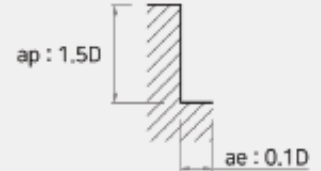
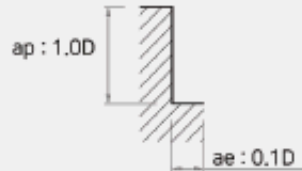


## TX204, TX224, TX304 SERIES

Workpiece	NON-Alloy Steels, Alloy Steels, Cast Iron		Alloy Steels, Heat Resistant Steels		Stainless Steels		Cast Iron		Aluminum Alloys		Copper, Brass nonferrous Metals	
Hardness	~ HRc30		HRc30 ~ HRc45		-		-		-		-	
Strength	~ 1000N/mm <sup>2</sup>		1000 ~ 1500N/mm <sup>2</sup>		-		-		-		-	
Diameter (mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1	17,600	150	10,250	85	8,650	75	18,700	620	44,000	1,050	24,700	605
1.5	11,800	215	7,050	115	7,050	120	12,100	620	27500	1,160	20,300	910
2	9,850	240	6,450	145	5,350	120	9,350	640	22000	1,320	16,500	1,035
3	7,600	270	4,750	170	3,950	145	6,050	640	15400	1,320	11,000	1,035
4	6,450	485	3,950	300	3,300	240	4,600	640	11000	1,320	8,800	1,035
5	5,350	510	3,200	305	2,700	255	3,650	640	9150	1,320	6,800	1,035
6	4,750	560	2,850	350	2,400	280	2,950	770	7600	1,430	5,700	1,100
8	3,550	605	2,150	325	1,800	300	2,200	815	5700	1,430	4,400	1,100
10	2,750	520	1,700	255	1,450	255	1,850	860	4600	1,430	3,400	1,100
12	2,350	440	1,450	215	1,150	205	1,450	900	3750	1,430	2,850	1,100
14	2,100	395	1,300	195	1,050	190	1,300	945	3300	1,430	2,400	1,100
16	1,850	350	1,150	170	950	170	1,100	970	2850	1,430	2,200	1,100
20	1,450	270	900	135	700	130	900	1,035	2200	1,430	1,700	1,100

RPM = rev/min  
FEED = mm/min



\* The FEED for long & extra long types, should be reduced by around 30~40%.