

ESB702, ESB712 SERIES

| Workpiece | Hardened Steels Heat Resistant Steels | | Hardened Steels | | | | | | | | | |
|------------------|--|-------|-----------------|-------|---------------|-------|---------------|-------|---------------|-------|----------------|-------|
| | HRc30 ~ HRc40 | | HRc40 ~ HRc50 | | HRc50 ~ HRc55 | | HRc55 ~ HRc60 | | HRc60 ~ HRc65 | | HRc 65 ~ HRc70 | |
| Diameter (mm) | RPM | FEED | RPM | FEED | RPM | FEED | RPM | FEED | RPM | FEED | RPM | FEED |
| ~0.2 | 50,000 | 1,200 | 50,000 | 1,050 | 45,000 | 960 | 40,000 | 770 | 35,000 | 674 | 31,500 | 570 |
| 0.3 | 50,000 | 1,500 | 50,000 | 1,350 | 45,000 | 1,200 | 40,000 | 765 | 35,000 | 840 | 31,500 | 700 |
| 0.4 | 50,000 | 1,900 | 50,000 | 1,700 | 45,000 | 1,500 | 40,000 | 1,200 | 35,000 | 1,050 | 31,500 | 1,100 |
| 0.5 | 50,000 | 2,400 | 50,000 | 2,100 | 45,000 | 1,900 | 40,000 | 1,500 | 35,000 | 1,300 | 31,500 | 1,100 |
| 0.6 | 50,000 | 2,900 | 50,000 | 2,500 | 45,000 | 2,200 | 40,000 | 1,800 | 35,000 | 1,600 | 31,500 | 1,400 |
| 0.8 | 50,000 | 3,900 | 50,000 | 3,300 | 45,000 | 3,000 | 40,000 | 2,400 | 35,000 | 1,600 | 31,500 | 1,800 |
| 1 | 50,000 | 4,800 | 50,000 | 4,200 | 45,000 | 3,800 | 40,000 | 3,000 | 35,000 | 2,600 | 35,000 | 2,300 |
| 1.5 | 50,000 | 5,400 | 48,000 | 4,500 | 43,000 | 4,000 | 23,000 | 3,100 | 33,000 | 2,700 | 29,700 | 2,300 |
| 2 | 49,700 | 5,700 | 47,800 | 4,800 | 40,000 | 4,000 | 35,000 | 3,150 | 32,000 | 2,800 | 28,500 | 2,300 |
| 3 | 33,100 | 6,000 | 31,800 | 5,300 | 26,500 | 4,000 | 23,500 | 3,150 | 21,000 | 28,00 | 19,000 | 2,300 |
| 4 | 24,900 | 6,000 | 23,900 | 5,300 | 20,000 | 4,000 | 17,500 | 3,150 | 16,000 | 2,800 | 14,500 | 2,300 |
| 5 | 18.6 | 5,800 | 17,800 | 4,900 | 15,000 | 3,750 | 13,500 | 3,050 | 11,500 | 2,550 | 10,500 | 2,100 |
| 6 | 13,900 | 4,850 | 13,400 | 4,100 | 11,000 | 3,100 | 10,000 | 2,500 | 8,800 | 2,150 | 8,000 | 1,750 |
| 8 | 11,100 | 4,200 | 10,700 | 3,500 | 9,000 | 2,700 | 8,000 | 2,150 | 7,000 | 1,850 | 6,500 | 1,550 |
| 10 | 9,300 | 3,700 | 8,900 | 3,100 | 7,500 | 2,400 | 6,600 | 1,900 | 5,800 | 1,650 | 5,300 | 1,380 |
| 12 | 6,950 | 2,950 | 6,680 | 2,500 | 5,600 | 1,900 | 5,000 | 1,550 | 4,400 | 1,250 | 4,000 | 1,050 |

RPM = rev/min
FEED = mm/min

