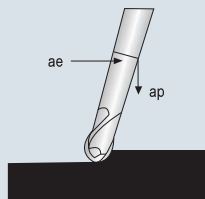


# TECHNICAL DATA | ZAMUS CLASSIC |

## DB534 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 <sup>2</sup>                   |       | 1000 ~ 1250N / mm <sup>2</sup>      |       | 1500N / mm <sup>2</sup> |       |
| Cutting Diameter(metric) | RPM   | FEED  | RPM                                 | FEED  | RPM                     | FEED  |
| 5                        | 21,000                                      | 4,000 | 20,000                              | 4,000 | 7,000                   | 1,400 |
| 6                        | 17,000                                      | 4,000 | 16,000                              | 3,500 | 6,000                   | 1,300 |
| 8                        | 13,000                                      | 3,500 | 12,000                              | 3,000 | 4,500                   | 1,100 |
| 10                       | 10,500                                      | 3,000 | 10,000                              | 2,500 | 3,500                   | 1,000 |
| 12                       | 9,000                                       | 2,800 | 8,000                               | 2,500 | 3,000                   | 950   |
| 16                       | 6,000                                       | 2,800 | 5,500                               | 2,200 | 2,000                   | 800   |

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

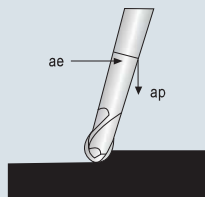


$$ae = 0.05 \times d1$$

$$ap = 0.02 \times d1$$

| 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 <sup>2</sup>                   |       | 1000 ~ 1250N / mm <sup>2</sup>      |       | 1500N / mm <sup>2</sup> |       |
| Cutting Diameter(metric) | RPM   | FEED  | RPM                                 | FEED  | RPM                     | FEED  |
| 5                        | 28,000                                      | 5,600 | 27,000                              | 5,300 | 11,000                  | 2,100 |
| 6                        | 23,000                                      | 5,100 | 22,000                              | 4,900 | 9,000                   | 1,900 |
| 8                        | 18,000                                      | 4,600 | 17,000                              | 4,300 | 7,000                   | 1,700 |
| 10                       | 14,000                                      | 3,900 | 13,000                              | 3,700 | 5,000                   | 1,400 |
| 12                       | 12,000                                      | 3,700 | 11,000                              | 3,500 | 4,500                   | 1,300 |
| 16                       | 9,000                                       | 3,100 | 8,000                               | 3,000 | 3,300                   | 1,100 |

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



$$ae = 0.05 \times d1$$

$$ap = 0.02 \times d1$$