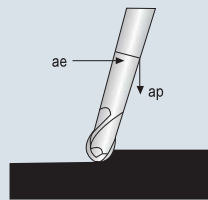


TECHNICAL DATA | ZAMUS CLASSIC |

DB532 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	35,000	2,800	33,000	2,600	12,000	900
4	26,000	2,300	25,000	2,200	9,000	800
5	21,000	2,100	20,000	2,000	7,000	700
6	17,000	1,900	16,000	1,800	6,000	650
8	13,000	1,700	12,000	1,600	4,500	550
10	10,500	1,450	10,000	1,400	3,500	500
12	9,000	1,400	8,000	1,300	3,000	450
16	6,000	1,200	5,500	1,100	2,000	400

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

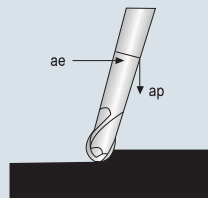


$$ae = 0.05 \times d1$$

$$ap = 0.02 \times d1$$

Feed Rate	High 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	47,000	3,700	44,000	3,500	17,000	1,400
4	35,000	3,200	33,000	3,000	13,000	1,200
5	28,000	2,800	27,000	2,600	10,000	1,100
6	23,000	2,600	22,000	2,400	8,000	950
8	18,000	2,300	17,000	2,100	6,000	850
10	14,000	2,000	13,000	1,900	5,000	750
12	12,000	1,800	11,000	1,800	4,000	700
16	9,000	1,600	8,000	1,500	3,300	600

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



$$ae = 0.05 \times d1$$

$$ap = 0.02 \times d1$$