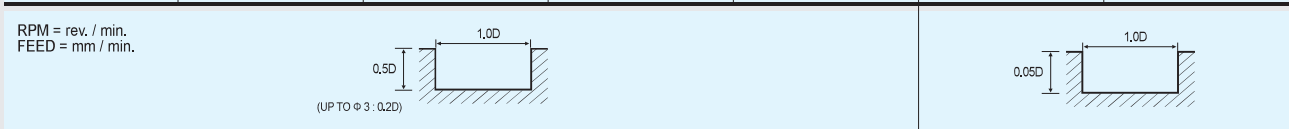


[ZE302, ZE322, ZE402, ZE502, ZE522, ZE512 series] ▶ 일반 가공

피삭재	합금강, 내열강		열처리강		스테인리스강	
경도	HRc30 ~ HRc40		HRc40 ~ HRc50			
강도	1000 ~ 1250N/mm ²		1250 ~ 1750N/mm ²			
외경(mm)	RPM	FEED	RPM	FEED	RPM	FEED
2	9,700	220	6,350	135	5,300	105
3	7,500	240	4,670	160	3,880	135
4	6,350	345	3,880	205	3,250	175
5	5,300	370	3,170	220	2,650	185
6	4,670	405	2,830	255	2,380	205
8	3,530	435	2,120	230	1,760	205
10	2,730	380	1,680	185	1,420	185
12	2,310	320	1,420	150	1,140	150
16	1,850	255	1,140	125	890	125
20	1,420	195	890	90	705	90
25	1,150	150	705	80	580	70



· ZE522, ZE322 시리즈는 절삭속도를 20~30% 줄여 사용하십시오.

[ZE302, ZE322, ZE402, ZE502, ZE522, ZE512 series] ▶ 고속 가공

피삭재	합금강, 내열강		열처리강		스테인리스강	
경도	HRc30 ~ HRc40		HRc40 ~ HRc50		HRc40 ~ HRc55	
강도	1000 ~ 1250N/mm ²		1250 ~ 1750N/mm ²		1750 ~ 2000N/mm ²	
외경(mm)	RPM	FEED	RPM	FEED	RPM	FEED
2	18,000	665	11,800	415	8,700	175
3	11,000	655	6,800	435	5,600	185
4	10,300	725	6,300	430	4,300	185
5	9,350	715	5,570	420	3,700	185
6	8,200	750	4,930	470	3,250	185
8	6,300	770	3,780	410	2,470	185
10	4,830	750	2,940	360	2,000	160
12	4,100	750	2,520	345	1,680	160
16	3,260	715	2,000	355	1,890	150
20	2,520	665	1,580	310	1,680	150
25	2,000	635	1,260	340	1,570	150

