

TECHNICAL DATA | GENERAL PURPOSE |

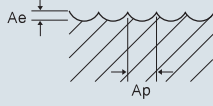
ZB302, ZB302S Series

General Speed Cutting

Work Material	Non-Alloyed Steels, Alloy Steels, Cast Iron		Alloy Steels, Heat Resistant Steels		Hardened Steels	
Hardness	≤ 30 HRc		30 ~ 40 HRc		45 ~ 65 HRc	
Strength	~ 145,038lbf / inch ²		145,038 ~ 181,298lbf / inch ²		217,557lbf / inch ²	
Cutting Diameter(inch)	RPM	FEED	RPM	FEED	RPM	FEED
1/32	15,760	9.80	12,720	7.80	5,800	3.80
1/16	15,760	13.80	12,140	1.60	5,320	4.70
3/32	14,400	29.50	10,700	19.30	4,680	5.90
1/8	13,100	26.70	10,000	18.10	4,520	5.90
3/16	9,140	32.30	7,300	22.80	3,680	7.10
1/4	7,780	33.00	6,300	24.80	3,160	7.50
5/16	5,260	37.50	4,420	26.00	2,100	7.50
3/8	4,620	40.10	3,780	28.00	1,780	7.50
1/2	3,780	35.40	2,940	26.00	1,360	7.50
5/8	2,740	36.20	2,320	26.00	1,160	7.50
3/4	2,100	33.00	1,900	25.00	840	7.50

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

Ae: D1/32~D1/4=.008 inch
D5/16~D3/4=.012 inch
Ap: 0.2 X D



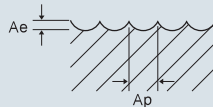
Ae: D1/32~D1/4=.008 inch
D5/16~D3/4=.012 inch
Ap: 0.1 X D

High Speed Cutting

Work Material	Non-Alloyed Steels, Alloy Steels, Cast Iron		Hardened Steels	
Hardness	≤ 45 HRc		45 ~ 65 HRc	
Strength	~ 217,557lbf / inch ²		217,557lbf / inch ²	
Cutting Diameter(inch)	RPM	FEED	RPM	FEED
1/32	25,000	25.60	25,000	15.70
1/16	23,000	27.50	23,000	16.90
3/32	21,000	34.60	19,000	19.30
1/8	21,000	39.40	17,000	20.50
3/16	21,000	70.90	12,000	23.60
1/4	21,000	90.90	10,500	24.80
5/16	15,760	111.80	7,880	29.10
3/8	13,660	120.00	6,300	33.00
1/2	10,500	103.50	5,260	33.00
5/8	8,200	103.50	3,780	28.00
3/4	6,300	99.00	2,940	20.80

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

Ae: D1/32~D1/4=.008 inch
D5/16~D3/4=.012 inch
Ap: 0.05 X D



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