

UE504, UXE504 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/mm2		1100 ~ 1500N/mm2		-		1500 ~ 2000N/mm2	
Diameter (mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2	11,560	280	7,560	170	6,300	140	6,300	5,040
3	8,920	320	5,560	200	4,620	170	4,620	3,360
4	7,560	570	4,620	350	3,880	280	3,880	2,940
5	6,300	600	3,780	360	3,160	300	3,160	2,320
6	5,560	660	3,360	410	2,840	330	2,840	2,000
8	4,200	710	2,520	380	2,100	350	2,100	1,680
10	3,260	610	2,000	300	1,680	300	1,680	1,360
12	2,740	520	1,680	250	1,360	240	1,360	1,160
16	2,200	410	1,360	200	1,100	300	1,100	900
20	1,680	320	1,060	160	840	150	840	680
25	1,360	250	840	130	680	120	680	540

RPM = rev / min
FEED = mm / min

