

■ UTB502 SERIES

Workpiece	Alloy Steels Carbon Steels [SCM, SNCM, S45C]		Prehardened Steels (NAK, CENA, KP4)	
Hardness	~ HRC35		HRC35 ~ HRC45	
Strength	~ 1100N/mm ²		1100 ~ 1500N/mm ²	
Diameter (mm)	RPM	FEED	RPM	FEED
0.4	36,000	144	27,900	113
0.6	25,200	144	18,900	113
0.8	18,000	144	13,950	108
1	14,850	149	11,250	113
2	7,560	153	5,670	113
3	3,969	108	3,213	90
4	3,213	126	2,556	104

RPM = rev/min
FEED = mm/min

