DHF

被切削材 Work Material	調質鋼、預硬鋼 Prehardened Steels: NAK80 : 1.2083 : AISI420 : M310 (HRc36~45)						
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
X-UB0804	25	330	12000~13000	4000~4400	0.08~0.13	0.16~0.26	3D銑(3D milling)
X-UB0804	45	225	8300~8800	2000~2400	0.08~0.1	0.16~0.2	3D銑(3D milling)
X-UB0804	65	175	6000~7000	1200~1600	0.08~0.1	0.16~0.2	3D銑(3D milling)
X-UB1004	40	290	8700~9200	3600~4000	0.1~0.15	0.2~0.3	3D銑(3D milling)
X-UB1004	60	290	8700~9200	2400~2800	0.06~0.1	0.12~0.2	3D銑(3D milling)
X-UB1004	100	260	7700~8200	1400~1700	0.06~0.1	0.12~0.2	3D銑(3D milling)
X-UB1204	40	325	8200~8600	3200~3600	0.1~0.15	0.2~0.3	3D銑(3D milling)
X-UB1204	60	325	8200~8600	2400~2800	0.1~0.15	0.2~0.3	3D銑(3D milling)
X-UB1204	100	220	5300~5800	800~1200	0.1~0.15	0.2~0.3	3D銑(3D milling)
X-UB1604	60	305	5500~6000	2800~3200	0.12~0.17	0.24~0.34	3D銑(3D milling)
X-UB1604	100	230	4000~4500	2200~2600	0.12~0.17	0.24~0.34	3D銑(3D milling)
X-UB1604	140	140	2300~2800	1300~1600	0.1~0.15	0.2~0.3	3D銑(3D milling)
X-UB2004	80	380	5500~6000	2800~3200	0.12~0.17	0.24~0.34	3D銑(3D milling)
X-UB2004	130	220	3000~3500	1600~2000	0.12~0.17	0.24~0.34	3D銑(3D milling)
X-UB2004	180	140	1700~2200	1000~1300	0.1~0.15	0.2~0.3	3D銑(3D milling)
X-UB2504	80	350	4000~4500	2000~2400	0.12~0.17	0.24~0.34	3D銑(3D milling)
X-UB2504	130	300	3400~3800	1300~1700	0.12~0.17	0.24~0.34	3D銑(3D milling)
X-UB2504	180	240	2500~3000	1100~1400	0.1~0.15	0.2~0.3	3D銑(3D milling)
X-UB3204	80	370	3500~4000	1600~2000	0.12~0.17	0.24~0.34	3D銑(3D milling)
X-UB3204	140	340	3200~3700	1200~1600	0.12~0.17	0.24~0.34	3D銑(3D milling)
X-UB3204	200	220	1800~2200	800~1200	0.1~0.15	0.2~0.3	3D銑(3D milling)

附註 / Note：

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)。

Due to spindle torque and the rigidity of machine differs, please lower the Speed(S) and Feed(F) if hearing sharp voices while 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)。

For the machine use with holder of BT50(SK50/HSK100A), please higher Speed(S) and Feed(F) according to the cutting condition.

3.以上冷卻方式皆為濕式。

Suggest to use wet coolant.

DHF

被切削材 Work Material	熱處理鋼 Hardened Steels:SKD61/ STAVAX / 17-4PH : 1.2083 / 1.2344 / 1.4542 : H13 / 420 (HRc48~54)						
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
X-UB0804	25	280	10000~11000	2800~3200	0.06~0.09	0.12~0.18	3D銑(3D milling)
X-UB0804	45	145	5400~5800	1800~2200	0.06~0.08	0.12~0.16	3D銑(3D milling)
X-UB0804	65	130	4700~5200	1200~1600	0.06~0.08	0.12~0.16	3D銑(3D milling)
X-UB1004	40	260	7700~8200	2600~3000	0.08~0.13	0.16~0.26	3D銑(3D milling)
X-UB1004	60	230	6700~7200	1600~2000	0.08~0.13	0.16~0.26	3D銑(3D milling)
X-UB1004	80	185	5300~5800	1000~1200	0.07~0.1	0.16~0.2	3D銑(3D milling)
X-UB1204	40	305	7500~8000	2200~2600	0.08~0.13	0.16~0.26	3D銑(3D milling)
X-UB1204	60	290	7200~7700	1400~1800	0.08~0.13	0.16~0.26	3D銑(3D milling)
X-UB1204	100	220	5300~5800	800~1100	0.08~0.13	0.16~0.26	3D銑(3D milling)
X-UB1604	60	215	3800~4200	2000~2400	0.1~0.15	0.2~0.3	3D銑(3D milling)
X-UB1604	100	160	2800~3200	1600~2000	0.1~0.15	0.2~0.3	3D銑(3D milling)
X-UB1604	130	115	2000~2300	800~1200	0.1~0.12	0.2~0.24	3D銑(3D milling)
X-UB2004	80	315	4500~5000	1400~1800	0.1~0.15	0.2~0.3	3D銑(3D milling)
X-UB2004	130	190	2500~3000	900~1300	0.1~0.15	0.2~0.3	3D銑(3D milling)
X-UB2004	180	140	1700~2200	800~1000	0.08~0.1	0.16~0.2	3D銑(3D milling)
X-UB2504	80	315	3500~4000	1400~1800	0.1~0.15	0.2~0.3	3D銑(3D milling)
X-UB2504	130	240	2500~3000	1100~1500	0.1~0.15	0.2~0.3	3D銑(3D milling)
X-UB2504	180	200	2000~2500	800~1200	0.1~0.15	0.2~0.3	3D銑(3D milling)
X-UB3204	80	330	3200~3700	1400~1800	0.12~0.17	0.2~0.3	3D銑(3D milling)
X-UB3204	140	260	2700~3200	1000~1400	0.12~0.17	0.24~0.34	3D銑(3D milling)
X-UB3204	200	200	1600~2000	700~1100	0.1~0.15	0.2~0.3	3D銑(3D milling)

附註 / Note：

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)。

Due to spindle torque and the rigidity of machine differs, please lower the Speed(S) and Feed(F) if hearing sharp voices while 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)。

For the machine use with holder of BT50(SK50/HSK100A), please higher Speed(S) and Feed(F) according to the cutting condition.

3.以上冷卻方式皆為乾式。

Suggest to use Dry coolant.

DHF

被切削材 Work Material	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
							溝銑(Slotting)
							溝銑(Slotting)
							3D銑(3D milling)
							3D銑(3D milling)
							溝銑(Slotting)
							溝銑(Slotting)
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							3D銑(3D milling)
							溝銑(Slotting)
							溝銑(Slotting)

附註 / Note：

以上冷卻方式皆為濕式。

Suggest to use Wet coolant.

DHF

被切削材 Work Material	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	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
MBTA0032	10mm	17000~18000	200~300	0.01~0.015	0,3	溝銑(Slotting)
MBTA0032	10mm	17000~18000	250~350	0.005~0.01	0,3	溝銑(Slotting)
MBTA0032	10mm	17000~18000	300~400	0.01~0.015	0,03	3D銑(3D milling)
MBTA0032	10mm	17000~18000	350~450	0.005~0.01	0,02	3D銑(3D milling)
MBTA0042	10mm	17000~18000	300~400	0.01~0.02	0,4	溝銑(Slotting)
MBTA0042	10mm	17000~18000	350~450	0.01~0.015	0,4	溝銑(Slotting)
MBTA0042	10mm	17000~18000	400~500	0.01~0.02	0,06	3D銑(3D milling)
MBTA0042	10mm	17000~18000	500~600	0.01~0.015	0,03	3D銑(3D milling)
MBTA0052	10mm	17000~18000	300~500	0.02~0.03	0,5	溝銑(Slotting)
MBTA0052	10mm	17000~18000	500~600	0.015~0.025	0,5	溝銑(Slotting)
MBTA0052	10mm	17000~18000	400~600	0.02~0.03	0,06	3D銑(3D milling)
MBTA0052	10mm	17000~18000	600~800	0.015~0.025	0,06	3D銑(3D milling)
MBTA0062	10mm	17000~18000	400~600	0.03~0.04	0,6	溝銑(Slotting)
MBTA0062	10mm	17000~18000	600~900	0.02~0.03	0,6	溝銑(Slotting)
MBTA0062	10mm	17000~18000	500~600	0.03~0.04	0,08	3D銑(3D milling)
MBTA0062	10mm	17000~18000	600~800	0.02~0.03	0,06	3D銑(3D milling)
MBTA0072	10mm	17000~18000	500~700	0.04~0.06	0,7	溝銑(Slotting)
MBTA0072	10mm	17000~18000	800~1000	0.03~0.04	0,7	溝銑(Slotting)
MBTA0082	10mm	17000~18000	700~900	0.05~0.06	0,12	3D銑(3D milling)
MBTA0082	10mm	17000~18000	1000~1300	0.03~0.04	0,08	3D銑(3D milling)
MBTA0102	10mm	16000~17000	700~800	0.05~0.06	1	溝銑(Slotting)
MBTA0102	10mm	16000~17000	1200~1400	0.04~0.05	1	溝銑(Slotting)
MBTA0102	10mm	16000~17000	900~1100	0.05~0.07	0,14	3D銑(3D milling)
MBTA0102	10mm	16000~17000	1300~1500	0.04~0.05	0,1	3D銑(3D milling)
MBTA0122	10mm	16000~17000	700~800	0.05~0.06	1,2	溝銑(Slotting)
MBTA0122	10mm	16000~17000	1300~1500	0.04~0.05	1,2	溝銑(Slotting)
MBTA0122	10mm	16000~17000	900~1100	0.05~0.07	0,14	3D銑(3D milling)
MBTA0122	10mm	16000~17000	1400~1600	0.04~0.05	0,1	3D銑(3D milling)
MBTA0142	10mm	16000~17000	800~1000	0.05~0.06	1,4	溝銑(Slotting)
MBTA0142	10mm	16000~17000	1600~1800	0.04~0.05	1,4	溝銑(Slotting)

附註 / Note：

以上冷卻方式皆為濕式。

Suggest to use Wet coolant.