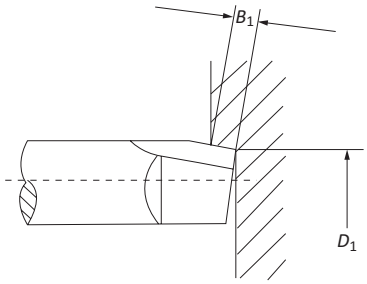
Technical Information | Chip Production Values

Technical Data

	Type	UPA 3	UPA 4	UPA 5-S 6
	Working accuracy	±0.005	±0.005	±0.005
	Diameter range	25.00	35.00	45.00
	MT shank	3.00	4.00	5.00
	ISO shank	30.00	40.00	40.00
	Facing and boring range	0.00 - 260.00	0.00 - 400.00	0.00 - 620.00
	Adjustment of slide (max)	48.00	52.00	112.00
	Self-activated feed of slide per revolution	0.05	0.02, 0.04, 0.06, 0.08, 0.10, 0.12, 0.14, 0.16, 0.18, 0.20, 0.22, 0.24	0.02, 0.04, 0.06, 0.08, 0.10, 0.12, 0.14, 0.16, 0.18, 0.20, 0.22, 0.24
(m)	Fine adjustment of one division	0.01	0.01	0.01
	Fine adjustment of one revolution	1.00	0.40	0.40
	Rapid return per revolution	1.00	–	–
	Rapid return setting per revolution	–	6.00	6.00
	Largest diameter of slide	85.00	115.00	170.00
	Height of boring head without shank	81.00	128.00	128.00
	Tool locations in slide	18.00	22.00	22.00
	Max permissible revolutions	1000	600	600
	End cut off accuracy	±0.05	±0.05	±0.05



Chip Production Values

	Chip Cutting Guide	Type	UPA 3	UPA 4	UPA 5-S 6
	Max load	kW	2.50	7.00	9.50
	With slide feed	mm/rev.	0.050	0.08, 0.12, 0.24	0.08, 0.12, 0.24
	For smaller working Ø	D_1	60.00	150.00	200.00
(m)	Maximum width of chip	B_1	4.00	7.00, 6.00, 4.00	8.00, 7.00, 5.00
	Maximum working Ø	D_1	260.00	400.00	500.00 / 620.00
	Max width of clip without reinforcement rings	B_1	2.00	2.20, 2.00, 1.50	2.50, 2.00, 1.50
	Max width of clip with reinforcement rings*	B_1	–	4.50, 4.00, 3.00	5.00, 4.00, 3.00

*By using the reinforcement rings contained in the normal attachment, chip cutting capacity is increased by 100%

B10-M: 12-13
Key on B10-I: 1
B10: VI-VII

(m) = Metric (mm)