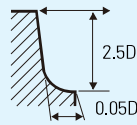


[WTB502 series]

피삭재	합금강, 탄소강		프리하든강	
	Alloy Steels Carbon Steels [SCM, SNCM, S45C]		Prehardened Steels [NAK, CENA, KP4]	
경도	~ HRC35		HRC35 ~ HRC45	
강도	~ 1100N/mm ²		1100 ~ 1500N/mm ²	
외경(mm)	RPM	FEED	RPM	FEED
0.4	36,000	144	27,900	113
0.6	25,200	144	18,900	113
0.8	18,000	144	13,950	108
1.0	14,850	149	11,250	113
2.0	7,560	153	5,670	113
3.0	3,969	108	3,213	90
4.0	3,213	126	2,556	104

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



[WTR504 series]

피삭재	합금강, 탄소강			프리하든강			고경도강		
	Alloy Steels Carbon Steels [SCM, SNCM, S45C]			Prehardened Steels [NAK, CENA, KP4]			Hardened Steels [SKD, SKT, STAVAX]		
경도	~HRC35			HRC35~HRC45			HRC45~HRC55		
강도	~1100N/mm ²			1100~1500N/mm ²			1500~2000N/mm ²		
외경(mm)	RPM	FEED	Ap(mm)	RPM	FEED	Ap(mm)	RPM	FEED	Ap(mm)
0.4	40,000	630	0.008~0.016	32,000	450	0.008~0.012	22,000	270	0.004~0.008
0.6	30,000	630	0.012~0.024	23,000	450	0.012~0.018	15,000	270	0.006~0.012
0.8	22,500	630	0.016~0.032	17,000	450	0.016~0.024	11,500	270	0.008~0.016
1.0	18,000	630	0.020~0.040	13,500	450	0.020~0.030	9,000	270	0.010~0.020
1.2	14,400	630	0.025~0.050	11,700	450	0.025~0.040	7,200	270	0.012~0.025
1.5	11,700	630	0.030~0.060	9,000	450	0.030~0.050	5,850	270	0.015~0.030
2.0	9,000	630	0.040~0.080	7,200	450	0.040~0.060	4,500	270	0.020~0.040

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

