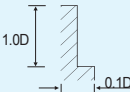
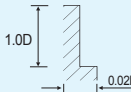


ZE304, ZE324, ZE404, ZE504, ZE524 series ▶ General Cutting

MATERIAL	NON-ALLOY STEELS ALLOY STEELS · CAST IRON		HARDENED STEELS				STAINLESS STEELS	
HARDNESS	~HRc30		HRc30 ~ HRc45		HRc45 ~ HRc55			
STRENGTH	~1000N/mm ²		1000 ~ 1500N/mm ²		1500 ~ 2000N/mm ²			
DIAMETER(mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2	12100	320	7900	195	2700	47	6600	160
3	9400	370	5840	230	2000	58	4850	195
4	7900	655	4850	405	1500	58	4070	320
5	6600	690	3970	415	1300	58	3320	345
6	5830	760	3530	470	1150	58	2980	380
8	4410	815	2650	435	880	58	2200	405
10	3420	700	2100	345	720	46	1760	345
12	2880	600	1760	290	590	46	1430	275
16	2310	470	1430	230	460	29	1150	230
20	1760	370	1110	185	340	29	880	175
25	1430	290	880	150	270	23	715	140

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

• Please reduce cutting speed around 20~30% from the above table for ZE524 & ZE324 series.

ZE304, ZE324, ZE404, ZE504, ZE524 series ▶ High Speed Cutting

MATERIAL	NON-ALLOY STEELS ALLOY STEELS · CAST IRON		HARDENED STEELS				STAINLESS STEELS	
HARDNESS	~HRc30		HRc30 ~ HRc45		HRc45 ~ HRc55			
STRENGTH	~1000N/mm ²		1000 ~ 1500N/mm ²		1500 ~ 2000N/mm ²			
DIAMETER(mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2	31400	1230	23500	520	12600	275	21600	465
3	19300	1210	13600	735	8900	390	13500	660
4	18100	1330	12600	865	7090	465	11800	775
5	16400	1310	11100	1010	6040	530	10300	910
6	14400	1380	9900	1100	5300	580	9100	990
8	11000	1430	7600	1090	3990	575	6900	980
10	8500	1380	5880	1110	3150	580	5420	1000
12	7200	1380	5040	1090	2620	575	4600	985
16	5700	1320	3990	1010	2000	535	3590	910
20	4400	1270	3150	930	1580	490	2840	840
25	3500	1170	2520	755	1260	390	2270	680

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

