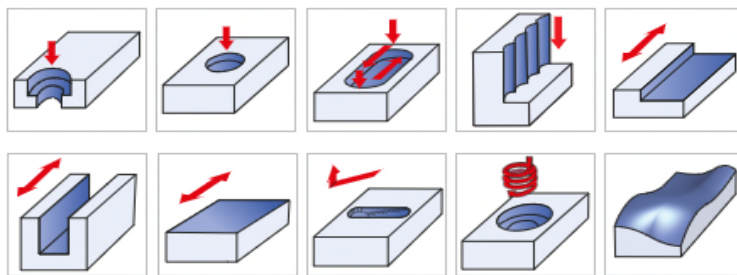
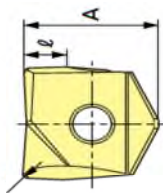
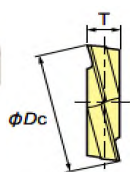


Material 피삭재		Grade 재종	Cutting Speed 절삭속도 (m/min)	Feed Rate 이송속도 FZ(mm/TOOTH)	Ø8		Ø10		Ø12	
					Revolution min ⁻¹	Feed Speed mm/min	Revolution min ⁻¹	Feed Speed mm/min	Revolution min ⁻¹	Feed Speed mm/min
P 강 Steel	탄소강 / 합금강 Carbon Steels Alloy Steels	PCS08M (PCA12M) (PCA08M)	100~200	0.2~0.3	6,370	2,550	5,090	2,040	4,240	1,700
		Vc = 160m/min fz = 0.2mm/tooth ap = 0.025mm ae = 0.1D								
		PCS08M (PCA12M) (PCA08M)	80~150	0.2~0.3	4,770	1,910	3,820	1,530	3,180	1,270
		Vc = 120m/min fz = 0.2mm/tooth ap = 0.025mm ae = 0.1D								
K 주철 Cast iron	주철 Cast iron	PTH08M (PCA12M) (PCA08M)	70~100	0.3~0.4	6,370	3,820	5,090	3,050	4,240	2,550
		Vc = 160m/min fz = 0.3mm/tooth ap = 0.025mm ae = 0.1D								
H 열처리강 Hardened Steel	금형강/프라하드강 Die Tool Steels Pre-Harden Steels	PTH08M (PCA12M) (PCA08M)	200~250	0.1~0.15	3,180	640	2,550	510	2,120	420
		Vc = 80m/min fz = 0.1mm/tooth ap = 0.025mm ae = 0.1D								
	조질강 Hardened Steels	PTH08M	100~200	0.2~0.4	9,150	3,660	7,320	2,930	6,100	2,440
		Vc = 230m/min fz = 0.2mm/tooth ap = 0.01mm ae = 0.02D								



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초경 상크 커터



Material 피삭재		Grade 재종	Cutting Speed 절삭속도 (m/min)	Feed Rate 이송속도 FZ(mm/TOOTH)	Ø16		Ø20		Ø25		Ø30(Ø32)	
					Revolution min ⁻¹	Feed Speed mm/min	Revolution min ⁻¹	Feed Speed mm/min	Revolution min ⁻¹	Feed Speed mm/min	Revolution min ⁻¹	Feed Speed mm/min
P강 Steel	탄소강 / 합금강 Carbon Steels Alloy Steels	PCS08M (PCA12M) (PCA08M)	100~200	0.2~0.3	3,180	1,600	2,550	1,300	2,050	1,030	1,700	850
		Vc = 160m/min fz = 0.25mm/tooth ap = 0.05mm ae = 0.1D										
		PCS08M (PCA12M) (PCA08M)	80~150	0.2~0.3	2,390	1,200	1,910	955	1,530	765	1,280	640
		Vc = 120m/min fz = 0.25mm/tooth ap = 0.05mm ae = 0.1D										
K주철 Cast iron	주철 Cast iron	PTH08M (PCA12M) (PCA08M)	70~100	0.3~0.4	3,200	2,240	2,250	1,790	2,050	1,440	1,700	1,190
		Vc = 160m/min fz = 0.35mm/tooth ap = 0.05mm ae = 0.1D										
H열처리강 Hardened Steel	금형강/프라하든강 Die Tool Steels Pre-Harden Steels	PTH08M (PCA12M) (PCA08M)	200~250	0.1~0.15	1,590	385	1,280	310	1,020	245	580	205
		Vc = 80m/min fz = 0.12mm/tooth ap = 0.05mm ae = 0.1D										
	조질강 Hardened Steels	PTH08M	100~200	0.2~0.4	4,575	2,740	3,660	2,200	2,930	1,760	2,440	1,460
		Vc = 230m/min fz = 0.3mm/tooth ap = 0.01mm ae = 0.02D										