

■ UTR504 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	ap (mm)	RPM	FEED	ap (mm)	RPM	FEED	ap (mm)
0.4	40,000	630	0.008~0.016	32,000	450	0.008~0.012	22,000	270	0.004~0.008
0.6	30,000	630	0.012~0.024	23,000	450	0.012~0.018	15,000	270	0.006~0.012
0.8	22,500	630	0.016~0.032	17,000	450	0.016~0.024	11,500	270	0.008~0.016
1	18,000	630	0.020~0.040	13,500	450	0.020~0.030	9,000	270	0.010~0.020
1.2	14,400	630	0.025~0.050	11,700	450	0.025~0.040	7,200	270	0.012~0.025
1.5	11,700	630	0.030~0.060	9,000	450	0.030~0.050	5,850	270	0.015~0.030
2	9,000	630	0.040~0.080	7,200	450	0.040~0.060	4,500	270	0.020~0.040

RPM = rev/min
FEED = mm/min

