

TECHNICAL DATA | ALU-WAVE |

WAR302A, WAR312A & WAR322A series

End Cutting	Slotting							
Work Material	Aluminum Alloy(<Si 4%)		Aluminum Alloy(<Si 8%)		Aluminum Alloy(Die Casted)		Copper Alloy	
Cutting Diameter(inch)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1/8	24,000	151.2	19,900	117.3	16,000	88.2	12,000	56.7
3/16	24,000	151.2	19,900	117.3	16,000	88.2	12,000	56.7
1/4	16,000	120.9	13,200	93.3	10,600	70.1	8,000	45.2
5/16	12,000	113.4	9,900	87.8	8,000	66.1	6,000	42.5
3/8	10,800	110.4	8,900	86.4	7,200	64.2	5,400	41.5
7/16	8,800	104.1	7,300	81.5	5,800	60.2	4,400	39.2
1/2	8,000	100.8	6,600	78.0	5,300	58.3	4,000	37.8
5/8	6,000	94.5	5,000	73.6	4,000	55.1	3,000	35.4
3/4	5,000	78.7	4,200	62.0	3,300	48.8	2,500	29.5
1	3,840	60.5	3,200	47.2	2,560	39.7	1,920	22.7

End Cutting	Side Milling							
Work Material	Aluminum Alloy(<Si 4%)		Aluminum Alloy(<Si 8%)		Aluminum Alloy(Die Casted)		Copper Alloy	
Cutting Diameter(inch)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1/8	24,000	188.9	19,900	156.7	16,000	126.0	12,000	94.5
3/16	24,000	188.9	19,900	156.7	16,000	126.0	12,000	94.5
1/4	16,000	151.2	13,200	124.4	10,600	100.2	8,000	75.6
5/16	12,000	141.7	9,900	116.9	8,000	94.5	6,000	70.9
3/8	10,800	138.2	8,900	115.2	7,200	91.7	5,400	69.3
7/16	8,800	130.3	7,300	108.7	5,800	86.2	4,400	65.4
1/2	8,000	126.0	6,600	103.9	5,300	83.5	4,000	63.0
5/8	6,000	118.1	5,000	98.4	4,000	78.7	3,000	59.1
3/4	5,000	98.4	4,200	82.7	3,300	46.3	2,500	49.2
1	3,840	75.6	3,200	63.0	2,560	50.4	1,920	37.8

RPM = rev. / min.
FEED = inch / min.

