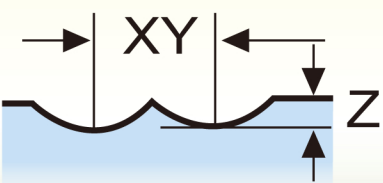


UBH-2T / UBI-2T

Work Material	HRC30-50		HRC50-55		HRC55-62	
Velocity	V=380m/min		V=300m/min		V=150m/min	
Radius	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)
R1	15000	1000	15000	875	15000	750
R1.5	15000	1500	15000	1200	12000	660
R2	15000	1500	15000	1250	10000	600
R2.5	15000	1500	15000	1300	9000	580
R3	15000	1500	15000	1300	8000	550
R4	15000	1500	12000	1000	6000	420
R5	12500	1250	9500	800	4800	340
R6	10000	1000	8000	700	4000	280

■ D:Diameter



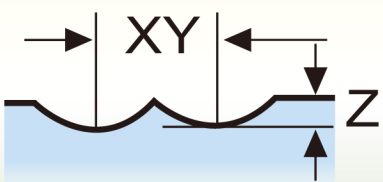
$$XY=0.2D$$

$$Z=0.05D$$

UBJ-2T

Work Material	Carbon Steels S45C.S50C HB150-250		Alloy Steels SCM.P20.PDS5.PDS3 HRC20-35		Prehardened Steels NAK80 HRC35-48		Hardened Steels SKD61 HRC48-60	
Radius	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)
R5	4400	990	3650	640	2950	510	1830	260
R6	3700	990	3050	720	2500	540	1530	300
R8	2800	1080	2300	720	1850	540	1150	270
R10	2200	1080	1850	720	14500	540	750	270

■ D:Diameter



$$XY=0.1D$$

$$Z=0.03D$$