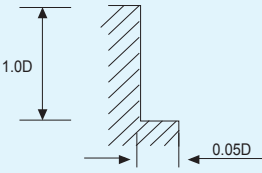
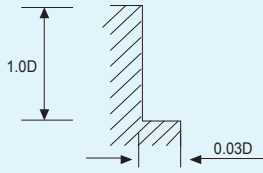


■ ZR706, ZR736, ZE716, ZE726 series

MATERIAL	HARDENED STEELS HEAT RESISTANT STEELS		HARDENED STEELS		HARDENED STEELS		HARDENED STEELS		HARDENED STEELS		HARDENED STEELS	
HARDNESS	HRc 30~ HRc 40		HRc 40~ HRc 50		HRc 50~ HRc 55		HRc 55~ HRc 60		HRc 60~ HRc 65		HRc 65~ HRc 70	
DIAMETER(mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
6	24800	5350	23500	4900	16000	4900	13500	3300	10500	2100	8000	1450
8	20000	5500	19000	5000	12000	4600	10000	3100	8000	2000	6000	1400
10	16000	4900	15500	4500	9500	4100	8000	2900	6400	1800	4800	1300
12	13000	4500	12500	4100	8000	3800	6600	2500	5300	1600	4000	1150
16	10000	4000	9700	3700	6000	3400	5000	2300	4000	1250	3000	870
20	8000	3350	7800	3400	4800	3200	4000	2100	3200	1020	2400	690

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

■ ZSLNB series

MATERIAL	ALLOY STEELS HEAT RESISTANT STEELS			HARDENED STEELS			HARDENED STEELS			COPPER		
HARDNESS	HRc 30~ HRc 45			HRc 45~ HRc 55			HRc 55~ HRc 65					
DIAMETER(mm)	RPM	FEED	Ae(mm)	RPM	FEED	Ae(mm)	RPM	FEED	Ae(mm)	RPM	FEED	Ae(mm)
0.5	34100-49500	600-870	0.007-0.028	31900-35200	490-540	0.005-0.023	31900-35200	440-480	0.005-0.021	49000-50000	1100-1400	0.010-0.042
0.6	28600-40700	590-850	0.007-0.034	26400-29700	480-540	0.006-0.028	26400-29700	400-480	0.006-0.025	42000-50000	1100-1700	0.011-0.050
0.8	22000-30800	640-890	0.016-0.064	19800-22000	490-550	0.013-0.052	19800-22000	440-500	0.012-0.048	31000-50000	1100-2250	0.024-0.096
1.0	17600-24200	600-850	0.008-0.080	15400-17600	470-540	0.007-0.065	15400-17600	440-500	0.006-0.060	24000-49500	1100-2200	0.012-0.120
1.2	14300-18700	590-780	0.024-0.032	12000-14000	480-540	0.020-0.026	12000-14000	420-480	0.018-0.024	28500-38500	1480-1950	0.036-0.048
1.5	11000-14300	580-760	0.031-0.048	10000-11500	480-540	0.025-0.039	10000-11500	420-480	0.023-0.036	17000-28500	1100-1950	0.046-0.072
2.0	8500-11000	590-800	0.024-0.160	7900-8800	470-530	0.020-0.130	7900-8800	440-480	0.018-0.120	12600-24000	1100-2150	0.036-0.240
3.0	5700-8200	730-1000	0.064-0.24	5300-5800	590-650	0.052-0.195	5300-5800	550-620	0.048-0.120	11900-17000	1850-2700	0.096-0.360
4.0	4300-6200	680-990	0.080-0.320	3950-4400	550-620	0.065-0.260	3850-4400	530-570	0.060-0.240	6600-12500	1260-2500	0.120-0.480

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

