DHF

被切削材 Work Material	熱處理鋼 Hardened Steels: SKD61/STAVAX/1.2083/17-4PH (HRc52)						
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-UBT0802	25	280	10000~11000	1800~2000	0.15~0.2	0.3~0.4	3D銑(3D milling)
X-UBT0802	25	280	10000~11000	3000~3400	0.07~0.1	0.14~0.2	3D銑(3D milling)
X-UBT0802	45	145	5400~5800	1600~2000	0.06~0.08	0.12~0.16	3D銑(3D milling)
X-UBT0802	65	130	4700~5200	1200~1600	0.06~0.08	0.12~0.16	3D銑(3D milling)
X-UBT1002	40	280	8700~9200	1600~2000	0.2~0.25	0.4~0.5	3D銑(3D milling)
X-UBT1002	40	280	8700~9200	2600~3000	0.08~0.13	0.16~0.26	3D銑(3D milling)
X-UBT1002	60	215	6700~7200	1600~2000	0.08~0.13	0.16~0.26	3D銑(3D milling)
X-UBT1002	80	175	5500~6000	1000~1200	0.07~0.1	0.14~0.2	3D銑(3D milling)
X-UBT1202	40	300	7800~8200	2200~2600	0.25~0.3	0.5~0.6	3D銑(3D milling)
X-UBT1202	40	300	7800~8200	2600~3000	0.1~0.15	0.2~0.3	3D銑(3D milling)
X-UBT1202	60	225	5800~6300	1200~1600	0.2~0.25	0.4~0.5	3D銑(3D milling)
X-UBT1202	60	280	7200~7700	2000~2400	0.1~0.15	0.2~0.3	3D銑(3D milling)
X-UBT1202	100	160	4000~4500	1100~1300	0.1~0.15	0.2~0.3	3D銑(3D milling)
X-UBT1602	60	200	3800~4200	1600~2000	0.2~0.25	0.4~0.5	3D銑(3D milling)
X-UBT1602	60	200	3800~4200	2000~2400	0.1~0.15	0.2~0.3	3D銑(3D milling)
X-UBT1602	100	170	3200~3700	1400~1700	0.1~0.15	0.2~0.3	3D銑(3D milling)
X-UBT1602	130	135	2500~3000	1000~1200	0.1~0.12	0.2~0.24	3D銑(3D milling)
X-UBT2002	80	325	5000~5500	1400~1800	0.2~0.23	0.4~0.46	3D銑(3D milling)
X-UBT2002	80	355	5500~6000	2000~2400	0.1~0.15	0.2~0.3	3D銑(3D milling)
X-UBT2002	130	220	3200~3700	800~1000	0.2~0.23	0.4~0.46	3D銑(3D milling)
X-UBT2002	130	315	4700~5200	1400~1800	0.1~0.15	0.2~0.3	3D銑(3D milling)
X-UBT2002	180	140	1700~2200	800~1000	0.08~0.1	0.16~0.2	3D銑(3D milling)
X-UBT2502	80	300	3200~3700	1000~1400	0.2~0.25	0.35~0.5	3D銑(3D milling)
X-UBT2502	80	315	3500~4000	1300~1700	0.1~0.15	0.2~0.3	3D銑(3D milling)
X-UBT2502	130	240	2500~3000	1000~1400	0.1~0.15	0.2~0.3	3D銑(3D milling)
X-UBT2502	180	200	2000~2500	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.以上冷卻方式皆為油霧、乾式。

Suggest to use MQL and Dry coolant.

DHF

被切削材 Work Material	熱處理鋼 Hardened Steels: SKD11/1.2379/D2 (HRc62)						
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-UBT0802	25	210	7800~8300	2000~2400	0.07~0.1	0.14~0.2	3D銑(3D milling)
X-UBT0802	45	125	4500~5000	1300~1700	0.05~0.08	0.1~0.16	3D銑(3D milling)
X-UBT0802	65	90	3000~3500	700~900	0.05~0.08	0.1~0.16	3D銑(3D milling)
X-UBT1002	40	155	4700~5200	1400~1800	0.1~0.13	0.2~0.26	3D銑(3D milling)
X-UBT1002	60	125	3700~4200	1200~1600	0.08~0.1	0.16~0.2	3D銑(3D milling)
X-UBT1002	80	45	1400~1700	600~800	0.08~0.1	0.16~0.2	3D銑(3D milling)
X-UBT1202	40	240	6200~6700	1600~2000	0.1~0.13	0.2~0.26	3D銑(3D milling)
X-UBT1202	60	185	4700~5200	800~1200	0.08~0.1	0.16~0.2	3D銑(3D milling)
X-UBT1202	100	95	2200~2700	500~700	0.08~0.1	0.16~0.2	3D銑(3D milling)
X-UBT1602	60	150	2700~3200	800~1200	0.1~0.15	0.15~0.25	3D銑(3D milling)
X-UBT1602	100	90	1500~2000	800~1200	0.07~0.1	0.07~0.1	3D銑(3D milling)
X-UBT1602	130	90	1500~2000	600~1000	0.07~0.1	0.07~0.1	3D銑(3D milling)
X-UBT2002	80	110	1500~2000	800~1200	0.07~0.1	0.07~0.1	3D銑(3D milling)
X-UBT2002	130	100	1500~1700	600~800	0.07~0.1	0.07~0.1	3D銑(3D milling)
X-UBT2502	80	150	1800~2300	800~1200	0.1~0.15	0.2~0.3	3D銑(3D milling)
X-UBT2502	130	120	1300~1700	700~1000	0.1~0.15	0.2~0.3	3D銑(3D milling)
X-UBT2502	180	100	1100~1400	600~900	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.以上冷卻方式皆為油霧、乾式。

Suggest to use MQL and 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)
							3D銑(3D milling)
							3D銑(3D milling)
							溝銑(Slotting)
							溝銑(Slotting)
							3D銑(3D milling)
							3D銑(3D milling)
							溝銑(Slotting)
							溝銑(Slotting)
							3D銑(3D milling)
							3D銑(3D milling)
							溝銑(Slotting)
							溝銑(Slotting)
							3D銑(3D milling)
							3D銑(3D milling)
							溝銑(Slotting)
							溝銑(Slotting)
							3D銑(3D milling)
							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.