

TECHNICAL DATA | ZAMUS SUS MATE |

DS502 Series

Feed Rate		General Speed Cutting										
Work Material	Carbon Steels, Cast Iron		Alloy Steels Prehardened Steels		Hardened Steels				Stainless Steels		Nickel Alloy Titanium Alloys	
Hardness	150~250HB		25~35HRc		35~45HRc		45~55HRc		SUS304, 316		-	
Cutting Diameter(metric)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2	19,100	770	12,800	370	10,200	270	8,900	190	8,900	210	6,400	120
4	10,800	1,100	7,200	550	5,700	400	5,000	280	5,000	310	3,600	180
6	7,700	1,300	5,200	660	4,100	480	3,600	330	3,600	380	2,600	210
8	6,000	1,400	4,000	700	3,200	510	2,800	360	2,800	400	2,000	230
10	4,800	1,400	3,200	700	2,600	520	2,300	370	2,300	410	1,600	230
12	4,000	1,400	2,700	710	2,200	530	1,900	370	1,900	410	1,400	240

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

Feed Rate		General Speed Cutting								
Work Material	Carbon Steels, Cast Iron		Alloy Steels Prehardened Steels		Hardened Steels				Stainless Steels	
Hardness	150~250HB		25~35HRc		35~45HRc		45~55HRc		SUS304, 316	
Cutting Diameter(metric)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2	51,000	2,100	29,800	1,300	35,700	960	23,700	640	35,700	960
4	2,550	2,700	19,900	1,700	17,900	1,300	11,900	830	17,900	1,300
6	17,000	3,000	13,300	1,900	11,900	1,400	7,900	920	11,900	1,400
8	12,800	3,100	10,000	2,000	9,000	1,500	6,000	960	9,000	1,500
10	10,200	3,100	8,000	2,000	7,200	1,500	4,800	960	7,200	1,500
12	8,500	3,100	6,700	2,000	6,000	1,500	4,000	960	6,000	1,500

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