

[CES series]

피삭재	탄소강, 합금강						스테인리스강, 티타늄강		알루미늄	
	~HRc20		HRc20~ HRc30		HRc30~ HRc40					
강도	500~800N/mm ²		800~1000N/mm ²		1000~1300N/mm ²					
외경(mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
3	5,900	60	4,000	30	3,300	25	2,400	20	14,000	220
4	4,800	60	3,300	30	2,800	25	2,000	20	11,800	230
5	3,800	60	2,500	30	2,200	25	1,760	20	9,500	240
6	3,000	60	2,000	30	1,800	30	1,400	20	7,700	250
8	2,300	65	1,540	35	1,300	35	1,100	20	5,800	260
10	2,000	65	1,300	35	1,200	35	1,000	20	5,000	260
12	1,760	65	1,000	40	1,000	35	540	20	4,400	260
16	1,400	65	900	40	770	35	660	25	3,300	270
20	1,100	65	700	40	600	35	440	25	2,600	270

[CEM series]

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	~HRc20		HRc20~ HRc30		HRc30~ HRc40					
강도	500~800N/mm ²		800~1000N/mm ²		1000~1300N/mm ²					
외경(mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
3	5,900	95	3,900	65	3,300	50	2,400	40	14,000	230
4	4,800	95	3,200	65	2,800	50	2,000	40	12,000	240
5	3,800	100	2,500	65	2,200	55	1,760	45	9,500	250
6	3,000	110	2,000	70	1,800	60	1,400	50	7,700	300
8	2,300	115	1,540	75	1,300	65	1,100	55	5,800	350
10	2,000	120	1,300	80	1,200	65	1,000	55	5,100	380
12	1,760	130	1,100	90	1,000	70	840	60	4,400	400
16	1,400	140	900	90	770	70	660	60	3,000	330
20	1,100	140	700	90	600	70	440	60	2,640	340