

# TECHNICAL DATA | ZAMUS STAR |

## DB702, DB712 series

Work Material	Hardened Steels Heat Resistant Steels		Hardened Steels									
	30 ~ 40 HRc		40 ~ 50 HRc		50 ~ 55 HRc		55 ~ 60 HRc		60 ~ 65 HRc		65 ~ 70 HRc	
Hardness	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
Cutting Diameter(metric)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
0.2	50,000	1,200	50,000	1,050	45,000	960	40,000	770	35,000	674	31,500	570
0.3	50,000	1,500	50,000	1,350	45,000	1,200	40,000	965	35,000	840	31,500	700
0.4	50,000	1,900	50,000	1,700	45,000	1,500	40,000	1,200	35,000	1,050	31,500	890
0.5	50,000	2,400	50,000	2,100	45,000	1,900	40,000	1,500	35,000	1,300	31,500	1,100
0.6	50,000	2,900	50,000	2,500	45,000	2,200	40,000	1,800	35,000	1,600	31,500	1,400
0.8	50,000	3,900	50,000	3,300	45,000	3,000	40,000	2,400	35,000	2,100	31,500	1,800
1	50,000	4,800	50,000	4,200	45,000	3,800	40,000	3,000	35,000	2,600	35,000	2,300
1.5	50,000	5,400	48,000	4,500	43,000	4,000	37,000	3,100	33,000	2,700	29,700	2,300
2	49,700	5,700	47,800	4,800	40,000	4,000	35,000	3,150	32,000	2,800	28,500	2,300
3	33,100	6,000	31,800	5,300	26,500	4,000	23,500	3,150	21,000	2,800	19,000	2,300
4	24,900	6,000	23,900	5,300	20,000	4,000	17,500	3,150	16,000	2,800	14,500	2,300
5	18,600	5,800	17,800	4,900	15,000	3,750	13,500	3,050	11,500	2,550	10,500	2,100
6	13,900	4,850	13,400	4,100	11,000	3,100	10,000	2,500	8,800	2,150	8,000	1,750
8	11,100	4,200	10,700	3,500	9,000	2,700	8,000	2,150	7,000	1,850	6,500	1,550
10	9,300	3,700	8,900	3,100	7,500	2,400	6,600	1,900	5,800	1,650	5,300	1,380
12	6,950	2,950	6,680	2,500	5,600	1,900	5,000	1,550	4,400	1,250	4,000	1,050

RPM = rev. / min.  
FEED = mm / min.

