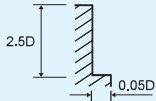
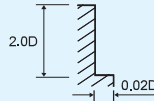


[ZA524 series] ▶ 일반 가공

피삭재	탄소강, 합금강, 주철		합금강		열처리강			
	~ 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
1/8	4,410	4.5	3,570	3.9	2,200	2.2	1,890	1.2
3/16	3,050	7.1	2,420	5.5	1,580	2.8	1,260	1.6
1/4	2,630	8.5	2,100	7.1	1,370	3.5	1,160	2.0
5/16	2,000	9.1	1,580	7.1	1,050	3.5	840	2.0
3/8	1,680	9.1	1,370	7.1	840	3.5	670	2.0
1/2	1,370	7.1	1,160	6.3	700	2.8	560	1.6
5/8	1,160	6.3	890	4.9	560	2.4	440	1.4
3/4	840	4.5	680	3.5	420	1.8	340	1.0
1	670	4.5	540	3.5	340	1.8	270	1.0

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

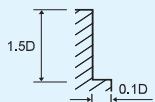


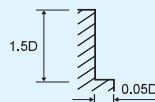


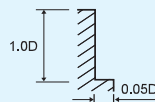
[ZA506 & 8 series] ▶ 일반 가공

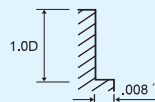
피삭재	탄소강, 합금강, 주철		합금강, 공구강		열처리강			
	~ HRc30		HRc30 ~ HRc50		HRc50 ~ HRc55		HRc60 ~ HRc65	
강도	~ 1000N/mm ²		1000 ~ 1750N/mm ²		1750 ~ 2080N/mm ²		2080N/mm ²	
외경(inch)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1/4	5,560	79.00	3,880	54.00	1,580	8.25	1,100	5.10
5/16	4,200	79.00	2,940	54.00	1,160	8.25	840	5.10
3/8	3,360	79.00	2,320	54.00	1,000	8.25	680	5.10
1/2	2,840	66.00	2,000	46.00	840	7.10	560	4.35
5/8	2,100	50.00	1,480	35.00	640	5.10	420	2.75
3/4	1,680	40.00	1,160	27.00	500	4.35	320	2.35
1	1,260	25.00	870	17.50	375	3.00	240	1.54

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









[ZA506 & 8 series] ▶ 고속 가공

피삭재	탄소강, 공구강		열처리강			
	~ HRc50		HRc50 ~ HRc60		HRc60 ~	
강도	1750N/mm ²		1750~ 2080N/mm ²		2080N/mm ²	
외경(inch)	RPM	FEED	RPM	FEED	RPM	FEED
1/8	16,800	240.00	8,400	120.00	4,200	58.00
3/16	12,600	240.00	6,300	120.00	3,160	58.00
1/4	9,980	235.00	5,040	120.00	2,520	58.00
5/16	8,400	199.00	4,200	100.00	2,100	50.00
3/8	6,300	149.00	3,160	75.00	1,580	37.00
1/2	5,040	120.00	2,520	58.00	1,260	30.00
5/8	3,790	75.00	1,890	38.00	950	19.00

RPM = rev. / min. FEED = inch / min.			
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[ZA526 & 8 series] ▶ 고속 가공

피삭재	비합금강, 합금강, 주철		합금강, 내열강		열처리강			
	~ HRc40		HRc40 ~ HRc50		HRc50 ~ HRc60		HRc60 ~ HRc65	
강도	~ 1250N/mm ²		1250 ~ 1750N/mm ²		1750 ~ 2080N/mm ²		2080N/mm ²	
외경(inch)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1/4	2,230	19.00	1,670	14.00	1,390	10.00	1,110	8.00
5/16	1,670	18.00	1,250	13.00	1,050	9.50	840	7.00
3/8	1,330	17.00	1,000	12.00	840	9.00	680	6.30
1/2	1,110	16.00	840	11.00	690	8.50	560	6.00
5/8	840	13.00	630	9.00	530	6.50	420	5.00
3/4	670	11.00	500	8.00	420	6.00	320	4.70
1	540	9.50	400	6.50	340	5.00	270	3.70

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