

## UE502, UXE502 SERIES

Workpiece	Alloy Steels Carbon Steels (SCM, SNCM, S45C)		Prehardened Steels (NAK, CENA, KP4)		Stainless Steels (SUS)		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)	n (min-1)	Vf (mm/min)	n (min-1)	Vf (mm/min)	n (min-1)	Vf (mm/min)	n (min-1)	Vf (mm/min)
2	11,560	190	7,560	120	6,300	90	5,040	35
3	8,920	210	5,560	140	4,620	120	3,360	40
4	7,560	300	4,620	180	3,880	150	2,940	40
5	6,300	320	3,780	190	3,160	160	2,320	50
6	5,560	350	3,360	220	2,840	180	2,000	55
8	4,200	380	2,520	200	2,100	180	1,680	75
10	3,260	330	2,000	160	1,680	160	1,360	60
12	2,740	280	1,680	130	1,360	130	1,160	55
16	2,200	220	1,360	110	1,060	110	900	40
20	1,680	170	1,060	80	840	80	680	30
25	1,360	130	840	70	680	60	540	20

RPM = rev/min  
FEED = mm/min

