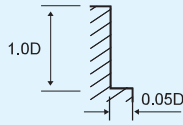


[ZE503 series] ▶ 측면 절삭 가공

피삭재	비합금강, 합금강, 주철		합금강, 내열강		스테인리스강		열처리강			
경도	~ HRc30		HRc30 ~ HRc45				HRc45 ~ HRc55		HRc55 ~ HRc65	
강도	~ 1000N/mm ²		1000 ~ 1500N/mm ²				1500 ~ 2000N/mm ²		2000N/mm ² ~	
외경(mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
6	5,560	500	3,360	310	2,840	250	2,000	60	1,100	45
8	4,200	530	2,520	290	2,100	265	1,680	80	840	45
10	3,260	460	2,000	230	1,680	230	1,360	70	680	35
12	2,740	390	1,680	190	1,360	180	1,160	60	560	35
16	2,200	310	1,360	150	1,060	150	900	45	440	20
18	1,940	280	1,210	135	950	130	790	35	380	20
20	1,680	240	1,060	120	840	115	680	30	320	20

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



[ZE503 series] ▶ 슬로팅 가공

피삭재	비합금강, 합금강, 주철		합금강, 내열강		스테인리스강		열처리강			
경도	~ HRc30		HRc30 ~ HRc45				HRc45 ~ HRc55		HRc55 ~ HRc65	
강도	~ 1000N/mm ²		1000 ~ 1500N/mm ²				1500 ~ 2000N/mm ²		2000N/mm ² ~	
외경(mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
6	5,560	310	3,360	200	2,840	160	2,000	50	1,100	35
8	4,200	340	2,520	180	2,100	160	1,680	65	840	35
10	3,260	300	2,000	140	1,680	145	1,360	55	680	30
12	2,740	250	1,680	120	1,360	120	1160	50	560	30
16	2,200	200	1,360	100	1,060	100	900	35	440	20
18	1,940	175	1,210	85	950	85	790	30	380	20
20	1,680	150	1,060	70	840	70	680	25	320	20

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

