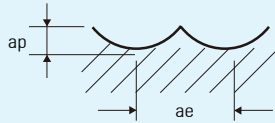


[WB542 series]

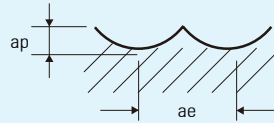
• Normal Speed

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	RPM	FEED	RPM	FEED
0.1	16,500	80	25500	185	25500	160
0.2	16,500	90	25500	220	25500	200
0.3	15,300	112	24000	260	24000	220
0.4	15,300	112	24000	260	24000	220
0.5	13,300	128	20800	300	20800	250
0.6	11,200	144	17600	330	17600	280
0.8	11,200	144	17600	330	17600	280
1.0	10,180	160	16000	370	16000	320
1.5	9,500	220	13000	500	12800	400
2.0	9,250	260	11500	640	11300	590
3.0	8,000	370	10200	880	9800	850
4.0	6,720	420	8500	880	8200	850
5.0	5,840	460	7500	880	7200	850
6.0	5,500	660	6900	920	6500	880
8.0	4,600	740	5600	840	5300	800
10.0	4,070	820	4850	800	4650	770
12.0	3,700	890	4350	800	4150	770

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



ap : D1~D6=0.2mm
D8~D12=0.3mm
ae : 0.2×D



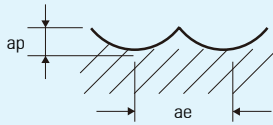
ap : D1~D4=0.05×D
D5~D8=0.25mm
D10~D12=0.3mm
ae : 0.1×D

[WB542 series]

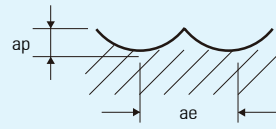
• High Speed

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	RPM	FEED	RPM	FEED
0.1	32,000	520	25,600	310	25,600	275
0.2	32,000	620	25,600	370	25,600	330
0.3	30,000	730	24,000	430	24,000	385
0.4	30,000	730	24,000	430	24,000	385
0.5	26,000	830	20,800	500	20,800	440
0.6	22,000	940	17,600	560	17,600	500
0.8	22,000	940	17,600	560	17,600	500
1.0	20,000	1,040	16,000	620	16,000	550
1.5	18,500	1,100	13,500	720	13,000	700
2.0	16,800	1,200	11,500	850	11,300	980
3.0	16,800	1,600	10,200	1,400	9,800	1,300
4.0	16,800	2,350	8,500	1,350	8,200	1,300
5.0	16,800	2,880	7,500	1,320	7,200	1,250
6.0	16,800	3,200	6,900	1,400	6,500	1,350
8.0	13,400	3,200	5,600	1,250	5,300	1,150
10.0	11,200	3,100	4,850	1,150	4,650	1,100
12.0	9,800	3,100	4,350	1,130	4,150	1,050

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



ap : D1~D6=0.2mm
D8~D12=0.3mm
ae : 0.05xD



ap : D1~D4=0.05xD
D5~D8=0.25mm
D10~D12=0.3mm
ae : 0.05xD