

## UR506 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 <sup>2</sup>		1100 - 1500N/mm <sup>2</sup>		1500 - 2000N/mm <sup>2</sup>	
Diameter (mm)	RPM	FEED	RPM	FEED	RPM	FEED
6	14,880	3,210	14,100	2,940	9,600	2,940
8	12,000	3,300	11,400	3,000	7,200	2,760
10	9,600	2,940	9,300	2,700	5,700	2,460
12	7,800	2,700	7,500	2,460	4,800	2,280
16	6,000	2,400	5,820	2,220	3,600	2,040
20	4,800	2,010	4,680	2,040	2,880	1,920

RPM = rev/min  
FEED = mm/min

