

TECHNICAL DATA | ZAMUS THUNDER |

TX204, TX224 & TX304 Series

Work Material	Non-Alloyed Steels Alloy Steels, Cast Iron		Alloy Steels, Heat Resistant Steels		Stainless Series		Cast Iron		Aluminum Alloy		Copper, Brass Nonferrous Metals	
Hardness	≤ 30 HRC		30 ~ 45 HRC		-		-		-		-	
Strength	~ 1000N / mm ²		1000 ~ 1500N / mm ²		-		-		-		-	
Cutting Diameter(metric)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1	17,600	150	10,250	85	8,650	75	18,700	620	44,000	1,050	24,700	605
1,5	11,800	215	7,050	115	7,050	120	12,100	620	27,500	1,160	20,300	910
2	9,850	240	6,450	145	5,350	120	9,350	640	22,000	1,320	16,500	1,035
3	7,600	270	4,750	170	3,950	145	6,050	640	15,400	1,320	11,000	1,035
4	6,450	485	3,950	300	3,300	240	4,600	640	11,000	1,320	8,800	1,035
5	5,350	510	3,200	305	2,700	255	3,650	640	9,150	1,320	6,800	1,035
6	4,750	560	2,850	350	2,400	280	2,950	770	7,600	1,430	5,700	1,100
8	3,550	605	2,150	325	1,800	300	2,200	815	5,700	1,430	4,400	1,100
10	2,750	520	1,700	255	1,450	255	1,850	860	4,600	1,430	3,400	1,100
12	2,350	440	1,450	215	1,150	205	1,450	900	3,750	1,430	2,850	1,100
14	2,100	395	1,300	195	1,080	190	1,300	945	3,300	1,430	2,400	1,100
16	1,850	350	1,150	170	950	170	1,100	970	2,850	1,430	2,200	1,100
20	1,450	270	900	135	700	130	900	1,035	2,200	1,430	1,700	1,100

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

