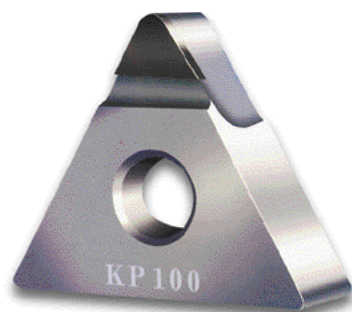


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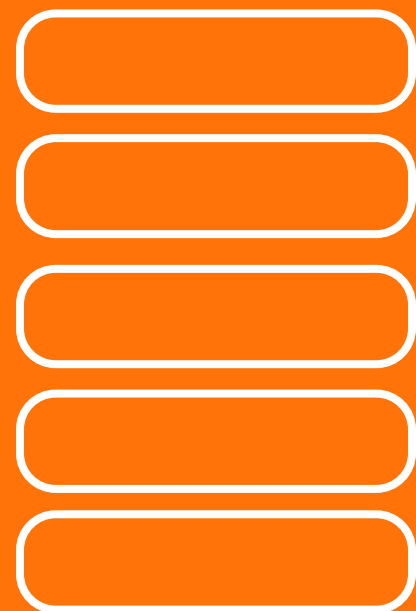
	↑	10~25 $\mu\text{m}$	<b>KP500</b>	(Si 12%), ( 가 )
		8~9 $\mu\text{m}$	<b>KP300</b>	(Si 12%),
	↓	4~5 $\mu\text{m}$	<b>KP100</b>	,

(Turning)

	(m/min)	(mm/rev)	(mm)	
(4~8% Si)	800~2500	0.1~0.3	0.05~3.0	<b>KP300</b>
(9~14% Si)	600~1280	0.1~0.3		<b>KP300, KP500</b>
(16~18% Si)	300~600	0.1~0.3		<b>KP500</b>
Si)	10~30	0.05~0.2	0.02~0.5	<b>KP500</b>
	1000~2500	0.1~0.5	0.2~5.0	<b>KP100</b>
	600~1000	0.05~0.2	0.05~3.0	<b>KP300</b>
	300~1000	0.05~0.25	0.05~3.0	<b>KP100</b>

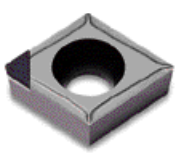
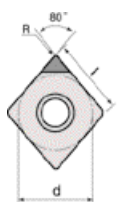
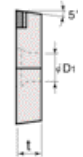
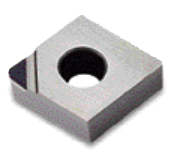
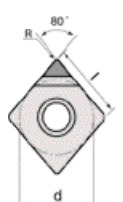
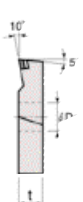
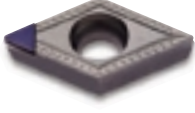
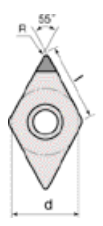
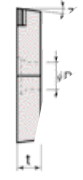
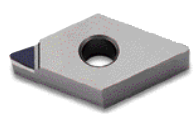
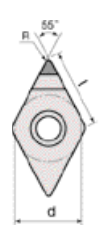
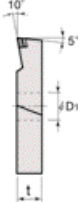
(Milling)

	(m/min)	(mm/rev)	(mm)	
(Si 14% )	300~3000	0.1~0.2	0.10~3.0	<b>KP500</b>
(Si 15% )	300~1200			





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		(mm)					KP 500	KP 300	KP 100
		l	d	ØD <sub>1</sub>	t	R			
  	CCMT 060202					0.2			
	CCMT 060204	6.5	6.35	2.8	2.38	0.4	●		
	CCMT 060208					0.8			
	CCMT 09T304	9.7	9.52	4.4	3.97	0.4	●		
	CCMT 09T308					0.8			
	CCMT 120404					0.4			
	CCMT 120408	12.9	12.70	5.5	4.76	0.8			
  	CNMA 120404					0.4	●		
	CNMA 120408	12.9	12.70	5.16	4.76	0.8	●		
	CNMA 120412					1.2			
  	DCMT 070202					0.2			
	DCMT 070204	7.8	6.35	2.8	2.38	0.4			
	DCMT 11T302					0.2	●		
	DCMT 11T304	11.6	9.52	4.4	3.97	0.4	●		
	DCMT 11T308					0.8			
  	DNMA 150404					0.4			
	DNMA 150408	15.5	12.70	5.16	4.76	0.8			
	DNMA 150412					1.2			

● : 가 . ● : 가 .

		(mm)					KP 500	KP 300	KP 100
		l	d	ØD <sub>1</sub>	t	R			
	TCMT 090204	9.0	5.56	2.5	2.38	0.4			
	TCMT 090208					0.8			
	TCMT 110204	11.0	6.35	2.8	2.38	0.4	●		
	TCMT 110208					0.8			
	TCMT 16T304	16.5	9.52	4.4	3.97	0.4			
	TCMT 16T308					0.8			
	TPGN 110304	11.0	6.35	-	3.18	0.4			
	TPGN 110308					0.8			
	TPGN 160304	16.5	9.52	-	3.18	0.4			
	TPGN 160308					0.8			
	TNMA 160404					0.4			
	TNMA 160408	16.5	9.52	3.81	4.76	0.8			
	TNMA 160412					1.2			
	VBMT 160404					0.4	●		
	VBMT 160408	16.6	9.52	4.4	4.76	0.8			
	VCGT 160404					0.4	●		
	VCGT 160408	16.6	9.52	4.4	4.76	0.8			
	VNMA 160404					0.4			
	VNMA 160408	16.6	9.52	3.81	4.76	0.8			
	VNMA 160412					1.2			

● : 가      ● : 가

