

ESLNB20 SERIES

Work-piece	Alloy Steels, Heat Resistant Steels			Herdened Steels			Herdened Steels			Copper, Copper alloy		
Hardness	HRc30-HRc45			HRc45-HRc55			HRc55-HRc65			-		
Diameter (mm)	RPM	FEED	Ap (mm)	RPM	FEED	Ap (mm)	RPM	FEED	Ap (mm)	RPM	FEED	Ap (mm)
0.5	34,100-49,500	600-870	0.007-0.028	31,900-35,200	490-540	0.005-0.023	31,900-35,200	440-480	0.005-0.021	49,000-50,000	1,100-1,400	0.010-0.042
0.6	28,600-40,700	590-850	0.007-0.034	26,400-29,700	480-540	0.006-0.028	26,400-29,700	400-480	0.006-0.025	42,000-50,000	1,100-1,700	0.011-0.050
0.8	22,000-30,800	640-890	0.016-0.064	19,800-22,000	490-550	0.013-0.052	19,800-22,000	440-500	0.012-0.048	31,000-50,000	1,100-2,250	0.024-0.096
1	17,600-24,200	600-850	0.008-0.080	15,400-17,600	470-540	0.007-0.065	15,400-17,600	440-500	0.006-0.060	24,000-49,500	1,100-2,200	0.012-0.120
1.2	14,300-18,700	590-790	0.024-0.032	12,000-14,000	480-540	0.020-0.026	12,000-14,000	420-480	0.018-0.024	28,500-38,500	1,480-1,950	0.036-0.048
1.5	11,000-14,300	580-760	0.031-0.048	10,000-11,500	480-540	0.025-0.039	10,000-11,500	420-480	0.023-0.036	17,000-28,500	1,100-1,950	0.046-0.072
2	8,500-11,000	590-800	0.024-0.160	7,900-8,800	470-530	0.020-0.130	7,900-8,800	440-480	0.018-0.120	12,600-24,000	1,100-2,150	0.036-0.240
3	5,700-8,200	730-1,000	0.064-0.24	5,300-5,800	590-650	0.052-0.195	5,300-5,800	550-620	0.048-0.120	11,900-17,000	1,850-2,700	0.096-0.360
4	4,300-6,200	680-990	0.080-0.320	3,950-4,400	550-620	0.065-0.260	3,850-4,400	530-570	0.060-0.240	6,600-12,500	1,260-2,500	0.120-0.480

RPM = rev/min
FEED = mm/min

