

UB532 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	35,000	2,800	33,000	2,600	12,000	900
4	26,000	2,300	25,000	2,200	9,000	800
5	21,000	2,100	20,000	2,000	7,000	700
6	17,000	1,900	16,000	1,800	6,000	650
8	13,000	1,700	12,000	1,600	4,500	550
10	10,500	1,450	10,000	1,400	3,500	500
12	9,000	1,400	8,000	1,300	3,000	450

RPM = rev/min
FEED = mm/min

