

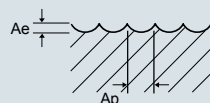
TECHNICAL DATA | ZAMUS CLASSIC |

DA412 Series

Feed Rate	General Speed Cutting							
Work Material	Hardened Steels							
Hardness	45 ~ 50 HRc		50 ~ 55 HRc		55 ~ 60 HRc		60 ~ 65 HRc	
Strength	217,557 ~ 253,817lbf / inch ²		253,817 ~ 290,076lbf / inch ²		290,076 ~ 301,679lbf / inch ²		301,679lbf / inch ²	
Cutting Diameter(inch)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1/8	12,700	43.30	12,300	41.30	11,800	39.40	8,400	26.00
3/16	9,400	43.30	9,050	41.30	8,600	37.40	5,600	26.80
1/4	8,600	45.30	8,250	43.30	7,850	37.40	4,850	27.60
5/16	7,000	41.30	6,700	39.40	6,350	37.40	3,800	25.60
3/8	6,050	39.40	5,800	37.80	5,450	35.40	3,200	24.40
1/2	5,450	39.40	5,200	37.80	4,900	35.40	2,750	24.40
5/8	4,350	34.30	4,150	32.70	3,900	32.30	2,150	10.40
3/4	3,500	27.20	3,300	25.60	3,150	24.80	1,700	8.70
1	2,800	27.20	2,650	25.60	2,520	24.80	1,360	8.70

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

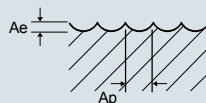
Ae: D1/8=.006
D3/16~D5/16=.010
D3/8~D1=.012
Ap: 0.1 X D



Feed Rate	High Speed Cutting					
Work Material	Hardened Steels					
Hardness	45 ~ 50 HRc		50 ~ 55 HRc		55 ~ 60 HRc	
Strength	217,557 ~ 253,817lbf / inch ²		253,817 ~ 290,076lbf / inch ²		290,076 ~ 301,679lbf / inch ²	
Cutting Diameter(inch)	RPM	FEED	RPM	FEED	RPM	FEED
1/8	12,700	43.30	12,300	41.30	11,800	26.00
3/16	9,400	43.30	9,050	41.30	8,600	26.80
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5/8	4,350	34.30	4,150	32.70	3,900	10.40
3/4	3,500	27.20	3,300	25.60	3,150	8.70
1	2,800	27.20	2,650	25.60	2,520	8.70

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

Ae: D1/8=.006
D3/16~D5/16=.010
D3/8~D1=.012
Ap: 0.05 X D



ZAMUS CLASSIC > INCH