

USPM4 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
1	49000	7650	40000	6500	35000	5750
1.5	37000	8550	30000	7200	27000	6400
2	29700	9000	24300	7560	21600	6750
3	19800	9900	16200	8100	14400	7650
4	15300	10800	12600	8550	10800	7920
6	9900	11700	8100	9900	7200	8640
8	7380	11700	6300	9900	5400	8640
10	5850	10800	4950	9000	4320	8550
12	4950	10800	4140	9000	3690	8100
16	3690	9000	3060	7920	2700	7020
20	2970	7200	2430	6300	2160	5670

RPM = rev/min
FEED = mm/min

