

WE712 Series

End Cutting	Rib Processing								
Work Material	Non-Alloyed Steels, Alloy Steels, Cast Iron			Alloy Steels, Heat Resistant Steels			Hardened Steels		
Hardness	≤ 30 HRC			30 ~ 45 HRC			45 ~ 55 HRC		
Strength	~ 1000N / mm ²			1000 ~ 1500N / mm ²			1500 ~ 2000N / mm ²		
Cutting Diameter(metric)	RPM	FEED	Ae (mm)	RPM	FEED	Ae (mm)	RPM	FEED	Ae (mm)
0.4	33000~42000	220~490	0.007~0.018	24000~30000	100~375	0.007~0.018	15000~18000	35~100	0.004~0.008
0.5	33000~42000	220~490	0.009~0.022	24000~30000	100~375	0.009~0.022	15000~18000	35~100	0.004~0.009
0.6	33000~42000	275~630	0.011~0.026	24000~30000	120~485	0.011~0.026	15000~18000	45~120	0.005~0.011
0.7	33000~42000	275~630	0.012~0.031	24000~30000	120~485	0.012~0.031	15000~18000	45~120	0.006~0.013
0.8	28500~37000	310~700	0.014~0.035	20500~26000	130~530	0.014~0.035	13000~15500	50~140	0.007~0.015
0.9	26000~33000	310~800	0.030~0.060	19000~24000	180~600	0.030~0.060	11500~13500	60~145	0.008~0.016
1.0	24000~30000	310~900	0.045~0.090	16500~21000	210~660	0.045~0.090	10500~13500	75~145	0.009~0.018
1.2	19500~24000	310~990	0.055~0.100	14000~17000	210~660	0.055~0.100	9000~11000	75~145	0.010~0.022
1.4	17000~21000	310~990	0.062~0.125	12000~15000	210~660	0.062~0.125	7500~9500	75~145	0.012~0.025
1.5	15500~20000	310~990	0.070~0.135	11000~14500	210~660	0.070~0.135	7000~8500	75~145	0.014~0.028
1.6	15000~19000	310~990	0.075~0.145	11000~13500	210~660	0.075~0.145	6500~8500	75~145	0.015~0.030
1.8	14000~18000	310~990	0.080~0.160	10000~12000	210~660	0.080~0.160	6000~7500	75~145	0.016~0.032
2.0	12500~15500	310~990	0.090~0.180	9000~11000	210~660	0.090~0.180	5500~7000	75~145	0.018~0.035
2.5	10000~13000	310~990	0.112~0.235	7000~9000	210~660	0.112~0.235	4500~5500	75~145	0.022~0.045
3.0	8500~10500	310~990	0.135~0.270	6000~7500	210~660	0.135~0.270	3500~4500	75~145	0.048~0.055
4.0	6500~8000	310~990	0.180~0.360	4500~5500	210~660	0.180~0.360	2700~3500	75~145	0.036~0.072

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

