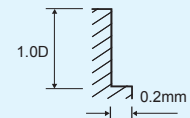
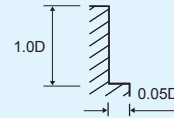
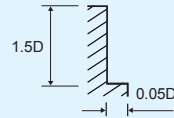
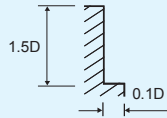


[ZE506, ZE516 series] ▶ General Cutting

WORKPIECE	NON-ALLOYED STEELS ALLOY STEELS - CAST IRON		ALLOY STEELS, HEAT RESISTANT STEELS		HARDENED STEELS			
HARDNESS	~ HRc30		HRc30 ~ HRc50		HRc50 ~ HRc60		HRc60 ~ HRc65	
STRENGTH	~ 1000N/mm ²		1000 ~ 1750N/mm ²		1750 ~ 2080N/mm ²		2080N/mm ²	
DIAMETER(mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
6	5,560	2,000	3,880	1,370	1,580	210	1,100	130
8	4,200	2,000	2,940	1,370	1,160	210	840	130
10	3,360	2,000	2,320	1,370	1,000	210	680	130
12	2,840	1,680	2,000	1,160	840	180	560	110
16	2,100	1,260	1,480	880	640	130	420	70
20	1,680	1,010	1,160	690	500	110	320	60
25	1,500	900	1,100	600	430	90	260	50

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



[ZE506, ZE516 series] ▶ High Speed Cutting

WORKPIECE	HIGH TEMP ALLOYS HARDENED STEELS		HARDENED STEELS			
HARDNESS	~ HRc50		HRc50 ~ HRc60		HRc60 ~ HRc65	
STRENGTH	1750N/mm ²		1750~2080N/mm ²		2080N/mm ² ~	
DIAMETER(mm)	RPM	FEED	RPM	FEED	RPM	FEED
6	16,800	6,090	8,400	3,050	4,200	1,470
8	12,600	6,090	6,300	3,050	3,160	1,470
10	9,980	5,990	5,040	3,050	2,520	1,470
12	8,400	5,040	4,200	2,520	2,100	1,260
16	6,300	3,780	3,160	1,890	1,580	950
20	5,040	3,050	2,520	1,470	1,260	760
25	4,500	2,750	2,200	1,300	1,120	670

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

