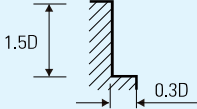
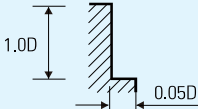


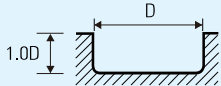
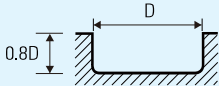
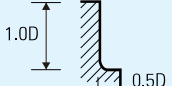
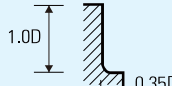
[WF61 series]

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	RPM	FEED	RPM	FEED
6.0	12,400	840	8,400	570	3,400	260
8.0	9,200	840	6,300	570	2,400	240
10.0	7,600	840	5,100	570	2,000	290
12.0	6,000	800	4,200	570	1,680	260
14.0	5,200	840	3,600	570	1,400	200
16.0	4,800	760	3,300	510	1,200	160
18.0	4,400	720	2,700	420	1,100	150
20.0	3,600	560	2,400	360	1,000	150
25.0	3,200	620	2,160	410	900	160

<p>RPM = rev. / min. FEED = mm / min.</p> 	
---	---

[WF60 series]

피삭재	합금강, 탄소강		합금강, 탄소강, 프리하든강		합금강, 탄소강		합금강, 탄소강, 프리하든강	
	Alloy Steels Carbon Steels [SCM, S45C, S50C]		Alloy Steels Carbon Steels Prehardened Steels [SCM, SKD, NAK, KP4]		Alloy Steels Carbon Steels [SCM, S45C, S50C]		Alloy Steels Carbon Steels Prehardened Steels [SCM, SKD, NAK, KP4]	
경도	~HRc25		HRc25~HRc40		~HRc25		HRc25~HRc40	
외경(mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
6.0	12,000	1,550	10,600	1,100	15,800	2,570	14,300	1,850
8.0	9,000	1,650	8,100	1,180	11,900	2,700	10,700	1,950
10.0	7,200	1,650	6,400	1,180	9,500	2,700	8,500	1,950
12.0	6,000	1,540	5,400	1,140	8,000	2,570	7,100	1,850
16.0	4,500	1,500	4,100	1,050	6,000	2,450	5,400	1,750
20.0	3,600	1,330	3,200	900	4,800	2,140	4,300	1,500

<p>RPM = rev. / min. FEED = mm / min.</p> 			
---	---	--	---