



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)						被切削材 Work Material		熱處理鋼 Hardened Steels: SKD11 / SKH9 : 1.2379 / 1.3342 : D2 / M2 (HRc55~62)					
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
Xs-UBT0802	25	280	10000~11000	1800~2000	0.15~0.2	0.3~0.4	3D銑(3D milling)	Xs-UBT0802	25	210	7800~8300	2000~2400	0.07~0.1	0.14~0.2	3D銑(3D milling)
Xs-UBT0802	25	280	10000~11000	3000~3400	0.07~0.1	0.14~0.2	3D銑(3D milling)	Xs-UBT0802	45	125	4500~5000	1300~1700	0.05~0.08	0.1~0.16	3D銑(3D milling)
Xs-UBT0802	45	145	5400~5800	1600~2000	0.06~0.08	0.12~0.16	3D銑(3D milling)	Xs-UBT0802	65	90	3000~3500	700~900	0.05~0.08	0.1~0.16	3D銑(3D milling)
Xs-UBT0802	65	130	4700~5200	1200~1600	0.06~0.08	0.12~0.16	3D銑(3D milling)	Xs-UBT1002	40	155	4700~5200	1400~1800	0.1~0.13	0.2~0.26	3D銑(3D milling)
Xs-UBT1002	40	280	8700~9200	1600~2000	0.2~0.25	0.4~0.5	3D銑(3D milling)	Xs-UBT1002	60	125	3700~4200	1200~1600	0.08~0.1	0.16~0.2	3D銑(3D milling)
Xs-UBT1002	40	280	8700~9200	2600~3000	0.08~0.13	0.16~0.26	3D銑(3D milling)	Xs-UBT1002	80	45	1400~1700	600~800	0.08~0.1	0.16~0.2	3D銑(3D milling)
Xs-UBT1002	60	215	6700~7200	1600~2000	0.08~0.13	0.16~0.26	3D銑(3D milling)	Xs-UBT1202	40	240	6200~6700	1600~2000	0.1~0.13	0.2~0.26	3D銑(3D milling)
Xs-UBT1002	80	175	5500~6000	1000~1200	0.07~0.1	0.14~0.2	3D銑(3D milling)	Xs-UBT1202	60	185	4700~5200	800~1200	0.08~0.1	0.16~0.2	3D銑(3D milling)
Xs-UBT1202	40	300	7800~8200	2200~2600	0.25~0.3	0.5~0.6	3D銑(3D milling)	Xs-UBT1202	100	95	2200~2700	500~700	0.08~0.1	0.16~0.2	3D銑(3D milling)
Xs-UBT1202	40	300	7800~8200	2600~3000	0.1~0.15	0.2~0.3	3D銑(3D milling)	Xs-UBT1602	60	150	2700~3200	800~1200	0.1~0.15	0.15~0.25	3D銑(3D milling)
Xs-UBT1202	60	225	5800~6300	1200~1600	0.2~0.25	0.4~0.5	3D銑(3D milling)	Xs-UBT1602	100	90	1500~2000	800~1200	0.07~0.1	0.07~0.1	3D銑(3D milling)
Xs-UBT1202	60	280	7200~7700	2000~2400	0.1~0.15	0.2~0.3	3D銑(3D milling)	Xs-UBT1602	130	90	1500~2000	600~1000	0.07~0.1	0.07~0.1	3D銑(3D milling)
Xs-UBT1202	100	160	4000~4500	1100~1300	0.1~0.15	0.2~0.3	3D銑(3D milling)	Xs-UBT2002	80	110	1500~2000	800~1200	0.07~0.1	0.07~0.1	3D銑(3D milling)
Xs-UBT1602	60	200	3800~4200	1600~2000	0.2~0.25	0.4~0.5	3D銑(3D milling)	Xs-UBT2002	130	100	1500~1700	600~800	0.07~0.1	0.07~0.1	3D銑(3D milling)
Xs-UBT1602	60	200	3800~4200	2000~2400	0.1~0.15	0.2~0.3	3D銑(3D milling)	Xs-UBT2502	80	150	1800~2300	800~1200	0.1~0.15	0.2~0.3	3D銑(3D milling)
Xs-UBT1602	100	170	3200~3700	1400~1700	0.1~0.15	0.2~0.3	3D銑(3D milling)	Xs-UBT2502	130	120	1300~1700	700~1000	0.1~0.15	0.2~0.3	3D銑(3D milling)
Xs-UBT1602	130	135	2500~3000	1000~1200	0.1~0.12	0.2~0.24	3D銑(3D milling)	Xs-UBT2502	180	100	1100~1400	600~900	0.1~0.15	0.2~0.3	3D銑(3D milling)
Xs-UBT2002	80	325	5000~5500	1400~1800	0.2~0.23	0.4~0.46	3D銑(3D milling)	附註 / Note:							
Xs-UBT2002	80	355	5500~6000	2000~2400	0.1~0.15	0.2~0.3	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)。							
Xs-UBT2002	130	220	3200~3700	800~1000	0.2~0.23	0.4~0.46	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.							
Xs-UBT2002	130	315	4700~5200	1400~1800	0.1~0.15	0.2~0.3	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)。							
Xs-UBT2002	180	140	1700~2200	800~1000	0.08~0.1	0.16~0.2	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.							
Xs-UBT2502	80	300	3200~3700	1000~1400	0.2~0.25	0.35~0.5	3D銑(3D milling)	3.以上冷卻方式皆為乾式。							
Xs-UBT2502	80	315	3500~4000	1300~1700	0.1~0.15	0.2~0.3	3D銑(3D milling)	Suggest to use Dry coolant.							
Xs-UBT2502	130	240	2500~3000	1000~1400	0.1~0.15	0.2~0.3	3D銑(3D milling)								
Xs-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.以上冷卻方式皆為乾式。
Suggest to use Dry coolant.