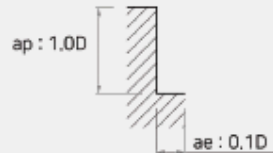


WAR503 SERIES ▶ Side Cutting, General Cutting

Workpiece	Aluminium Alloy (A7075)		Aluminium Alloy Casting (Si13%)		Magnesium Alloy, Copper Alloy	
	Diameter (mm)	RPM	FEED	RPM	FEED	RPM
3	21,000	1,100	21,000	1,100	7,950	325
4	15,500	1,250	15,500	1,250	5,950	365
5	12,500	1,300	12,500	1,275	4,750	385
6	10,500	1,400	10,500	1,400	3,950	400
8	7,950	1,500	7,950	1,500	2,950	460
10	6,350	1,700	6,350	1,700	2,350	475
12	5,300	1,750	5,300	1,750	1,950	510
16	3,950	1,750	3,950	1,750	1,450	510
20	3,150	1,750	3,150	1,750	1,150	510

RPM = rev/min
FEED = mm/min



WAR503 SERIES ▶ Slotting, General Cutting

Workpiece	Aluminium Alloy (A7075)		Aluminium Alloy Casting (Si13%)		Magnesium Alloy, Copper Alloy	
	Diameter (mm)	RPM	FEED	RPM	FEED	RPM
3	40,000	2,100	24,000	1,250	17,000	625
4	32,000	2,250	19,200	1,550	14,300	800
5	32,000	3,250	19,200	1,950	12,700	925
6	26,500	3,500	15,900	2,150	10,600	960
8	20,000	3,750	12,000	2,250	8,000	1,130
10	16,000	4,300	9,600	2,580	6,350	1,150
12	13,300	4,400	8,000	2,650	5,300	1,250
16	10,000	4,400	6,000	2,650	4,000	1,250
20	8,000	4,400	4,800	2,650	3,200	1,250

RPM = rev/min
FEED = mm/min



WAR503 SERIES ▶ Slotting, High Speed Cutting

Workpiece	Aluminium Alloy (A7075)		Aluminium Alloy Casting (Si13%)	
	Diameter (mm)	RPM	FEED	RPM
3	40,000	1,450	24,000	880
4	32,000	1,700	19,200	1,000
5	32,000	2,200	19,200	1,350
6	26,500	2,400	15,900	1,450
8	20,000	2,500	12,000	1,500
10	16,000	2,800	9,600	1,700
12	13,300	2,950	8,000	1,800
16	10,000	3,000	6,000	1,800
20	8,000	3,000	4,800	1,800

RPM = rev/min
FEED = mm/min

