

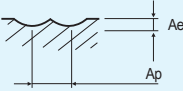
[DB312, 342, 402, 502, 512, 522, 54(5)2 series]

▶ 일반 가공

피삭재	비합금강, 합금강, 주철		합금강, 내열강		열처리강	
경도	~ HRC30		HRc30 ~ HRc40		HRc40 ~ HRc55	
강도	~ 1000N/mm ²		1000 ~ 1250N/mm ²		1500N/mm ²	
외경(mm)	RPM	FEED	RPM	FEED	RPM	FEED
1	16,500	290	13,300	230	6,100	105
1.5	16,500	405	12,700	310	5,590	140
2	15,100	865	11,200	565	4,900	175
2.5	15,100	865	11,200	565	4,900	175
3	13,800	780	10,500	530	4,750	175
4	11,000	850	8,800	610	4,410	205
5	9,600	945	7,600	665	3,860	205
6	8,900	1,150	7,200	955	3,340	220
8	7,500	1,500	6,050	1,060	2,590	255
10	6,700	1,750	5,300	1,170	2,140	260
12	6,150	2,000	4,900	1,280	1,840	280
16	5,000	1,950	3,900	1,220	1,420	280
20	4,350	1,900	3,400	1,200	1,170	290

RPM = rev. / min.
FEED = mm / min.

Ae : D1~D6=0.2mm
D8~D20=0.3mm
Ap : 0.2XD



Ae : D1~D6=0.2mm
D8~D20=0.3mm
Ap : 0.1XD

· DB522 시리즈는 절삭 속도를 20~30% 줄여 사용하십시오.

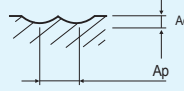
[DB312, 342, 402, 502, 512, 522, 54(5)2 series]

▶ 고속 가공

피삭재	비합금강, 합금강, 주철		합금강, 내열강	
경도	~ HRC45		HRc30 ~ HRc40	
강도	~ 1500N/mm ²		1500 ~ 2000N/mm ²	
외경(mm)	RPM	FEED	RPM	FEED
1	26,000	1,500	26,000	920
1.5	24,000	1,600	24,000	990
2	22,000	1,700	22,000	1,080
2.5	22,000	2,000	20,000	1,130
3	22,000	2,300	17,800	1,200
4	22,000	3,350	14,300	1,300
5	22,000	4,150	12,600	1,380
6	22,000	4,600	11,000	1,440
8	17,500	4,600	8,800	1,440
10	14,700	4,450	7,350	1,380
12	12,800	4,450	6,400	1,330
16	10,000	4,000	5,000	1,150
20	8,350	3,650	4,150	1,060

RPM = rev. / min.
FEED = mm / min.

Ae : D1~D6=0.2mm
D8~D20=0.3mm
Ap : 0.2XD



· DB522 시리즈는 절삭 속도를 20~30% 줄여 사용하십시오.