

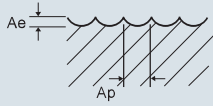
# TECHNICAL DATA | ZAMUS CLASSIC |

## DA512 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		45 ~ 65 HRC	
Strength	145,038 lbf / inch <sup>2</sup>		145,038 ~ 181,298 lbf / inch <sup>2</sup>		217,557 lbf / inch <sup>2</sup>	
Cutting Diameter(inch)	RPM	FEED	RPM	FEED	RPM	FEED
1/32	15,760	9.80	12,720	7.80	5,800	3.80
1/16	15,760	13.80	12,140	1.60	5,320	4.70
3/32	14,400	29.50	10,700	19.30	4,680	5.90
1/8	13,100	26.70	10,000	18.10	4,520	5.90
3/16	9,140	32.30	7,300	22.80	3,680	7.10
1/4	7,780	33.00	6,300	24.80	3,160	7.50
5/16	5,260	37.50	4,420	26.00	2,100	7.50
3/8	4,620	40.10	3,780	28.00	1,780	7.50
1/2	3,780	35.40	2,940	26.00	1,360	7.50
5/8	2,740	36.20	2,320	26.00	1,160	7.50
3/4	2,100	33.00	1,900	25.00	840	7.50

RPM = rev. / min.  
FEED = inch / min.

Ae: D1/32~D1/4=.008inch  
D5/16~D3/4=.012inch  
Ap: 0.2 X D



Ae: D1/32~D1/4=.008inch  
D5/16~D3/4=.012inch  
Ap: 0.1 X D

Feed Rate		High Speed Cutting			
Work Material	Non-Alloyed Steels, Alloy Steels, Cast Iron			Hardened Steels	
Hardness	≤ 45 HRC			45 ~ 65 HRC	
Strength	~ 217,557 lbf / inch <sup>2</sup>			217,557 lbf / inch <sup>2</sup>	
Cutting Diameter(inch)	RPM	FEED	RPM	FEED	
1/32	25,000	25.60	12,720	15.70	
1/16	23,000	27.50	12,140	16.90	
3/32	21,000	34.60	10,700	19.30	
1/8	21,000	39.40	10,000	20.50	
3/16	21,000	70.90	7,300	23.60	
1/4	21,000	90.90	6,300	24.80	
5/16	15,760	111.80	4,420	29.10	
3/8	13,660	120.00	3,780	33.00	
1/2	10,500	103.50	2,940	33.00	
5/8	8,200	103.50	2,320	28.00	
3/4	6,300	99.00	1,900	20.80	

RPM = rev. / min.  
FEED = inch / min.

Ae: D1/32~D1/4=.008 inch  
D5/16~D3/4=.012 inch  
Ap: 0.05 X D

