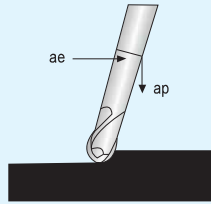


[DB534 series] ▶ 일반 가공

피삭재	비합금강, 합금강, 주철		합금강, 내열강		열처리강	
경도	~ HRc30		HRc30 ~ HRc40		HRc45 ~ HRc65	
강도	~ 1000N/mm ²		1000 ~ 1250N/mm ²		1500N/mm ²	
외경(mm)	RPM	FEED	RPM	FEED	RPM	FEED
5	21,000	4,000	20,000	4,000	7,000	1,400
6	17,000	4,000	16,000	3,500	6,000	1,300
8	13,000	3,500	12,000	3,000	4,500	1,100
10	10,500	3,000	10,000	2,500	3,500	1,000
12	9,000	2,800	8,000	2,500	3,000	950
16	6,000	2,800	5,500	2,200	2,000	800

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



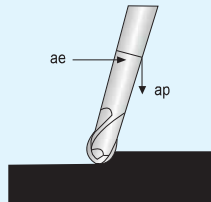
$$ae = 0.05 \times d1$$

$$ap = 0.02 \times d1$$

[DB534 series] ▶ 고속 가공

피삭재	비합금강, 합금강, 주철		합금강, 내열강		열처리강	
경도	~ HRc30		HRc30 ~ HRc40		HRc45 ~ HRc65	
강도	~ 1000N/mm ²		1000 ~ 1250N/mm ²		1500N/mm ²	
외경(mm)	RPM	FEED	RPM	FEED	RPM	FEED
5	28,000	5,600	27,000	5,300	11,000	2,100
6	23,000	5,100	22,000	4,900	9,000	1,900
8	18,000	4,600	17,000	4,300	7,000	1,700
10	14,000	3,900	13,000	3,700	5,000	1,400
12	12,000	3,700	11,000	3,500	4,500	1,300
16	9,000	3,100	8,000	3,000	3,300	1,100

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



$$ae = 0.05 \times d1$$

$$ap = 0.02 \times d1$$