

UE524 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
2	6,300	100	5,040	80	3,150	45
3	4,410	115	3,570	100	2,200	55
4	3,570	140	2,840	115	1,790	60
5	3,050	180	2,420	140	1,580	70
6	2,630	215	2,100	180	1,370	90
8	2,000	230	1,580	180	1,050	90
10	1,680	230	1,370	180	840	90
12	1,370	180	1,160	160	700	70
16	1,160	160	890	125	560	60
20	840	115	680	90	420	45

RPM = rev/min
FEED = mm/min

