

## UB504 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/mm <sup>2</sup>		1100 - 1500N/mm <sup>2</sup>		1500 - 2000N/mm <sup>2</sup>	
Diameter (mm)	RPM	FEED	RPM	FEED	RPM	FEED
1	48,000	3,300	35,000	2,350	32,000	2,200
1.5	38,400	4,100	28,000	2,900	25,600	2,700
2	31,680	4,600	23,100	3,300	21,000	3,100
3	24,000	5,430	17,500	3,880	16,000	3,650
4	20,130	5,430	14,880	3,880	14,220	3,650
5	16,780	5,430	12,400	3,690	11,670	3,470
6	15,200	6,220	12,200	4,500	11,100	3,830
8	11,300	5,250	9,200	3,980	8,320	3,350
10	9,100	4,590	7,350	3,450	6,660	2,870
12	7,590	4,260	6,130	3,190	5,530	2,400

RPM = rev/min  
FEED = mm/min

