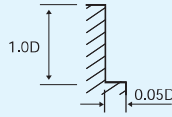


▣ ZE503 series ▶ Side Cutting

MATERIAL	NON-ALLOY STEELS ALLOY STEELS-CAST IRON		ALLOY STEELS HEAT RESISTANT STEELS		STAINLESS 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	RPM	FEED
6	5560	500	3360	310	2840	250	2000	60	1100	45
8	4200	530	2520	290	2100	265	1680	80	840	45
10	3260	460	2000	230	1680	230	1360	70	680	35
12	2740	390	1680	190	1360	180	1160	60	560	35
16	2200	310	1360	150	1060	150	900	45	440	20
18	1940	280	1210	135	950	130	790	35	380	20
20	1680	240	1060	120	840	115	680	30	320	20

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



▣ ZE503 series ▶ Slotting

MATERIAL	NON-ALLOY STEELS ALLOY STEELS-CAST IRON		ALLOY STEELS HEAT RESISTANT STEELS		STAINLESS 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	RPM	FEED
6	5560	310	3360	200	2840	160	2000	50	1100	35
8	4200	340	2520	180	2100	160	1680	65	840	35
10	3260	300	2000	140	1680	145	1360	55	680	30
12	2740	250	1680	120	1360	120	1160	50	560	30
16	2200	200	1360	100	1060	100	900	35	440	20
18	1940	175	1210	85	950	85	790	30	380	20
20	1680	150	1060	70	840	70	680	25	320	20

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

