

## ■ ZR304H, ZR324H SERIES

Workpiece	NON-Alloy Steels, Alloy Steels, Cast Iron		Alloy Steels, Heat Resistant Steels		Hardened Steels	
Hardness	~ HRC30		HRC30 ~ HRC45		HRC45 ~ HRC50	
Strength	~ 1000N/mm <sup>2</sup>		1000 ~ 1500N/mm <sup>2</sup>		1500 ~ 2000N/mm <sup>2</sup>	
Diameter (mm)	RPM	FEED	RPM	FEED	RPM	FEED
6	7,000	910	4,200	560	3,000	140
8	5,300	980	3,200	530	2,500	190
10	4,100	840	2,500	410	2,050	165
12	3,500	730	2,100	340	1,700	140

RPM = rev/min  
FEED = mm/min

