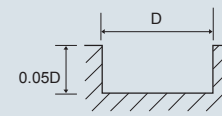
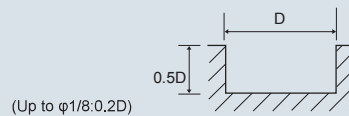


TECHNICAL DATA | GENERAL PURPOSE |

ZA302 Series

Work Material	Carbon Steels, Alloy Steels, Cast Iron		Alloy Steels, Tool Steels		Stainless Steels		Hardened Steels		Hardened Steels	
Hardness	≤ 30 HRc		30 ~ 40 HRc		-		45 ~ 55 HRc		55 ~ 65 HRc	
Strength	~ 145,038lbf / inch ²		145,038 ~ 217,557lbf / inch ²		-		217,557 ~ 290,076lbf / inch ²		290,076lbf / inch ²	
Cutting Diameter(inch)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1/16	11,560	7.50	7,560	4.70	6,300	3.55	5,040	1.40		
1/8	8,920	8.25	5,560	5.50	4,620	4.70	3,360	1.55	1,900	1.55
3/16	6,300	12.60	3,780	7.50	3,160	6.30	2,320	1.95	1,260	1.55
1/4	5,560	13.80	3,360	8.65	2,840	7.10	2,000	2.15	1,100	1.55
5/16	4,200	14.95	2,520	7.85	2,100	7.10	1,680	2.95	840	1.55
3/8	3,260	13.00	2,000	6.30	1,680	6.30	1,360	2.35	680	1.40
1/2	2,740	11.00	1,680	5.10	1,360	5.10	1,160	2.15	560	1.40
5/8	2,200	8.65	1,360	4.30	1,060	4.30	900	1.55	440	0.80
3/4	1,680	6.70	1,060	3.15	840	3.15	680	1.20	320	0.80
1	1,360	5.10	840	2.75	680	2.35	540	0.80	260	0.60

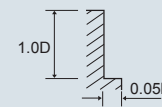
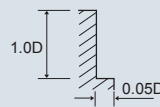
RPM = rev. / min.
FEED = inch / min.



ZA304 Series

Work Material	Carbon Steels, Alloy Steels, Cast Iron		Alloy Steels, Tool Steels		Stainless Steels		Hardened Steels		Hardened Steels	
Hardness	≤ 30 HRc		30 ~ 40 HRc		-		45 ~ 55 HRc		55 ~ 65 HRc	
Strength	~ 145,038lbf / inch ²		145,038 ~ 217,557lbf / inch ²		-		217,557 ~ 290,076lbf / inch ²		290,076lbf / inch ²	
Cutting Diameter(inch)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1/16	11,560	11.00	7,560	6.70	6,300	5.50	5,040	1.95		
1/8	8,920	12.60	5,560	7.85	4,620	6.70	3,360	2.35	1,900	2.35
3/16	6,300	23.60	3,780	14.15	3,160	11.80	2,320	2.75	1,260	2.35
1/4	5,560	26.00	3,360	16.15	2,840	13.00	2,000	3.15	1,100	2.35
5/16	4,200	27.95	2,520	14.95	2,100	13.80	1,680	4.30	840	2.35
3/8	3,260	24.00	2,000	11.80	1,680	11.80	1,360	3.55	680	1.95
1/2	2,740	20.50	1,680	9.85	1,360	9.45	1,160	3.15	560	1.95
5/8	2,200	16.15	1,360	7.85	1,060	7.85	900	2.35	440	1.20
3/4	1,680	12.60	1,060	6.30	840	5.90	680	1.55	320	1.20
1	1,360	9.85	840	5.10	680	4.70	540	1.20	260	0.80

RPM = rev. / min.
FEED = inch / min.



GENERAL PURPOSE > INCH