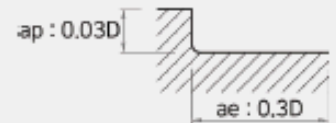


UDR503 SERIES ► General Cutting

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 ²		1100 ~ 1500N/mm ²		1500 ~ 2000N/mm ²	
Diameter (mm)	RPM	FEED	RPM	FEED	RPM	FEED
6.0	5,100	3,500	5,500	3,750	3,850	2,700
8.0	3,800	3,400	4,150	3,700	2,850	2,550
10	3,800	3,750	3,600	3,500	2,700	2,700
12	3,200	4,200	3,250	4,250	2,250	2,300
16	2,400	3,100	2,250	2,900	1,700	1,750
20	1,900	2,500	1,800	2,350	1,350	1,400

RPM = rev/min
FEED = mm/min



UDR503 SERIES ► High Speed Cutting

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 ²		1100 ~ 1500N/mm ²		1500 ~ 2000N/mm ²	
Diameter (mm)	RPM	FEED	RPM	FEED	RPM	FEED
6.0	8,300	5,700	7,650	5,250	6,400	4,550
8.0	6,200	5,550	5,750	5,100	5,250	4,700
10	5,750	5,650	5,000	4,900	4,200	4,250
12	4,800	6,300	4,150	5,450	3,500	3,650
16	3,600	4,700	3,100	4,050	2,650	2,700
20	2,900	3,750	2,500	3,250	2,100	2,150

RPM = rev/min
FEED = mm/min

