

UB502, UB502-P SERIES

Workpiece	Alloy Steels Carbon Steels (SCM, SNCM, S45C)		Prehardened Steels (NAK, CENA, KP4)		Hardened Steels (SKD, SKT, STAVAX)	
Hardness	~ HRC35		HRC35 ~ HRC45		HRC45~HRC55	
Strength	~ 1100N/mm2		1100 ~ 1500N/mm2		1500 ~ 2000N/mm2	
Diameter (mm)	RPM	FEED	RPM	FEED	RPM	FEED
0.1	40,000	550	40,000	500	33,000	400
0.2	30,000	720	30,000	630	27,000	575
0.3	30,000	900	30,000	810	27,000	720
0.4	30,000	1,140	30,000	1,020	27,000	900
0.5	30,000	1,440	30,000	1,260	27,000	1,140
0.6	30,000	1,740	30,000	1,500	27,000	1,320
0.8	30,000	2,340	30,000	1,980	27,000	1,800
1	30,000	2,880	30,000	2,520	27,000	2,280
1.2	30,000	3,060	28,800	2,580	25,800	2,310
1.5	30,000	3,240	28,800	2,700	25,800	2,400
2	29,820	3,420	28,680	2,880	24,000	2,400
3	19,860	3,600	19,080	3,180	15,900	2,400
4	14,940	3,600	14,340	3,180	12,000	2,400
5	11,160	3,480	10,680	2,940	9,000	2,250
6	8,340	2,910	8,040	2,460	6,600	1,860
8	6,660	2,520	6,420	2,100	5,400	1,620
10	5,580	2,220	5,340	1,860	4,500	1,440
12	4,170	1,770	4,008	1,500	3,360	1,140
16	3,340	1,590	3,210	1,320	2,700	1,020
20	2,670	1,410	2,580	1,170	2,160	900
25	2,130	1,150	2,060	950	1,730	730

RPM = rev/min
FEED = mm/min

