

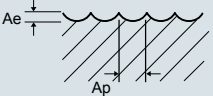
TECHNICAL DATA | ZAMUS CLASSIC |

DA522 Series

Feed Rate	General Speed Cutting					
Work Material	Alloy Steels, Heat Resistant Steels		Hardened Steels			
Hardness	30 ~ 40 HRC		45 ~ 50 HRC		50 ~ 55 HRC	
Strength	145,038 ~ 181,298lbf / inch ²		217,557 ~ 253,817lbf / inch ²		253,817 ~ 290,076lbf / inch ²	
Cutting Diameter(inch)	RPM	FEED	RPM	FEED	RPM	FEED
1/8	10,000	18.10	12,700	43.30	12,300	41.30
3/16	7,300	22.80	9,400	43.30	9,050	41.30
1/4	6,300	24.80	8,600	45.30	8,250	43.30
5/16	4,420	26.00	7,000	41.30	6,700	39.40
3/8	3,780	28.00	6,050	39.40	5,800	37.80
1/2	2,940	26.00	5,450	39.40	5,200	37.80
5/8	2,320	26.00	4,350	34.30	4,150	32.70
3/4	1,900	25.00	3,500	27.20	3,300	25.60
1	1,520	25.00	2,800	27.20	2,650	25.60

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

Ae: D1/8~D1/4=.008
D5/16~D1=.012
Ap: 0.2 X D

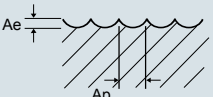


Ae: D1/8=.006
D3/16~D5/16=.010
D3/8~D1=.012
Ap: 0.1 X D

Feed Rate	High Speed Cutting					
Work Material	Alloy Steels, Heat Resistant Steels		Hardened Steels			
Hardness	30 ~ 40 HRC		45 ~ 50 HRC		50 ~ 55 HRC	
Strength	145,038 ~ 181,298lbf / inch ²		217,557 ~ 253,817lbf / inch ²		253,817 ~ 290,076lbf / inch ²	
Cutting Diameter(inch)	RPM	FEED	RPM	FEED	RPM	FEED
1/8	21,000	39.40	12,700	68.90	12,300	65.70
3/16	21,000	70.90	9,400	65.00	9,050	61.80
1/4	21,000	90.90	8,600	69.00	8,250	65.70
5/16	15,760	111.80	7,000	61.00	6,700	57.50
3/8	13,660	120.10	6,050	57.10	5,800	53.50
1/2	10,500	103.50	5,450	55.90	5,200	52.40
5/8	8,200	103.50	4,350	48.40	4,150	44.50
3/4	6,300	99.20	3,500	39.40	3,300	35.40
1	5,040	99.20	2,800	39.40	2,650	35.40

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

Ae: D1/8~D1/4=.008
D5/16~D1=.012
Ap: 0.05 X D



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