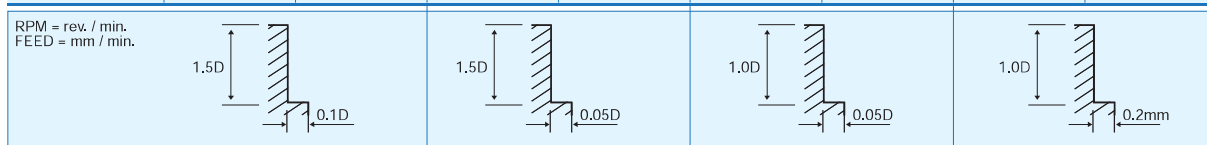


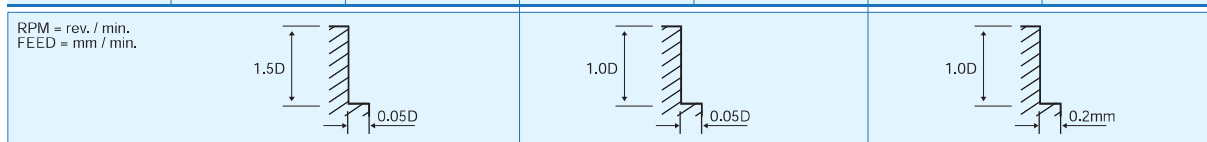
▣ ZE506, ZE516 series ▶ General Speed Cutting

| MATERIAL     | NON-ALLOY STEELS<br>ALLOY STEELS - CAST IRON |      | ALLOY STEELS<br>HEAT RESISTANT STEELS |      | HARDENED STEELS              |      | HARDENED STEELS       |      |
|--------------|--|------|---------------------------------------|------|------------------------------|------|-----------------------|------|
| HARDNESS     | ~ HRc30                                      |      | HRc30 ~ HRc50                         |      | HRc50 ~ HRc60                |      | HRc60 ~ HRc65         |      |
| STRENGTH     | ~ 1000N/mm <sup>2</sup>                      |      | 1000 ~ 1750N/mm <sup>2</sup>          |      | 1750 ~ 2080N/mm <sup>2</sup> |      | 2080N/mm <sup>2</sup> |      |
| DIAMETER(mm) | RPM  | FEED | RPM                                   | FEED | RPM                          | FEED | RPM                   | FEED |
| 6            | 5560   | 2000 | 3880                                  | 1370 | 1580                         | 210  | 1100                  | 130  |
| 8            | 4200   | 2000 | 2940                                  | 1370 | 1160                         | 210  | 840                   | 130  |
| 10           | 3360   | 2000 | 2320                                  | 1370 | 1000                         | 210  | 680                   | 130  |
| 12           | 2840   | 1680 | 2000                                  | 1160 | 840                          | 180  | 560                   | 110  |
| 16           | 2100   | 1260 | 1480                                  | 880  | 640                          | 130  | 420                   | 70   |
| 20           | 1680   | 1010 | 1160                                  | 690  | 500                          | 110  | 320                   | 60   |
| 25           | 1500   | 900  | 1100                                  | 600  | 430                          | 90   | 260                   | 50   |



▣ ZE506, ZE516 series ▶ High Speed Cutting

| MATERIAL     | HEAT RESISTANT STEELS<br>HARDENED STEELS |      | HARDENED STEELS            |      | HARDENED STEELS         |      |
|--------------|--|------|----------------------------|------|-------------------------|------|
| HARDNESS     | ~ HRc50                                  |      | HRc50 ~ HRc60              |      | HRc60 ~ HRc65           |      |
| STRENGTH     | 1750N/mm <sup>2</sup>                    |      | 1750~2080N/mm <sup>2</sup> |      | 2080N/mm <sup>2</sup> ~ |      |
| DIAMETER(mm) | RPM                                      | FEED | RPM                        | FEED | RPM                     | FEED |
| 6            | 16800                                    | 6090 | 8400                       | 3050 | 4200                    | 1470 |
| 8            | 12600                                    | 6090 | 6300                       | 3050 | 3160                    | 1470 |
| 10           | 9980                                     | 5990 | 5040                       | 3050 | 2520                    | 1470 |
| 12           | 8400                                     | 5040 | 4200                       | 2520 | 2100                    | 1260 |
| 16           | 6300                                     | 3780 | 3160                       | 1890 | 1580                    | 950  |
| 20           | 5040                                     | 3050 | 2520                       | 1470 | 1260                    | 760  |
| 25           | 4500                                     | 2750 | 2200                       | 1300 | 1120                    | 670  |



• Please reduce cutting speed around 20~30% from the above tablef or Extra long series.