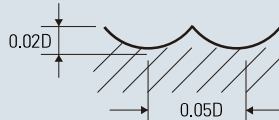


TECHNICAL DATA | WINNER |

WB503 series

Work Material	Alloy Steels, Carbon Steels (SCM, SNCM, S45C)		Prehardened Steels (NAK, CENA, KP4)		Hardened Steels (SKD, SKT, STAVAX)	
Hardness	≤ 35 HRc		35 ~ 45 HRc		45 ~ 55 HRc	
Strength	≤ 1100N / mm ²		1100~1500N / mm ²		1500~2000N / mm ²	
Cutting Diameter (metric)	RPM	FEED	RPM	FEED	RPM	FEED
1.0	50,000	4,150	44,000	3,000	33,000	2,100
1.5	40,000	5,100	35,000	3,660	36,400	2,600
2.0	33,000	5,890	29,000	4,150	21,700	3,000
3.0	25,000	6,930	22,000	4,880	16,500	3,490
4.0	21,670	6,930	18,120	4,880	13,400	3,490
5.0	18,000	6,520	15,100	4,880	11,160	3,320
6.0	16,200	7,710	13,680	5,590	10,980	4,050
8.0	12,150	6,610	10,170	4,720	8,280	3,580
10.0	9,720	5,870	8,190	4,130	6,620	3,100
12.0	8,150	5,490	4,130	3,830	5,520	2,870
12.0	8,150	5,490	4,130	3,830	5,520	2,870

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



WB504 series

Work Material	Alloy Steels, Carbon Steels (SCM, SNCM, S45C)		Prehardened Steels (NAK, CENA, KP4)		Hardened Steels (SKD, SKT, STAVAX)	
Hardness	≤ 35 HRc		35 ~ 45 HRc		45 ~ 55 HRc	
Strength	≤ 1100N / mm ²		1100~1500N / mm ²		1500~2000N / mm ²	
Cutting Diameter (metric)	RPM	FEED	RPM	FEED	RPM	FEED
1.0	48,000	3,300	35,000	2,350	32,000	2,200
1.5	38,400	4,100	28,000	2,900	25,600	2,700
2.0	31,680	4,600	23,100	3,300	21,000	3,100
3.0	24,000	5,430	17,500	3,880	16,000	3,650
4.0	20,130	5,430	14,880	3,880	14,220	3,650
5.0	16,780	5,430	12,400	3,690	11,670	3,470
6.0	15,200	6,220	12,200	4,500	11,100	3,830
8.0	11,300	5,250	9,200	3,980	8,320	3,350
10.0	9,100	4,590	7,350	3,450	6,660	2,870
12.0	7,590	4,260	6,130	3,190	5,530	2,400

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

