

UE514 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 ²		1100 ~ 1500N/mm ²		-		1500 ~ 2000N/mm ²	
Diameter (mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1.0	22,000	310	13,500	180	10,750	140	8,500	50
1.5	17,000	320	10,700	190	8,500	150	6,500	50
2.0	13,900	330	9,070	200	7,560	165	6,000	60
2.5	12,000	350	7,600	220	6,000	180	4,500	60
3.0	10,700	380	6,670	240	5,110	200	4,030	70
4.0	9,070	680	5,540	420	4,650	330	3,530	70
5.0	7,560	720	4,530	430	3,800	360	2,780	85
6.0	6,670	790	4,030	490	3,400	390	2,400	95
8.0	5,040	850	3,020	450	2,520	420	2,010	130
10	3,910	730	2,400	360	2,010	360	1,630	105
12	3,300	620	2,010	300	1,630	280	1,400	95

RPM = rev/min
FEED = mm/min

