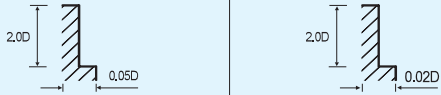


[ZR324, ZR504, ZR514, ZR524 series]

피삭재	비합금강, 합금강, 주철		합금강, 내열강		열처리강	
경도	~ HRc30		HRc30 ~ HRc45		HRc45 ~ HRc55	
강도	~ 1000N/mm ²		1000 ~ 1500N/mm ²		1500 ~ 2000N/mm ²	
외경(mm)	RPM	FEED	RPM	FEED	RPM	FEED
3	6,950	195	4,500	150	3,300	100
4	5,600	240	3,600	170	2,700	105
5	4,800	250	3,050	210	2,350	125
6	4,150	250	2,650	210	2,050	125
8	3,150	265	2,000	210	1,600	125
10	2,150	265	1,700	210	1,250	125
12	1,800	210	1,500	185	1,050	105
16	1,880	185	1,100	140	840	90
20	1,300	130	860	105	625	65

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



[ZR304H, ZR324H series]

피삭재	비합금강, 합금강, 주철		합금강, 내열강		열처리강	
경도	~ HRc30		HRc30 ~ HRc45		HRc45 ~ HRc55	
강도	~ 1000N/mm ²		1000 ~ 1500N/mm ²		1500 ~ 2000N/mm ²	
외경(mm)	RPM	FEED	RPM	FEED	RPM	FEED
6	7,000	910	4,200	560	3,000	140
8	5,300	980	3,200	530	2,500	190
10	4,100	840	2,500	410	2,050	165
12	3,500	730	2,100	340	1,700	140

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

