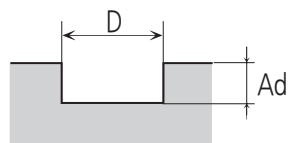
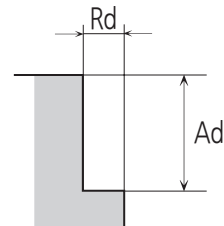


피삭재	알루미늄		합금강, 주철	
Workpiece	Acrylic, Aluminium		Alloy Steels, Cast Iron	
Outside Diameter	Speed (min ⁻¹)	Feed (mm/min)	Speed (min ⁻¹)	Feed (mm/min)
1.0	15,000~20,000	700~1,000	15,000~20,000	500~800
1.5	15,000~20,000	700~1,000	10,000~15,000	500~800
2.0	10,000~15,000	700~1,000	10,000~15,000	400~700
3.0	8,000~12,000	800~1,200	8,000~12,000	400~700
4.0	8,000~12,000	1,000~1,300	8,000~12,000	800~1,200
6.0	8,000~12,000	1,200~1,500	8,000~12,000	1,000~1,500
8.0	6,500~9,000	1,500~2,000	6,500~9,000	1,200~1,600
10.0	6,500~9,000	1,800~2,300	6,500~9,000	1,500~2,000
12.0	6,000~8,500	2,000~2,500	6,000~8,500	2,000~2,500
14.0	5,500~8,000	2,000~2,500	5,500~8,000	1,500~2,000
16.0	5,000~8,000	2,300~2,700	5,000~8,000	1,500~2,000
18.0	3,500~5,000	1,800~2,300	3,500~5,000	1,300~1,800
20.0	3,500~5,000	1,800~2,300	3,500~5,000	1,300~1,800

Depth of Cut



$$Ad = 0.5D$$



$$Ad = 1.0D, Rd = 0.25D (D \leq \varnothing 10)$$

$$Ad = 1.0D, Rd = 0.5D (D \leq \varnothing 20)$$

경고 Warning

- 강성을 지닌 경밀한 장비와 홀더를 사용하십시오.
 - 절삭유 사용을 추천합니다.
- Use a rigid precise machine and holder.
 - Recommend water soluble fluids.