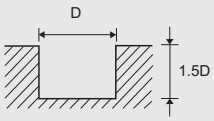
WAE303A, 313A and 323A series

	SLOTTING		SIDE MILLING	
MATERIAL	ALUMINUM ALLOY NON FERROUS METALS		ALUMINUM ALLOY NON FERROUS METALS	
DIAMETER (inch)	RPM	FEED	RPM	FEED
1/8"	7000	17.9	7000	13.8
3/16"	7000	25.6	7000	19.8
1/4"	7000	29.8	7000	23.9
5/16"	5600	33.9	5600	27.6
3/8"	5600	37.6	5600	30.6
7/16"	5600	38.0	5600	37.5
1/2"	5600	34.7	5600	41.3
5/8"	4200	47.6	4200	37.2
3/4"	2800	36.7	2800	29.6
1"	2800	36.7	2800	29.6

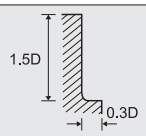
RPM=rev. / min.
FEED=inch / min.



WAR303A, 313A and 323A series

SLOTTING						
MATERIAL	ALUMINUM ALLOY (< Si 4%)		ALUMINUM ALLOY (< Si 8%)		ALUMINUM ALLOY (Die Casted)	
DIAMETER (inch)	RPM	FEED	RPM	FEED	RPM	FEED
1/8"	24000	151.2	19900	117.3	16000	88.2
3/16"	24000	151.2	19900	117.3	16000	88.2
1/4"	16000	120.9	13200	93.3	10600	70.1
5/16"	12000	113.4	9900	87.8	8000	66.1
3/8"	10800	110.4	8900	86.4	7200	64.2
7/16"	8800	104.1	7300	81.5	5800	60.2
1/2"	8000	100.8	6600	78.0	5300	58.3
5/8"	6000	94.5	5000	73.6	4000	55.1
3/4"	5000	78.7	4200	62.0	3300	48.8
1"	3840	60.5	3200	47.2	2560	39.7

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



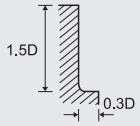
Technical Data

INCH

WAR303A, 313A and 323A series

SIDE MILLING								
MATERIAL	ALUMINUM ALLOY (< Si 4%)		ALUMINUM ALLOY (< Si 8%)		ALUMINUM ALLOY (Die Casted)		COPPER ALLOY	
DIAMETER (inch)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1/8"	24000	188.9	19900	156.7	16000	126.0	12000	94.5
3/16"	24000	188.9	19900	156.7	16000	126.0	12000	94.5
1/4"	16000	151.2	13200	124.4	10600	100.2	8000	75.6
5/16"	12000	141.7	9900	116.9	8000	94.5	6000	70.9
3/8"	10800	138.2	8900	115.2	7200	91.7	5400	69.3
7/16"	8800	130.3	7300	108.7	5800	86.2	4400	65.4
1/2"	8000	126.0	6600	103.9	5300	83.5	4000	63.0
5/8"	6000	118.1	5000	98.4	4000	78.7	3000	59.1
3/4"	5000	98.4	4200	82.7	3300	46.3	2500	49.2
1"	3840	75.6	3200	63.0	2560	50.4	1920	37.8

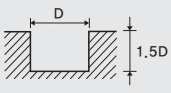
RPM=rev. / min.
FEED=inch / min.

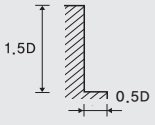


WAF303A, 313A series

SLOTTING & A159SIDE MILLING				
	SLOTTING		SIDE MILLING	
MATERIAL	ALUMINUM ALLOY			
DIAMETER (inch)	RPM	FEED	RPM	FEED
3/8"	4700	16.1	6700	22.8
1/2"	3600	16.3	5100	23.0
5/8"	2800	16.9	4000	24.0
3/4"	2300	18.5	3300	26.4
1"	1800	17.3	2500	24.4

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

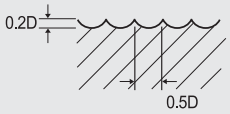




WAB312 series

MATERIAL	GENERAL CUTTING			
	ALUMINIUM ALLOY		COPPER ALLOY	
DIAMETER(mm)	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

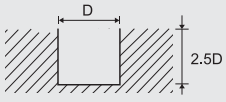
RPM = rev. / min.
FEED = mm / min.



WAE301 series

MATERIAL	SLOTTING		GENERAL CUTTING	
	ACRYLIC		ALLOY STEELS	
DIAMETER(mm)	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.



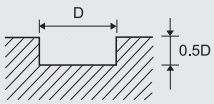
Technical Data

METRIC

WAE302 series

MATERIAL	ALLOY STEELS, CAST IRON		ALUMINUM	
HARDNESS	~HB 230			
DIAMETER(mm)	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.

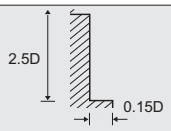


A : Φ3 ~ Φ10 = 0.25 x D
Φ12 ~ Φ20 = 0.5 x D

WAE30(2)3 series

MATERIAL	ALUMINUM, NONFERROUS METALS	
DIAMETER(mm)	RPM	FEED
3	7,000	455
4	7,000	546
5	7,000	651
6	7,000	756
8	5,600	861
10	5,600	1,050
12	5,600	882
14	4,200	1,106
16	4,200	1,211
18	2,800	910
20	2,800	956

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



▫ Please reduce cutting speed around 20~30% from the above table for WAE323 series