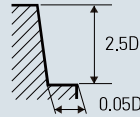


TECHNICAL DATA | WINNER |

WTE502 Series

Work Material	Alloy Steels, Carbon Steels(SCM, SNCM, S45C)		Prehardened Steels(NAK, CENA, KP4)	
Hardness	≤ 35 HRc		35 ~ 45 HRc	
Strength	≤ 1100N / mm ²		1100~1500N / mm ²	
Cutting Diameter(metric)	RPM	FEED	RPM	FEED
0.3	45,000	135	35,000	105
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
6.0	2,367	189	1,890	153
8.0	1,800	225	1,422	162
10.0	1,440	225	1,170	167

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



WTE504 Series

Work Material	Alloy Steels, Carbon Steels(SCM, SNCM, S45C)		Prehardened Steels(NAK, CENA, KP4)	
Hardness	≤ 35 HRc		35 ~ 45 HRc	
Strength	≤ 1100N / mm ²		1100~1500N / mm ²	
Cutting Diameter(metric)	RPM	FEED	RPM	FEED
3.0	3,969	216	3,213	180
4.0	3,213	252	2,556	207
6.0	2,367	378	1,890	306
8.0	1,800	450	1,422	324
10.0	1,440	450	1,170	333

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

