

UR502 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/mm ²		1100 ~ 1500N/mm ²		1500 ~ 2000N/mm ²	
Diameter (mm)	RPM	FEED	RPM	FEED	RPM	FEED
0.2	44,000	145	28,800	60	17,600	40
0.3	41,000	170	27,000	70	16,500	45
0.4	41,000	170	27,000	70	16,500	45
0.5	36,000	190	23,400	80	14,300	50
0.6	30,000	210	19,800	90	12,100	55
0.8	30,000	210	19,800	90	12,100	55
1	27,600	240	18,000	100	11,000	60
1.5	22,000	250	13,500	110	8,500	60
2	18,000	260	11,560	120	7,200	70
2.5	15,000	270	9,500	130	6,100	70
3	13,240	280	8,560	140	5,280	70
4	10,720	340	6,820	170	4,300	80
5	9,160	420	5,800	200	3,800	100
6	7,900	500	5,040	250	3,280	120
8	6,000	540	3,800	250	2,520	120
10	5,040	540	3,280	250	2,020	120
12	4,120	420	2,780	230	1,680	100
16	3,100	360	2,100	170	1,280	80
20	2,520	280	1,640	120	1,000	60

RPM = rev/min
FEED = mm/min

