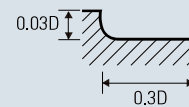
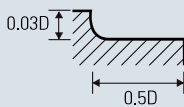


TECHNICAL DATA | WINNER |

WDR503 Series

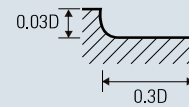
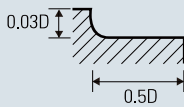
| Feed Rate | | General Cutting Speed | | | | |
|---------------------------|---|-------------------------------------|-------|------------------------------------|-------|-------|
| Work Material | Alloy Steels, Carbon Steels (SCM, SNCM, S45C) | Prehardened Steels (NAK, CENA, KP4) | | Hardened Steels (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 |
| 6.0 | 5,100 | 3,500 | 5,500 | 3,750 | 3,850 | 2,700 |
| 8.0 | 3,800 | 3,400 | 4,150 | 3,700 | 2,850 | 2,550 |
| 10.0 | 3,800 | 3,750 | 3,600 | 3,500 | 2,700 | 2,700 |
| 12.0 | 3,200 | 4,200 | 3,250 | 4,250 | 2,250 | 2,300 |
| 16.0 | 2,400 | 3,100 | 2,250 | 2,900 | 1,700 | 1,750 |
| 20.0 | 1,900 | 2,500 | 1,800 | 2,350 | 1,350 | 1,400 |

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



| Feed Rate | | High Cutting Speed | | | | |
|---------------------------|---|-------------------------------------|-------|------------------------------------|-------|-------|
| 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 |
| 6.0 | 5,100 | 3,500 | 5,500 | 3,750 | 3,850 | 2,700 |
| 8.0 | 3,800 | 3,400 | 4,150 | 3,700 | 2,850 | 2,550 |
| 10.0 | 3,800 | 3,750 | 3,600 | 3,500 | 2,700 | 2,700 |
| 12.0 | 3,200 | 4,200 | 3,250 | 4,250 | 2,250 | 2,300 |
| 16.0 | 2,400 | 3,100 | 2,250 | 2,900 | 1,700 | 1,750 |
| 20.0 | 1,900 | 2,500 | 1,800 | 2,350 | 1,350 | 1,400 |

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



WR506 Series

| Feed Rate | | General Cutting Speed | | | | |
|---------------------------|---|-------------------------------------|--------|------------------------------------|-------|-------|
| 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 |
| 6.0 | 14,880 | 3,210 | 1,410 | 2,940 | 9,600 | 2,940 |
| 8.0 | 12,000 | 3,300 | 11,400 | 3,000 | 7,200 | 2,760 |
| 10.0 | 9,600 | 2,940 | 9,300 | 2,700 | 5,700 | 2,460 |
| 12.0 | 7,800 | 2,700 | 7,500 | 2,460 | 4,800 | 2,280 |
| 16.0 | 6,000 | 2,400 | 5,820 | 2,220 | 3,600 | 2,040 |
| 20.0 | 4,800 | 2,010 | 4,680 | 2,040 | 2,880 | 1,920 |

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

