

UB503 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
3	13,500	1,700	13,200	1,620	12,500	860
4	10,600	1,700	10,300	1,620	9,800	860
5	9,400	1,650	9,050	1,570	8,600	860
6	8,600	1,750	8,250	1,670	7,850	865
8	7,000	1,550	6,700	1,460	6,350	890
10	6,050	1,450	5,800	1,360	5,450	870
12	5,450	1,420	5,200	1,330	4,900	785
16	4,300	1,200	4,000	1,100	3,700	650
20	3,600	1,050	3,200	900	3,000	550

RPM = rev/min
FEED = mm/min

