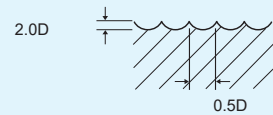


[WAB312 series]

WORKPIECE DIAMETER(mm)	ALUMINIUM ALLOY		COPPER ALLOY	
	RPM	FEED	RPM	FEED
6	18,000	1,750	5,500	440
8	14,000	2,000	4,200	500
10	14,000	2,350	4,200	580
12	14,000	3,000	4,200	750
16	11,000	2,700	3,300	670
20	8,000	2,200	2,200	600

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

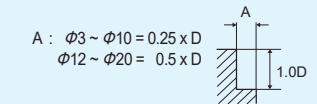
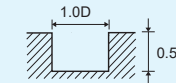


[WAE302 series]

▶ Slotting, Side cutting

WORKPIECE HARDNESS DIAMETER(mm)	ALLOY STEELS, CAST IRON ~HB230		ALUMINIUM	
	RPM	FEED	RPM	FEED
1.0	16,870	505	16,870	845
1.5	13,150	525	13,150	790
2.0	11,300	565	11,300	790
2.5	10,565	635	10,565	845
3.0	10,000	700	10,000	900
4.0	10,000	900	10,000	1,100
5.0	10,000	1,000	10,000	1,300
6.0	10,000	1,200	10,000	1,500
7.0	8,850	1,240	8,850	1,505
8.0	8,000	1,400	8,000	1,800
9.0	8,000	1,550	8,000	1,680
10.0	8,000	1,700	8,000	2,100
12.0	8,000	2,100	8,000	2,600
14.0	6,000	1,800	6,000	2,200
16.0	6,000	1,900	6,000	2,400
18.0	4,000	1,400	4,000	1,800
20.0	4,000	1,600	4,000	1,900

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



[WAE301 series]

▶ Slotting, General Cutting

WORKPIECE DIAMETER(mm)	ACRYLIC		ALLOY STEELS	
	RPM	FEED	RPM	FEED
1.0	32,000	2,000	23,000	1,300
2.0	32,000	2,200	23,000	1,500
3.0	25,000	2,400	18,000	1,700
4.0	20,000	2,400	15,000	1,800
5.0	15,000	2,200	12,000	1,800
6.0	13,500	2,300	10,000	1,800
8.0	10,000	2,400	7,800	1,900
10.0	8,000	2,400	6,000	2,000
12.0	7,000	2,200	5,000	1,900

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

