

# TECHNICAL DATA | ZAMUS CLASSIC |

## WB712 Series

Feed Rate	Slotting								
Work Material	Non-Alloyed Steels, Alloy Steels, Cast Iron			Alloy Steels, Heat Resistant Steels			Hardened Steels		
Hardness	≤ 30 HRc			30 ~ 45 HRc			45 ~ 55 HRc		
Strength	~ 1000N / mm <sup>2</sup>			1000 ~ 1500N / mm <sup>2</sup>			1500 ~ 2000N / mm <sup>2</sup>		
Cutting Diameter(metric)	RPM	FEED	Ae (mm)	RPM	FEED	Ae (mm)	RPM	FEED	Ae (mm)
0.5	33000~42000	200~540	0.023~0.045	24000~30000	100~300	0.023~0.045	15000~19000	100~200	0.005~0.009
0.6	33000~42000	250~700	0.027~0.054	24000~30000	120~385	0.027~0.054	15000~19000	120~250	0.005~0.011
0.8	33000~42000	250~700	0.036~0.072	24000~30000	120~385	0.036~0.072	15000~19000	120~250	0.007~0.014
1.0	30000~38000	275~770	0.045~0.090	22000~27000	140~420	0.045~0.090	13500~17500	140~280	0.009~0.018
1.2	25000~32000	275~860	0.055~0.100	18000~23000	140~430	0.055~0.100	11500~14500	140~280	0.010~0.022
1.4	22000~27000	275~860	0.062~0.125	16000~19000	140~430	0.062~0.125	10000~12500	140~280	0.012~0.025
1.5	20000~25000	275~860	0.070~0.135	14500~18500	140~430	0.070~0.135	9500~11500	140~280	0.014~0.028
1.6	19000~25000	275~860	0.075~0.145	14000~17500	140~430	0.075~0.145	9000~10000	140~280	0.015~0.030
1.8	18000~23000	275~860	0.080~0.160	12500~16000	140~430	0.080~0.160	8000~10000	140~280	0.016~0.032
2.0	16000~20000	275~860	0.090~0.180	11500~14500	140~430	0.090~0.180	7500~9000	140~280	0.018~0.035
3.0	11000~14000	275~860	0.135~0.270	7500~9500	140~430	0.135~0.270	5000~6000	140~280	0.028~0.055
4.0	9000~12000	275~860	0.180~0.360	6100~8200	140~430	0.180~0.360	4000~5000	140~280	0.035~0.070

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

