

UE504H 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
1	45,000	750	37,000	560	23,000	300
2	23,500	800	18,000	540	12,000	360
3	15,750	810	12,600	580	8,280	380
4	12,150	830	9,540	600	6,345	400
6	9,450	900	7,470	640	4,950	440
8	7,110	860	5,625	620	3,780	410
10	5,580	800	4,410	570	2,925	380
12	4,770	800	3,780	570	2,520	380
16	3,600	810	2,900	570	2,000	400
20	3,000	810	2,300	570	1,600	400

RPM = rev/min
FEED = mm/min

