

[TE503, TB503, TB504 series]

피삭재	주철 FC, FCD		연강 · 탄소강 SS400, S55C (~750N/mm ²)		합금강, 공구강 SCM, SKT, SKS, SKD (~30HRc)		프리하든강 (괘삭) SKT, SKD, NAK55, HPM1 (30~38HRc)		스테인리스강, 열처리강 SUS304, SKD (38~45HRc)		열처리강 (45~55HRc)	
	외경(mm)	SPEED (min ⁻¹)	FEED (mm/min)	SPEED (min ⁻¹)	FEED (mm/min)	SPEED (min ⁻¹)	FEED (mm/min)	SPEED (min ⁻¹)	FEED (mm/min)	SPEED (min ⁻¹)	FEED (mm/min)	SPEED (min ⁻¹)
1.0	20,125	231.25	17,825	193.75	17,825	162.5	14,950	112.5	13,800	112.5	12,075	50
1.5	13,225	231.25	12,075	193.75	12,075	162.5	10,235	112.5	9,487.5	112.5	8,050	50
2.0	10,235	237.5	9,142.5	193.75	9,142.5	162.5	76,475	112.5	7,130	112.5	6,037.5	50
2.5	8,165	237.5	7,130	181.25	7,130	156.25	6,095	112.5	5,692.5	112.5	4,830	50
3.0	6,785	237.5	5,922.5	181.25	5,922.5	156.25	5,117.5	112.5	4,715	112.5	4,025	50
4.0	5,562.5	237.5	4,457.5	181.25	4,457.5	156.25	3,795	112.5	3,565	106.25	2,990	50
5.0	4,437.5	237.5	3,565	181.25	3,565	156.25	3,047.5	112.5	2,817.5	106.25	2,415	50
6.0	3,392.5	237.5	2,990	181.25	2,990	156.25	2,530	112.5	2,357.5	106.25	2,012.5	50
8.0	2,530	231.25	2,242.5	181.25	2,242.5	156.25	1,897.5	112.5	1,782.5	106.25	1,495	50
10	2,012.5	218.75	1,782.5	181.25	1,782.5	150	1,495	112.5	1,380	106.25	1,207.5	50