

DHF 被切削材 Work Material									DHF 被切削材 Work Material									DHF 被切削材 Work Material									DHF 被切削材 Work Material								
調質鋼、預硬鋼 Prehardened Steels: NAK80 : 1.2083 : AISI420 : M310 (HRC36-45)									熱處理鋼 Hardened Steels:SKD61/ STAVAX / 17-4PH : 1.2083 / 1.2344 / 1.4542 : H13 / 420 (HRC48-54)									耐蝕不銹鋼 Hardened Steels:(SUS316、1.4401)、(SUS304、1.4301) (HRC30)									耐蝕不銹鋼 Hardened Steels:(SUS316、1.4401)、(SUS304、1.4301) (HRC30)								
型號 Type NO.	刀具伸長量 Extension Length	切削速度 Cutting Speed (m/ min)	迴轉速度 Speed (min ⁻¹)	進給速度 Feed (mm/min)	加工深度(Aa) Depth of Cut	加工寬度(Ap) Width of Cut	加工方式 Milling Type	型號 Type NO.	刀具伸長量 Extension Length	切削速度 Cutting Speed (m/ min)	迴轉速度 Speed (min ⁻¹)	進給速度 Feed (mm/min)	加工深度(Aa) Depth of Cut	加工寬度(Ap) Width of Cut	加工方式 Milling Type	型號 Type NO.	刀具伸長量 Extension Length	切削速度 Cutting Speed (m/ min)	迴轉速度 Speed (min ⁻¹)	進給速度 Feed (mm/min)	加工深度(Aa) Depth of Cut	加工寬度(Ap) Width of Cut	加工方式 Milling Type	型號 Type NO.	刀具伸長量 Extension Length	迴轉速度 Speed (min ⁻¹)	進給速度 Feed (mm/min)	加工深度(Aa) Depth of Cut	加工寬度(Ap) Width of Cut	加工方式 Milling Type					
X-UB0802	25	280	10000~11000	2000~2400	0.18~0.23	0.36~0.46	3D銑(3D milling)	X-UB0802	25	280	10000~11000	2600~3000	0.06~0.09	0.12~0.18	3D銑(3D milling)									溝銑(Slotting)	MBTA0032	10mm	17000~18000	200~300	0.01~0.015	0.3	溝銑(Slotting)				
X-UB0802	25	330	12000~13000	3800~4200	0.08~0.13	0.16~0.26	3D銑(3D milling)	X-UB0802	45	145	5400~5800	1600~2000	0.06~0.08	0.12~0.16	3D銑(3D milling)									溝銑(Slotting)	MBTA0032	10mm	17000~18000	250~350	0.005~0.01	0.3	溝銑(Slotting)				
X-UB0802	45	185	6700~7300	1200~1600	0.15~0.2	0.3~0.4	3D銑(3D milling)	X-UB0802	65	130	4700~5200	1200~1600	0.06~0.08	0.12~0.16	3D銑(3D milling)									3D銑(3D milling)	MBTA0032	10mm	17000~18000	300~400	0.01~0.015	0.03	3D銑(3D milling)				
X-UB0802	45	225	8300~8800	1800~2200	0.08~0.1	0.16~0.2	3D銑(3D milling)	X-UB1002	40	260	7700~8200	2600~3000	0.08~0.13	0.16~0.26	3D銑(3D milling)									3D銑(3D milling)	MBTA0032	10mm	17000~18000	350~450	0.005~0.01	0.02	3D銑(3D milling)				
X-UB0802	65	175	6000~7000	1200~1600	0.08~0.1	0.16~0.2	3D銑(3D milling)	X-UB1002	60	230	6700~7200	1400~1800	0.08~0.13	0.16~0.26	3D銑(3D milling)									溝銑(Slotting)	MBTA0042	10mm	17000~18000	300~400	0.01~0.02	0.4	溝銑(Slotting)				
X-UB1002	40	290	8700~9200	2600~3000	0.23~0.28	0.46~0.56	3D銑(3D milling)	X-UB1002	80	185	5300~5800	1000~1200	0.07~0.1	0.16~0.2	3D銑(3D milling)									溝銑(Slotting)	MBTA0042	10mm	17000~18000	350~450	0.01~0.015	0.4	溝銑(Slotting)				
X-UB1002	40	290	8700~9200	3600~4000	0.1~0.15	0.2~0.3	3D銑(3D milling)	X-UB1202	40	305	7500~8000	1800~2200	0.08~0.13	0.16~0.26	3D銑(3D milling)									3D銑(3D milling)	MBTA0042	10mm	17000~18000	400~500	0.01~0.02	0.06	3D銑(3D milling)				
X-UB1002	60	290	8700~9200	1800~2200	0.1~0.15	0.2~0.3	3D銑(3D milling)	X-UB1202	60	290	7200~7700	1200~1600	0.08~0.13	0.16~0.26	3D銑(3D milling)									3D銑(3D milling)	MBTA0042	10mm	17000~18000	500~600	0.01~0.015	0.03	3D銑(3D milling)				
X-UB1002	60	290	8700~9200	2200~2600	0.06~0.1	0.12~0.2	3D銑(3D milling)	X-UB1202	100	220	5300~5800	800~1100	0.08~0.13	0.16~0.26	3D銑(3D milling)									溝銑(Slotting)	MBTA0052	10mm	17000~18000	300~500	0.02~0.03	0.5	溝銑(Slotting)				
X-UB1002	100	195	5700~6200	1100~1300	0.1~0.14	0.2~0.28	3D銑(3D milling)	X-UB1602	60	215	3800~4200	2000~2400	0.1~0.15	0.2~0.3	3D銑(3D milling)									溝銑(Slotting)	MBTA0052	10mm	17000~18000	500~600	0.015~0.025	0.5	溝銑(Slotting)				
X-UB1002	100	260	7700~8200	1400~1700	0.06~0.1	0.12~0.2	3D銑(3D milling)	X-UB1602	100	160	2800~3200	1600~2000	0.1~0.15	0.2~0.3	3D銑(3D milling)									3D銑(3D milling)	MBTA0052	10mm	17000~18000	400~600	0.02~0.03	0.06	3D銑(3D milling)				
X-UB1202	40	325	8200~8600	2200~2600	0.28~0.3	0.56~0.6	3D銑(3D milling)	X-UB1602	130	115	2000~2300	800~1200	0.1~0.12	0.2~0.24	3D銑(3D milling)									3D銑(3D milling)	MBTA0052	10mm	17000~18000	600~800	0.015~0.025	0.06	3D銑(3D milling)				
X-UB1202	40	325	8200~8600	3000~3400	0.1~0.15	0.2~0.3	3D銑(3D milling)	X-UB2002	80	315	4500~5000	1200~1600	0.1~0.15	0.2~0.3	3D銑(3D milling)									溝銑(Slotting)	MBTA0062	10mm	17000~18000	400~600	0.03~0.04	0.6	溝銑(Slotting)				
X-UB1202	60	325	8200~8600	1600~2000	0.2~0.25	0.4~0.5	3D銑(3D milling)	X-UB2002	130	190	2500~3000	800~1200	0.1~0.15	0.2~0.3	3D銑(3D milling)									溝銑(Slotting)	MBTA0062	10mm	17000~18000	600~900	0.02~0.03	0.6	溝銑(Slotting)				
X-UB1202	60	325	8200~8600	2200~2600	0.1~0.15	0.2~0.3	3D銑(3D milling)	X-UB2002	180	140	1700~2200	800~1000	0.08~0.1	0.16~0.2	3D銑(3D milling)									3D銑(3D milling)	MBTA0062	10mm	17000~18000	500~600	0.03~0.04	0.08	3D銑(3D milling)				
X-UB1202	100	220	5300~5800	800~1200	0.1~0.15	0.2~0.3	3D銑(3D milling)	X-UB2502	80	315	3500~4000	1300~1700	0.1~0.15	0.2~0.3	3D銑(3D milling)									3D銑(3D milling)	MBTA0062	10mm	17000~18000	600~800	0.02~0.03	0.06	3D銑(3D milling)				
X-UB1602	60	230	4000~4500	1400~1800	0.23~0.28	0.46~0.56	3D銑(3D milling)	X-UB2502	130	240	2500~3000	1000~1400	0.1~0.15	0.2~0.3	3D銑(3D milling)									溝銑(Slotting)	MBTA0072	10mm	17000~18000	500~700	0.04~0.06	0.7	溝銑(Slotting)				
X-UB1602	60	305	5500~6000	2800~3200	0.12~0.17	0.24~0.34	3D銑(3D milling)	X-UB2502	180	200	2000~2500	800~1200	0.1~0.15	0.2~0.3	3D銑(3D milling)									溝銑(Slotting)	MBTA0072	10mm	17000~18000	800~1000	0.03~0.04	0.7	溝銑(Slotting)				
X-UB1602	100	175	3000~3500	1200~1600	0.23~0.28	0.46~0.56	3D銑(3D milling)	X-UB3202	80	330	3200~3700	1300~1700	0.12~0.17	0.2~0.3	3D銑(3D milling)																				
X-UB1602	100	230	4000~4500	2200~2600	0.12~0.17	0.24~0.34	3D銑(3D milling)	X-UB3202	140	260	2700~3200	1000~1400	0.12~0.17	0.24~0.34	3D銑(3D milling)																				
X-UB1602	140	140	2300~2800	1300~1600	0.1~0.15	0.2~0.3	3D銑(3D milling)	X-UB3202	200	200	1600~2000	700~1100	0.1~0.15	0.2~0.3	3D銑(3D milling)																				
X-UB2002	80	360	5200~5700	1400~1800	0.23~0.28	0.46~0.56	3D銑(3D milling)	附註 / Note:																											
X-UB2002	80	380	5500~6000	2400~2800	0.12~0.17	0.24~0.34	3D銑(3D milling)	1.由於機器剛性及主軸扭力不同，加工時若有尖銳聲音，請調降轉速(S)及進給(F)。																											
X-UB2002	130	190	2500~3000	900~1200	0.2~0.25	0.4~0.5	3D銑(3D milling)	Due to spindle torque and the rigidity of machine differs, please lower the Speed(S) and Feed(F) if hearing sharp voices while milling.																											
X-UB2002	130	220	3000~3500	1600~2000	0.12~0.17	0.24~0.34	3D銑(3D milling)	2.使用BT50(SK50/HSK100A)刀把夾持之機器，可視情況調高轉速(S)及進給(F)。																											
X-UB2002	180	140	1700~2200	1000~1300	0.1~0.15	0.2~0.3	3D銑(3D milling)	For the machine use with holder of BT50(SK50/HSK100A), please higher Speed(S) and Feed(F) according to the cutting condition.																											
X-UB2502	80	330	3500~4000	1300~1700	0.23~0.28	0.46~0.56	3D銑(3D milling)	3.X-UB1002在HRC52伸長量100mm時，條件非常差。																											
X-UB2502	80	350	4000~4500	1800~2200	0.12~0.17	0.24~0.34	3D銑(3D milling)	When X-UB1002 of extension is 100mm in HRC52, the cutting data is not good.																											
X-UB2502	130	220	2400~2800	1000~1400	0.2~0.25	0.4~0.5	3D銑(3D milling)	4.以上冷卻方式皆為乾式。																											
X-UB2502	130	300	3400~3800	1300~1700	0.12~0.17	0.24~0.34	3D銑(3D milling)	Suggest to use Dry coolant.																											
X-UB2502	180	240	2500~3000	1100~1400	0.1~0.15	0.2~0.3	3D銑(3D milling)																												
X-UB3202	80	330	2700~3200	1100~1500	0.23~0.28	0.46~0.56	3D銑(3D milling)																	3D銑(3D milling)	MBTA0082	10mm	17000~18000	700~900	0.05~0.06	0.12	3D銑(3D milling)				
X-UB3202	80	370	3500~4000	1500~1900	0.12~0.17	0.24~0.34	3D銑(3D milling)																	3D銑(3D milling)	MBTA0082	10mm	17000~18000	1000~1300	0.03~0.04	0.08	3D銑(3D milling)				
X-UB3202	140	280	2400~2800	900~1300	0.2~0.25	0.4~0.5	3D銑(3D milling)																	溝銑(Slotting)	MBTA0102	10mm	16000~17000	700~800	0.05~0.06	1	溝銑(Slotting)				
X-UB3202	140	340	3200~3700	1200~1600	0.12~0.17	0.24~0.34	3D銑(3D milling)																	溝銑(Slotting)	MBTA0102	10mm	16000~17000	1200~1400	0.04~0.05	1	溝銑(Slotting)				
X-UB3202	200	220	1800~2200	800~1200	0.1~0.15	0.2~0.3	3D銑(3D milling)																	3D銑(3D milling)	MBTA0102	10mm	16000~17000	900~1100	0.05~0.07	0.14	3D銑(3D milling)				
																								3D銑(3D milling)	MBTA0102	10mm	16000~17000	1300~1500	0.04~0.05	0.1	3D銑(3D milling)				
																								溝銑(Slotting)	MBTA0122	10mm	16000~17000	700~800	0.05~0.06	1.2	溝銑(Slotting)				
																								溝銑(Slotting)	MBTA0122	10mm	16000~17000	1300~1500	0.04~0.05	1.2	溝銑				