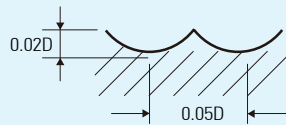


[WSB502 series]

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
3.0	13,500	1,700	13,200	1,620	12,500	860
4.0	10,600	1,700	10,300	1,620	9,800	860
5.0	9,400	1,650	9,050	1,570	8,600	860
6.0	8,600	1,750	8,250	1,670	7,850	865
8.0	7,000	1,550	6,700	1,460	6,350	890
10.0	6,050	1,450	5,800	1,360	5,450	870
12.0	5,450	1,420	5,200	1,330	4,900	785
16.0	4,300	1,200	4,000	1,100	3,700	650
20.0	3,600	1,050	3,200	900	3,000	550

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



[WB503 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
1.0	50,000	4,150	44,000	3,000	33,000	2100
1.5	40,000	5,100	35,000	3,660	36,400	2600
2.0	33,000	5,890	29,000	4,150	21,700	3000
3.0	25,000	6,930	22,000	4,880	16,500	3490
4.0	21,670	6,930	18,120	4,880	13,400	3490
5.0	18,000	6,520	15,100	4,880	11,160	3320
6.0	16,200	7,710	13,680	5,590	10,980	4050
8.0	12,150	6,610	10,170	4,720	8,280	3580
10.0	9,720	5,870	8,190	4,130	6,620	3100
12.0	8,150	5,490	4,130	3,830	5,520	2870

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

