

ZE302, ZE322 SERIES ▶ General Cutting

Workpiece	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	9,700	220	6,350	135	5,300	105
3	7,500	240	4,670	160	3,880	135
4	6,350	345	3,880	205	3,250	175
5	5,300	370	3,170	220	2,650	185
6	4,670	405	2,830	255	2,380	205
8	3,530	435	2,120	230	1,760	205
10	2,730	380	1,680	185	1,420	185
12	2,310	320	1,420	150	1,140	150
16	1,850	255	1,140	125	890	125
20	1,420	195	890	90	705	90
25	1,150	150	705	80	580	70

RPM = rev/min
FEED = mm/min



ZE302, ZE322 SERIES ▶ High Speed Cutting

Workpiece	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	18,000	665	11,800	415	8,700	175	9,800	345
3	11,000	655	6,800	435	5,600	185	6,200	370
4	10,300	725	6,300	430	4,300	185	5,300	370
5	9,350	715	5,570	420	3,700	185	4,620	355
6	8,200	750	4,930	470	3,250	185	4,100	390
8	6,300	770	3,780	410	2,470	185	3,120	355
10	4,830	750	2,940	360	2,000	160	2,470	310
12	4,100	750	2,520	345	1,680	160	2,100	300
16	3,260	715	2,000	355	1,890	150	1,940	290
20	2,520	665	1,580	310	1,680	150	1,630	275
25	2,000	635	1,260	340	1,570	150	1,420	290

RPM = rev/min
FEED = mm/min

