

## ZE714A Series

| End Cutting            | Side Milling                             |       |                 |       |             |       |             |       |        |       |             |       |
|------------------------|------------------------------------------|-------|-----------------|-------|-------------|-------|-------------|-------|--------|-------|-------------|-------|
| Work Material          | Hardened Steels<br>Heat Resistant Steels |       | Hardened Steels |       |             |       |             |       |        |       |             |       |
| Hardness               | 30 ~ 40 HRc                              |       | 40 ~ 50 HRc     |       | 50 ~ 55 HRc |       | 55 ~ 60 HRc |       | 65 HRc |       | 65 ~ 70 HRc |       |
| Cutting Diameter(inch) | RPM                                      | FEED  | RPM             | FEED  | RPM         | FEED  | RPM         | FEED  | RPM    | FEED  | RPM         | FEED  |
| 1/16                   | 33,300                                   | 68.90 | 26,000          | 49.21 | 17,500      | 33.07 | 14,500      | 20.47 | 11,000 | 12.60 | 9,500       | 9.06  |
| 1/8                    | 21,800                                   | 68.90 | 17,300          | 49.21 | 11,500      | 33.07 | 9,500       | 20.47 | 7,500  | 12.60 | 6,400       | 9.06  |
| 3/16                   | 15,700                                   | 78.74 | 12,500          | 59.06 | 8,300       | 39.37 | 6,400       | 22.83 | 5,100  | 14.57 | 4,450       | 10.63 |
| 1/4                    | 13,100                                   | 76.77 | 10,350          | 55.12 | 6,900       | 37.40 | 5,300       | 22.05 | 4,200  | 13.78 | 3,700       | 10.24 |
| 5/16                   | 9,880                                    | 74.02 | 7,800           | 53.15 | 5,200       | 35.43 | 4,000       | 20.47 | 3,200  | 12.99 | 2,800       | 9.45  |
| 3/8                    | 7,800                                    | 68.90 | 6,150           | 49.61 | 4,100       | 33.07 | 3,200       | 18.90 | 2,550  | 12.20 | 2,200       | 8.66  |
| 1/2                    | 6,650                                    | 68.90 | 5,250           | 49.61 | 3,500       | 33.07 | 2,650       | 18.90 | 2,100  | 11.81 | 1,860       | 8.66  |

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

## ZE716A Series

| Work Material          | Hardened Steels<br>Heat Resistant Steels |        | Hardened Steels |        |             |        |             |        |        |       |             |       |
|------------------------|------------------------------------------|--------|-----------------|--------|-------------|--------|-------------|--------|--------|-------|-------------|-------|
| Hardness               | 30 ~ 40 HRc                              |        | 40 ~ 50 HRc     |        | 50 ~ 55 HRc |        | 55 ~ 60 HRc |        | 65 HRc |       | 65 ~ 70 HRc |       |
| Cutting Diameter(inch) | RPM                                      | FEED   | RPM             | FEED   | RPM         | FEED   | RPM         | FEED   | RPM    | FEED  | RPM         | FEED  |
| 1/4                    | 24,800                                   | 210.63 | 23,500          | 192.91 | 16,000      | 192.91 | 13,500      | 129.92 | 10,500 | 82.68 | 8,000       | 57.09 |
| 5/16                   | 20,000                                   | 216.54 | 19,000          | 196.85 | 12,000      | 181.10 | 10,000      | 122.05 | 8,000  | 78.74 | 6,000       | 55.12 |
| 3/8                    | 16,000                                   | 192.91 | 15,500          | 177.17 | 9,500       | 161.42 | 8,000       | 114.17 | 6,400  | 70.87 | 4,800       | 51.18 |
| 1/2                    | 13,000                                   | 177.17 | 12,500          | 161.42 | 8,000       | 149.61 | 6,600       | 98.43  | 5,300  | 62.99 | 4,000       | 45.28 |
| 5/8                    | 10,000                                   | 157.48 | 9,700           | 145.67 | 6,000       | 133.86 | 5,000       | 90.55  | 4,000  | 49.21 | 3,000       | 34.25 |
| 3/4                    | 8,000                                    | 131.89 | 7,800           | 133.86 | 4,800       | 125.98 | 4,000       | 82.68  | 3,200  | 40.16 | 2,400       | 27.17 |

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