

ZR304A Corner Radius Series

| Material | Carbon Steels Alloy Steels · Cast Iron | | Alloy Steels Tool Steels | | StainlessSteels | | Hardened Steels | | Hardened Steels | |
|-----------------|---|-------|------------------------------|-------|-----------------|-------|------------------------------|------|-----------------------|------|
| Hardness | ~ HRC30 | | HRC30 ~ HRC45 | | | | HRC45 ~ HRC55 | | HRC55 ~ HRC65 | |
| Strength | ~ 1000N/mm ² | | 1000 ~ 1500N/mm ² | | | | 1500 ~ 2000N/mm ² | | 2000N/mm ² | |
| Diameter (INCH) | RPM | FEED | RPM | FEED | RPM | FEED | RPM | FEED | RPM | FEED |
| 1/16 | 11560 | 11.00 | 7560 | 6.70 | 6300 | 5.50 | 5040 | 1.95 | | |
| 1/8 | 8920 | 12.60 | 5560 | 7.85 | 4620 | 6.70 | 3360 | 2.35 | 1900 | 2.35 |
| 3/16 | 6300 | 23.60 | 3780 | 14.15 | 3160 | 11.80 | 2320 | 2.75 | 1260 | 2.35 |
| 1/4 | 5560 | 26.00 | 3360 | 16.15 | 2840 | 13.00 | 2000 | 3.15 | 1100 | 2.35 |
| 5/16 | 4200 | 27.95 | 2520 | 14.95 | 2100 | 13.80 | 1680 | 4.30 | 840 | 2.35 |
| 3/8 | 3260 | 24.00 | 2000 | 11.80 | 1680 | 11.80 | 1360 | 3.55 | 680 | 1.95 |
| 1/2 | 2740 | 20.50 | 1680 | 9.85 | 1360 | 9.45 | 1160 | 3.15 | 560 | 1.95 |
| 5/8 | 2200 | 16.15 | 1360 | 7.85 | 1060 | 7.85 | 900 | 2.35 | 440 | 1.20 |
| 3/4 | 1680 | 12.60 | 1060 | 6.30 | 840 | 5.90 | 680 | 1.55 | 320 | 1.20 |
| 1 | 1360 | 9.85 | 840 | 5.10 | 680 | 4.70 | 540 | 1.20 | 260 | 0.80 |

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