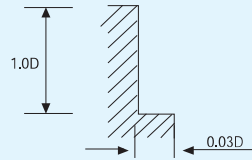
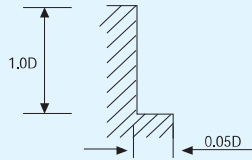


ZE704, ZE714, ZE724 series ▶ Side Cutting

MATERIAL	HARDENED STEELS HEAT RESISTANT STEELS		HARDENED STEELS		HARDENED STEELS		HARDENED STEELS		HARDENED STEELS		HARDENED STEELS	
	HARDNESS	HRc 30~ HRc 40	HRc 40~ HRc 50	HRc 50~ HRc 55	HRc 55~ HRc 60	HRc 60~ HRc 65	HRc 65~ HRc 70					
DIAMETER(mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1	48000	1480	38000	1050	25500	710	20500	430	16000	270	12500	175
2	33300	1750	26000	1250	17500	840	14500	520	11000	320	9500	230
3	21800	1750	17300	1250	11500	840	9500	520	7500	320	6400	230
4	16700	1800	13200	1300	8800	880	7200	540	5600	335	4750	240
5	15700	2000	12500	1500	8300	1000	6400	580	5100	370	4450	270
6	13100	1950	10350	1400	6900	950	5300	560	4200	350	3700	260
8	9880	1880	7800	1350	5200	900	4000	520	3200	330	2800	240
10	7800	1750	6150	1260	4100	840	3200	480	2550	310	2200	220
12	6650	1750	5250	1260	3500	840	2650	480	2100	300	1860	220
16	4900	1500	3900	1100	2600	730	2000	420	1600	270	1400	200
20	3900	1300	3100	970	2050	650	1600	380	1300	250	1100	180

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



ZR702, ZR732 series ▶ Slotting

MATERIAL	HARDENED STEELS HEAT RESISTANT STEELS		HARDENED STEELS		HARDENED STEELS		HARDENED STEELS		HARDENED STEELS		HARDENED STEELS	
	HARDNESS	HRc 30~ HRc 40	HRc 40~ HRc 50	HRc 50~ HRc 55	HRc 55~ HRc 60	HRc 60~ HRc 65	HRc 65~ HRc 70					
DIAMETER(mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2	33300	680	26000	544	17500	336	14500	208	11000	128	9500	92
3	21800	680	17300	544	11500	336	9500	208	7500	128	6400	92
4	16700	704	13200	560	8800	352	7200	216	5600	136	4750	94
5	15700	800	12500	644	8300	400	6400	228	5100	144	4450	106
6	13100	760	10350	616	6900	384	5300	224	4200	144	3700	104
8	9880	744	7800	576	5200	356	4000	204	3200	132	2800	96
10	7800	680	6150	544	4100	332	3200	192	2550	124	2200	90
12	6650	680	5250	544	3500	332	2650	192	2100	124	1860	90
16	4900	584	3900	464	2600	292	2000	168	1600	108	1400	78
20	3900	528	3100	420	2050	268	1600	168	1300	100	1100	70

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

