

TECHNICAL DATA | ZAMUS CLASSIC |

DB514 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
3	13,100	1,020	10,000	690	4,520	220
4	10,500	1,110	8,400	800	4,200	270
5	9,140	1,230	7,300	870	3,680	270
6	7,780	1,260	6,300	950	3,160	280
8	5,260	1,430	4,420	990	2,100	280
10	4,620	1,530	3,780	1,070	1,780	280
12	3,780	1,350	2,940	990	1,360	280
16	2,740	1,380	2,320	980	1,160	280
20	2,100	1,260	1,900	950	840	280

<p>RPM = rev. / min. FEED = mm / min.</p> <p>Ae: D1~D6=0.2mm D8~D20=0.3mm Ap: 0.2 X D</p>		<p>Ae: D1~D6=0.2mm D8~D20=0.3mm Ap: 0.1 X D</p>
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Feed Rate	General 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

<p>RPM = rev. / min. FEED = mm / min.</p> <p>Ae: D1~D6=0.2mm D8~D20=0.3mm Ap: 0.05 X D</p>	
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