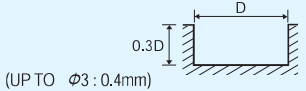
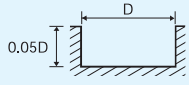


▣ ZM502, ZM522 series

MATERIAL	NON-ALLOYED STEELS ALLOY STEELS · CAST IRON		ALLOY STEELS HEAT RESISTANT STEELS		HARDENED 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
2	6300	60	5040	50	3150	25
3	4410	70	3570	60	2200	30
4	3570	85	2840	70	1790	35
5	3050	105	2420	85	1580	40
6	2630	125	2100	105	1370	50
8	2000	135	1580	105	1050	50
10	1680	135	1370	105	840	50
12	1370	105	1160	95	700	40
16	1160	95	890	75	560	35
20	840	70	680	50	420	25

RPM=rev./min. FEED=mm/min.		
	(UP TO Ø3: 0.4mm)	

▣ ZM504, ZM524 series

MATERIAL	NON-ALLOY STEELS ALLOY STEELS · CAST IRON		ALLOY STEELS HEAT RESISTANT STEELS		HARDENED STEELS		HARDENED STEELS	
HARDNESS	~ HRc30		HRc30 ~ HRc45		HRc45 ~ HRc55		HRc55 ~ HRc65	
STRENGTH	~ 1000N/mm ²		1000 ~ 1500N/mm ²		1500 ~ 2000N/mm ²		2000N/mm ²	
DIAMETER(mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2	6300	100	5040	80	3150	45		
3	4410	115	3570	100	2200	55	1890	30
4	3570	140	2840	115	1790	60	1470	35
5	3050	180	2420	140	1580	70	1260	40
6	2630	215	2100	180	1370	90	1160	50
8	2000	230	1580	180	1050	90	840	50
10	1680	230	1370	180	840	90	670	50
12	1370	180	1160	160	700	70	560	40
16	1160	160	890	125	560	60	440	35
20	840	115	680	90	420	45	340	25

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