

# TECHNICAL DATA | WINNER |

## WF61x 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 <sup>2</sup>		1100~1500N / mm <sup>2</sup>		1500~2000N / mm <sup>2</sup>	
Cutting Diameter (metric)	RPM	FEED	RPM	FEED	RPM	FEED
6.0	12,400	840	8,400	570	3,400	260
8.0	9,200	840	6,300	570	2,400	240
10.0	7,600	840	5,100	570	2,000	290
12.0	6,000	800	4,200	570	1,680	260
14.0	5,200	840	3,600	570	1,400	200
16.0	4,800	760	3,300	510	1,200	160
18.0	4,400	720	2,700	420	1,100	150
20.0	3,600	560	2,400	360	1,000	150
25.0	3,200	620	2,160	410	900	160

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

