

□ SF, PI, HPI SERIES

Work piece	Alloy Steel(C<0.3%) Alloy Steels/SS400 SCM -710N/mm ²		Alloy Steel(C≥0.3%) Alloy Steels/S50C SCM -1,060N/mm ²		SUJ2-SUS440		SKD61 HRc34-43		HRc43-48		SKD11 HRc48-53		Cast Iron FC 250-350		Ductile FC 400-500	
	80-125		80-125		63-80		40-63		32-45		25-36		80-125		63-90	
V(m/min)	80-125		80-125		63-80		40-63		32-45		25-36		80-125		63-90	
Diameter (mm)	RPM	fn (mm/rev)	RPM	fn (mm/rev)	RPM	fn (mm/rev)	RPM	fn (mm/rev)	RPM	fn (mm/rev)	RPM	fn (mm/rev)	RPM	fn (mm/rev)	RPM	fn (mm/rev)
3	12,000	0.09-0.12	13,000	0.09-0.12	7,600	0.09-0.12	6,400	0.09-0.12	5,300	0.07-0.11	3,800	0.05-0.09	12,000	0.09-0.12	8,500	0.09-0.12
4	9,500	0.1-0.15	10,000	0.1-0.15	5,700	0.1-0.15	4,800	0.1-0.15	4,000	0.08-0.13	2,950	0.06-0.1	9,000	0.1-0.15	6,350	0.1-0.15
5	7,600	0.12-0.18	8,000	0.12-0.18	4,600	0.12-0.18	3,800	0.12-0.18	3,200	0.1-0.15	2,300	0.08-0.12	7,600	0.12-0.18	5,100	0.12-0.18
6	6,400	0.14-0.20	6,600	0.14-0.20	3,800	0.14-0.20	3,200	0.14-0.20	2,650	0.12-0.18	1,900	0.09-0.15	6,400	0.14-0.20	4,250	0.14-0.20
8	4,800	0.16-0.24	5,000	0.16-0.24	2,900	0.16-0.24	2,400	0.16-0.24	2,000	0.14-0.22	1,450	0.12-0.2	4,800	0.16-0.24	3,200	0.16-0.24
10	3,800	0.18-0.27	4,000	0.18-0.27	2,300	0.18-0.27	1,900	0.18-0.27	1,600	0.15-0.25	1,150	0.13-0.23	3,800	0.18-0.27	2,550	0.18-0.27
12	3,200	0.20-0.30	3,300	0.20-0.30	1,900	0.20-0.30	1,600	0.20-0.30	1,300	0.17-0.26	950	0.14-0.24	3,200	0.20-0.30	2,100	0.20-0.30
14	2,700	0.22-0.35	2,800	0.22-0.35	1,600	0.22-0.35	1,350	0.22-0.35	1,150	0.18-0.3	800	0.15-0.26	2,700	0.22-0.35	1,800	0.22-0.35
16	2,400	0.25-0.36	2,500	0.25-0.36	1,400	0.25-0.36	1,200	0.25-0.36	1,000	0.2-0.32	700	0.16-0.26	2,400	0.25-0.36	1,600	0.25-0.36
18	2,100	0.28-0.38	2,200	0.28-0.38	1,300	0.28-0.38	1,100	0.28-0.38	900	0.23-0.33	650	0.18-0.28	2,100	0.28-0.38	1,400	0.28-0.38
20	1,900	0.30-0.40	2,000	0.30-0.40	1,150	0.30-0.40	1,000	0.30-0.40	800	0.25-0.35	600	0.2-0.3	1,900	0.30-0.40	1,250	0.30-0.40

· 8D : fn 70~80%