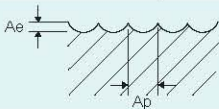


ZB302 Series | General Speed Cutting

Material	Non-Alloyed Steels Alloy Steels - Cast Iron		Alloy Steels Heat Resistant Steels		Hardened Steels	
Hardness	~ HRc30		HRc30 ~ HRc40		HRc45 ~ HRc65	
Strength	~ 1000N/mm ²		1000 ~ 1250N/mm ²		1500N/mm ²	
Diameter [INCH]	RPM	FEED	RPM	FEED	RPM	FEED
R1/64 X 1/32	15760	9.80	12720	7.80	5800	3.80
R1/32 X 1/16	15760	13.80	12140	1.60	5320	4.70
R3/64 X 3/32	14400	29.50	10700	19.30	4680	5.90
R1/16 X 1/8	13100	26.70	10000	18.10	4520	5.90
R3/32 X 3/16	9140	32.30	7300	22.80	3680	7.10
R1/8 X 1/4	7780	33.00	6300	24.80	3160	7.50
R5/32 X 5/16	5260	37.50	4420	26.00	2100	7.50
R3/16 X 3/8	4620	40.10	3780	28.00	1780	7.50
R1/4 X 1/2	3780	35.40	2940	26.00	1360	7.50
R5/16 X 5/8	2740	36.20	2320	26.00	1160	7.50
R3/8 X 3/4	2100	33.00	1900	25.00	840	7.50

RPM = rev. / min.
FEED = inch / min.

Ae: D1/32~D1/4=.008 inch
D5/16~D3/4=.012 inch
Ap: 0.2 X D



Ae: D1/32~D1/4=.008 inch
D5/16~D3/4=.012 inch
Ap: 0.1 X D

ZB302 Series | High Speed Cutting

Material	Non-Alloyed Steels Alloy Steels - Cast Iron		Hardened Steels	
Hardness	~ HRc45		~ HRc65	
Strength	~ 1500N/mm ²		1500N/mm ²	
Diameter [INCH]	RPM	FEED	RPM	FEED
R1/64 X 1/32	25000	25.60	25000	15.70
R1/32 X 1/16	23000	27.50	23000	16.90
R3/64 X 3/32	21000	34.60	19000	19.30
R1/16 X 1/8	21000	39.40	17000	20.50
R3/32 X 3/16	21000	70.90	12000	23.60
R1/8 X 1/4	21000	90.90	10500	24.80
R5/32 X 5/16	15760	111.80	7880	29.10
R3/16 X 3/8	13660	120.00	6300	33.00
R1/4 X 1/2	10500	103.50	5260	33.00
R5/16 X 5/8	8200	103.50	3780	28.00
R3/8 X 3/4	6300	99.00	2940	20.80

RPM = rev. / min.
FEED = inch / min.

Ae: D1/32~D1/4=.008 inch
D5/16~D3/4=.012 inch
Ap: 0.05 X D

