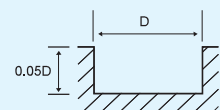
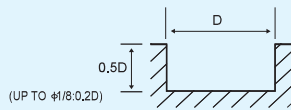


[ ZA302, ZA502 series ]

피삭재	탄소강, 합금강, 주철		합금강, 공구강		스테인리스강		열처리강			
경도	~ HRc30		HRc30 ~ HRc45				HRc45 ~ HRc55		HRc55 ~ HRc65	
강도	~ 1000N/mm <sup>2</sup>		1000 ~ 1500N/mm <sup>2</sup>				1500 ~ 2000N/mm <sup>2</sup>		2000N/mm <sup>2</sup>	
외경(inch)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1/16	11,560	11,560	7,560	4.70	6,300	3.55	5,040	1.40		
1/8	8,920	8,920	5,560	5.50	4,620	4.70	3,360	1.55	1,900	1.55
3/16	6,300	6,300	3,780	7.50	3,160	6.30	2,320	1.95	1,260	1.55
1/4	5,560	5,560	3,360	8.65	2,840	7.10	2,000	2.15	1,100	1.55
5/16	4,200	4,200	2,520	7.85	2,100	7.10	1,680	2.95	840	1.55
3/8	3,260	3,260	2,000	6.30	1,680	6.30	1,360	2.35	680	1.40
1/2	2,740	2,740	1,680	5.10	1,360	5.10	1,160	2.15	560	1.40
5/8	2,200	2,200	1,360	4.30	1,060	4.30	900	1.55	440	0.80
3/4	1,680	1,680	1,060	3.15	840	3.15	680	1.20	320	0.80
1	1,360	1,360	840	2.75	680	2.35	540	0.80	260	0.60

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



[ ZA522 series ] ▶ 일반 가공

피삭재	탄소강, 합금강, 주철		합금강, 공구강		열처리강	
경도	~ HRc30		HRc30 ~ HRc45		HRc45 ~ HRc55	
강도	~ 1000N/mm <sup>2</sup>		1000 ~ 1500N/mm <sup>2</sup>		1500 ~ 2000N/mm <sup>2</sup>	
외경(inch)	RPM	FEED	RPM	FEED	RPM	FEED
1/8	4,410	7.8	3,570	2.4	2,200	1.2
3/16	3,050	4.1	2,420	3.3	1,580	1.6
1/4	2,630	4.9	2,100	4.1	1,370	2.0
5/16	2,000	5.3	1,580	4.1	1,050	2.0
3/8	1,680	5.3	1,370	4.1	840	2.0
1/2	1,370	4.1	1,160	3.7	700	1.6
5/8	1,160	3.7	890	3.0	560	1.4
3/4	840	2.8	680	2.0	420	1.0
1	610	2.0	540	1.6	330	0.7

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

