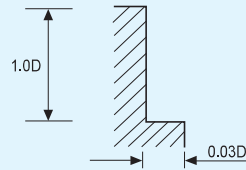
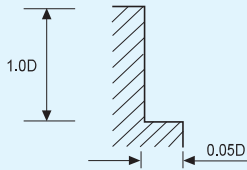


[ZR706, ZR736, ZE716, ZE726 series]

피삭재	열처리강, 내열강		열처리강									
	HRc30 ~ HRc40		HRc40 ~ HRc50		HRc50 ~ HRc 55		HRc55 ~ HRc60		HRc60 ~ HRc65		HRc65 ~ HRc70	
외경(mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
6	24,800	5,350	23,500	4,900	16,000	4,900	13,500	3,300	10,500	2,100	8,000	1,450
8	20,000	5,500	19,000	5,000	12,000	4,600	10,000	3,100	8,000	2,000	6,000	1,400
10	16,000	4,900	15,500	4,500	9,500	4,100	8,000	2,900	6,400	1,800	4,800	1,300
12	13,000	4,500	12,500	4,100	8,000	3,800	6,600	2,500	5,300	1,600	4,000	1,150
16	10,000	4,000	9,700	3,700	6,000	3,400	5,000	2,300	4,000	1,250	3,000	870
20	8,000	3,350	7,800	3,400	4,800	3,200	4,000	2,100	3,200	1,020	2,400	690

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



[ZSLNB series]

피삭재	합금강, 내열강			열처리강			열처리강			동, 동합금		
	HRc30 ~ HRc45			HRc45 ~ HRc55			HRc55 ~ HRc65					
외경(mm)	RPM	FEED	Ae(mm)	RPM	FEED	Ae(mm)	RPM	FEED	Ae(mm)	RPM	FEED	Ae(mm)
0.5	34,100-49,500	600-870	0.007-0.028	31,900-35,200	490-540	0.005-0.023	31,900-35,200	440-480	0.005-0.021	49,000-50,000	1,100-1,400	0.010-0.042
0.6	28,600-40,700	590-850	0.007-0.034	26,400-29,700	480-540	0.006-0.028	26,400-29,700	400-480	0.006-0.025	42,000-50,000	1,100-1,700	0.011-0.050
0.8	22,000-30,800	640-890	0.016-0.064	19,800-22,000	490-550	0.013-0.052	19,800-22,000	440-500	0.012-0.048	31,000-50,000	1,100-2,250	0.024-0.096
1.0	17,600-24,200	600-850	0.008-0.080	15,400-17,600	470-540	0.007-0.065	15,400-17,600	440-500	0.006-0.060	24,000-49,500	1,100-2,200	0.012-0.120
1.2	14,300-18,700	590-780	0.024-0.032	12,000-14,000	480-540	0.020-0.026	12,000-14,000	420-480	0.018-0.024	28,500-38,500	1,480-1,950	0.036-0.048
1.5	11,000-14,300	580-760	0.031-0.048	10,000-11,500	480-540	0.025-0.039	10,000-11,500	420-480	0.023-0.036	17,000-28,500	1,100-1,950	0.046-0.072
2.0	8,500-11,000	590-800	0.024-0.160	7,900-8,800	470-530	0.020-0.130	7,900-8,800	440-480	0.018-0.120	12,600-24,000	1,100-2,150	0.036-0.240
3.0	5,700-8,200	730-1,000	0.064-0.24	5,300-5,800	590-650	0.052-0.195	5,300-5,800	550-620	0.048-0.120	11,900-17,000	1,850-2,700	0.096-0.360
4.0	4,300-6,200	680-990	0.080-0.320	3,950-4,400	550-620	0.065-0.260	3,850-4,400	530-570	0.060-0.240	6,600-12,500	1,260-2,500	0.120-0.480

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

