

TECHNICAL DATA | WINNER |

WB532 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
3.0	35,000	2,800	33,000	2,600	12,000	900
4.0	26,000	2,300	25,000	2,200	9,000	800
5.0	21,000	2,100	20,000	2,000	7,000	700
6.0	17,000	1,900	16,000	1,800	6,000	650
8.0	13,000	1,700	12,000	1,600	4,500	550
10.0	10,500	1,450	10,000	1,400	3,500	500
12.0	9,000	1,400	8,000	1,300	3,000	450

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

