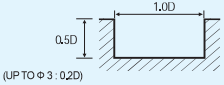
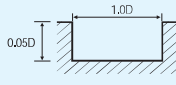


ZE302, ZE322, ZE402, ZE502, ZE522 series ▶ General Cutting

MATERIAL	ALLOY STEELS-HEAT RESISTANT STEELS		HARDENED STEELS		STAINLESS STEELS	
HARDNESS	HRc30 ~ HRc40		HRc40 ~ HRc50			
STRENGTH	1000 ~ 1250N/mm ²		1250 ~ 1750N/mm ²			
DIAMETER(mm)	RPM	FEED	RPM	FEED	RPM	FEED
2	9700	220	6350	135	5300	105
3	7500	240	4670	160	3880	135
4	6350	345	3880	205	3250	175
5	5300	370	3170	220	2650	185
6	4670	405	2830	255	2380	205
8	3530	435	2120	230	1760	205
10	2730	380	1680	185	1420	185
12	2310	320	1420	150	1140	150
16	1850	255	1140	125	890	125
20	1420	195	890	90	705	90
25	1150	150	705	80	580	70

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





• Please reduce cutting speed around 20~30% from the above table for ZE522, ZE322 series.

ZE302, ZE322, ZE402, ZE502, ZE522 series ▶ High Speed Cutting

MATERIAL	ALLOY STEELS-HEAT RESISTANT STEELS		HARDENED STEELS				STAINLESS STEELS	
HARDNESS	HRc30 ~ HRc40		HRc40 ~ HRc50		HRc40 ~ HRc55			
STRENGTH	1000 ~ 1250N/mm ²		1250 ~ 1750N/mm ²		1750 ~ 2000N/mm ²			
DIAMETER(mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2	18000	665	11800	415	8700	175	9800	345
3	11000	655	6800	435	5600	185	6200	370
4	10300	725	6300	430	4300	185	5300	370
5	9350	715	5570	420	3700	185	4620	355
6	8200	750	4930	470	3250	185	4100	390
8	6300	770	3780	410	2470	185	3120	355
10	4830	750	2940	360	2000	160	2470	310
12	4100	750	2520	345	1680	160	2100	300
16	3260	715	2000	355	1890	150	1940	290
20	2520	665	1580	310	1680	150	1630	275
25	2000	635	1260	340	1570	150	1420	290

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

