

TECHNICAL DATA | ZAMUS STAR |

ZSTNB20, ZSTNB30 Series

Work Material				Carbon Steels, Alloy Steels (180 ~ 250 HB)		Prehardened Steels (35 ~ 45 HRC)		Hardened Steels (45 ~ 55 HRC)		Hardened Steels (55 ~ 65 HRC)	
Ratio to standard depth of cut				Depth of Cut X 100%		Depth of Cut X 80%		Depth of Cut X 65%		Depth of Cut X 60%	
Cutting Diameter (metric)	Neck Length (metric)	Neck Angle(°)	Depth of Cut (metric)	n (min ⁻¹)	Vf (mm/min)	n (min ⁻¹)	Vf (mm/min)	n (min ⁻¹)	Vf (mm/min)	n (min ⁻¹)	Vf (mm/min)
0.2	1	0.4	0.017	40,000	800	28,000	504	26,000	416	26,000	364
0.2	1.5	0.4	0.009	40,000	800	28,000	504	26,000	416	26,000	364
0.2	2	0.9	0.007	32,000	461	22,400	323	20,800	266	20,800	233
0.2	2.5	0.9	0.004	26,000	333	18,200	204	16,900	189	16,900	162
0.3	2	0.4	0.025	40,000	1,200	28,000	756	26,000	624	26,000	546
0.3	3	0.9	0.013	32,000	691	22,400	484	20,800	399	20,800	349
0.3	4	0.9	0.010	26,000	499	18,200	306	16,900	284	16,900	243
0.4	2	0.4	0.035	40,000	1,600	28,000	1,008	26,000	832	26,000	728
0.4	3	0.4	0.020	40,000	1,600	28,000	1,008	26,000	832	26,000	728
0.4	4	0.4	0.007	32,000	922	22,400	645	20,800	532	20,800	466
0.4	4	0.9	0.009	32,000	922	22,400	645	20,800	532	20,800	466
0.4	5	0.4	0.006	26,000	666	18,200	408	16,900	379	16,900	324
0.4	5	0.9	0.007	26,000	666	18,200	408	16,900	379	16,900	324
0.5	4	0.4	0.040	40,000	2,000	28,000	1,260	26,000	1,040	26,000	910
0.5	8	0.9	0.010	26,000	728	18,200	446	16,900	414	16,900	355
0.5	12	0.9	0.005	22,400	627	15,680	384	14,560	357	14,560	306
0.54	2	0.4	0.050	40,000	2,160	28,000	1,361	26,000	1,123	26,000	983
0.54	4	0.4	0.037	40,000	2,160	28,000	1,361	26,000	1,123	26,000	983
0.54	5	0.4	0.031	40,000	1,512	28,000	1,176	26,000	1,040	26,000	832
0.54	6	0.4	0.025	26,000	1,244	18,200	871	16,900	676	16,900	629
0.54	6.5	0.4	0.020	26,000	1,011	18,200	619	16,900	575	16,900	493
0.54	7	0.4	0.015	26,000	899	18,200	585	16,900	543	16,900	465
0.6	2	0.4	0.055	40,000	2,400	28,000	1,512	26,000	1,248	26,000	1,092
0.6	4	0.4	0.035	40,000	2,400	28,000	1,512	26,000	1,248	26,000	1,092
0.6	6	0.4	0.018	32,000	1,382	22,400	968	20,800	799	20,800	699
0.6	6	0.9	0.020	32,000	1,382	22,400	968	20,800	799	20,800	699
0.6	8	0.9	0.020	26,000	998	18,200	612	16,900	568	16,900	487
0.6	10	0.4	0.013	26,000	874	18,200	535	16,900	497	16,900	426
0.6	10	0.9	0.015	26,000	874	18,200	535	16,900	497	16,900	426
0.6	12	0.9	0.010	26,000	874	18,200	535	16,900	497	16,900	426
0.6	15	0.4	0.005	22,400	753	15,680	461	14,560	367	14,560	367
0.6	15	0.9	0.006	22,400	753	15,680	461	14,560	367	14,560	367
0.8	4	0.4	0.062	32,000	2,560	22,400	1,613	20,800	1,331	20,800	1,165
0.8	6	0.4	0.045	32,000	2,560	22,400	1,613	20,800	1,331	20,800	1,165
0.8	8	0.9	0.026	25,600	1,475	17,920	1,032	16,640	852	16,640	745
0.8	12	0.9	0.020	20,800	1,065	14,560	699	13,520	606	13,520	519
0.8	16	0.9	0.018	20,800	932	14,560	612	13,520	530	13,520	454
0.9	4	0.4	0.063	28,300	2,547	19,810	1,605	18,395	1,324	18,395	1,159
0.9	8	0.4	0.050	28,300	2,547	19,810	1,605	18,395	1,324	18,395	1,159
0.9	12	0.4	0.037	18,400	1,325	12,880	811	11,960	753	11,960	646
0.9	16	0.4	0.024	18,400	1,325	12,880	811	11,960	753	11,960	646
0.9	18	0.4	0.018	18,400	1,325	12,880	811	11,960	753	11,960	646
0.9	20	0.4	0.015	15,850	1,141	11,095	699	10,303	649	10,303	556
0.9	22	0.4	0.012	15,850	1,141	11,095	699	10,303	649	10,303	556
0.9	24	0.4	0.009	14,150	1,019	9,905	624	9,198	579	9,198	497
1	6	0.4	0.055	25,600	2,560	17,920	1,613	16,640	1,331	16,640	1,165
1	8	0.4	0.055	25,600	2,560	17,920	1,613	16,640	1,331	16,640	1,165
1	10	0.4	0.032	20,800	1,872	14,560	1,310	13,520	1,082	13,520	946
1	10	0.9	0.035	20,800	1,872	14,560	1,310	13,520	1,082	13,520	946
1	15	0.9	0.028	16,640	1,331	11,648	874	10,816	757	10,816	649
1	20	0.4	0.018	16,640	1,331	11,648	874	10,816	757	10,816	649