

[SSD, SSDL series]

피삭재	공구강, 합금강		알루미늄, 알루미늄 합금		황동, 청동		엑포시, 레진	
	RPM (mm ⁻¹)	FEED (mm/rev)	RPM (mm ⁻¹)	FEED (mm/rev)	RPM (mm ⁻¹)	FEED (mm/rev)	RPM (mm ⁻¹)	FEED (mm/rev)
3	4000~7000	0.02	10000~12000	0.03	7000~10000	0.02	9000~12000	0.08
5	2400~4200	0.03	6000~8000	0.05	4200~6000	0.04	5400~7200	0.08
8	1500~2600	0.05	3700~5000	0.08	2600~3700	0.08	3400~4500	0.09
12	1000~1700	0.06	2500~3200	0.12	1700~2500	0.12	2200~3000	0.11

[PF50, P50 series]

피삭재	탄소강(C<0.3%) 합금강/SS400 SCM ~710N/mm ²		탄소강(C≥0.3%) 합금강 / S50C SCM ~1.060N/mm ²		SUJ2-SUS440		SKD61 HRc34~43		HRc43~48		SKD11 HRc48~53		주철 FC 250~350		덕타일 FC 400~500	
	V	80~125m/min	80~125m/min	63~80m/min	40~63m/min	32~45m/min	25~36m/min	80~125m/min	63~90m/min							
외경(mm)	RPM (mm ⁻¹)	FEED (mm/rev)	RPM (mm ⁻¹)	FEED (mm/rev)	RPM (mm ⁻¹)	FEED (mm/rev)	RPM (mm ⁻¹)	FEED (mm/rev)	RPM (mm ⁻¹)	FEED (mm/rev)	RPM (mm ⁻¹)	FEED (mm/rev)	RPM (mm ⁻¹)	FEED (mm/rev)	RPM (mm ⁻¹)	FEED (mm/rev)
2	12,000	0.06-0.08	12,000	0.06-0.08	11,000	0.06-0.08	8,000	0.06-0.08	6,000	0.05-0.07	4,500	0.03-0.06	15,000	0.06-0.08	11,000	0.06-0.08
3	9,600	0.09-0.12	9,600	0.09-0.12	7,500	0.09-0.12	5,300	0.09-0.12	4,000	0.07-0.11	3,200	0.05-0.09	10,000	0.09-0.12	7,600	0.09-0.12
4	8,000	0.10-0.15	8,000	0.10-0.15	5,650	0.10-0.15	4,000	0.10-0.15	3,000	0.08-0.13	2,600	0.06-0.10	8,000	0.10-0.15	6,000	0.10-0.15
5	6,400	0.12-0.18	6,400	0.12-0.18	4,550	0.12-0.18	3,300	0.12-0.18	2,400	0.10-0.15	2,000	0.8-0.12	6,400	0.12-0.18	4,800	0.12-0.18
6	5,300	0.14-0.20	5,300	0.14-0.20	3,800	0.14-0.20	2,750	0.14-0.20	2,000	0.12-0.18	1,700	0.09-0.15	5,300	0.14-0.20	4,000	0.14-0.20
8	4,000	0.16-0.24	4,000	0.16-0.24	2,850	0.16-0.24	2,100	0.16-0.24	1,500	0.14-0.22	1,300	0.12-0.20	4,000	0.16-0.24	3,000	0.16-0.24
10	3,200	0.18-0.27	3,200	0.18-0.27	2,250	0.18-0.27	1,700	0.18-0.27	1,200	0.15-0.25	1,000	0.13-0.23	3,200	0.18-0.27	2,400	0.18-0.27
12	2,650	0.20-0.30	2,650	0.20-0.30	1,900	0.20-0.30	1,400	0.20-0.30	1,000	0.17-0.26	850	0.14-0.24	2,700	0.20-0.30	2,000	0.20-0.30
14	2,300	0.22-0.35	2,300	0.22-0.35	1,600	0.22-0.35	1,200	0.22-0.35	860	0.18-0.30	730	0.15-0.26	2,300	0.22-0.35	1,700	0.22-0.35
16	2,000	0.25-0.36	2,000	0.25-0.36	1,400	0.25-0.36	1,050	0.25-0.36	760	0.20-0.32	640	0.16-0.26	2,000	0.25-0.36	1,500	0.25-0.36
18	1,800	0.28-0.38	1,800	0.28-0.38	1,250	0.28-0.38	920	0.28-0.38	670	0.23-0.33	570	0.18-0.28	1,800	0.28-0.38	1,350	0.28-0.38
20	1,600	0.30-0.40	1,600	0.30-0.40	1,150	0.30-0.40	850	0.30-0.40	600	0.25-0.35	500	0.20-0.30	1,600	0.30-0.40	1,200	0.30-0.40

[SF50, PI50 series]

피삭재	탄소강(C<0.3%) 합금강/SS400 SCM ~710N/mm ²		탄소강(C≥0.3%) 합금강 / S50C SCM ~1.060N/mm ²		SUJ2-SUS440		SKD61 HRc34~43		HRc43~48		SKD11 HRc48~53		주철 FC 250~350		덕타일 FC 400~500	
	V	80~150m/min	80~150m/min	63~100m/min	40~70m/min	32~50m/min	25~40m/min	80~150m/min	63~100m/min							
외경(mm)	RPM (mm ⁻¹)	FEED (mm/rev)	RPM (mm ⁻¹)	FEED (mm/rev)	RPM (mm ⁻¹)	FEED (mm/rev)	RPM (mm ⁻¹)	FEED (mm/rev)	RPM (mm ⁻¹)	FEED (mm/rev)	RPM (mm ⁻¹)	FEED (mm/rev)	RPM (mm ⁻¹)	FEED (mm/rev)	RPM (mm ⁻¹)	FEED (mm/rev)
3	12,000	0.09-0.12	13,000	0.09-0.12	7,600	0.09-0.12	6,400	0.09-0.12	5,300	0.07-0.11	3,800	0.05-0.09	12,000	0.09-0.12	8,500	0.09-0.12
4	9,500	0.10-0.15	10,000	0.10-0.15	5,700	0.10-0.15	4,800	0.10-0.15	4,000	0.08-0.13	2,950	0.06-0.10	9,000	0.10-0.15	6,350	0.10-0.15
5	7,600	0.12-0.18	8,000	0.12-0.18	4,600	0.12-0.18	3,800	0.12-0.18	3,200	0.10-0.15	2,300	0.8-0.12	7,600	0.12-0.18	5,100	0.12-0.18
6	6,400	0.14-0.20	6,600	0.14-0.20	3,800	0.14-0.20	3,200	0.14-0.20	2,650	0.12-0.18	1,900	0.09-0.15	6,400	0.14-0.20	4,250	0.14-0.20
8	4,800	0.16-0.24	5,000	0.16-0.24	2,900	0.16-0.24	2,400	0.16-0.24	2,000	0.14-0.22	1,450	0.12-0.20	4,800	0.16-0.24	3,200	0.16-0.24
10	3,800	0.18-0.27	4,000	0.18-0.27	2,300	0.18-0.27	1,900	0.18-0.27	1,600	0.15-0.25	1,150	0.13-0.23	3,800	0.18-0.27	2,550	0.18-0.27
12	3,200	0.20-0.30	3,300	0.20-0.30	1,900	0.20-0.30	1,600	0.20-0.30	1,300	0.17-0.26	950	0.14-0.24	3,200	0.20-0.30	2,100	0.20-0.30
14	2,700	0.22-0.35	2,800	0.22-0.35	1,600	0.22-0.35	1,350	0.22-0.35	1,150	0.18-0.30	800	0.15-0.26	2,700	0.22-0.35	1,800	0.22-0.35
16	2,400	0.25-0.36	2,500	0.25-0.36	1,400	0.25-0.36	1,200	0.25-0.36	1,000	0.20-0.32	700	0.16-0.26	2,400	0.25-0.36	1,600	0.25-0.36
18	2,100	0.28-0.38	2,200	0.28-0.38	1,300	0.28-0.38	1,100	0.28-0.38	900	0.23-0.33	650	0.18-0.28	2,100	0.28-0.38	1,400	0.28-0.38
20	1,900	0.30-0.40	2,000	0.30-0.40	1,150	0.30-0.40	1,000	0.30-0.40	800	0.25-0.35	600	0.20-0.30	1,900	0.30-0.40	1,250	0.30-0.40