

TECHNICAL DATA | ZAMUS CLASSIC |

DB542, DB522 Series

Feed Rate	General Speed Cutting					
Work Material	Non-Alloyed Steels, Alloy Steels, Cast Iron		Alloy Steels, Heat Resistant Steels		Hardened Steels	
Hardness	≤ 30 HRc		30 ~ 40 HRc		40 ~ 55 HRc	
Strength	~ 1000N / mm ²		1000 ~ 1250N / mm ²		1500N / mm ²	
Cutting Diameter(metric)	RPM	FEED	RPM	FEED	RPM	FEED
1	16,500	290	13,300	230	6,100	105
1.5	16,500	405	12,700	310	5,590	140
2	15,100	865	11,200	565	4,900	175
2.5	15,100	865	11,200	565	4,900	175
3	13,800	780	10,500	530	4,750	175
4	11,000	850	8,800	610	4,410	205
5	9,600	945	7,600	665	3,860	205
6	8,900	1,150	7,200	955	3,340	220
8	7,500	1,500	6,050	1,060	2,590	255
10	6,700	1,750	5,300	1,170	2,140	260
12	6,150	2,000	4,900	1,280	1,840	280
16	5,000	1,950	3,900	1,220	1,420	280
20	4,350	1,900	3,400	1,200	1,170	290

RPM = rev. / min.
FEED = mm / min.

Ae : D1~D6=0.2mm
D8~D20=0.3mm
Ap : 0.2XD



Ae : D1~D6=0.2mm
D8~D20=0.3mm
Ap : 0.1XD

Feed Rate	High Speed Cutting			
Work Material	Non-Alloyed Steels, Alloy Steels, Cast Iron		Alloy Steels, Heat Resistant Steels	
Hardness	≤ 45 HRc		30 ~ 40 HRc	
Strength	~ 1500N / mm ²		1500 ~ 2000N / mm ²	
Cutting Diameter(metric)	RPM	FEED	RPM	FEED
1	26,000	1,500	26,000	920
1.5	24,000	1,600	24,000	990
2	22,000	1,700	22,000	1,080
2.5	22,000	2,000	20,000	1,130
3	22,000	2,300	17,800	1,200
4	22,000	3,350	14,300	1,300
5	22,000	4,150	12,600	1,380
6	22,000	4,600	11,000	1,440
8	17,500	4,600	8,800	1,440
10	14,700	4,450	7,350	1,380
12	12,800	4,450	6,400	1,330
16	10,000	4,000	5,000	1,150
20	8,350	3,650	4,150	1,060

RPM = rev. / min.
FEED = mm / min.

Ae : D1~D6=0.2mm
D8~D20=0.3mm
Ap : 0.2XD

