

UTE502 SERIES

Workpiece	Alloy Steels Carbon Steels (SCM, SNCM, S45C)		Prehardened Steels (NAK, CENA, KP4)	
Hardness	~ HRc35		HRc35 ~ HRc45	
Strength	~ 1100N/mm2		1100 ~ 1500N/mm2	
Diameter (mm)	RPM	FEED	RPM	FEED
0.3	45,000	135	35,000	105
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
6	2,367	189	1,890	153
8	1,800	225	1,422	162
10	1,440	225	1,170	167

RPM = rev/min
FEED = mm/min

