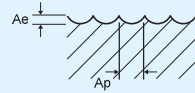


**[ DA512, DA302 series ]** ▶ 고속 가공

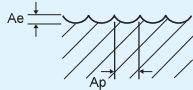
피삭재	비합금강 합금강, 주철		열처리강	
경도	~ HRC45		HRc45 ~ HRc65	
강도	~ 1500N/mm <sup>2</sup>		1500N/mm <sup>2</sup>	
외경(inch)	RPM	FEED	RPM	FEED
R1/64 X 1/32	25,000	25.60	12,720	15.70
R1/32 X 1/16	23,000	27.50	12,140	16.90
R3/64 X 3/32	21,000	34.60	10,700	19.30
R1/16 X 1/8	21,000	39.40	10,000	20.50
R3/32 X 3/16	21,000	70.90	7,300	23.60
R1/8 X 1/4	21,000	90.90	6,300	24.80
R5/32 X 5/16	15,760	111.80	4,420	29.10
R3/16 X 3/8	13,660	120.00	3,780	33.00
R1/4 X 1/2	10,500	103.50	2,940	33.00
R5/16 X 5/8	8,200	103.50	2,320	28.00
R3/8 X 3/4	6,300	99.00	1,900	20.80

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

 Ae: D1/32~D1/4=.008 inch  
 D5/16~D3/4=.012 inch  
 Ap: 0.05 X D

**[ DA514 series ]** ▶ 일반 가공

피삭재	비합금강 합금강, 주철		합금강 내열강		열처리강	
경도	~ HRC30		HRc30 ~ HRc40		HRc45 ~ HRc65	
강도	~ 1000N/mm <sup>2</sup>		1000 ~ 1250N/mm <sup>2</sup>		1500N/mm <sup>2</sup>	
외경(inch)	RPM	FEED	RPM	FEED	RPM	FEED
R1/16 X 1/8	13,100	40.10	10,000	27.00	4,520	8.85
R3/32 X 3/16	9,140	48.50	7,300	34.00	3,680	10.50
R1/8 X 1/4	7,780	49.50	6,300	37.00	3,160	11.25
R5/32 X 5/16	5,260	56.00	4,420	39.00	2,100	11.25
R3/16 X 3/8	4,620	60.00	3,780	42.00	1,780	11.25
R1/4 X 1/2	3,780	53.00	2,940	39.00	1,360	11.25
R5/16 X 5/8	2,740	54.50	2,320	38.50	1,160	11.25

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

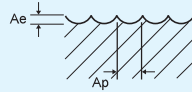
 Ae: D1/8~D1/4=.008 inch  
 D5/16~D5/8=.012 inch  
 Ap: 0.02 X D

 Ae: D1/8~D1/4=.008 inch  
 D5/16~D5/8=.012 inch  
 Ap: 0.1 X D

[ DA514 series ] ▶ 고속 가공

피삭재	비합금강, 합금강, 주철		합금강, 내열강	
경도	~ HRc45		HRc45 ~ HRc65	
강도	~ 1500N/mm <sup>2</sup>		~ 1500N/mm <sup>2</sup>	
외경(inch)	RPM	FEED	RPM	FEED
R1/16 X 1/8	21,000	59.00	17,000	30.50
R3/32 X 3/16	21,000	106.25	12,000	35.50
R1/8 X 1/4	21,000	136.50	10,500	37.00
R5/32 X 5/16	15,760	167.50	7,800	43.50
R3/16 X 3/8	13,660	180.00	6,300	49.50
R1/4 X 1/2	10,500	155.50	5,260	49.50
R5/16 X 5/8	8,200	155.50	3,780	42.00

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

Ae: D1/8~D1/4=.008 inch  
D5/16~D5/8=.012 inch  
Ap: 0.05 X D

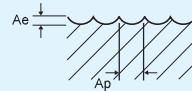


[ DA522 series ] ▶ 일반 가공

피삭재	합금강, 내열강		열처리강			
경도	HRc30 ~ HRc40		HRc45 ~ HRc50		HRc50 ~ HRc55	
강도	1000 ~ 1250N/mm <sup>2</sup>		1500 ~ 1750N/mm <sup>2</sup>		1750N/mm <sup>2</sup> ~ 2000N/mm <sup>2</sup>	
외경(inch)	RPM	FEED	RPM	FEED	RPM	FEED
R1/16 X 1/8	10,000	18.10	12,700	43.30	12,300	41.30
R3/32 X 3/16	7,300	22.80	9,400	43.30	9,050	41.30
R1/8 X 1/4	6,300	24.80	8,600	45.30	8,250	43.30
R5/32 X 5/16	4,420	26.00	7,000	41.30	6,700	39.40
R3/16 X 3/8	3,780	28.00	6,050	39.40	5,800	37.80
R1/4 X 1/2	2,940	26.00	5,450	39.40	5,200	37.80
R5/16 X 5/8	2,320	26.00	4,350	34.30	4,150	32.70
R3/8 X 3/4	1,900	25.00	3,500	27.20	3,300	25.60
R1/2 X 1	1,520	25.00	2,800	27.20	2,650	25.60

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

Ae: D1/8~D1/4=.008  
D5/16~D1=.012  
Ap: 0.2 X D



Ae: D1/8=.006  
D3/16~D5/16=.010  
D3/8~D1=.012  
Ap: 0.1 X D