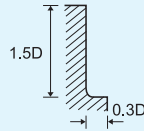


**[ WAR302 series ] ▶ 측면 절삭 가공, 일반가공**

피삭재 외경(mm)	알루미늄 합금 (<Si 4%)		알루미늄 합금 (<Si 8%)		알루미늄 합금 (다이캐스팅)		알루미늄 합금 (Cu계)	
	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
4	24,000	4,800	19,900	3,980	16,000	3,200	12,000	2,400
6	16,000	3,840	13,200	3,160	10,600	2,544	8,000	1,920
8	12,000	3,600	9,900	2,970	8,000	2,400	6,000	1,800
10	9,500	3,420	8,000	2,880	6,300	2,260	4,800	1,720
12	8,000	3,200	6,600	2,640	5,300	2,120	4,000	1,600
14	6,800	2,990	5,600	2,460	4,500	1,980	3,400	1,490
16	6,000	3,000	5,000	2,500	4,000	2,000	3,000	1,500
18	5,300	2,600	4,400	2,200	3,500	1,750	2,600	1,300
20	4,800	2,400	4,000	2,000	3,200	1,600	2,400	1,200

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


**[ WAR302 series ] ▶ 슬로팅 가공, 일반가공**

피삭재 외경(mm)	알루미늄 합금 (<Si 4%)		알루미늄 합금 (<Si 8%)		알루미늄 합금 (다이캐스팅)		알루미늄 합금 (Cu계)	
	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
4	24,000	3,840	19,900	2,980	16,000	2,240	12,000	1,440
6	16,000	3,072	13,200	2,370	10,600	1,780	8,000	1,150
8	12,000	2,880	9,900	2,230	8,000	1,680	6,000	1,080
10	9,500	2,730	8,000	2,160	6,300	1,580	4,800	1,030
12	8,000	2,560	6,600	1,980	5,300	1,480	4,000	960
14	6,800	2,390	5,600	1,845	4,500	1,380	3,400	890
16	6,000	2,400	5,000	1,870	4,000	1,400	3,000	900
18	5,300	2,080	4,400	1,650	3,500	1,220	2,600	780
20	4,800	1,920	4,000	1,500	3,200	1,260	2,400	720

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

