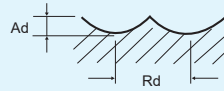


## [ BC502 series ]

| WORKPIECE |              | UNALLOYED COPPER |       |       |       |
|-----------|--------------|------------------|-------|-------|-------|
| R(mm)     | DIAMETER(mm) | RPM              | FEED  | Rd    | Ad    |
| 0.5       | 1            | 41,000           | 1,660 | 0.040 | 0.063 |
| 0.75      | 1.5          | 27,000           | 1,830 | 0.068 | 0.087 |
| 1         | 2            | 20,000           | 1,780 | 0.089 | 0.112 |
| 1.25      | 2.5          | 16,000           | 1,840 | 0.115 | 0.090 |
| 1.5       | 3            | 13,000           | 2,220 | 0.171 | 0.168 |
| 2         | 4            | 10,000           | 2,080 | 0.208 | 0.200 |
| 2.5       | 5            | 8,300            | 1,990 | 0.240 | 0.200 |
| 3         | 6            | 6,900            | 1,940 | 0.281 | 0.250 |
| 4         | 8            | 5,720            | 1,000 | 0.175 | 0.400 |
| 5         | 10           | 4,550            | 700   | 0.154 | 0.500 |
| 6         | 12           | 3,770            | 600   | 0.159 | 0.600 |

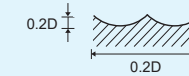
RPM = rev. / min.  
FEED = mm / min.



## [ G series ]

| WORKPIECE    | GRAPHITE |       |
|--------------|----------|-------|
| DIAMETER(mm) | RPM      | FEED  |
| 0.5          | 16,000   | 480   |
| 0.75         | 16,000   | 640   |
| 1            | 16,000   | 800   |
| 1.5          | 16,000   | 1,450 |
| 2            | 16,000   | 2,100 |
| 3            | 15,000   | 2,950 |
| 4            | 13,000   | 3,000 |
| 5            | 11,500   | 3,050 |
| 6            | 10,500   | 3,150 |
| 8            | 8,555    | 2,960 |

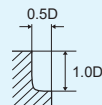
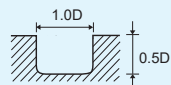
RPM = rev. / min.  
FEED = mm / min.



## [ RC502 series ]

| WORKPIECE    | UNALLOYED COPPER |       |        |       |
|--------------|------------------|-------|--------|-------|
| DIAMETER(mm) | RPM              | FEED  | RPM    | FEED  |
| 3            | 44,500           | 2,350 | 50,000 | 3,700 |
| 4            | 33,400           | 2,100 | 50,000 | 4,700 |
| 6            | 22,300           | 2,100 | 33,400 | 4,900 |
| 8            | 16,700           | 2,100 | 25,000 | 4,700 |
| 10           | 13,370           | 2,100 | 20,000 | 4,800 |
| 12           | 11,100           | 2,100 | 16,700 | 4,700 |

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



## [ WGB504 series ]

| WORKPIECE    | GRAPHITE |       |
|--------------|----------|-------|
| DIAMETER(mm) | RPM      | FEED  |
| 1.0          | 20,000   | 700   |
| 2.0          | 16,000   | 1,200 |
| 3.0          | 16,000   | 2,000 |
| 4.0          | 16,000   | 3,100 |
| 5.0          | 15,000   | 3,800 |
| 6.0          | 15,000   | 4,400 |
| 8.0          | 13,000   | 4,500 |
| 10.0         | 12,000   | 4,600 |
| 12.0         | 10,000   | 4,700 |
| 16.0         | 7,500    | 3,800 |
| 20.0         | 6,000    | 3,500 |

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

