



被切削材 Work Material	調質鋼、預硬鋼 Prehardened Steels: NAK80 : 1.2083 : AISI420 : M310 (HRc38)							Milling
	型號 Type NO.	刀具伸長量 Extension Length	切削速度 Cutting Speed (m/min)	迴轉速度 Speed (mim ⁻¹)	進給速度 Feed (mm/min)	加工深度(Aa) Depth of Cut	加工寬度(Ap) Width of Cut	
Xs-BTB0802	30	280	10000~11000	2200~2600	0.18~0.23	0.36~0.46	3D銑(3D milling)	
Xs-BTB0802	30	330	12000~13000	3600~4000	0.08~0.13	0.16~0.26	3D銑(3D milling)	
Xs-BTB0802	50	185	6700~7300	1400~1800	0.15~0.2	0.3~0.4	3D銑(3D milling)	
Xs-BTB0802	50	225	8300~8800	2000~2400	0.08~0.1	0.16~0.2	3D銑(3D milling)	
Xs-BTB0802	70	175	6000~7000	1400~1800	0.08~0.1	0.16~0.2	3D銑(3D milling)	
Xs-BTB1002	40	290	8700~9200	2200~2600	0.23~0.28	0.46~0.56	3D銑(3D milling)	
Xs-BTB1002	40	290	8700~9200	3200~3600	0.1~0.15	0.2~0.3	3D銑(3D milling)	
Xs-BTB1002	60	290	8700~9200	1600~2000	0.1~0.15	0.2~0.3	3D銑(3D milling)	
Xs-BTB1002	60	290	8700~9200	2000~2400	0.06~0.1	0.12~0.2	3D銑(3D milling)	
Xs-BTB1002	100	195	5700~6200	1000~1200	0.1~0.14	0.2~0.28	3D銑(3D milling)	
Xs-BTB1002	100	260	7700~8200	1200~1500	0.06~0.1	0.12~0.2	3D銑(3D milling)	
Xs-BTB1202	40	325	8200~8600	2100~2500	0.28~0.3	0.56~0.6	3D銑(3D milling)	
Xs-BTB1202	40	325	8200~8600	2800~3200	0.1~0.15	0.2~0.3	3D銑(3D milling)	
Xs-BTB1202	60	325	8200~8600	1600~2000	0.2~0.25	0.4~0.5	3D銑(3D milling)	
Xs-BTB1202	60	325	8200~8600	2200~2600	0.1~0.15	0.2~0.3	3D銑(3D milling)	
Xs-BTB1202	100	220	5300~5800	800~1200	0.1~0.15	0.2~0.3	3D銑(3D milling)	
Xs-BTB1602	60	230	4000~4500	1600~2000	0.23~0.28	0.46~0.56	3D銑(3D milling)	
Xs-BTB1602	60	305	5500~6000	2600~3000	0.12~0.17	0.24~0.34	3D銑(3D milling)	
Xs-BTB1602	100	175	3000~3500	1400~1800	0.23~0.28	0.46~0.56	3D銑(3D milling)	
Xs-BTB1602	100	230	4000~4500	2000~2400	0.12~0.17	0.24~0.34	3D銑(3D milling)	
Xs-BTB1602	140	140	2300~2800	1200~1500	0.1~0.15	0.2~0.3	3D銑(3D milling)	
Xs-BTB2002	80	330	4700~5200	1600~2000	0.23~0.28	0.46~0.56	3D銑(3D milling)	
Xs-BTB2002	80	380	5500~6000	2000~2400	0.12~0.17	0.24~0.34	3D銑(3D milling)	
Xs-BTB2002	130	160	2000~2500	1100~1400	0.2~0.25	0.4~0.5	3D銑(3D milling)	
Xs-BTB2002	130	220	3000~3500	1200~1600	0.12~0.17	0.24~0.34	3D銑(3D milling)	
Xs-BTB2002	180	140	1800~2200	1000~1300	0.1~0.15	0.2~0.3	3D銑(3D milling)	
Xs-BTB2502	80	330	3500~4000	1300~1700	0.23~0.28	0.46~0.56	3D銑(3D milling)	
Xs-BTB2502	80	350	4000~4500	1800~2200	0.12~0.17	0.24~0.34	3D銑(3D milling)	
Xs-BTB2502	130	220	2400~2800	1000~1400	0.2~0.25	0.4~0.5	3D銑(3D milling)	
Xs-BTB2502	130	300	3400~3800	1300~1700	0.12~0.17	0.24~0.34	3D銑(3D milling)	
Xs-BTB2502	180	240	2500~3000	1100~1400	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.