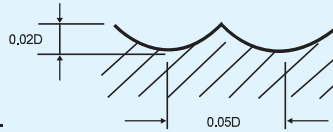


[DA702, ZB702A, DA703, DA734 series]

피삭재	열처리강 내열강		열처리강									
	HRc30 ~ HRc40		HRc40 ~ HRc50		HRc50 ~ HRc55		HRc55 ~ HRc60		HRc60 ~ HRc65		HRc65 ~ HRc70	
경도	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
외경(inch)												
R1/64 X 1/32	50,000	188.98	50,000	165.35	45,000	149.61	40,000	118.11	35,000	102.36	35,000	90.55
R1/32 X 1/16	49,700	224.41	47,800	188.98	40,000	157.48	35,000	124.02	32,000	110.24	28,500	90.55
R3/64 X 3/32	49,700	224.41	47,800	188.98	40,000	157.48	35,000	124.02	32,000	110.24	28,500	90.55
R1/16 X 1/8	33,100	236.22	31,800	208.66	26,500	157.48	23,500	124.02	21,000	110.24	19,000	90.55
R3/32 X 3/16	18,600	228.35	17,800	192.91	15,000	147.64	13,500	120.08	11,500	100.39	10,500	82.68
R1/8 X 1/4	13,900	190.94	13,400	161.42	11,000	122.05	10,000	98.43	8,800	84.65	8,000	68.90
R5/32 X 5/16	11,100	165.35	10,700	137.80	9,000	106.30	8,000	84.65	7,000	72.83	6,500	61.02
R3/16 X 3/8	9,300	145.67	8,900	122.05	7,500	94.49	6,600	74.80	5,800	64.96	5,300	54.33
R1/4 X 1/2	6,950	116.14	6,680	98.43	5,600	74.80	5,000	61.02	4,400	49.21	4,000	41.34

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



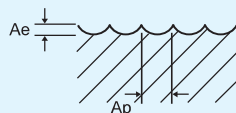
※ 롱 또는 엑스트라 롱 시리즈는 절삭속도를 50% 줄여 사용하십시오.

[DA412 series] ▶ 고속 가공

피삭재	열처리강							
	HRc45 ~ HRc50		HRc50 ~ HRc55		HRc55 ~ HRc60		HRc60 ~ HRc65	
강도	1500 ~ 1750N/mm ²		1750 ~ 2000N/mm ²		2000 ~ 2080N/mm ²		2080N/mm ²	
외경(inch)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
R1/16 X 1/8	12,700	43.30	12,300	41.30	11,800	39.40	8,400	26.00
R3/32 X 3/16	9,400	43.30	9,050	41.30	8,600	37.40	5,600	26.80
R1/8 X 1/4	8,600	45.30	8,250	43.30	7,850	37.40	4,850	27.60
R5/32 X 5/16	7,000	41.30	6,700	39.40	6,350	37.40	3,800	25.60
R3/16 X 3/8	6,050	39.40	5,800	37.80	5,450	35.40	3,200	24.40
R1/4 X 1/2	5,450	39.40	5,200	37.80	4,900	35.40	2,750	24.40
R5/16 X 5/8	4,350	34.30	4,150	32.70	3,900	32.30	2,150	10.40
R3/8 X 3/4	3,500	27.20	3,300	25.60	3,150	24.80	1,700	8.70
R1/2 X 1	2,800	27.20	2,650	25.60	2,520	24.80	1,360	8.70

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

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



[DA412 series] ▶ 고속 가공

피삭재	열처리강					
	HRc45 ~ HRc50		HRc50 ~ HRc55		HRc55 ~ HRc60	
경도	1500 ~ 1750N/mm ²		1750 ~ 2000N/mm ²		2000 ~ 2080N/mm ²	
외경(inch)	RPM	FEED	RPM	FEED	RPM	FEED
R1/16 X 1/8	12,700	68.90	12,300	65.70	11,800	39.90
R3/32 X 3/16	9,400	65.00	9,050	61.80	8,600	29.50
R1/8 X 1/4	8,600	68.90	8,250	65.70	7,850	27.60
R5/32 X 5/16	7,000	61.00	6,700	57.50	6,350	25.60
R3/16 X 3/8	6,050	57.10	5,800	53.50	5,450	24.40
R1/4 X 1/2	5,450	55.90	5,200	52.40	4,900	24.00
R5/16 X 5/8	4,350	48.40	4,150	44.50	3,900	10.40
R3/8 X 3/4	3,500	39.40	3,300	35.40	3,150	8.70
R1/2 X 1	2,800	39.40	2,640	35.40	2,520	8.70

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

Ae: D1/8=,006
D3/16~D5/16=,010
D3/8~D1=,012
Ap: 0,05 X D

[DA512, DA302 series] ▶ 일반 가공

피삭재	비합금강 합금강, 주철		합금강 내열강		열처리강	
	~ HRc30		HRc30 ~ HRc40		HRc45 ~ HRc65	
경도	~ 1000N/mm ²		1000 ~ 1250N/mm ²		1500N/mm ²	
외경(inch)	RPM	FEED	RPM	FEED	RPM	FEED
R1/64 X 1/32	15,760	9.80	12,720	7.80	5,800	3.80
R1/32 X 1/16	15,760	13.80	12,140	1.60	5,320	4.70
R3/64 X 3/32	14,400	29.50	10,700	19.30	4,680	5.90
R1/16 X 1/8	13,100	26.70	10,000	18.10	4,520	5.90
R3/32 X 3/16	9,140	32.30	7,300	22.80	3,680	7.10
R1/8 X 1/4	7,780	33.00	6,300	24.80	3,160	7.50
R5/32 X 5/16	5,260	37.50	4,420	26.00	2,100	7.50
R3/16 X 3/8	4,620	40.10	3,780	28.00	1,780	7.50
R1/4 X 1/2	3,780	35.40	2,940	26.00	1,360	7.50
R5/16 X 5/8	2,740	36.20	2,320	26.00	1,160	7.50
R3/8 X 3/4	2,100	33.00	1,900	25.00	840	7.50

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

Ae: D1/32~D1/4=,008inch
D5/16~D3/4=,012inch
Ap: 0,2 X D

Ae: D1/32~D1/4=,008inch
D5/16~D3/4=,012inch
Ap: 0,1 X D