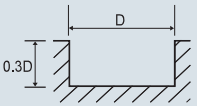
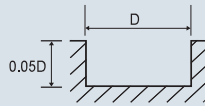


# TECHNICAL DATA | ZAMUS CLASSIC |

## ZR502A, ZR522A, ZR532A Series

Feed Rate	General Speed Cutting							
Work Material	Carbon Steels, Alloy Steels, Cast Iron		Alloy Steels, Tool Steels		Hardened Steels			
Hardness	≤ 30 HRc		30 ~ 38 HRc		45 ~ 55 HRc		55 ~ 65 HRc	
Strength	~ 145,038 lbf / inch <sup>2</sup>		145,038 ~ 174,046 lbf / inch <sup>2</sup>		203,053 ~ 290,076 lbf / inch <sup>2</sup>		290,076 lbf / inch <sup>2</sup>	
Cutting Diameter (inch)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1/4	2,630	4.90	2,100	4.20	1,370	2.00	1,160	1.40
5/16	2,000	5.30	1,580	4.20	1,050	2.00	840	1.40
3/8	1,680	5.30	1,370	4.20	840	2.00	670	1.40
1/2	1,370	4.20	1,160	3.80	700	1.50	550	1.00

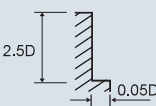
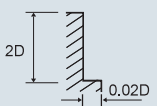
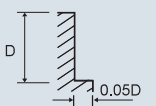
RPM = rev. / min.  
FEED = inch / min.

## ZR504A, ZR524A, ZR534A Series

Feed Rate	General Speed Cutting							
Work Material	Carbon Steels, Alloy Steels, Cast Iron		Alloy Steels, Tool Steels		Hardened Steels			
Hardness	≤ 30 HRc		30 ~ 50 HRc		50 ~ 55 HRc		55 ~ 65 HRc	
Strength	~ 145,038 lbf / inch <sup>2</sup>		145,038 ~ 174,046 lbf / inch <sup>2</sup>		203,053 ~ 290,076 lbf / inch <sup>2</sup>		290,076 lbf / inch <sup>2</sup>	
Cutting Diameter (inch)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1/4	2,630	8.50	2,100	7.10	1,370	3.30	1,160	2.00
5/16	2,000	9.00	1,580	7.10	1,050	3.30	840	2.00
3/8	1,680	9.00	1,370	7.10	840	3.30	670	2.00
1/2	1,370	7.10	1,160	6.30	700	2.80	550	1.50

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

## ZR506A, ZR508A Series

Feed Rate	High Speed Cutting					
Work Material	Carbon Steels, Alloy Steels, Cast Iron		Alloy Steels, Tool Steels		Hardened Steels	
Hardness	≤ 50 HRc		50 ~ 60 HRc		60 ~ 65 HRc	
Strength	253,817 lbf / inch <sup>2</sup>		253,817 lbf / inch <sup>2</sup>		301,679 lbf / inch <sup>2</sup>	
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	3,200	58.00
3/8	10,000	235.00	5,000	120.00	2,500	58.00
1/2	8,400	200.00	4,200	100.00	2,100	50.00
5/8	6,300	150.00	3,150	75.00	1,600	37.00
3/4	5,000	120.00	2,500	58.00	1,260	30.00

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

