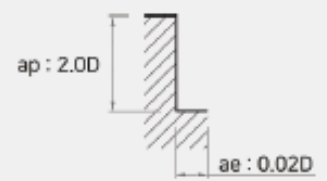
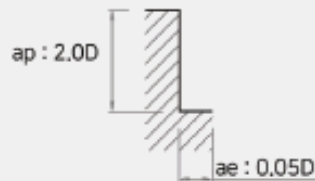


## ▣ ZR322 SERIES ▶ Side Cutting

Workpiece	NON-Alloy Steels, Alloy Steels, Cast Iron		Alloy Steels, Heat Resistant Steels		Hardened Steels	
Hardness	~ HRc30		HRc30 ~ HRc45		HRc45 ~ HRc55	
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
3	6,950	195	4,500	150	3,300	100
4	5,600	240	3,600	170	2,700	105
5	4,800	250	3,050	210	2,350	125
6	4,150	250	2,650	210	2,050	125
8	3,150	265	2,000	210	1,600	125
10	2,150	265	1,700	210	1,250	125
12	1,800	210	1,500	185	1,050	105
16	1,800	185	1,100	140	840	90
20	1,300	130	860	105	625	65

RPM = rev/min  
FEED = mm/min



## ▣ ZR322 SERIES ▶ Slotting

Workpiece	NON-Alloy Steels, Alloy Steels, Cast Iron		Alloy Steels, Heat Resistant Steels		Hardened Steels	
Hardness	~ HRc30		HRc30 ~ HRc45		HRc45 ~ HRc55	
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
3	6,950	160	4,500	80	3,300	55
4	5,600	195	3,600	100	2,700	60
5	4,800	240	3,050	115	2,350	75
6	4,150	290	2,650	145	2,050	90
8	3,150	210	2,000	145	1,600	90
10	2,150	250	1,700	140	1,250	90
12	1,800	200	1,500	135	1,050	75
16	1,800	215	1,100	100	840	60
20	1,300	160	860	70	625	45

RPM = rev/min  
FEED = mm/min

