

# TECHNICAL DATA | WINNER |

## WTB502 Series

Work Material	Alloy Steels, Carbon Steels(SCM, SNCM, S45C)		Prehardened Steels(NAK, CENA, KP4)	
Hardness	$\leq 35 \text{ HRC}$		35 ~ 45 HRC	
Strength	$\leq 1100 \text{ N / mm}^2$		1100~1500N / mm <sup>2</sup>	
Cutting Diameter(metric)	RPM	FEED	RPM	FEED
0.4	36,000	144	27,900	113
0.6	25,200	144	18,900	113
0.8	18,000	144	13,950	108
1.0	14,850	149	11,250	113
2.0	7,560	153	5,670	113
3.0	3,969	108	3,213	90
4.0	3,213	126	2,556	104

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

