

# TECHNICAL DATA | ZAMUS STAR |

## ZR732 Series

End Cutting	Slotting												
Work Material	Hardened Steels Heat Resistant Steels		Hardened Steels										
	Hardness		30 ~ 40 HRc		40 ~ 50 HRc		50 ~ 55 HRc		55 ~ 60 HRc		60 ~ 65 HRc		65 ~ 70 HRc
Cutting Diameter(metric)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	
2	33,300	680	26,000	544	17,500	336	14,500	208	11,000	128	9,500	92	
3	21,800	680	17,300	544	11,500	336	9,500	208	7,500	128	6,400	92	
4	16,700	704	13,200	560	8,800	352	7,200	216	5,600	136	4,750	94	
5	15,700	800	12,500	644	8,300	400	6,400	228	5,100	144	4,450	106	
6	13,100	760	10,350	616	6,900	384	5,300	224	4,200	144	3,700	104	
8	9,880	744	7,800	576	5,200	356	4,000	204	3,200	132	2,800	96	
10	7,800	680	6,150	544	4,100	332	3,200	192	2,550	124	2,200	90	
12	6,650	680	5,250	544	3,500	332	2,650	192	2,100	124	1,860	90	
16	4,900	584	3,900	464	2,600	292	2,000	168	1,600	108	1,400	78	
20	3,900	528	3,100	420	2,050	268	1,600	168	1,300	100	1,100	70	

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

End Cutting	Side Milling												
Work Material	Hardened Steels Heat Resistant Steels		Hardened Steels										
	Hardness		30 ~ 40 HRc		40 ~ 50 HRc		50 ~ 55 HRc		55 ~ 60 HRc		60 ~ 65 HRc		65 ~ 70 HRc
Cutting Diameter(metric)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	
2	33,300	960	26,000	776	17,500	480	14,500	296	11,000	184	9,500	132	
3	21,800	960	17,300	776	11,500	480	9,500	296	7,500	184	6,400	132	
4	16,700	1,000	13,200	800	8,800	500	7,200	308	5,600	192	4,750	136	
5	15,700	1,160	12,500	920	8,300	568	6,400	328	5,100	208	4,450	152	
6	13,100	1,080	10,350	880	6,900	552	5,300	320	4,200	204	3,700	148	
8	9,880	1,056	7,800	824	5,200	508	4,000	292	3,200	188	2,800	136	
10	7,800	960	6,150	776	4,100	472	3,200	272	2,550	176	2,200	128	
12	6,650	960	5,250	776	3,500	472	2,650	272	2,100	176	1,860	128	
16	4,900	840	3,900	672	2,600	416	2,000	240	1,600	152	1,400	112	
20	3,900	760	3,100	600	2,050	380	1,600	220	1,300	140	1,100	100	

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