

DHF 被切削材 Work Material									DHF 被切削材 Work Material									DHF 被切削材 Work Material								
合金工具鋼 / 碳工具鋼 : Alloy Tool Steels / Carbon Tool Steels (P20 / P5 / SK3 / SKD61 / SKD11 : 1.2311 / 1.1545 / 1.2379 / 1.2344 : H13 / D2 (HRC23-32))									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))								
型號 Type NO.	刀具伸長量 Extension Length	切削速度 Cutting Speed (m/min)	進轉速度 Speed (mm/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	型號 Type NO.	刀具伸長量 Extension Length	切削速度 Cutting Speed (m/min)	進轉速度 Speed (mm/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	型號 Type NO.	刀具伸長量 Extension Length	切削速度 Cutting Speed (m/min)	進轉速度 Speed (mm/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			
X-UET0804	25	105	5000-5500	1200-1600	0.15-0.3	6-8	溝銹(Slotting)	X-UET0804	25	105	5000-5500	1200-1600	0.15-0.3	6-8	溝銹(Slotting)	X-UET0804	25	80	3000-3400	800-1000	0.05-0.1	6-8	溝銹(Slotting)			
X-UET0804	25	105	5000-5500	700-900	0.5-1	6-8	溝銹(Slotting)	X-UET0804	25	105	5000-5500	700-900	0.5-1	6-8	溝銹(Slotting)	X-UET0804	25	65	2400-2800	400-600	8	0.05-0.1	6-8	側銹(Side milling)		
X-UET0804	25	105	5000-5500	800-1200	0.05-0.1	6-8	溝銹(Slotting)	X-UET0804	25	105	5000-5500	800-1200	0.05-0.1	6-8	溝銹(Slotting)	X-UET0804	25	130	5000-5500	800-1000	8	0.05-0.1	6-8	側銹(Side milling)		
X-UET0804	25	105	5000-5500	1600-2000	8	0.15-0.3	側銹(Side milling)	X-UET0804	25	105	5000-5500	1600-2000	8	0.15-0.3	側銹(Side milling)	X-UET0804	45	65	2400-2800	400-600	0.05-0.1	6-8	溝銹(Slotting)			
X-UET0804	25	105	5000-5500	1000-1400	8	0.5-1	側銹(Side milling)	X-UET0804	25	105	5000-5500	1000-1400	8	0.5-1	側銹(Side milling)	X-UET0804	45	55	2000-2400	400-600	8	0.05-0.1	8-10	側銹(Side milling)		
X-UET0804	25	105	5000-5500	800-1000	8	0.05-0.1	側銹(Side milling)	X-UET0804	25	105	5000-5500	800-1000	8	0.05-0.1	側銹(Side milling)	X-UET1004	30	80	2400-2800	600-800	0.05-0.1	8-10	溝銹(Slotting)			
X-UET0804	45	65	2500-2800	600-800	0.1-0.2	6-8	溝銹(Slotting)	X-UET0804	45	65	2500-2800	600-800	0.1-0.2	6-8	溝銹(Slotting)	X-UET1004	30	70	2000-2400	400-600	10	0.05-0.1	側銹(Side milling)			
X-UET0804	45	100	3800-4200	600-800	0.05-0.1	6-8	溝銹(Slotting)	X-UET0804	45	100	3800-4200	600-800	0.05-0.1	6-8	溝銹(Slotting)	X-UET1004	50	60	1800-2200	400-600	0.05-0.1	8-10	溝銹(Slotting)			
X-UET0804	45	95	3600-4000	800-1000	8	0.1-0.2	側銹(Side milling)	X-UET0804	45	95	3600-4000	800-1000	8	0.1-0.2	側銹(Side milling)	X-UET1004	50	60	1800-2200	400-600	10	0.05-0.1	側銹(Side milling)			
X-UET0804	45	100	3800-4200	600-800	8	0.05-0.1	側銹(Side milling)	X-UET0804	45	100	3800-4200	600-800	8	0.05-0.1	側銹(Side milling)	X-UET1004	70	55	1600-2000	200-400	0.05-0.1	8-10	側銹(Side milling)			
X-UET0804	60	50	1800-2200	300-500	0.05-0.1	6-8	溝銹(Slotting)	X-UET0804	60	50	1800-2200	300-500	0.05-0.1	6-8	溝銹(Slotting)	X-UET1004	70	55	1600-2000	300-500	10	0.05-0.1	側銹(Side milling)			
X-UET0804	60	75	2700-3200	400-600	8	0.05-0.1	側銹(Side milling)	X-UET0804	60	75	2700-3200	400-600	8	0.05-0.1	側銹(Side milling)	X-UET1204	35	80	2000-2400	450-650	0.1-0.15	10-12	溝銹(Slotting)			
X-UET1004	30	150	4500-5000	1400-1800	0.2-0.4	8-10	溝銹(Slotting)	X-UET1004	30	150	4500-5000	1400-1800	0.2-0.4	8-10	溝銹(Slotting)	X-UET1204	35	80	2000-2400	400-600	12	0.1-0.15	側銹(Side milling)			
X-UET1004	30	150	4500-5000	800-1000	0.5-1	8-10	溝銹(Slotting)	X-UET1004	30	150	4500-5000	800-1000	0.5-1	8-10	溝銹(Slotting)	X-UET1204	60	75	1800-2200	300-500	0.1-0.15	10-12	溝銹(Slotting)			
X-UET1004	30	150	4500-5000	800-1200	0.05-0.1	8-10	溝銹(Slotting)	X-UET1004	30	150	4500-5000	800-1200	0.05-0.1	8-10	溝銹(Slotting)	X-UET1204	60	75	1800-2200	300-500	12	0.1-0.15	側銹(Side milling)			
X-UET1004	30	150	4500-5000	2000-2400	10	0.2-0.4	側銹(Side milling)	X-UET1004	30	150	4500-5000	2000-2400	10	0.2-0.4	側銹(Side milling)	X-UET1204	80	50	1200-1600	200-300	0.1-0.15	10-12	溝銹(Slotting)			
X-UET1004	30	150	4500-5000	1200-1600	10	0.5-1	側銹(Side milling)	X-UET1004	30	150	4500-5000	1200-1600	10	0.5-1	側銹(Side milling)	X-UET1204	80	70	1600-2000	300-400	12	0.1-0.15	側銹(Side milling)			
X-UET1004	30	150	4500-5000	800-1200	10	0.05-0.1	側銹(Side milling)	X-UET1004	30	150	4500-5000	800-1200	10	0.05-0.1	側銹(Side milling)	X-UET1604	45	80	1400-1800	300-500	0.1-0.15	14-16	溝銹(Slotting)			
X-UET1004	50	80	2400-2800	800-1200	0.1-0.25	8-10	溝銹(Slotting)	X-UET1004	50	80	2400-2800	800-1200	0.15-0.25	8-10	溝銹(Slotting)	X-UET1604	45	70	1300-1600	300-500	16	0.1-0.15	側銹(Side milling)			
X-UET1004	50	100	3000-3400	600-800	0.05-0.1	8-10	溝銹(Slotting)	X-UET1004	50	100	3000-3400	600-800	0.05-0.1	8-10	溝銹(Slotting)	X-UET1604	70	65	1200-1600	300-400	0.1-0.15	14-16	溝銹(Slotting)			
X-UET1004	50	120	3600-4000	800-1200	10	0.2-0.4	側銹(Side milling)	X-UET1004	50	120	3600-4000	800-1200	10	0.2-0.4	側銹(Side milling)	X-UET1604	70	65	1200-1600	300-400	16	0.1-0.15	側銹(Side milling)			
X-UET1004	50	120	3600-4000	600-800	10	0.05-0.1	側銹(Side milling)	X-UET1004	50	120	3600-4000	600-800	10	0.05-0.1	側銹(Side milling)	X-UET1604	110	50	800-1200	200-300	0.1-0.15	14-16	溝銹(Slotting)			
X-UET1004	70	30	800-1200	300-500	0.05-0.1	8-10	溝銹(Slotting)	X-UET1004	70	30	800-1200	300-500	0.05-0.1	8-10	溝銹(Slotting)	X-UET1604	110	50	800-1200	200-300	16	0.1-0.15	側銹(Side milling)			
X-UET1004	70	60	1800-2200	300-500	10	0.05-0.1	側銹(Side milling)	X-UET1004	70	60	1800-2200	300-500	10	0.05-0.1	側銹(Side milling)	X-UET2004	60	80	1100-1500	300-500	0.1-0.2	18-20	溝銹(Slotting)			
X-UET1204	35	145	3600-4000	1800-2200	0.3-0.5	10-12	溝銹(Slotting)	X-UET1204	35	145	3600-4000	1800-2200	0.3-0.5	10-12	溝銹(Slotting)	X-UET2004	60	70	1000-1300	300-500	20	0.1-0.2	側銹(Side milling)			
X-UET1204	35	135	3400-3800	800-1000	0.8-1.2	10-12	溝銹(Slotting)	X-UET1204	35	135	3400-3800	800-1000	0.8-1.2	10-12	溝銹(Slotting)	X-UET2004	90	65	900-1300	300-400	0.15-0.2	18-20	溝銹(Slotting)			
X-UET1204	35	145	3600-4000	800-1200	0.1-0.15	10-12	溝銹(Slotting)	X-UET1204	35	145	3600-4000	800-1200	0.1-0.15	10-12	溝銹(Slotting)	X-UET2004	90	65	900-1300	300-400	20	0.15-0.2	側銹(Side milling)			
X-UET1204	35	145	3600-4000	2000-2400	12	0.3-0.5	側銹(Side milling)	X-UET1204	35	145	3600-4000	2000-2400	12	0.3-0.5	側銹(Side milling)	X-UET2004	120	50	600-1000	200-300	0.15-0.2	18-20	溝銹(Slotting)			
X-UET1204	35	145	3600-4000	1200-1600	12	0.8-1.2	側銹(Side milling)	X-UET1204	35	145	3600-4000	1200-1600	12	0.8-1.2	側銹(Side milling)	X-UET2004	120	50	600-1000	200-300	20	0.15-0.2	側銹(Side milling)			
X-UET1204	35	145	3600-4000	800-1200	12	0.1-0.15	側銹(Side milling)	X-UET1204	35	145	3600-4000	800-1200	12	0.1-0.15	側銹(Side milling)	X-UET2504	60	80	800-1200	250-450	0.1-0.2	23-25	溝銹(Slotting)			
X-UET1204	60	75	1800-2200	700-900	0.2-0.3	10-12	溝銹(Slotting)	X-UET1204	60	75	1800-2200	700-900	0.2-0.3	10-12	溝銹(Slotting)	X-UET2504	60	70	700-1100	250-450	25	0.1-0.2	側銹(Side milling)			
X-UET1204	60	135	3400-3800	600-800	0.1-0.15	10-12	溝銹(Slotting)	X-UET1204	60	135	3400-3800	600-800	0.1-0.15	10-12	溝銹(Slotting)	X-UET2504	100	65	650-950	200-350	0.1-0.2	23-25	溝銹(Slotting)			
X-UET1204	60	135	3400-3800	800-1200	12	0.2-0.3	側銹(Side milling)	X-UET1204	60	135	3400-3800	800-1200	12	0.2-0.3	側銹(Side milling)	X-UET2504	100	65	650-950	200-350	25	0.1-0.2	側銹(Side milling)			
X-UET1204	60	135	3400-3800	600-800	12	0.1-0.15	側銹(Side milling)	X-UET1204	60	135	3400-3800	600-800	12	0.1-0.15	側銹(Side milling)	X-UET2504	130	50	500-800	150-250	0.1-0.2	23-25	溝銹(Slotting)			
X-UET1204	80	75	1800-2200	300-500	0.1-0.15	10-12	溝銹(Slotting)	X-UET1204	80	75	1800-2200	300-500	0.1-0.15	10-12	溝銹(Slotting)	X-UET2504	130	50	500-800	150-250	25	0.1-0.2	側銹(Side milling)			
X-UET1204	80	80	2000-2400	300-500	12	0.1-0.15	側銹(Side milling)	X-UET1204	80	80	2000-2400	300-500	12	0.1-0.15	側銹(Side milling)											
X-UET1604	45	150	2700-3200	600-800	0.4-0.7	14-16	溝銹(Slotting)	X-UET1604	45	150	2700-3200	600-800	0.4-0.7	14-16	溝銹(Slotting)	X-UET3204	70	80	700-900	200-400	0.1-0.2	30-32	溝銹(Slotting)			
X-UET1604	45	150	2700-3200	700-900	0.1-0.15	14-16	溝銹(Slotting)	X-UET1604	45	150	2700-3200	700-900	0.1-0.15	14-16	溝銹(Slotting)	X-UET3204	70	70	600-800	200-400	32	0.1-0.2	側銹(Side milling)			
X-UET1604	45	150	2700-3200	1200-1600	16	0.4-0.7	側銹(Side milling)	X-UET1604	45	150	2700-3200	1200-1600	16	0.4-0.7	側銹(Side milling)	X-UET3204	110	65	500-800	150-300	0.1-0.2	30-32	溝銹(Slotting)			
X-UET1604	45	150	2700-3200	600-1000	16	0.8-1.2	側銹(Side milling)	X-UET1604	45	150	2700-3200	600-1000	16	0.8-1.2	側銹(Side milling)	X-UET3204	110	65	500-800	150-300	32	0.1-0.2	側銹(Side milling)			
X-UET1604	45	150	2700-3200	700-900	16	0.1-0.15	側銹(Side milling)	X-UET1604	45	150	2700-3200	700-900	16	0.1-0.15	側銹(Side milling)	X-UET3204	150	50	350-650	100-200	0.1-0.2	30-32	溝銹(Slotting)			
X-UET1604	70	120	2200-2600	800-1000	0.2-0.35	14-16	溝銹(Slotting)	X-UET1604	70	120	2200-2600	800-1000	0.2-0.35	14-16	溝銹(Slotting)	X-UET3204	150	50	350-650	100-200	32	0.1-0.2	側銹(Side milling)			
X-UET1604	70	130	2400-2700	600-800	0.1-0.15	14-16	溝銹(Slotting)	X-UET1604	70	130	2400-2700	600-800	0.1-0.15	14-16	溝銹(Slotting)											
X-UET1604	70	120	2200-2600	1000-1400	16	0.2-0.35	側銹(Side milling)	X-UET1604	70	120	2200-2600	1000-1400	16	0.2-0.35	側銹(Side milling)											
X-UET1604	70	130	2400-2700	600-800	16	0.1-0.15	側銹(Side milling)	X-UET1604	70	130	2400-2700	600-800	16	0.1-0.15	側銹(Side milling)											
X-UET1604	110	100	1800-2200	300-500	0.1-0.15	14-16	溝銹(Slotting)	X-UET1604	110	100	1800-2200	300-500	0.1-0.15	14-16	溝銹(Slotting)											
X-UET1604	110	60	1000-1400	300-500	16	0.1-0.15	側銹(Side milling)	X-UET1604	110	60	1000-1400	300-500	16	0.1-0.15	側銹(Side milling)											
X-UET2004	60	150	2100-2600	500-700	0.5-1	18-20	溝銹(Slotting)	X-UET2004	60																	