

TECHNICAL DATA | ZAMUS CLASSIC |

ZA506 & ZA508 Series

Feed Rate	General Speed Cutting							
Work Material	Carbon Steels, Alloy Steels, Cast Iron		Alloy Steels, Tool Steels		Hardened Steels			
Hardness	≤ 30 HRC		30 ~ 45 HRC		45 ~ 55 HRC		55 ~ 65 HRC	
Strength	~ 145,038lbf / inch ²		145,038 ~ 217,557lbf / inch ²		217,557 ~ 290,076lbf / inch ²		290,076lbf / inch ²	
Cutting Diameter(inch)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1/4	5,560	79.00	3,880	54.00	1,580	8.25	1,100	5.10
5/16	4,200	79.00	2,940	54.00	1,160	8.25	840	5.10
3/8	3,360	79.00	2,320	54.00	1,000	8.25	680	5.10
1/2	2,840	66.00	2,000	46.00	840	7.10	560	4.35
5/8	2,100	50.00	1,480	35.00	640	5.10	420	2.75
3/4	1,680	40.00	1,160	27.00	500	4.35	320	2.35
1	1,260	25.00	870	17.50	375	3.00	240	1.54

RPM = rev. / min. FEED = inch / min.				
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Feed Rate	High Speed Cutting					
Work Material	Carbon Steels, Tool Steels		Hardened Steels			
Hardness	≤ 50 HRC		50 ~ 60 HRC		≥ 65 HRC	
Strength	253,817lbf / inch ²		253,817 ~ 301,679lbf / inch ²		301,679lbf / inch ²	
Cutting Diameter(inch)	RPM	FEED	RPM	FEED	RPM	FEED
1/4	16,800	240.00	8,400	120.00	4,200	58.00
5/16	12,600	240.00	6,300	120.00	3,160	58.00
3/8	9,980	235.00	5,040	120.00	2,520	58.00
1/2	8,400	199.00	4,200	100.00	2,100	50.00
5/8	6,300	149.00	3,160	75.00	1,580	37.00
3/4	5,040	120.00	2,520	58.00	1,260	30.00
1	3,790	75.00	1,890	38.00	950	19.00

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