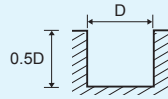


[SM504 series]

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.

