

[TPRB4, TPRE4 series]

WORKPIECE	MILD STEEL, CARBON STEEL, CAST IRON SS400, S55C, FC250 (~750N/mm ²)			CARBON STEEL, TOOL STEELS SCM,SKT,SKS,SKD (~30HRc)			HIGH HARDENED STEELS, PREHARDENED STEELS(FREE-MACHINING) SKT, SKD, NAK55, HPM1 (30~38HRc)		
	DIAMETER(mm)	SPEED (min ⁻¹)	FEED (mm/min)	ap	SPEED (min ⁻¹)	FEED (mm/min)	ap	SPEED (min ⁻¹)	FEED (mm/min)
0.5	31,500	630	0.01~0.025	31,500	565	0.01~0.025	31,500	475	0.01~0.025
0.6	31,500	755	0.012~0.03	31,500	680	0.012~0.03	29,500	530	0.012~0.03
0.7	29,000	940	0.014~0.035	27,000	680	0.014~0.035	25,000	530	0.014~0.035
0.8	25,000	935	0.016~0.04	23,500	680	0.016~0.04	22,000	530	0.016~0.04
0.9	22,500	935	0.018~0.045	21,000	680	0.018~0.045	19,500	530	0.018~0.045
1.0	20,000	930	0.02~0.05	19,000	680	0.02~0.05	17,500	530	0.02~0.05
1.2	16,500	930	0.024~0.06	15,500	680	0.024~0.06	14,500	530	0.024~0.06
1.5	13,500	930	0.03~0.075	12,500	680	0.03~0.075	11,500	530	0.03~0.075
1.6	12,500	930	0.032~0.08	11,500	680	0.032~0.08	11,000	530	0.032~0.08
1.8	11,000	930	0.036~0.09	10,500	680	0.036~0.09	9,900	530	0.036~0.09
2.0	10,000	930	0.04~0.1	9,500	680	0.04~0.1	8,900	530	0.04~0.1
2.5	8,100	930	0.05~0.125	7,600	680	0.05~0.125	7,100	530	0.05~0.125
3.0	6,750	930	0.06~0.15	6,350	680	0.06~0.15	5,900	530	0.06~0.15

WORKPIECE	MILD STEEL, CARBON STEELS, CAST IRON SS400, S55C, FC250 (~750N/mm ²)			ALLOY STEELS, TOOL STEELS SCM,SKT,SKS,SKD (~30HRc)		
	DIAMETER(mm)	SPEED (min ⁻¹)	FEED (mm/min)	ap	SPEED (min ⁻¹)	FEED (mm/min)
0.5	31,500	440	0.01~0.025	19,000	250	0.005~0.01
0.6	26,500	445	0.012~0.03	15,500	260	0.006~0.012
0.7	22,500	445	0.014~0.035	13,500	260	0.007~0.014
0.8	19,500	445	0.016~0.04	11,500	260	0.008~0.016
0.9	17,500	445	0.018~0.045	10,500	260	0.009~0.018
1.0	15,500	445	0.02~0.05	9,500	260	0.01~0.02
1.2	13,000	445	0.024~0.06	7,950	260	0.012~0.024
1.5	10,500	445	0.03~0.075	6,350	260	0.015~0.03
1.6	9,900	445	0.032~0.08	5,950	260	0.016~0.032
1.8	8,800	445	0.036~0.09	5,300	260	0.018~0.036
2.0	7,950	445	0.04~0.1	4,750	260	0.02~0.04
2.5	6,350	445	0.05~0.125	3,800	260	0.025~0.05
3.0	5,300	445	0.06~0.15	3,150	260	0.03~0.06