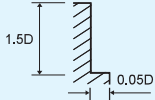
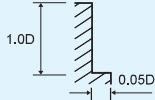
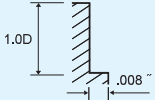


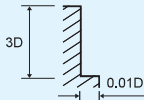
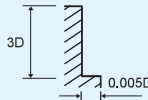
[ZA506 & 8 series] ▶ 고속 가공

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

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

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