

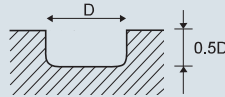
TECHNICAL DATA | ALU-WAVE |

WAR503 series

Slotting, General Cutting

End Cutting	Slotting					
Feed Rate	General Speed Cutting					
Work Material	Aluminum Alloy(A7075)		Aluminum Alloy Casting(Si13%)		Magnesium Alloy Copper Alloy	
Cutting Diameter(metric)	RPM	FEED	RPM	FEED	RPM	FEED
3	21,000	770	2,100	770	7,950	325
4	15,500	810	15,500	810	5,950	375
5	12,500	860	12,500	860	4,750	385
6	10,500	950	10,500	950	3,950	400
8	8,000	1,000	8,000	1,000	2,950	460
10	6,350	1,150	6,350	1,150	2,350	475
12	5,300	1,200	5,300	1,200	1,950	510
16	3,950	1,200	3,950	1,200	1,450	510
20	3,150	1,200	3,150	1,200	1,150	510

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



WAR503 series

Slotting, High Speed Cutting

End Cutting	Slotting			
Feed Rate	High Speed Cutting			
Work Material	Aluminum Alloy(A7075)		Aluminum Alloy Casting(Si13%)	
Cutting Diameter(metric)	RPM	FEED	RPM	FEED
3	40,000	1,450	24,000	880
4	32,000	1,700	19,200	1,000
5	32,000	2,200	19,200	1,350
6	26,500	2,400	15,900	1,450
8	20,000	2,500	12,000	1,500
10	16,000	2,800	9,600	1,700
12	13,300	2,950	8,000	1,800
16	10,000	3,000	6,000	1,800
20	8,000	3,000	4,800	1,800

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

