

ZR304H, ZR324H Series

Work Material	Non-Alloyed Steels, Alloy Steels, Cast Iron		Alloy Steels, Heat Resistant Steels		Hardened Steels	
Hardness	$\leq 30 \text{ HRc}$		$30 \sim 45 \text{ HRc}$		$45 \sim 55 \text{ HRc}$	
Strength	$\sim 1000 \text{ N / mm}^2$		$1000 \sim 1500 \text{ N / mm}^2$		$1500 \sim 2000 \text{ N / mm}^2$	
Cutting Diameter(metric)	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.

