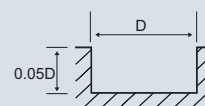
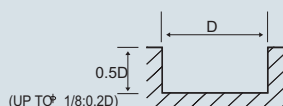


TECHNICAL DATA | ZAMUS CLASSIC |

ZA502 Series

Work Material	Carbon Steels, Alloy Steels, Cast Iron		Alloy Steels, Tool Steels		Stainless Steels		Hardened Steels			
Hardness	≤ 30 HRC		30 ~ 45 HRC		-		45 ~ 55 HRC		55 ~ 65 HRC	
Strength	~ 145,038 lbf / inch ²		145,038 ~ 217,557 lbf / inch ²		-		217,557 ~ 290,076 lbf / inch ²		290,076 lbf / inch ²	
Cutting Diameter(inch)	RPM		FEED		RPM		FEED		RPM	
1/16	11,560	7.50	7,560	4.70	6,300	3.55	5,040	1.40		
1/8	8,920	8.25	5,560	5.50	4,620	4.70	3,360	1.55	1,900	1.55
3/16	6,300	12.60	3,780	7.50	3,160	6.30	2,320	1.95	1,260	1.55
1/4	5,560	13.80	3,360	8.65	2,840	7.10	2,000	2.15	1,100	1.55
5/16	4,200	14.95	2,520	7.85	2,100	7.10	1,680	2.95	840	1.55
3/8	3,260	13.00	2,000	6.30	1,680	6.30	1,360	2.35	680	1.40
1/2	2,740	11.00	1,680	5.10	1,360	5.10	1,160	2.15	560	1.40
5/8	2,200	8.65	1,360	4.30	1,060	4.30	900	1.55	440	0.80
3/4	1,680	6.70	1,060	3.15	840	3.15	680	1.20	320	0.80
1	1,360	5.10	840	2.75	680	2.35	540	0.80	260	0.60

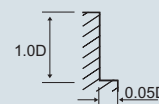
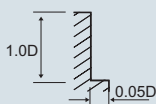
RPM = rev. / min.
FEED = inch / min.



ZA504 Series

Work Material	Carbon Steels, Alloy Steels, Cast Iron		Alloy Steels, Tool Steels		Stainless Steels		Hardened Steels			
Hardness	≤ 30 HRC		30 ~ 45 HRC		-		45 ~ 55 HRC		55 ~ 65 HRC	
Strength	~ 145,038 lbf / inch ²		145,038 ~ 217,557 lbf / inch ²		-		217,557 ~ 290,076 lbf / inch ²		290,076 lbf / inch ²	
Cutting Diameter(inch)	RPM		FEED		RPM		FEED		RPM	
1/16	11,560	11.00	7,560	6.70	6,300.00	5.50	5,040	1.95		
1/8	8,920	12.60	5,560	7.85	4,620.00	6.70	3,360	2.35	1,900	2.35
3/16	6,300	23.60	3,780	14.15	3,160.00	11.80	2,320	2.75	1,260	2.35
1/4	5,560	26.00	3,360	16.15	2,840.00	13.00	2,000	3.15	1,100	2.35
5/16	4,200	27.95	2,520	14.95	2,100.00	13.80	1,680	4.30	840	2.35
3/8	3,260	24.00	2,000	11.80	1,680.00	11.80	1,360	3.55	680	1.95
1/2	2,740	20.50	1,680	9.85	1,360.00	9.45	1,160	3.15	560	1.95
5/8	2,200	16.15	1,360	7.85	1,060.00	7.85	900	2.35	440	1.20
3/4	1,680	12.60	1,060	6.30	840.00	5.90	680	1.55	320	1.20
1	1,360	9.85	840	5.10	680.00	4.70	540	1.20	260	0.80

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

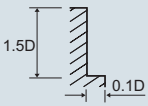
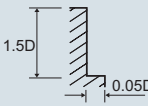
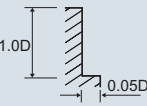
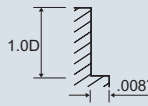


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ZA506 & ZA508 Series

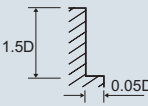
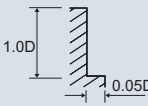
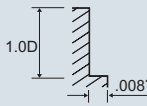
Feed Rate	General Speed Cutting							
Work Material	Carbon Steels, Alloy Steels, Cast Iron		Alloy Steels, Tool Steels		Hardened Steels			
Hardness	≤ 30 HRC		30 ~ 45 HRC		45 ~ 55 HRC		55 ~ 65 HRC	
Strength	~ 145,038lbf / inch ²		145,038 ~ 217,557lbf / inch ²		217,557 ~ 290,076lbf / inch ²		290,076lbf / inch ²	
Cutting Diameter(inch)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1/4	5,560	79.00	3,880	54.00	1,580	8.25	1,100	5.10
5/16	4,200	79.00	2,940	54.00	1,160	8.25	840	5.10
3/8	3,360	79.00	2,320	54.00	1,000	8.25	680	5.10
1/2	2,840	66.00	2,000	46.00	840	7.10	560	4.35
5/8	2,100	50.00	1,480	35.00	640	5.10	420	2.75
3/4	1,680	40.00	1,160	27.00	500	4.35	320	2.35
1	1,260	25.00	870	17.50	375	3.00	240	1.54

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

Feed Rate	High Speed Cutting					
Work Material	Carbon Steels, Tool Steels		Hardened Steels			
Hardness	≤ 50 HRC		50 ~ 60 HRC		≥ 65 HRC	
Strength	253,817lbf / inch ²		253,817 ~ 301,679lbf / inch ²		301,679lbf / 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	3,160	58.00
3/8	9,980	235.00	5,040	120.00	2,520	58.00
1/2	8,400	199.00	4,200	100.00	2,100	50.00
5/8	6,300	149.00	3,160	75.00	1,580	37.00
3/4	5,040	120.00	2,520	58.00	1,260	30.00
1	3,790	75.00	1,890	38.00	950	19.00

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

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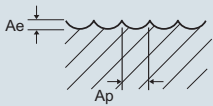
TECHNICAL DATA | ZAMUS CLASSIC |

ZA522 Series

Feed Rate	General Speed Cutting					
Work Material	Carbon Steels, Alloy Steels, Cast Iron		Alloy Steels, Tool Steels		Hardened Steels	
Hardness	≤ 30 HRC		30 ~ 45 HRC		45 ~ 55 HRC	
Strength	~ 145,038 lbf / inch ²		145,038 ~ 217,557 lbf / inch ²		217,557 ~ 290,076 lbf / inch ²	
Cutting Diameter(inch)	RPM	FEED	RPM	FEED	RPM	FEED
1/8	4,410	7.80	3,570	2.40	2,200	1.20
3/16	3,050	4.10	2,420	3.30	1,580	1.60
1/4	2,630	4.90	2,100	4.10	1,370	2.00
5/16	2,000	5.30	1,580	4.10	1,050	2.00
3/8	1,680	5.30	1,370	4.10	840	2.00
1/2	1,370	4.10	1,160	3.70	700	1.60
5/8	1,160	3.70	890	3.00	560	1.40
3/4	840	2.80	680	2.00	420	1.00
1	610	2.00	540	1.60	330	0.70

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

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

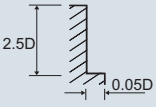
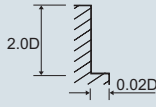


Ae: D3/16-D5/16=.010
D3/8-D1/2=.012
Ap: 0.1 X D

ZA524 Series

Feed Rate	General Speed Cutting							
Work Material	Carbon Steels, Alloy Steels, Cast Iron		Alloy Steels, Tool Steels		Hardened Steels			
Hardness	≤ 30 HRC		30 ~ 45 HRC		45 ~ 55 HRC		55 ~ 65 HRC	
Strength	~ 145,038 lbf / inch ²		145,038 ~ 217,557 lbf / inch ²		217,557 ~ 290,076 lbf / inch ²		290,076 lbf / inch ²	
Cutting Diameter(inch)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1/16	4,410	4.50	3,570	3.90	2,200	2.20	1,890	1.20
1/8	3,050	7.10	2,420	5.50	1,580	2.80	1,260	1.60
3/16	2,630	8.50	2,100	7.10	1,370	3.50	1,160	2.00
1/4	2,000	9.10	1,580	7.10	1,050	3.50	840	2.00
5/16	1,680	9.10	1,370	7.10	840	3.50	670	2.00
3/8	1,370	7.10	1,160	6.30	700	2.80	560	1.60
1/2	1,160	6.30	890	4.90	560	2.40	440	1.40
5/8	840	4.50	680	3.50	420	1.80	340	1.00
3/4	670	4.50	540	3.50	340	1.80	270	1.00
1	1,360	9.85	840	5.10	540	1.20	260	0.80

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

TECHNICAL DATA | ZAMUS CLASSIC |

ZA526 & ZA528 Series

Feed Rate	High Speed Cutting							
Work Material	Carbon Steels, Alloy Steels, Cast Iron		Alloy Steels, Tool Steels		Hardened Steels			
Hardness	≤ 40 HRC		40 ~ 50 HRC		50 ~ 60 HRC		60 ~ 65 HRC	
Strength	~ 181,298lbf / inch ²		181,298 ~ 253,817lbf / inch ²		253,817 ~ 301,679lbf / inch ²		301,679lbf / inch ²	
Cutting Diameter(inch)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1/4	2,230	19.00	1,670	14.00	1,390	10.00	1,110	8.00
5/16	1,670	18.00	1,250	13.00	1,050	9.50	840	7.00
3/8	1,330	17.00	1,000	12.00	840	9.00	680	6.30
1/2	1,110	16.00	840	11.00	690	8.50	560	6.00
5/8	840	13.00	630	9.00	530	6.50	420	5.00
3/4	670	11.00	500	8.00	420	6.00	320	4.70
1	540	9.50	400	6.50	340	5.00	270	3.70

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

