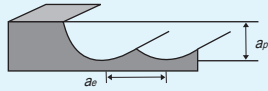


[B302, BL422 series]

피삭재	탄소강, 합금강, 공구강		합금강, 공구강	
	~ HB225		HB225~325	
경도	RPM	FEED	RPM	FEED
외경(mm)				
R0.5	31,800	572	27,900	502
R1	31,800	1,910	27,900	1,670
R2	15,900	1,910	13,900	1,670
R3	10,600	1,910	9,280	1,670
R4	7,960	1,910	6,960	1,670
R5	6,370	1,780	5,570	1,560
R6	5,310	1,590	4,640	1,390
R8	4,000	1,300	3,500	1,050
R10	3,200	1,000	2,800	840
R12.5	2,400	800	2,100	650

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



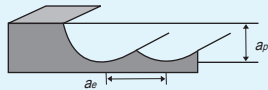
R	a_p	a_e
$R \leq 1.0$	$0.05 \times R$ 이하	$0.2 \times R$ 이하
$1.0 < R$	$0.1 \times R$ 이하	$0.2 \times R$ 이하

· BL422 시리즈는 절삭속도를 20~30% 줄여 사용하십시오.

[B304 series]

피삭재	탄소강, 합금강, 공구강		합금강, 공구강	
	~ HB225		HB225~325	
경도	RPM	FEED	RPM	FEED
외경(mm)				
R0.5	39,750	718.25	34,875	6,275
R1	39,750	2,387.5	34,875	2,087.5
R2	19,875	2,387.5	17,375	2,087.5
R3	13,250	2,387.5	11,600	2,087.5
R4	9,950	2,387.5	8,700	2,087.5
R5	7,962.5	2,225	6,962.5	1,950
R6	6,637.5	1,987.5	5,800	1,737.5
R8	5,000	1,625	4,375	1,312.5
R10	4,000	1,250	3,500	1,050
R12.5	3,000	1,000	2,625	812.5

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



R	a_p	a_e
$R \leq 1.0$	$0.05 \times R$ 이하	$0.2 \times R$ 이하
$1.0 < R$	$0.1 \times R$ 이하	$0.2 \times R$ 이하