

[MZ502 series] ▶ 고속 가공

피삭재	합금강, 공구강		열처리강	
경도	HRc30 ~ HRc45		HRc45 ~ HRc55	
강도	1000 ~ 1500N/mm ²		1500 ~ 2000N/mm ²	
외경(inch)	RPM	FEED	RPM	FEED
.016	30,000	23.60	23,000	3.90
.031	27,000	25.60	18,000	5.10
.040	25,000	25.60	15,000	5.90
.047	24,000	26.40	12,000	5.90
.062	23,000	27.60	9,000	5.50

<p>RPM = rev. / min. FEED = inch / min.</p> <p>D < .040 Depth=0.15 X D D ≥ .040 Depth=0.25 X D</p>		<p>D < .040 Depth=0.02 X D D ≥ .040 Depth=0.05 X D</p>	
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[ZA304, ZA504 series]

피삭재	탄소강, 합금강, 주철		합금강, 공구강		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(inch)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1/16	11,560	11.00	7,560	6.70	6,300	5.50	5,040	1.95		
1/8	8,920	12.60	5,560	7.85	4,620	6.70	3,360	2.35	1,900	2.35
3/16	6,300	23.60	3,780	14.15	3,160	11.80	2,320	2.75	1,260	2.35
1/4	5,560	26.00	3,360	16.15	2,840	13.00	2,000	3.15	1,100	2.35
5/16	4,200	27.95	2,520	14.95	2,100	13.80	1,680	4.30	840	2.35
3/8	3,260	24.00	2,000	11.80	1,680	11.80	1,360	3.55	680	1.95
1/2	2,740	20.50	1,680	9.85	1,360	9.45	1,160	3.15	560	1.95
5/8	2,200	16.15	1,360	7.85	1,060	7.85	900	2.35	440	1.20
3/4	1,680	12.60	1,060	6.30	840	5.90	680	1.55	320	1.20
1	1,360	9.85	840	5.10	680	4.70	540	1.20	260	0.80

<p>RPM = rev. / min. FEED = inch / min.</p>		
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