

ZR714 Series

End Cutting	Slotting											
Work Material	Hardened Steels Heat Resistant Steels		Hardened Steels									
	30 ~ 40 HRc		40 ~ 50 HRc		50 ~ 55 HRc		55 ~ 60 HRc		60 ~ 65 HRc		65 ~ 70 HRc	
Hardness												
Cutting Diameter(metric)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
3	21,800	1,400	17,300	1,000	11,500	672	9,500	416	7,500	256	6,400	184
4	16,700	1,440	13,200	1,040	8,800	704	7,200	432	5,600	268	4,750	192
5	15,700	1,600	12,500	1,200	8,300	800	6,400	464	5,100	296	4,450	216
6	13,100	1,560	10,350	1,120	6,900	760	5,300	448	4,200	280	3,700	208
8	9,880	1,504	7,800	1,080	5,200	720	4,000	416	3,200	264	2,800	192
10	7,800	1,400	6,150	1,008	4,100	672	3,200	384	2,550	248	2,200	176
12	6,650	1,400	5,250	1,008	3,500	672	2,650	384	2,100	240	1,860	176
16	4,900	1,200	3,900	880	2,600	584	2,000	336	1,600	216	1,400	160
20	3,900	1,040	3,100	776	2,050	520	1,600	304	1,300	200	1,100	144

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

