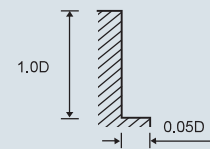
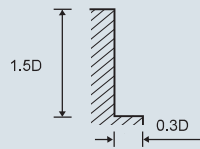


TECHNICAL DATA | ZAMUS CLASSIC |

ZF60x, ZF61x Series

| End Cutting | Side Milling | | | | | | | | | |
|--------------------------|---|-------|-------------------------------------|------|--------------------------------|------|--------------------------------|------|---------------------------|------|
| Work Material | Non-Alloyed Steels, Alloy Steels, Cast Iron | | Alloy Steels, Heat Resistant Steels | | Stainless Steels | | Hardened Steels | | Hardened Steels | |
| Hardness | ≤ 30 HRC | | 30 ~ 38 HRC | | 38 ~ 45 HRC | | 45 ~ 55 HRC | | 55 ~ 65 HRC | |
| Strength | ~ 1000N / mm ² | | 1000 ~ 1200N / mm ² | | 1200 ~ 1400N / mm ² | | 1400 ~ 2000N / mm ² | | 2000N / mm ² ~ | |
| Cutting Diameter(metric) | RPM | FEED | RPM | FEED | RPM | FEED | RPM | FEED | RPM | FEED |
| 6 | 15,600 | 2,320 | 12,400 | 840 | 8,400 | 570 | 3,400 | 260 | 2,400 | 190 |
| 8 | 11,600 | 2,320 | 9,200 | 840 | 6,300 | 570 | 2,400 | 240 | 1,800 | 180 |
| 10 | 9,200 | 2,320 | 7,600 | 840 | 5,100 | 570 | 2,000 | 290 | 1,300 | 190 |
| 12 | 8,000 | 2,400 | 6,000 | 800 | 4,200 | 570 | 1,680 | 260 | 1,200 | 190 |
| 14 | 6,800 | 2,400 | 5,200 | 840 | 3,600 | 570 | 1,400 | 200 | 900 | 130 |
| 16 | 6,000 | 2,400 | 4,800 | 760 | 3,300 | 510 | 1,200 | 160 | 800 | 110 |
| 18 | 5,200 | 2,320 | 4,400 | 720 | 2,700 | 420 | 1,100 | 150 | 700 | 100 |
| 20 | 4,800 | 2,160 | 3,600 | 560 | 2,400 | 360 | 1,000 | 150 | 660 | 100 |
| 25 | 4,300 | 2,150 | 3,200 | 620 | 2,160 | 410 | 900 | 160 | 600 | 100 |

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



PK503 Series

| Work Material | Alloy Steels, High Carbon Steels | | | Prehardened Steels, Tool Steels 30 ~ 40 HRC | | | SUS304 · 316, Prehardened Steel 40 ~ 45 HRC | | | Titanium Alloys | | | | | | |
|---------------------------|----------------------------------|----------|--------------|---|-------|----------|---|----------|---------|-----------------|--------------|-------|---------|-------|--------------|-------|
| (V) m / min | 130 ~ 150 | | | 100 ~ 120 | | | 50 ~ 70 | | | 30 ~ 50 | | | | | | |
| Cutting Diameter (metric) | RPM | fz | | | RPM | fz | | | (r.p.m) | fz | | | (r.p.m) | fz | | |
| | | Slotting | Side Milling | Slotting | | Slotting | Side Milling | Slotting | | Slot | Side Milling | Slot | | Slot | Side Milling | Slot |
| 6 | 7,400 | 0.030 | 0.045 | 0.018 | 5,800 | 0.025 | 0.030 | 0.012 | 3,200 | 0.020 | 0.030 | 0.012 | 2,100 | 0.017 | 0.020 | 0.008 |
| 8 | 5,600 | 0.035 | 0.062 | 0.025 | 4,400 | 0.030 | 0.045 | 0.018 | 2,400 | 0.030 | 0.040 | 0.016 | 1,600 | 0.025 | 0.025 | 0.010 |
| 10 | 4,600 | 0.045 | 0.075 | 0.030 | 3,500 | 0.040 | 0.048 | 0.019 | 1,900 | 0.040 | 0.055 | 0.022 | 1,300 | 0.036 | 0.040 | 0.016 |
| 12 | 3,700 | 0.050 | 0.087 | 0.035 | 3,000 | 0.045 | 0.052 | 0.020 | 1,600 | 0.045 | 0.065 | 0.026 | 1,100 | 0.040 | 0.050 | 0.020 |
| 14 | 3,200 | 0.055 | 0.090 | 0.036 | 2,500 | 0.053 | 0.056 | 0.022 | 1,360 | 0.048 | 0.070 | 0.028 | 900 | 0.043 | 0.053 | 0.021 |
| 16 | 2,800 | 0.055 | 0.090 | 0.036 | 2,200 | 0.060 | 0.060 | 0.024 | 1,200 | 0.050 | 0.075 | 0.030 | 800 | 0.045 | 0.055 | 0.022 |
| 20 | 2,200 | 0.080 | 0.095 | 0.038 | 1,800 | 0.066 | 0.066 | 0.026 | 1,000 | 0.052 | 0.083 | 0.033 | 600 | 0.050 | 0.057 | 0.023 |
| Ap | | 1.0D | 1.0D | 0.5D | | 1.0D | 1.0D | 0.5D | | 0.5D | 1.0D | 0.5D | | 0.5D | 1.0D | 0.5D |
| Ae | | 1.0D | 0.5D | 1.0D | | 1.0D | 0.3D | 1.0D | | 1.0D | 0.5D | 1.0D | | 1.0D | 0.3D | 1.0D |