

■ ZR324 SERIES

Workpiece	NON-Alloy Steels, Alloy Steels, Cast Iron		Alloy Steels, Heat Resistant Steels		Herdened Steels	
Hardness	~ HRc30		HRc30 ~ HRc45		HRc45 ~ HRc55	
Strength	~ 1000N/mm2		1000 ~ 1500N/mm2		1500 ~ 2000N/mm2	
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	1,880	185	1,100	140	840	90
20	1,300	130	860	105	625	65

RPM = rev/min
FEED = mm/min

