

UXR504 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
1	27,600	300	18,000	220	11,000	120
1.5	22,000	310	13,500	230	8,500	120
2	18,000	320	11,560	240	7,200	130
2.5	15,000	330	9,500	250	6,100	130
3	13,240	340	8,560	260	5,280	130
4	10,720	420	6,820	300	4,300	140
5	9,160	430	5,800	360	3,800	170
6	7,900	430	5,040	360	3,280	170
8	6,000	460	3,800	360	2,520	170
10	5,040	460	3,280	360	2,020	170
12	4,120	360	2,780	320	1,680	140
16	3,100	280	2,100	230	1,280	115
20	2,520	230	1,640	180	1,000	90

RPM = rev/min
FEED = mm/min

