

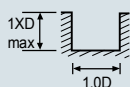
TECHNICAL DATA | ZAMUS SUS MATE |

XXB5xxA, XxE5xxA & XxR5xxA Series

Work Material	Low Carbon Steels				Medical Alloy Steels		Mold & Die Steels		Cast Iron Gray		Cast Iron Ductile	
Hardness	≤ 175 HB		≤ 275 HB		≤ 275 HB		≤ 275 HB		≤ 200 HB		≤ 300 HB	
Cutting Diameter(inch)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	FEED	RPM
1/8	15,585	12	12,835	10	10,695	8	5,500	4	14,515	11	7,335	5
3/16	10,360	20	8,560	17	7,150	14	3,670	8	9,690	19	4,880	9
1/4	7,795	24	6,420	20	5,350	17	2,750	8	7,260	23	3,665	11
5/16	6,235	29	5,135	24	4,280	20	2,200	10	5,805	27	2,935	14
3/8	5,195	39	4,280	32	3,565	27	1,835	13	4,840	36	2,445	18
7/16	4,455	38	3,665	31	3,055	26	1,570	13	4,145	35	2,095	18
1/2	3,895	37	3,210	30	2,675	25	1,375	13	3,630	34	1,835	17
9/16	3,465	35	2,850	29	2,375	24	1,220	12	3,225	32	1,630	16
5/8	3,115	33	2,565	27	2,140	23	1,100	11	2,905	31	1,465	15
3/4	2,600	31	2,140	25	1,785	21	915	11	2,420	29	1,220	14
1	1,950	25	1,605	21	1,335	17	690	9	1,815	24	915	12

Work Material	Cast Iron Malleable		Stainless 300 Series		Stainless 400 Series		Stainless PH Series		Titanium Alloys		High Temp Alloys	
Hardness	≤ 300 HB		≤ 275 HB		≤ 185 HB		≤ 232 HB		≤ 295 HB		≤ 300 HB	
Cutting Diameter(inch)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1/8	4,585	4	9,170	7	12,835	10	7,640	5	9,170	9	2,445	2
3/16	3,070	6	6,080	12	8,550	17	5,080	10	6,080	14	1,600	3
1/4	2,290	7	4,585	14	6,420	22	3,820	12	4,585	16	1,220	3
5/16	1,835	8	3,665	16	5,135	25	3,055	14	3,665	18	980	4
3/8	1,530	11	3,055	16	4,280	25	2,545	14	3,055	18	815	4
7/16	1,310	11	2,620	16	3,665	25	2,185	14	2,620	18	700	4
1/2	1,145	11	2,290	16	3,210	25	1,910	14	2,290	18	610	4
9/16	1,020	10	2,035	20	2,850	29	1,700	17	2,035	20	545	6
5/8	915	9	1,835	16	2,565	25	1,530	14	1,835	18	490	4
3/4	765	9	1,520	15	2,410	22	1,275	12	1,520	16	400	4
1	575	7	1,145	15	1,605	22	955	12	1,145	16	305	3

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

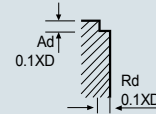
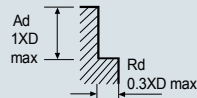
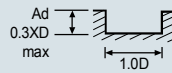


- ※ Use a rigid and precise machines and holders.
- ※ Use a suitable cutting oil.

TECHNICAL DATA | ZAMUS SUS MATE |

End Cutting / Feed Speed	Slotting		Side Milling		High Speed Cutting	
Work Material	Hardened Steels		Hardened Steels		Hardened Steels	
Hardness	30 ~ 45 HRc		30 ~ 45 HRc		30 ~ 45 HRc	
Cutting Diameter(inch)	RPM	FEED	RPM	FEED	RPM	FEED
1/8	6,573	16	6,573	16	17,121	75
3/16	4,382	16	4,382	16	11,414	78
1/4	3,287	17	3,287	17	8,561	75
5/16	2,629	17	2,629	17	6,848	77
3/8	2,191	17	2,191	17	5,707	75
7/16	1,878	17	1,878	17	4,892	76
1/2	1,643	16	1,643	16	4,280	75
9/16	1,461	16	1,461	16	3,805	75
5/8	1,315	16	1,315	16	3,424	75
3/4	1,096	17	1,096	17	2,854	75
1	822	16	822	16	2,140	73

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



- ※ Use a rigid and precise machines and holders.
- ※ Use a suitable cutting oil.