

# TECHNICAL DATA | ZAMUS GRA MATE |

## MATERIAL : GRAPHITE

Endmill dia.(Metric)	Machine speed(rpm)	Cutting speed(m/min)	Operation	Feed rate(mpt)
0.5	20,000 ~ 40,000	24.4 ~ 48.8	Finishing	0.0002 ~ 0.0005
1.0	18,000 ~ 40,000	45.7 ~ 91.5	Finishing	0.0128 ~ 0.0257
1.5	12,000 ~ 40,000	53.4 ~ 182.9	General	0.0257 ~ 0.0514
1.5	12,000 ~ 40,000	53.4 ~ 182.9	Finishing	0.0128 ~ 0.0257
3.0	6,000 ~ 40,000	61.0 ~ 403.9	General	0.0257 ~ 0.0514
3.0	6,000 ~ 40,000	61.0 ~ 403.9	Finishing	0.0128 ~ 0.0257
5.0	4,000 ~ 40,000	61.0 ~ 548.8	General	0.0257 ~ 0.0514
5.0	4,000 ~ 40,000	61.0 ~ 548.8	Finishing	0.0128 ~ 0.0257
6.0	3,000 ~ 36,700	61.0 ~ 716.5	General	0.0514 ~ 0.1028
6.0	3,000 ~ 36,700	61.0 ~ 716.5	Finishing	0.0257 ~ 0.0514
8.0	2,500 ~ 31,800	61.0 ~ 792.7	General	0.0514 ~ 0.1028
8.0	2,500 ~ 31,800	61.0 ~ 792.7	Finishing	0.0257 ~ 0.0514
10.0	2,000 ~ 28,500	61.0 ~ 853.6	General	0.0771 ~ 0.1280
10.0	2,000 ~ 28,500	61.0 ~ 853.6	Finishing	0.0257 ~ 0.0771
12.0	1,500 ~ 23,000	61.0 ~ 914.6	General	0.0771 ~ 0.1280
12.0	1,500 ~ 23,000	61.0 ~ 914.6	Finishing	0.0257 ~ 0.0771

## MATERIAL : GREEN CERAMIC

Endmill dia.(Metric)	Machine speed(rpm)	Cutting speed(m/min)	Operation	Feed rate(mpt)
0.5	6,000 ~ 19,500	7.6 ~ 21.3	Finishing	0.0002 ~ 0.0005
1.0	6,000 ~ 19,500	15.2 ~ 45.7	Finishing	0.0128 ~ 0.0257
1.5	6,000 ~ 19,500	30.5 ~ 91.5	General	0.0257 ~ 0.0514
1.5	6,000 ~ 19,500	30.5 ~ 91.5	Finishing	0.0128 ~ 0.0257
3.0	4,800 ~ 16,000	61.0 ~ 213.4	General	0.0257 ~ 0.0514
3.0	4,800 ~ 16,000	61.0 ~ 213.4	Finishing	0.0128 ~ 0.0257
5.0	4,100 ~ 15,000	61.0 ~ 213.4	General	0.0257 ~ 0.0514
5.0	4,100 ~ 15,000	61.0 ~ 213.4	Finishing	0.0128 ~ 0.0257
6.0	3,000 ~ 12,000	61.0 ~ 243.9	General	0.0514 ~ 0.1028
6.0	3,000 ~ 12,000	61.0 ~ 243.9	Finishing	0.0257 ~ 0.0514
8.0	2,500 ~ 11,000	61.0 ~ 274.4	General	0.0514 ~ 0.1028
8.0	2,500 ~ 11,000	61.0 ~ 274.4	Finishing	0.0257 ~ 0.0514
10.0	2,000 ~ 10,800	61.0 ~ 304.9	General	0.0771 ~ 0.1280
10.0	2,000 ~ 10,800	61.0 ~ 304.9	Finishing	0.0257 ~ 0.0771
12.0	1,500 ~ 10,000	61.0 ~ 304.9	General	0.0771 ~ 0.128
12.0	1,500 ~ 10,000	61.0 ~ 304.9	Finishing	0.0257 ~ 0.0771

## MATERIAL: GLASS FIBER PRODUCTS

Endmill dia.(Metric)	Machine speed(rpm)	Cutting speed(m/min)	Operation	Feed rate(mpt)
1.5	3,700 ~ 7,300	18.3 ~ 36.6	General	0.0257 ~ 0.002
1.5	5,200 ~ 10,400	26.2 ~ 51.8	Finishing	0.0128 ~ 0.0257
3.0	3,600 ~ 7,300	36.6 ~ 73.2	General	0.0128 ~ 0.0257
3.0	5,200 ~ 9,200	51.8 ~ 91.5	Finishing	0.0064 ~ 0.1285
5.0	4,100 ~ 7,100	61.0 ~ 106.7	General	0.0257 ~ 0.0514
5.0	6,100 ~ 10,200	91.5 ~ 152.4	Finishing	0.0128 ~ 0.0257
6.0	4,600 ~ 6,900	91.5 ~ 137.2	General	0.0257 ~ 0.0514
6.0	5,300 ~ 8,400	106.7 ~ 167.7	Finishing	0.0128 ~ 0.0257
8.0	4,300 ~ 6,100	106.7 ~ 152.4	General	0.0257 ~ 0.0514
8.0	4,300 ~ 7,300	106.7 ~ 182.9	Finishing	0.0128 ~ 0.0257
10.0	4,100 ~ 5,600	121.9 ~ 167.7	General	0.0514 ~ 0.1028
10.0	3,500 ~ 6,600	106.7 ~ 198.2	Finishing	0.0257 ~ 0.0514
12.0	3,400 ~ 4,600	137.2 ~ 182.9	General	0.0514 ~ 0.1028
12.0	2,600 ~ 5,700	106.7 ~ 228.7	Finishing	0.0257 ~ 0.0514