

[WHPB902 series]

| 피삭재 | 합금강/탄소강 | | 프리하든강 | | 고경도강 | |
|--------|------------------------|-------|----------------------------|-------|----------------------------|-------|
| 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 | 40,000 | 550 | 40,000 | 500 | 33,000 | 400 |
| 0.2 | 30,000 | 720 | 30,000 | 630 | 27,000 | 575 |
| 0.3 | 30,000 | 900 | 30,000 | 810 | 27,000 | 720 |
| 0.4 | 30,000 | 1,140 | 30,000 | 1,020 | 27,000 | 900 |
| 0.5 | 30,000 | 1,440 | 30,000 | 1,260 | 27,000 | 1,140 |
| 0.6 | 30,000 | 1,740 | 30,000 | 1,500 | 27,000 | 1,320 |
| 0.8 | 30,000 | 2,340 | 30,000 | 1,980 | 27,000 | 1,800 |
| 1.0 | 30,000 | 2,880 | 30,000 | 2,520 | 27,000 | 2,280 |
| 1.2 | 30,000 | 3,060 | 28,800 | 2,580 | 25,800 | 2,310 |
| 1.5 | 30,000 | 3,240 | 28,800 | 2,700 | 25,800 | 2,400 |
| 2.0 | 29,820 | 3,420 | 28,680 | 2,880 | 24,000 | 2,400 |
| 3.0 | 19,860 | 3,600 | 19,080 | 3,180 | 15,900 | 2,400 |
| 4.0 | 14,940 | 3,600 | 14,340 | 3,180 | 12,000 | 2,400 |
| 5.0 | 11,160 | 3,480 | 10,680 | 2,940 | 9,000 | 2,250 |
| 6.0 | 8,340 | 2,910 | 8,040 | 2,460 | 6,600 | 1,860 |
| 8.0 | 6,660 | 2,520 | 6,420 | 2,100 | 5,400 | 1,620 |
| 10.0 | 5,580 | 2,220 | 5,340 | 1,860 | 4,500 | 1,440 |
| 12.0 | 4,170 | 1,770 | 4,008 | 1,500 | 3,360 | 1,440 |
| 16.0 | 3,340 | 1,590 | 3,210 | 1,320 | 2,700 | 1,020 |
| 20.0 | 2,670 | 1,410 | 2,580 | 1,170 | 2,160 | 900 |
| 25.0 | 2,130 | 1,150 | 2,060 | 950 | 1,730 | 730 |

[WB502 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 |
| 0.1 | 40,000 | 550 | 40,000 | 500 | 33,000 | 400 |
| 0.2 | 30,000 | 720 | 30,000 | 630 | 27,000 | 575 |
| 0.3 | 30,000 | 900 | 30,000 | 810 | 27,000 | 720 |
| 0.4 | 30,000 | 1,140 | 30,000 | 1,020 | 27,000 | 900 |
| 0.5 | 30,000 | 1,440 | 30,000 | 1,260 | 27,000 | 1,140 |
| 0.6 | 30,000 | 1,740 | 30,000 | 1,500 | 27,000 | 1,320 |
| 0.8 | 30,000 | 2,340 | 30,000 | 1,980 | 27,000 | 1,800 |
| 1.0 | 30,000 | 2,880 | 30,000 | 2,520 | 27,000 | 2,280 |
| 1.2 | 30,000 | 3,060 | 28,800 | 2,580 | 25,800 | 2,310 |
| 1.5 | 30,000 | 3,240 | 28,800 | 2,700 | 25,800 | 2,400 |
| 2.0 | 29,820 | 3,420 | 28,680 | 2,880 | 24,000 | 2,400 |
| 3.0 | 19,860 | 3,600 | 19,080 | 3,180 | 15,900 | 2,400 |
| 4.0 | 14,940 | 3,600 | 14,340 | 3,180 | 12,000 | 2,400 |
| 5.0 | 11,160 | 3,480 | 10,680 | 2,940 | 9,000 | 2,250 |
| 6.0 | 8,340 | 2,910 | 8,040 | 2,460 | 6,600 | 1,860 |
| 8.0 | 6,660 | 2,520 | 6,420 | 2,100 | 5,400 | 1,620 |
| 10.0 | 5,580 | 2,220 | 5,340 | 1,860 | 4,500 | 1,440 |
| 12.0 | 4,170 | 1,770 | 4,008 | 1,500 | 3,360 | 1,140 |
| 16.0 | 3,340 | 1,590 | 3,210 | 1,320 | 2,700 | 1,020 |
| 20.0 | 2,670 | 1,410 | 2,580 | 1,170 | 2,160 | 900 |
| 25.0 | 2,130 | 1,150 | 2,060 | 950 | 1,730 | 730 |

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

