

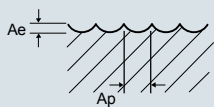
# TECHNICAL DATA | ZAMUS CLASSIC |

## DA552 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 <sup>2</sup> |       | 217,557 ~ 253,817lbf / inch <sup>2</sup> |       | 253,817 ~ 290,076lbf / inch <sup>2</sup> |       |
| Cutting Diameter(inch) | RPM                                      | FEED  | RPM                                      | FEED  | RPM                                      | FEED  |
| 3/16                   | 4,670                                    | 14.50 | 6,000                                    | 27.70 | 5,760                                    | 26.80 |
| 1/4                    | 4,030                                    | 15.80 | 5,520                                    | 29.00 | 5,200                                    | 27.70 |
| 5/16                   | 2,830                                    | 16.70 | 4,480                                    | 26.50 | 4,240                                    | 25.20 |
| 3/8                    | 2,420                                    | 17.90 | 3,880                                    | 25.20 | 3,720                                    | 24.20 |
| 1/2                    | 1,880                                    | 16.70 | 3,480                                    | 25.20 | 3,320                                    | 24.20 |

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

Ae: D3/16~D1/4=.008  
D5/16~D1/2=.012  
Ap: 0.2 X D

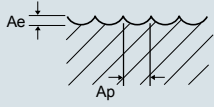


Ae: D3/16~D5/16=.010  
D3/8~D1/2=.012  
Ap: 0.1 X D

| 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 <sup>2</sup> |       | 217,557 ~ 253,817lbf / inch <sup>2</sup> |       | 253,817 ~ 290,076lbf / inch <sup>2</sup> |       |
| Cutting Diameter(inch) | RPM                                      | FEED  | RPM                                      | FEED  | RPM                                      | FEED  |
| 3/16                   | 13,440                                   | 45.40 | 6,000                                    | 41.60 | 5,760                                    | 39.40 |
| 1/4                    | 13,440                                   | 58.20 | 5,520                                    | 44.10 | 5,200                                    | 42.50 |
| 5/16                   | 10,080                                   | 71.50 | 4,480                                    | 39.40 | 4,240                                    | 36.20 |
| 3/8                    | 8,740                                    | 76.90 | 3,880                                    | 36.30 | 3,720                                    | 34.60 |
| 1/2                    | 6,720                                    | 66.20 | 3,480                                    | 35.60 | 3,320                                    | 33.00 |

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

Ae: D3/16~D1/4=.008  
D5/16~D1/2=.012  
Ap: 0.5 X D



Ae: D3/16~D5/16=.010  
D3/8~D1/2=.012  
Ap: 0.05 X D

ZAMUS CLASSIC > INCH