



被切削材 Work Material		調質鋼 / 預硬鋼 : Prehardened Steels NAK80 : 1.2083 ; AISI420 : M310 (HRc36-45)							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)	進給速度 Feed	迴轉速度 Speed (mm/min)	加工深度(Aa) Depth of Cut	加工寬度(Ap) Width of Cut	加工方式 Type Milling	型號 Type NO.	刀具伸長量 Extension Length	切削速度 Cutting Speed (m/min)	進給速度 Feed	迴轉速度 Speed (mm/min)	加工深度(Aa) Depth of Cut	加工寬度(Ap) Width of Cut	加工方式 Type Milling
X-UXR0803	30	210	8500-9000	2200-2600	0.15-0.2	7-8	溝銹(Slotting)	X-UXR0803	30	150	5500-6500	1200-1600	0.07-0.1	7-8	溝銹(Slotting)
X-UXR0803	30	210	8500-9000	1400-1800	0.08-0.11	7-8	溝銹(Slotting)	X-UXR0803	30	150	5500-6500	2200-2600	0.07-0.1	0.07-0.1	3D銹(3D milling)
X-UXR0803	30	210	8500-9000	3000-3400	0.15-0.2	0.15-0.2	3D銹(3D milling)	X-UXR0803	50	125	4500-5000	600-1000	0.06-0.08	7-8	溝銹(Slotting)
X-UXR0803	30	210	8500-9000	3200-3600	0.08-0.11	0.08-0.11	3D銹(3D milling)	X-UXR0803	50	125	4500-5000	800-1200	0.07-0.1	0.07-0.1	3D銹(3D milling)
X-UXR0803	50	140	5400-5600	1800-2200	0.15-0.2	7-8	溝銹(Slotting)	X-UXR0803	70	50	1600-2000	400-800	0.06-0.08	7-8	溝銹(Slotting)
X-UXR0803	50	140	5400-5600	700-1100	0.07-0.1	7-8	溝銹(Slotting)	X-UXR0803	70	75	2500-3000	600-1000	0.07-0.1	0.07-0.1	3D銹(3D milling)
X-UXR0803	50	140	5400-5600	2600-3000	0.15-0.2	0.15-0.2	3D銹(3D milling)	X-UXR0805	30	150	5500-6500	1200-1600	0.07-0.1	6-8	溝銹(Slotting)
X-UXR0803	50	140	5400-5600	1400-1800	0.08-0.11	0.08-0.11	3D銹(3D milling)	X-UXR0805	30	150	5500-6500	2200-2600	0.07-0.1	0.07-0.1	3D銹(3D milling)
X-UXR0803	70	55	1700-2200	400-800	0.07-0.1	7-8	溝銹(Slotting)	X-UXR0805	50	125	4500-5000	600-1000	0.06-0.08	6-8	溝銹(Slotting)
X-UXR0803	70	75	2500-3000	800-1200	0.07-0.1	0.07-0.1	3D銹(3D milling)	X-UXR0805	50	125	4500-5000	800-1200	0.07-0.1	0.07-0.1	3D銹(3D milling)
X-UXR0805	30	210	8500-9000	2200-2600	0.15-0.2	6-8	溝銹(Slotting)	X-UXR0805	70	50	1600-2000	400-800	0.06-0.08	6-8	溝銹(Slotting)
X-UXR0805	30	210	8500-9000	1400-1800	0.08-0.11	6-8	溝銹(Slotting)	X-UXR0805	70	75	2500-3000	600-1000	0.07-0.1	0.07-0.1	3D銹(3D milling)
X-UXR0805	30	210	8500-9000	3000-3400	0.15-0.2	0.15-0.2	3D銹(3D milling)	X-UXR0810	30	150	5500-6500	1200-1600	0.07-0.1	5-8	溝銹(Slotting)
X-UXR0805	30	210	8500-9000	3200-3600	0.08-0.11	0.08-0.11	3D銹(3D milling)	X-UXR0810	30	150	5500-6500	2200-2600	0.07-0.1	0.07-0.1	3D銹(3D milling)
X-UXR0805	50	140	5400-5600	1800-2200	0.15-0.2	6-8	溝銹(Slotting)	X-UXR0810	50	125	4500-5000	600-1000	0.06-0.08	5-8	溝銹(Slotting)
X-UXR0805	50	140	5400-5600	700-1100	0.07-0.1	6-8	溝銹(Slotting)	X-UXR0810	50	125	4500-5000	800-1200	0.07-0.1	0.07-0.1	3D銹(3D milling)
X-UXR0805	50	140	5400-5600	2600-3000	0.15-0.2	0.15-0.2	3D銹(3D milling)	X-UXR0810	70	50	1600-2000	400-800	0.06-0.08	5-8	溝銹(Slotting)
X-UXR0805	50	140	5400-5600	1400-1800	0.08-0.11	0.08-0.11	3D銹(3D milling)	X-UXR0810	70	75	2500-3000	600-1000	0.07-0.1	0.07-0.1	3D銹(3D milling)
X-UXR0805	70	55	1700-2200	400-800	0.07-0.1	6-8	溝銹(Slotting)	X-UXR1005	35	160	5000-5500	1400-1800	0.08-0.12	8-10	溝銹(Slotting)
X-UXR0805	70	75	2500-3000	800-1200	0.07-0.1	0.07-0.1	3D銹(3D milling)	X-UXR1005	35	160	5000-5500	2600-3000	0.08-0.12	0.08-0.12	3D銹(3D milling)
X-UXR0810	30	210	8500-9000	2200-2600	0.15-0.2	5-8	溝銹(Slotting)	X-UXR1005	55	150	4700-5200	1200-1600	0.08-0.12	8-10	溝銹(Slotting)
X-UXR0810	30	210	8500-9000	1400-1800	0.08-0.11	5-8	溝銹(Slotting)	X-UXR1005	55	150	4700-5200	1400-1800	0.08-0.12	0.08-0.12	3D銹(3D milling)
X-UXR0810	30	210	8500-9000	3000-3400	0.15-0.2	0.15-0.2	3D銹(3D milling)	X-UXR1005	75	65	1600-2000	400-800	0.07-0.11	8-10	溝銹(Slotting)
X-UXR0810	30	210	8500-9000	3200-3600	0.08-0.11	0.08-0.11	3D銹(3D milling)	X-UXR1005	75	90	2400-2800	600-1000	0.07-0.11	0.07-0.11	3D銹(3D milling)
X-UXR0810	50	140	5400-5600	1800-2200	0.15-0.2	5-8	溝銹(Slotting)	X-UXR1010	35	160	5000-5500	1400-1800	0.08-0.12	7-10	溝銹(Slotting)
X-UXR0810	50	140	5400-5600	700-1100	0.07-0.1	5-8	溝銹(Slotting)	X-UXR1010	35	160	5000-5500	2600-3000	0.08-0.12	0.08-0.12	3D銹(3D milling)
X-UXR0810	50	140	5400-5600	2600-3000	0.15-0.2	0.15-0.2	3D銹(3D milling)	X-UXR1010	55	150	4700-5200	1200-1600	0.08-0.12	7-10	溝銹(Slotting)
X-UXR0810	50	140	5400-5600	1400-1800	0.08-0.11	0.08-0.11	3D銹(3D milling)	X-UXR1010	55	150	4700-5200	1400-1800	0.08-0.12	0.08-0.12	3D銹(3D milling)
X-UXR0810	70	55	1700-2200	400-800	0.07-0.1	5-8	溝銹(Slotting)	X-UXR1010	75	65	1600-2000	400-800	0.07-0.11	7-10	溝銹(Slotting)
X-UXR0810	70	75	2500-3000	800-1200	0.07-0.1	0.07-0.1	3D銹(3D milling)	X-UXR1010	75	90	2400-2800	600-1000	0.07-0.11	0.07-0.11	3D銹(3D milling)
X-UXR1005	35	220	7000-7500	2000-2400	0.18-0.23	8-10	溝銹(中胚)	X-UXR1205	40	140	3500-4000	1200-1600	0.1-0.13	10-12	溝銹(Slotting)
X-UXR1005	35	220	7000-7500	1400-1800	0.08-0.13	8-10	溝銹(精銹)	X-UXR1205	40	140	3500-4000	1600-2000	0.1-0.13	0.1-0.13	3D銹(3D milling)
X-UXR1005	35	220	7000-7500	2800-3200	0.18-0.23	0.18-0.23	3D銹(中胚)	X-UXR1205	60	120	2700-3200	800-1200	0.1-0.13	10-12	溝銹(Slotting)
X-UXR1005	35	220	7000-7500	3000-3500	0.08-0.13	0.08-0.13	3D銹(精銹)	X-UXR1205	60	120	2700-3200	1000-1400	0.1-0.13	0.1-0.13	3D銹(3D milling)
X-UXR1005	55	195	5700-6200	2000-2400	0.18-0.23	8-10	溝銹(中胚)	X-UXR1205	100	90	2000-2400	400-800	0.06-0.08	10-12	溝銹(Slotting)
X-UXR1005	55	195	5700-6200	1400-1800	0.08-0.13	8-10	溝銹(精銹)	X-UXR1205	100	75	1600-2000	600-1000	0.06-0.08	0.06-0.08	3D銹(3D milling)
X-UXR1005	55	195	5700-6200	2200-2600	0.18-0.23	0.18-0.23	3D銹(中胚)	X-UXR1210	40	130	3000-3400	1200-1600	0.1-0.13	9-12	溝銹(Slotting)
X-UXR1005	55	195	5700-6200	2200-2600	0.08-0.13	0.08-0.13	3D銹(精銹)	X-UXR1210	40	130	3000-3400	1600-2000	0.1-0.13	0.1-0.13	3D銹(3D milling)
X-UXR1005	75	65	1600-2000	600-1000	0.07-0.11	8-10	溝銹(Slotting)	X-UXR1210	60	120	2700-3200	800-1200	0.1-0.13	9-12	溝銹(Slotting)
X-UXR1005	75	100	2700-3200	800-1200	0.07-0.11	0.07-0.11	3D銹(3D milling)	X-UXR1210	60	120	2700-3200	1000-1400	0.1-0.13	0.1-0.13	3D銹(3D milling)
X-UXR1010	35	220	7000-7500	2000-2400	0.18-0.23	7-10	溝銹(Slotting)	X-UXR1210	100	90	2000-2400	400-800	0.06-0.08	9-12	溝銹(Slotting)
X-UXR1010	35	220	7000-7500	1400-1800	0.08-0.13	7-10	溝銹(Slotting)	X-UXR1210	100	75	1600-2000	600-1000	0.06-0.08	0.06-0.08	3D銹(3D milling)
X-UXR1010	35	220	7000-7500	2800-3200	0.18-0.23	0.18-0.23	3D銹(3D milling)	X-UXR1605	60	150	2500-3000	800-1100	0.12-0.16	14-16	溝銹(Slotting)
X-UXR1010	35	220	7000-7500	3000-3500	0.08-0.13	0.08-0.13	3D銹(3D milling)	X-UXR1605	60	150	2500-3000	1200-1600	0.12-0.16	0.12-0.16	3D銹(3D milling)
X-UXR1010	55	195	5700-6200	2000-2400	0.18-0.23	7-10	溝銹(Slotting)	X-UXR1605	100	110	1800-2200	600-1000	0.1-0.15	14-16	溝銹(Slotting)
X-UXR1010	55	195	5700-6200	1400-1800	0.08-0.13	7-10	溝銹(Slotting)	X-UXR1605	100	110	1800-2200	600-1000	0.1-0.15	0.1-0.15	3D銹(3D milling)
X-UXR1010	55	195	5700-6200	2200-2600	0.18-0.23	0.18-0.23	3D銹(3D milling)	X-UXR1605	130	90	1400-1800	400-700	0.08-0.12	14-16	溝銹(Slotting)
X-UXR1010	55	195	5700-6200	2200-2600	0.08-0.13	0.08-0.13	3D銹(3D milling)	X-UXR1605	130	90	1400-1800	400-700	0.08-0.12	0.08-0.12	3D銹(3D milling)
X-UXR1010	75	65	1600-2000	600-1000	0.07-0.11	7-10	溝銹(Slotting)	X-UXR1610	60	150	2500-3000	800-1100	0.12-0.16	13-16	溝銹(Slotting)
X-UXR1010	75	100	2700-3200	800-1200	0.07-0.11	0.07-0.11	3D銹(3D milling)	X-UXR1610	60	150	2500-3000	1200-1600	0.12-0.16	0.12-0.16	3D銹(3D milling)
X-UXR1205	40	190	4500-5000	1400-1800	0.15-0.2	10-12	溝銹(Slotting)	X-UXR1610	100	110	1800-2200	600-1000	0.1-0.15	13-16	溝銹(Slotting)
X-UXR1205	40	190	4500-5000	1200-1600	0.1-0.15	10-12	溝銹(Slotting)	X-UXR1610	100	110	1800-2200	600-1000	0.1-0.15	0.1-0.15	3D銹(3D milling)
X-UXR1205	40	190	4500-5000	2200-2600	0.15-0.2	0.15-0.2	3D銹(3D milling)	X-UXR1610	130	90	1400-1800	400-700	0.08-0.12	13-16	溝銹(Slotting)
X-UXR1205	40	190	4500-5000	2000-2400	0.1-0.15	0.1-0.15	3D銹(3D milling)	X-UXR1610	130	90	1400-1800	400-700	0.08-0.12	0.08-0.12	3D銹(3D milling)
X-UXR1205	60	180	4200-4700	1100-1500	0.1-0.15	10-12	溝銹(Slotting)	X-UXR1620	60	150	2500-3000	800-1100	0.12-0.16	11-16	溝銹(Slotting)
X-UXR1205	60	180	4200-4700	1200-1600	0.1-0.15	0.1-0.15	3D銹(3D milling)	X-UXR1620	60	150	2500-3000	1200-1600	0.12-0.16	0.12-0.16	3D銹(3D milling)
X-UXR1205	100	90	2000-2400	600-900	0.07-0.1	10-12	溝銹(Slotting)	X-UXR1620	100	110	1800-2200	600-900	0.1-0.15	11-16	溝銹(Slotting)
X-UXR1205	100	85	1700-2200	800-1200	0.07-0.1	0.07-0.1	3D銹(3D milling)	X-UXR1620	100	110	1800-2200	600-1000	0.1-0.15	0.1-0.15	3D銹(3D milling)
X-UXR1210	40	190	4500-5000	1400-1800	0.15-0.2	9-12	溝銹(Slotting)	X-UXR1620	130	90	1400-1800	400-600	0.08-0.12	11-16	溝銹(Slotting)
X-UXR1210	40	190	4500-5000	1200-1600	0.1-0.15	9-12	溝銹(Slotting)	X-UXR1620	130	90	1400-1800	400-700	0.08-0.12	0.08-0.12	3D銹(3D milling)
X-UXR1210	40	190	4500-5000	2200-2600	0.15-0.2	0.15-0.2	3D銹(3D milling)	X-UXR2010	70	175	2500-3000	500-700	0.1-0.2	17-20	溝銹(Slotting)
X-UXR1210	40	190	4500-5000	2000-2400	0.1-0.15	0.1-0.15	3D銹(3D milling)	X-UXR2010	70	175	2500-3000	1200-1600	0.1-0.2	0.1-0.2	3D銹(3D milling)
X-UXR1210	60	180	4200-4700	1100-1500	0.1-0.15	9-12	溝銹(Slotting)	X-UXR2010	130	110	1600-2000	400-600	0.1-0.2	17-20	溝銹(Slotting)
X-UXR1210	60	180	4200-4700	1200-1600	0.1-0.15	0.1-0.15	3D銹(3D milling)	X-UXR2010	130	120	1800-2200	600-1000			