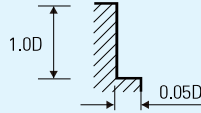


## [ WME504, WXE504 series ]

피삭재	합금강, 탄소강		프리하든강		스테인리스강		고경도강	
	Alloy Steels Carbon Steels (SCM, SNCM, S45C)		Prehardened Steels (NAK, CENA, KP4)		Stainless Steels (SUS)		Hardened Steels (SKD, SKT, STAVAX)	
경도	~HRc35		HRc35~HRc45				HRc45~HRc55	
강도	~1100N/mm <sup>2</sup>		1100~1500N/mm <sup>2</sup>				1500~2000N/mm <sup>2</sup>	
외경(mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2.0	11,560	280	7,560	170	6,300	140	5,040	50
3.0	8,920	320	5,560	200	4,620	170	3,360	60
4.0	7,560	570	4,620	350	3,880	280	2,940	60
5.0	6,300	600	3,780	360	3,160	300	2,320	70
6.0	5,560	660	3,360	410	2,840	330	2,000	80
8.0	4,200	710	2,520	380	2,100	350	1,680	110
10.0	3,260	610	2,000	300	1,680	300	1,360	90
12.0	2,740	520	1,680	250	1,360	240	1,160	80
16.0	2,200	410	1,360	200	1,100	300	900	60
20.0	1,680	320	1,060	160	840	150	680	40
25.0	1,360	250	840	130	680	120	540	30

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



## [ WE524 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 <sup>2</sup>		1100~1500N/mm <sup>2</sup>		1500~2000N/mm <sup>2</sup>	
외경(mm)	RPM	FEED	RPM	FEED	RPM	FEED
2.0	6,300	100	5,040	80	3,150	45
3.0	4,410	115	3,570	100	2,200	55
4.0	3,570	140	2,840	115	1,790	60
5.0	3,050	180	2,420	140	1,580	70
6.0	2,630	215	2,100	180	1,370	90
8.0	2,000	230	1,580	180	1,050	90
10.0	1,680	230	1,370	180	840	90
12.0	1,370	180	1,160	160	700	70
16.0	1,160	160	890	125	560	60
20.0	840	115	680	90	420	45

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

