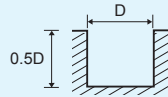


[SM504 series]

| 피삭재 | 합금강, 주철 | | 스테인리스강 300 SERIES 티타늄 | | 스테인리스강 400 SERIES | |
|--------|---------|------|--------------------------|------|-------------------|------|
| 경도 | ~HB230 | | | | | |
| 외경(mm) | RPM | FEED | RPM | FEED | RPM | FEED |
| 3 | 13,500 | 275 | 6,690 | 105 | 9,350 | 145 |
| 4 | 10,100 | 370 | 5,050 | 135 | 7,000 | 185 |
| 5 | 8,090 | 410 | 4,050 | 165 | 5,600 | 230 |
| 6 | 6,750 | 480 | 3,350 | 190 | 4,700 | 265 |
| 8 | 5,050 | 620 | 2,500 | 250 | 3,500 | 340 |
| 10 | 4,050 | 780 | 2,050 | 320 | 2,800 | 430 |
| 12 | 3,370 | 750 | 1,680 | 310 | 2,350 | 435 |
| 14 | 2,890 | 670 | 1,400 | 280 | 2,000 | 405 |
| 16 | 2,500 | 630 | 1,250 | 265 | 1,750 | 370 |
| 18 | 2,250 | 630 | 1,100 | 260 | 1,550 | 365 |
| 20 | 2,000 | 620 | 1,000 | 260 | 1,400 | 365 |

RPM = rev. / min.
FEED = mm / min.



[BC502 series]

| 피삭재 | | 공 | | | |
|------|--------|--------|-------|-------|-------|
| R | 외경(mm) | RPM | FEED | Rd | Ad |
| 0.5 | 1 | 41,000 | 1,660 | 0.040 | 0.063 |
| 0.75 | 1.5 | 27,000 | 1,830 | 0.068 | 0.087 |
| 1 | 2 | 20,000 | 1,780 | 0.089 | 0.112 |
| 1.25 | 2.5 | 16,000 | 1,840 | 0.115 | 0.090 |
| 1.5 | 3 | 13,000 | 2,220 | 0.171 | 0.168 |
| 2 | 4 | 10,000 | 2,080 | 0.208 | 0.200 |
| 2.5 | 5 | 8,300 | 1,990 | 0.240 | 0.200 |
| 3 | 6 | 6,900 | 1,940 | 0.281 | 0.250 |
| 4 | 8 | 5,720 | 1,000 | 0.175 | 0.400 |
| 5 | 10 | 4,550 | 700 | 0.154 | 0.500 |
| 6 | 12 | 3,770 | 600 | 0.159 | 0.600 |

RPM = rev. / min.
FEED = mm / min.

