

TECHNICAL DATA | ZAMUS CLASSIC |

DA552 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
3/16	4,670	14.50	6,000	27.70	5,760	26.80
1/4	4,030	15.80	5,520	29.00	5,200	27.70
5/16	2,830	16.70	4,480	26.50	4,240	25.20
3/8	2,420	17.90	3,880	25.20	3,720	24.20
1/2	1,880	16.70	3,480	25.20	3,320	24.20

<p>RPM = rev. / min. FEED = inch / min.</p> <p>Ae: D3/16~D1/4=.008 D5/16~D1/2=.012 Ap: 0.2 X D</p>		<p>Ae: D3/16~D5/16=.010 D3/8~D1/2=.012 Ap: 0.1 X D</p>
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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
3/16	13,440	45.40	6,000	41.60	5,760	39.40
1/4	13,440	58.20	5,520	44.10	5,200	42.50
5/16	10,080	71.50	4,480	39.40	4,240	36.20
3/8	8,740	76.90	3,880	36.30	3,720	34.60
1/2	6,720	66.20	3,480	35.60	3,320	33.00

<p>RPM = rev. / min. FEED = inch / min.</p> <p>Ae: D3/16~D1/4=.008 D5/16~D1/2=.012 Ap: 0.5 X D</p>		<p>Ae: D3/16~D5/16=.010 D3/8~D1/2=.012 Ap: 0.05 X D</p>
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