

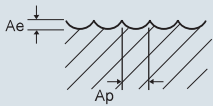
TECHNICAL DATA | ZAMUS CLASSIC |

ZA522 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	
Strength	~ 145,038 lbf / inch ²		145,038 ~ 217,557 lbf / inch ²		217,557 ~ 290,076 lbf / inch ²	
Cutting Diameter (inch)	RPM	FEED	RPM	FEED	RPM	FEED
1/8	4,410	7.80	3,570	2.40	2,200	1.20
3/16	3,050	4.10	2,420	3.30	1,580	1.60
1/4	2,630	4.90	2,100	4.10	1,370	2.00
5/16	2,000	5.30	1,580	4.10	1,050	2.00
3/8	1,680	5.30	1,370	4.10	840	2.00
1/2	1,370	4.10	1,160	3.70	700	1.60
5/8	1,160	3.70	890	3.00	560	1.40
3/4	840	2.80	680	2.00	420	1.00
1	610	2.00	540	1.60	330	0.70

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

Ae: D3/16~D1/4=.008
D5/16~D1/2=.012
Ap: 0.2 X D



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

ZA524 Series

Feed Rate	General Speed Cutting							
Work Material	Carbon Steels, Alloy Steels, Cast Iron		Alloy Steels, Tool Steels		Hardened Steels		Hardened Steels	
Hardness	≤ 30 HRC		30 ~ 45 HRC		45 ~ 55 HRC		55 ~ 65 HRC	
Strength	~ 145,038 lbf / inch ²		145,038 ~ 217,557 lbf / inch ²		217,557 ~ 290,076 lbf / inch ²		290,076 lbf / inch ²	
Cutting Diameter (inch)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1/16	4,410	4.50	3,570	3.90	2,200	2.20	1,890	1.20
1/8	3,050	7.10	2,420	5.50	1,580	2.80	1,260	1.60
3/16	2,630	8.50	2,100	7.10	1,370	3.50	1,160	2.00
1/4	2,000	9.10	1,580	7.10	1,050	3.50	840	2.00
5/16	1,680	9.10	1,370	7.10	840	3.50	670	2.00
3/8	1,370	7.10	1,160	6.30	700	2.80	560	1.60
1/2	1,160	6.30	890	4.90	560	2.40	440	1.40
5/8	840	4.50	680	3.50	420	1.80	340	1.00
3/4	670	4.50	540	3.50	340	1.80	270	1.00
1	1,360	9.85	840	5.10	540	1.20	260	0.80

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

