

[ZR506(8)A series] ▶ 고속 가공

피삭재	탄소강, 합금강, 주철		합금강, 공구강		열처리강	
경도	~ HRc50		HRc50 ~ HRc60		HRc60 ~ HRc65	
강도	1750N/mm ²		1750N/mm ²		2080N/mm ²	
외경(inch)	RPM	FEED	RPM	FEED	RPM	FEED
1/4	16,800	240.00	8,400	120.00	4,200	58.00
5/16	12,600	240.00	6,300	120.00	3,200	58.00
3/8	10,000	235.00	5,000	120.00	2,500	58.00
1/2	8,400	200.00	4,200	100.00	2,100	50.00
5/8	6,300	150.00	3,150	75.00	1,600	37.00
3/4	5,000	120.00	2,500	58.00	1,260	30.00

RPM = rev. / min. FEED = inch / min.			
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[FA50 series] ▶ 일반 가공

피삭재	비합금강, 합금강, 주철		합금강, 내열강		합금강, 내열강		열처리강			
경도	~ HRc30		HRc30 ~ HRc38		HRc38 ~ HRc45		HRc45 ~ HRc55		HRc55 ~ HRc65	
강도	~ 1000N/mm ²		1000 ~ 1200N/mm ²		1200 ~ 1400N/mm ²		1400 ~ 2000N/mm ²		2000N/mm ²	
외경(inch)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1/4	15,600	91.35	12,400	33.10	8,400	22.45	3,400	10.25	2,400	7.50
5/16	11,600	91.35	9,200	33.10	6,300	22.45	2,400	9.50	1,800	7.10
3/8	9,200	91.35	7,600	33.10	5,100	22.45	2,000	11.40	1,300	7.50
1/2	8,000	94.50	6,000	31.50	4,200	22.45	1,680	10.25	1,200	7.50
5/8	6,000	94.50	4,800	29.90	3,300	20.05	1,200	6.30	800	4.35
3/4	5,200	91.35	4,400	28.35	2,700	16.55	1,100	5.90	700	3.95
1	4,800	85.05	3,600	22.05	2,400	14.15	1,000	5.90	660	3.95

RPM = rev. / min. FEED = inch / min.		
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