

TECHNICAL DATA | ZAMUS CLASSIC |

DA542 Series

Feed Rate		General Speed Cutting				
Work Material	Alloy Steels, Heat Resistant Steels		Hardened Steels			
Hardness	30 ~ 40 HRc		45 ~ 50 HRc		50 ~ 55 HRc	
Strength	145,038 ~ 181,298lbf / inch ²		217,557 ~ 253,817lbf / inch ²		253,817 ~ 290,076lbf / inch ²	
Cutting Diameter(inch)	RPM	FEED	RPM	FEED	RPM	FEED
1/16	9,000	8.30	13,800	19.90	13,600	17.90
1/8	8,000	14.60	10,200	34.60	9,800	33.50
3/16	5,840	18.10	7,500	34.60	7,200	33.50
1/4	5,040	19.70	6,900	36.20	6,500	34.60
5/16	3,540	20.90	5,600	33.10	5,300	31.50
3/8	3,020	22.40	4,850	31.50	4,650	30.30
1/2	2,350	20.90	4,350	31.50	4,150	30.30

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

Ae: D1/16~D1/4=.008
D5/16~D1/2=.012
Ap: 0.2 X D

Ae: D1/16~D1/8=0.05 X D
D3/16~D5/16=.010
D3/8~D1/2=.012
Ap: 0.1 X D

Feed Rate		High Speed Cutting				
Work Material	Alloy Steels, Heat Resistant Steels		Hardened Steels			
Hardness	30 ~ 40 HRc		45 ~ 50 HRc		50 ~ 55 HRc	
Strength	145,038 ~ 181,298lbf / inch ²		217,557 ~ 253,817lbf / inch ²		253,817 ~ 290,076lbf / inch ²	
Cutting Diameter(inch)	RPM	FEED	RPM	FEED	RPM	FEED
1/16	18,400	21.90	13,800	28.90	13,600	30.10
1/8	16,800	31.50	10,200	55.10	9,800	51.20
3/16	16,800	56.70	7,500	52.00	7,200	49.20
1/4	16,800	72.80	6,900	55.10	6,500	53.10
5/16	12,600	89.40	5,600	49.20	5,300	45.30
3/8	10,930	96.10	4,850	45.30	4,650	43.30
1/2	8,400	82.70	4,350	44.50	4,150	41.30

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

Ae: D1/16~D1/4=.008
D5/16~D1/2=.012
Ap: 0.05 X D

Ae: D1/16~D1/8=0.05 X D
D3/16~D5/16=.010
D3/8~D1/2=.012
Ap: 0.05 X D