

## [ ZSTNR series ]

피삭재				탄소강, 합금강 (180~250HB)		프리하든강 (HRc35~45)		열처리강 (HRc45~55)		열처리강 (HRc55~65)	
표준절삭깊이비율				절삭깊이 X 100%		절삭깊이 X 100%		절삭깊이 X 100%		절삭깊이 X 100%	
Mill Dia (mm)	R (mm)	목부길이 (mm)	절삭깊이 (mm)	n (min <sup>-1</sup> )	Vf (mm/min)	n (min <sup>-1</sup> )	Vf (mm/min)	n (min <sup>-1</sup> )	Vf (mm/min)	n (min <sup>-1</sup> )	Vf (mm/min)
0.2	0.05	2	0.007	39,660	887	33,660	754	29,700	591	27,720	483
0.4	0.05	4	0.009	30,096	899	25,582	764	22,572	599	21,067	489
		5	0.007	26,752	710	22,739	528	20,064	466	18,726	373
	0.1	4	0.009	31,680	946	26,928	804	23,760	631	22,176	515
		5	0.007	28,160	747	23,936	556	21,120	490	19,712	392
0.5	0.1	5	0.013	30,413	1,090	25,851	753	22,810	562	21,289	453
		8	0.008	24,330	678	20,681	468	18,248	350	17,031	282
		10	0.007	18,248	509	15,511	351	13,686	262	12,773	211
0.6	0.1	12	0.010	20,377	791	17,320	546	15,282	408	14,264	329
		15	0.006	16,727	649	14,218	448	12,545	335	11,709	270
0.8	0.2	6	0.045	31,680	1,084	26,928	921	23,760	723	22,176	590
		12	0.020	28,160	943	23,936	695	21,120	613	19,712	490
1	0.2	8	0.040	28,512	1,463	24,235	1,244	21,384	976	19,958	797
		10	0.035	28,512	1,596	24,235	1,357	21,384	1,064	19,958	869
		15	0.028	25,344	1,261	21,542	938	19,008	828	17,741	662
		20	0.020	19,008	828	16,157	653	14,256	532	13,306	414
		25	0.017	15,840	690	13,464	544	11,880	443	11,088	345
		30	0.017	15,840	690	13,464	544	11,880	443	11,088	345
		35	0.010	15,840	690	13,464	544	11,880	443	11,088	345
	0.3	8	0.040	28,512	1,463	24,235	1,244	21,384	976	19,958	797
		15	0.028	25,344	1,261	21,542	938	19,008	828	17,741	662
		25	0.017	15,840	690	13,464	544	11,880	443	11,088	345
30		0.017	15,840	690	13,464	544	11,880	443	11,088	345	
1.5	0.2	10	0.050	21,683	1,079	18,431	803	16,262	708	15,178	567
		15	0.045	19,712	981	16,755	730	14,784	644	13,798	515
		20	0.042	17,347	863	14,745	642	13,010	567	12,143	453
		25	0.032	14,784	644	12,566	508	11,088	414	10,349	322
		30	0.028	12,320	536	10,472	423	9,240	345	8,624	268
	0.3	10	0.050	21,683	1,079	18,431	803	16,262	708	15,178	567
		20	0.042	17,347	863	14,745	642	13,010	567	12,143	453
		25	0.032	14,784	644	12,566	508	11,088	414	10,349	322
30		0.028	12,320	536	10,472	423	9,240	345	8,624	268	

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표준절삭깊이비율				절삭깊이 X 100%		절삭깊이 X 100%		절삭깊이 X 100%		절삭깊이 X 100%		
Mill Dia (mm)	R (mm)	목부길이 (mm)	절삭깊이 (mm)	n (min <sup>-1</sup> )	Vf (mm/min)	n (min <sup>-1</sup> )	Vf (mm/min)	n (min <sup>-1</sup> )	Vf (mm/min)	n (min <sup>-1</sup> )	Vf (mm/min)	
2	0.2	30	0.045	13,440	1,254	11,424	933	10,080	823	9,408	658	
		40	0.035	10,080	823	8,568	650	7,560	529	7,056	412	
		50	0.017	8,400	686	7,140	541	6,300	441	5,880	343	
	0.3	12	0.088	22,680	1,814	19,278	1,427	17,010	1,191	15,876	1,048	
		20	0.054	18,144	1,452	15,422	1,141	13,608	953	12,701	838	
		30	0.045	13,440	1,393	11,424	1,036	10,080	914	9,408	732	
		40	0.035	10,080	914	8,568	722	7,560	588	7,056	457	
		50	0.017	8,400	762	7,140	601	6,300	490	5,880	381	
	0.5	8	0.170	22,680	1,814	19,278	1,427	17,010	1,191	15,876	1,048	
		12	0.088	22,680	1,814	19,278	1,427	17,010	1,191	15,876	1,048	
		16	0.088	19,278	1,542	16,386	1,213	14,459	1,012	13,495	891	
		20	0.054	18,114	1,452	15,422	1,141	13,608	953	12,701	838	
		25	0.054	15,876	1,270	13,495	999	11,907	833	11,113	733	
		30	0.045	13,440	1,393	11,424	1,036	10,080	914	9,408	732	
		40	0.035	10,080	914	8,568	722	7,560	588	7,056	457	
	50	0.017	8,400	762	7,140	601	6,300	490	5,880	381		
	3	0.2	40	0.070	10,240	956	8,704	711	7,680	627	7,168	502
			50	0.050	7,680	627	6,528	495	5,760	403	5,376	314
60			0.030	6,400	523	5,440	412	4,800	336	4,480	261	
0.3		40	0.070	10,240	1,062	8,704	790	7,680	697	7,168	557	
		50	0.050	7,680	697	6,528	550	5,760	448	5,376	348	
		60	0.030	6,400	581	5,440	458	4,800	373	4,480	290	
0.5		40	0.070	10,240	1,062	8,704	790	7,680	697	7,168	557	
		50	0.050	7,680	697	6,528	550	5,760	448	5,376	348	
		60	0.030	6,400	581	5,440	458	4,800	373	4,480	290	

- 절삭 깊이(Depth of Cut)는 위 표에서 해당되는 경도 아래 표시된 비율대로 줄여 사용하십시오.
- 상기의 절삭 조건표는 실제 상황과 다를 수 있으니, 기계의 상태, 가공형태 및 목적에 맞게 조정하여 사용하십시오.
- RPM이 낮은 기계일 경우에는 Feed도 같은 비율로 낮추어 사용하십시오.