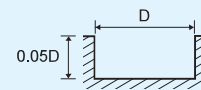
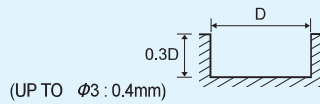


## [ ZM502, ZM522 series ]

피삭재	비합금강, 합금강, 주철		합금강, 내열강		열처리강	
경도	~ HRc30		HRc30 ~ HRc45		HRc45 ~ HRc55	
강도	~ 1000N/mm <sup>2</sup>		1000 ~ 1500N/mm <sup>2</sup>		1500 ~ 2000N/mm <sup>2</sup>	
외경(mm)	RPM	FEED	RPM	FEED	RPM	FEED
2	6,300	60	5,040	50	3,150	25
3	4,410	70	3,570	60	2,200	30
4	3,570	85	2,840	70	1,790	35
5	3,050	105	2,420	85	1,580	40
6	2,630	125	2,100	105	1,370	50
8	2,000	135	1,580	105	1,050	50
10	1,680	135	1,370	105	840	50
12	1,370	105	1,160	95	700	40
16	1,160	95	890	75	560	35
20	840	70	680	50	420	25

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



## [ ZM504, ZM524 series ]

피삭재	비합금강, 합금강, 주철		합금강, 내열강		열처리강			
경도	~ HRc30		HRc30 ~ HRc45		HRc45 ~ HRc55		HRc55 ~ HRc65	
강도	~ 1000N/mm <sup>2</sup>		1000 ~ 1500N/mm <sup>2</sup>		1500 ~ 2000N/mm <sup>2</sup>		2000N/mm <sup>2</sup>	
외경(mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2	6,300	100	5,040	80	3,150	45		
3	4,410	115	3,570	100	2,200	55	1,890	30
4	3,570	140	2,840	115	1,790	60	1,470	35
5	3,050	180	2,420	140	1,580	70	1,260	40
6	2,630	215	2,100	180	1,370	90	1,160	50
8	2,000	230	1,580	180	1,050	90	840	50
10	1,680	230	1,370	180	840	90	670	50
12	1,370	180	1,160	160	700	70	560	40
16	1,160	160	890	125	560	60	440	35
20	840	115	680	90	420	45	340	25

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

