

ZE304, ZE324 SERIES ▶ General Cutting

Workpiece	Alloy Steels, Heat Resistant Steels		Hardened Steels				Stainless Steels	
Hardness	~ HRc30		HRc30 ~ HRc45		HRc45 ~ HRc55		-	
Strength	~ 1000N/mm ²		1000 ~ 1500N/mm ²		1500 ~ 2000N/mm ²		-	
Diameter (mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2	12,100	320	7,900	195	2,700	47	6,600	160
3	9,400	370	5,840	230	2,000	58	4,850	195
4	7,900	655	4,850	405	1,500	58	4,070	320
5	6,600	690	3,970	415	1,300	58	3,320	345
6	5,830	760	3,530	470	1,150	58	2,980	380
8	4,410	815	2,650	435	880	58	2,200	405
10	3,420	700	2,100	345	720	46	1,760	345
12	2,880	600	1,760	290	590	46	1,430	275
16	2,310	470	1,430	230	460	29	1,150	230
20	1,760	370	1,110	185	340	29	880	175
25	1,430	290	880	150	270	23	715	140

RPM = rev/min
FEED = mm/min

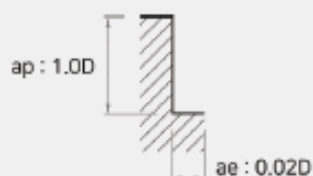


※ Please reduce cutting speed around 20~30% from the above table or ZE524 & ZE324 series.

ZE304, ZE324 SERIES ▶ High Speed Cutting

Workpiece	Alloy Steels, Heat Resistant Steels		Hardened Steels				Stainless Steels	
Hardness	~ HRc30		HRc30 ~ HRc45		HRc45 ~ HRc55		-	
Strength	~ 1000N/mm ²		1000 ~ 1500N/mm ²		1500 ~ 2000N/mm ²		-	
Diameter (mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2	31,400	1,230	23,500	520	12,600	275	21,600	465
3	19,300	1,210	13,600	735	8,900	390	13,500	660
4	18,100	1,330	12,600	865	7,090	465	11,800	775
5	16,400	1,310	11,100	1,010	6,040	530	10,300	910
6	14,400	1,380	9,900	1,100	5,300	580	9,100	990
8	11,000	1,430	7,600	1,090	3,990	575	6,900	980
10	8,500	1,380	5,880	1,110	3,150	580	5,420	1,000
12	7,200	1,380	5,040	1,090	2,620	575	4,600	985
16	5,700	1,320	3,990	1,010	2,000	535	3,590	910
20	4,400	1,270	3,150	930	1,580	490	2,840	840
25	3,500	1,170	2,520	755	1,260	390	2,270	680

RPM = rev/min
FEED = mm/min



※ Please reduce cutting speed around 20~30% from the above table or ZE524 & ZE324 series.