

UR512, UR504 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
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	85
8	2,000	230	1,580	180	1,050	85
10	1,680	230	1,370	180	840	85
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

