

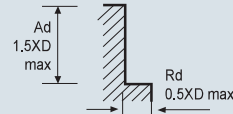
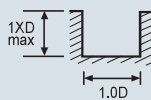
TECHNICAL DATA | ZAMUS SUS MATE |

XE504, XE505, XE514, XE515, XE524, XCE503, XCE504 Series

Work Material	Low Carbon Steels				Medical Alloy Steels		Mold & Die Steels		Cast Iron Gray		Cast Iron Ductile	
Hardness	≤ 175 HB		≤ 275 HB		≤ 275 HB		≤ 275 HB		≤ 200 HB		≤ 300 HB	
Cutting Diameter(metric)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
6	8,250	586	6,795	483	5,660	403	2,910	207	7,680	546	3,880	276
8	6,185	754	5,095	620	4,245	517	2,185	266	5,760	702	2,910	354
10	4,950	955	4,075	786	3,395	656	1,745	337	4,610	889	2,330	449
12	4,125	963	3,395	793	2,830	661	1,455	340	3,840	897	1,940	453
14	3,535	890	2,910	733	2,425	592	1,250	314	3,290	829	1,665	419
16	3,095	817	2,545	672	2,125	561	1,090	288	2,880	761	1,455	384
18	2,750	809	2,265	667	1,885	556	970	285	2,560	754	1,295	381
20	2,475	804	2,040	662	1,700	552	875	283	2,305	749	1,165	378
25	1,975	631	1,630	521	1,360	435	700	230	1,850	600	930	300

Work Material	Cast Iron Malleable		Stainless 300 Series		Stainless 400 Series		Stainless PH Series		Titanium Alloys		High Temp Alloys	
Hardness	≤ 300 HB		≤ 275 HB		≤ 185 HB		≤ 232 HB		≤ 295 HB		≤ 300 HB	
Cutting Diameter(metric)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
6	2,425	173	4,850	355	6,795	560	4,045	300	4,850	405	1,295	75
8	1,820	221	3,640	405	5,095	635	3,030	355	3,640	455	970	100
10	1,455	280	2,910	405	4,075	635	2,425	355	2,910	455	775	100
12	1,215	283	2,425	405	3,395	635	2,020	355	2,425	455	645	100
14	1,040	262	2,080	405	2,910	635	1,735	355	2,080	455	555	100
16	910	240	1,820	405	2,545	635	1,515	355	1,820	455	485	100
18	810	238	1,615	380	2,265	560	1,350	300	1,615	405	430	100
20	730	236	1,455	380	2,040	560	1,215	300	1,455	405	390	100
25	585	187	1,160	370	1,630	560	970	300	1,160	405	305	73

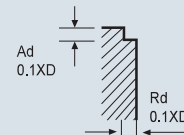
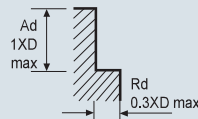
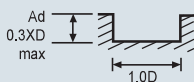
RPM = rev. / min.
FEED = mm / min.



- ※Use a rigid and precise machines and holders.
- ※Use a suitable cutting oil.

End Cutting / Feed Speed	Slotting		Side Milling		High Speed Cutting	
Work Material	Hardened Steels		Hardened Steels		Hardened Steels	
Hardness	30 ~ 45 HRC		30 ~ 45 HRC		30 ~ 45 HRC	
Cutting Diameter(metric)	RPM	FEED	RPM	FEED	RPM	FEED
6	3,450	414	4,246	849	9,023	2,166
8	2,588	414	3,185	764	6,768	1,895
10	2,070	414	2,548	713	5,414	1,732
12	1,725	414	2,123	764	4,512	1,985
14	1,479	414	1,820	728	3,867	1,856
16	1,294	414	1,592	701	3,384	1,895
18	1,150	368	1,415	679	3,008	1,805
20	1,035	414	1,274	662	2,707	1,841
25	828	397	1,019	611	2,166	1,646

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



- ※Use a rigid and precise machines and holders.
- ※Use a suitable cutting oil.