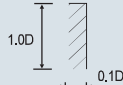
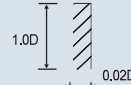


TECHNICAL DATA | ZAMUS THUNDER |

ZE304, ZE324 Series

| Feed Rate | General Speed Cutting | | | | | | | |
|--------------------------|--|------|--------------------------------|------|--------------------------------|------|------------------|------|
| Work Material | Alloy Steels, Heat Resistant Steels | | Hardened Steels | | | | Stainless Series | |
| Hardness | ≤ 30 HRc | | 30 ~ 45 HRc | | 45 ~ 55 HRc | | - | |
| Strength | ~ 1000N / mm ² | | 1000 ~ 1500N / mm ² | | 1500 ~ 2000N / mm ² | | - | |
| Cutting Diameter(metric) | RPM | FEED | RPM | FEED | RPM | FEED | RPM | FEED |
| 2 | 12,100 | 320 | 7,900 | 195 | 2,700 | 47 | 6,600 | 160 |
| 3 | 9,400 | 370 | 5,840 | 230 | 2,000 | 58 | 4,850 | 195 |
| 4 | 7,900 | 655 | 4,850 | 405 | 1,500 | 58 | 4,070 | 320 |
| 5 | 6,600 | 690 | 3,970 | 415 | 1,300 | 58 | 3,320 | 345 |
| 6 | 5,830 | 760 | 3,530 | 470 | 1,150 | 58 | 2,980 | 380 |
| 8 | 4,410 | 815 | 2,650 | 435 | 880 | 58 | 2,200 | 405 |
| 10 | 4,320 | 700 | 2,100 | 345 | 720 | 46 | 1,760 | 345 |
| 12 | 2,880 | 600 | 1,760 | 290 | 590 | 46 | 1,430 | 275 |
| 16 | 2,310 | 470 | 1,430 | 230 | 460 | 29 | 1,150 | 230 |
| 20 | 1,760 | 370 | 1,110 | 185 | 340 | 29 | 880 | 175 |
| 25 | 1,430 | 290 | 880 | 150 | 270 | 23 | 715 | 140 |

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

| Feed Rate | High Speed Cutting | | | | | | | |
|--------------------------|--|-------|--------------------------------|-------|--------------------------------|------|------------------|-------|
| Work Material | Alloy Steels, Heat Resistant Steels | | Hardened Steels | | | | Stainless Series | |
| Hardness | ≤ 30 HRc | | 30 ~ 45 HRc | | 45 ~ 55 HRc | | - | |
| Strength | ~ 1000N / mm ² | | 1000 ~ 1500N / mm ² | | 1500 ~ 2000N / mm ² | | - | |
| Cutting Diameter(metric) | RPM | FEED | RPM | FEED | RPM | FEED | RPM | FEED |
| 2 | 31,400 | 1,230 | 23,500 | 520 | 12,600 | 275 | 21,600 | 465 |
| 3 | 19,300 | 1,210 | 13,600 | 735 | 8,900 | 390 | 13,500 | 660 |
| 4 | 18,100 | 1,330 | 12,600 | 865 | 7,090 | 465 | 11,800 | 775 |
| 5 | 16,400 | 1,310 | 11,100 | 1,010 | 6,040 | 530 | 10,300 | 910 |
| 6 | 14,400 | 1,380 | 9,900 | 1,100 | 5,300 | 580 | 9,100 | 990 |
| 8 | 11,000 | 1,430 | 7,600 | 1,090 | 3,990 | 575 | 6,900 | 990 |
| 10 | 8,500 | 1,380 | 5,880 | 1,110 | 3,150 | 580 | 5,420 | 1,000 |
| 12 | 7,200 | 1,380 | 5,040 | 1,090 | 2,620 | 575 | 4,600 | 985 |
| 16 | 5,700 | 1,320 | 3,990 | 1,010 | 2,000 | 535 | 3,590 | 910 |
| 20 | 4,400 | 1,270 | 3,150 | 930 | 1,580 | 490 | 2,840 | 840 |
| 25 | 3,500 | 1,170 | 2,520 | 755 | 1,260 | 390 | 2,270 | 680 |

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

