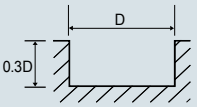
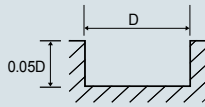


# TECHNICAL DATA | ZAMUS CLASSIC |

## ZR502A, ZR522A, ZR532A Series

| Feed Rate              | General Speed Cutting                  |      |                                             |      |                                             |      |                                |      |
|------------------------|----------------------------------------|------|---------------------------------------------|------|---------------------------------------------|------|--------------------------------|------|
| Work Material          | Carbon Steels, Alloy Steels, Cast Iron |      | Alloy Steels, Tool Steels                   |      | Hardened Steels                             |      |                                |      |
| Hardness               | $\leq 30 \text{ HRc}$                  |      | $30 \sim 38 \text{ HRc}$                    |      | $45 \sim 55 \text{ HRc}$                    |      | $55 \sim 65 \text{ HRc}$       |      |
| Strength               | $\sim 145,038 \text{ lbf / inch}^2$    |      | $145,038 \sim 174,046 \text{ lbf / inch}^2$ |      | $203,053 \sim 290,076 \text{ lbf / inch}^2$ |      | $290,076 \text{ lbf / inch}^2$ |      |
| Cutting Diameter(inch) | RPM                                    | FEED | RPM                                         | FEED | RPM                                         | FEED | RPM                            | FEED |
| 1/4                    | 2,630                                  | 4.90 | 2,100                                       | 4.20 | 1,370                                       | 2.00 | 1,160                          | 1.40 |
| 5/16                   | 2,000                                  | 5.30 | 1,580                                       | 4.20 | 1,050                                       | 2.00 | 840                            | 1.40 |
| 3/8                    | 1,680                                  | 5.30 | 1,370                                       | 4.20 | 840                                         | 2.00 | 670                            | 1.40 |
| 1/2                    | 1,370                                  | 4.20 | 1,160                                       | 3.80 | 700                                         | 1.50 | 550                            | 1.00 |

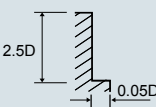
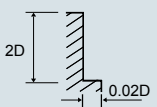
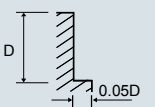
RPM = rev. / min.  
FEED = inch / min.

## ZR504A, ZR524A, ZR534A Series

| Feed Rate              | General Speed Cutting                  |      |                                             |      |                                             |      |                                |      |
|------------------------|----------------------------------------|------|---------------------------------------------|------|---------------------------------------------|------|--------------------------------|------|
| Work Material          | Carbon Steels, Alloy Steels, Cast Iron |      | Alloy Steels, Tool Steels                   |      | Hardened Steels                             |      |                                |      |
| Hardness               | $\leq 30 \text{ HRc}$                  |      | $30 \sim 50 \text{ HRc}$                    |      | $50 \sim 55 \text{ HRc}$                    |      | $55 \sim 65 \text{ HRc}$       |      |
| Strength               | $\sim 145,038 \text{ lbf / inch}^2$    |      | $145,038 \sim 174,046 \text{ lbf / inch}^2$ |      | $203,053 \sim 290,076 \text{ lbf / inch}^2$ |      | $290,076 \text{ lbf / inch}^2$ |      |
| Cutting Diameter(inch) | RPM                                    | FEED | RPM                                         | FEED | RPM                                         | FEED | RPM                            | FEED |
| 1/4                    | 2,630                                  | 8.50 | 2,100                                       | 7.10 | 1,370                                       | 3.30 | 1,160                          | 2.00 |
| 5/16                   | 2,000                                  | 9.00 | 1,580                                       | 7.10 | 1,050                                       | 3.30 | 840                            | 2.00 |
| 3/8                    | 1,680                                  | 9.00 | 1,370                                       | 7.10 | 840                                         | 3.30 | 670                            | 2.00 |
| 1/2                    | 1,370                                  | 7.10 | 1,160                                       | 6.30 | 700                                         | 2.80 | 550                            | 1.50 |

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

## ZR506A, ZR508A Series

| Feed Rate              | High Speed Cutting                     |        |                                |        |                                |       |
|------------------------|----------------------------------------|--------|--------------------------------|--------|--------------------------------|-------|
| Work Material          | Carbon Steels, Alloy Steels, Cast Iron |        | Alloy Steels, Tool Steels      |        | Hardened Steels                |       |
| Hardness               | $\leq 50 \text{ HRc}$                  |        | $50 \sim 60 \text{ HRc}$       |        | $60 \sim 65 \text{ HRc}$       |       |
| Strength               | $253,817 \text{ lbf / inch}^2$         |        | $253,817 \text{ lbf / inch}^2$ |        | $301,679 \text{ lbf / inch}^2$ |       |
| Cutting Diameter(inch) | RPM                                    | FEED   | RPM                            | FEED   | RPM                            | FEED  |
| 1/4                    | 16,800                                 | 240.00 | 8,400                          | 120.00 | 4,200                          | 58.00 |
| 5/16                   | 12,600                                 | 240.00 | 6,300                          | 120.00 | 3,200                          | 58.00 |
| 3/8                    | 10,000                                 | 235.00 | 5,000                          | 120.00 | 2,500                          | 58.00 |
| 1/2                    | 8,400                                  | 200.00 | 4,200                          | 100.00 | 2,100                          | 50.00 |
| 5/8                    | 6,300                                  | 150.00 | 3,150                          | 75.00  | 1,600                          | 37.00 |
| 3/4                    | 5,000                                  | 120.00 | 2,500                          | 58.00  | 1,260                          | 30.00 |

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

