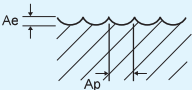


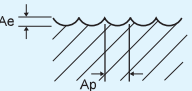
[DA542 series] ▶ 일반 가공

피삭재	합금강, 내열강		열처리강			
	HRc30 ~ HRc40		HRc45 ~ HRc50		HRc50 ~ HRc55	
경도	1000 ~ 1250N/mm ²		1250 ~ 1750N/mm ²		1750N/mm ² ~ 2000N/mm ²	
강도	1000 ~ 1250N/mm ²		1250 ~ 1750N/mm ²		1750N/mm ² ~ 2000N/mm ²	
외경(inch)	RPM	FEED	RPM	FEED	RPM	FEED
R1/32 X 1/16	97,000	8.30	13,800	19.90	13,600	17.90
R1/16 X 1/8	8,000	14.60	10,200	34.60	9,800	33.50
R3/32 X 3/16	5,840	18.10	7,500	34.60	7,200	33.50
R1/8 X 1/4	5,040	19.70	6,900	36.20	6,500	34.60
R5/32 X 5/16	3,540	20.90	5,600	33.10	5,300	31.50
R3/16 X 3/8	3,020	22.40	4,850	31.50	4,650	30.30
R1/4 X 1/2	2,350	20.90	4,350	31.50	4,150	30.30

RPM = rev. / min. FEED = inch / min. Ae: D1/16~D1/4=.008 D5/16~D1/2=.012 Ap: 0.2 X D		Ae: D1/16~D1/8=0.05 X D D3/16~D5/16=.010 D3/8~D1/2=.012 Ap: 0.1 X D
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[DA542 series] ▶ 고속 가공

피삭재	합금강, 내열강		열처리강			
	HRc45		HRc45 ~ HRc50		HRc50 ~ HRc55	
경도	1500N/mm ²		1250 ~ 1750N/mm ²		1750N/mm ² ~ 2000N/mm ²	
강도	1500N/mm ²		1250 ~ 1750N/mm ²		1750N/mm ² ~ 2000N/mm ²	
외경(inch)	RPM	FEED	RPM	FEED	RPM	FEED
R1/32 X 1/16	18,400	21.90	13,800	28.90	13,600	30.10
R1/16 X 1/8	16,800	31.50	10,200	55.10	9,800	51.20
R3/32 X 3/16	16,800	56.70	7,500	52.00	7,200	49.20
R1/8 X 1/4	16,800	72.80	6,900	55.10	6,500	53.10
R5/32 X 5/16	12,600	89.40	5,600	49.20	5,300	45.30
R3/16 X 3/8	10,930	96.10	4,850	45.30	4,650	43.30
R1/4 X 1/2	8,400	82.70	4,350	44.50	4,150	41.30

RPM = rev. / min. FEED = inch / min. Ae: D1/16~D1/4=.008 D5/16~D1/2=.012 Ap: 0.05 X D		Ae: D1/16~D1/8=0.05 X D D3/16~D5/16=.010 D3/8~D1/2=.012 Ap: 0.05 X D
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