

DHF										DHF										DHF															
被切削材 Work Material		碳素鋼 : Carbon Steels S50C / SS400 : 1.1210 / 1.0036 : 1050 / A570 Gr.45 (~HRc22)										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)										被切削材 Work Material		調質鋼 / 預硬鋼 : Prehardened Steels NAK80 : 1.2083 : AISI420 : M310 (HRc36~45)									
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 Type	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 (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 Type	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 (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 Type	Milling									
X-UPS0804	25	120	4600-5000	1200-1400	0-0.3	6-8	溝銼(Slotting)		X-UPS0804	25	105	4000-4500	1000-1200	0-0.3	6-8	溝銼(Slotting)		X-UPS0804	25	105	4000-4500	1000-1200	0-0.3	6-8	溝銼(Slotting)										
X-UPS0804	25	120	4600-5000	800-1000	1-2	6-8	溝銼(Slotting)		X-UPS0804	25	105	4000-4500	800-1100	1-1.5	6-8	溝銼(Slotting)		X-UPS0804	25	105	4000-4500	800-1100	1-1.5	6-8	溝銼(Slotting)										
X-UPS0804	25	120	4600-5000	800-1000	0.05-0.1	6-8	溝銼(Slotting)		X-UPS0804	25	105	4000-4500	700-900	0.05-0.1	6-8	溝銼(Slotting)		X-UPS0804	25	105	4000-4500	700-900	0.05-0.1	6-8	溝銼(Slotting)										
X-UPS0804	25	120	4600-5000	1200-1400	8	0-0.3	側銼(Side milling)		X-UPS0804	25	105	4000-4500	1000-1200	8	0-0.3	側銼(Side milling)		X-UPS0804	25	105	4000-4500	1000-1200	8	0-0.3	側銼(Side milling)										
X-UPS0804	25	120	4600-5000	700-900	8	1-2	側銼(Side milling)		X-UPS0804	25	105	4000-4500	600-800	8	1-1.5	側銼(Side milling)		X-UPS0804	25	105	4000-4500	700-1000	8	1-1.5	側銼(Side milling)										
X-UPS0804	25	120	4600-5000	700-1000	8	0.05-0.1	側銼(Side milling)		X-UPS0804	25	105	4000-4500	700-900	8	0.05-0.1	側銼(Side milling)		X-UPS0804	25	105	4000-4500	700-900	8	0.05-0.1	側銼(Side milling)										
X-UPS0804	45	60	2200-2600	900-1100	0-0.2	6-8	溝銼(Slotting)		X-UPS0804	45	55	2000-2400	800-1000	0-0.2	6-8	溝銼(Slotting)		X-UPS0804	45	55	2000-2400	800-1000	0-0.2	6-8	溝銼(Slotting)										
X-UPS0804	45	70	2600-3000	500-700	0.05-0.1	6-8	溝銼(Slotting)		X-UPS0804	45	65	2400-2700	400-600	0.05-0.1	6-8	溝銼(Slotting)		X-UPS0804	45	65	2400-2700	400-600	0.05-0.1	6-8	溝銼(Slotting)										
X-UPS0804	45	70	2600-3000	300-500	8	0.05-0.1	側銼(Side milling)		X-UPS0804	45	65	2400-2700	250-450	8	0.05-0.1	側銼(Side milling)		X-UPS0804	45	65	2400-2700	250-450	8	0.05-0.1	側銼(Side milling)										
X-UPS0804	60	45	1500-2000	350-550	0.05-0.1	6-8	溝銼(Slotting)		X-UPS0804	60	40	1400-1800	300-500	0.05-0.1	6-8	溝銼(Slotting)		X-UPS0804	60	40	1400-1800	300-500	0.05-0.1	6-8	溝銼(Slotting)										
X-UPS0804	60	45	1500-2000	200-400	8	0.05-0.1	側銼(Side milling)		X-UPS0804	60	45	1500-2000	200-400	8	0.05-0.1	側銼(Side milling)		X-UPS0804	60	45	1500-2000	200-400	8	0.05-0.1	側銼(Side milling)										
X-UPS1004	30	110	3300-3700	1200-1400	0-0.4	8-10	溝銼(Slotting)		X-UPS1004	30	95	2800-3300	1000-1200	0-0.4	8-10	溝銼(Slotting)		X-UPS1004	30	95	2800-3300	1000-1200	0-0.4	8-10	溝銼(Slotting)										
X-UPS1004	30	110	3300-3700	600-800	1-2	8-10	溝銼(Slotting)		X-UPS1004	30	95	2800-3300	500-700	1-1.5	8-10	溝銼(Slotting)		X-UPS1004	30	95	2800-3300	500-700	1-1.5	8-10	溝銼(Slotting)										
X-UPS1004	30	120	3600-4000	700-900	0.05-0.1	8-10	溝銼(Slotting)		X-UPS1004	30	100	3000-3500	600-800	0.05-0.1	8-10	溝銼(Slotting)		X-UPS1004	30	100	3000-3500	600-800	0.05-0.1	8-10	溝銼(Slotting)										
X-UPS1004	30	110	3300-3700	1200-1400	10	0-0.4	側銼(Side milling)		X-UPS1004	30	95	2800-3300	1200-1400	10	0-0.4	側銼(Side milling)		X-UPS1004	30	95	2800-3300	1200-1400	10	0-0.4	側銼(Side milling)										
X-UPS1004	30	110	3300-3700	600-800	10	1-2	側銼(Side milling)		X-UPS1004	30	95	2800-3300	500-700	10	1-1.5	側銼(Side milling)		X-UPS1004	30	95	2800-3300	500-700	10	1-1.5	側銼(Side milling)										
X-UPS1004	30	110	3300-3700	600-800	10	0.05-0.1	側銼(Side milling)		X-UPS1004	30	100	3000-3500	500-700	10	0.05-0.1	側銼(Side milling)		X-UPS1004	30	100	3000-3500	500-700	10	0.05-0.1	側銼(Side milling)										
X-UPS1004	50	80	2400-2800	800-1000	0-0.2	8-10	溝銼(Slotting)		X-UPS1004	50	80	2400-2800	800-1000	0-0.2	8-10	溝銼(Slotting)		X-UPS1004	50	80	2400-2800	800-1000	0-0.2	8-10	溝銼(Slotting)										
X-UPS1004	50	75	2200-2600	250-400	0.05-0.1	8-10	溝銼(Slotting)		X-UPS1004	50	75	2200-2600	250-400	0.05-0.1	8-10	溝銼(Slotting)		X-UPS1004	50	75	2200-2600	250-400	0.05-0.1	8-10	溝銼(Slotting)										
X-UPS1004	50	80	2400-2800	800-1000	10	0-0.2	側銼(Side milling)		X-UPS1004	50	80	2400-2800	800-1000	10	0-0.2	側銼(Side milling)		X-UPS1004	50	80	2400-2800	800-1000	10	0-0.2	側銼(Side milling)										
X-UPS1004	50	75	2200-2600	400-600	10	0.05-0.1	側銼(Side milling)		X-UPS1004	50	75	2200-2600	400-600	10	0.05-0.1	側銼(Side milling)		X-UPS1004	50	75	2200-2600	400-600	10	0.05-0.1	側銼(Side milling)										
X-UPS1004	70	60	1700-2200	250-350	0.05-0.1	8-10	溝銼(Slotting)		X-UPS1004	70	50	1300-1700	200-300	0.05-0.1	8-10	溝銼(Slotting)		X-UPS1004	70	50	1300-1700	200-300	0.05-0.1	8-10	溝銼(Slotting)										
X-UPS1004	70	60	1700-2200	200-350	10	0.05-0.1	側銼(Side milling)		X-UPS1004	70	60	1700-2200	200-350	10	0.05-0.1	側銼(Side milling)		X-UPS1004	70	60	1700-2200	200-350	10	0.05-0.1	側銼(Side milling)										
X-UPS1204	35	120	3000-3400	1000-1200	0-0.5	10-12	溝銼(Slotting)		X-UPS1204	35	115	2800-3200	800-1000	0-0.5	10-12	溝銼(Slotting)		X-UPS1204	35	115	2800-3200	800-1000	0-0.5	10-12	溝銼(Slotting)										
X-UPS1204	35	110	2600-3000	400-600	2-3	10-12	溝銼(Slotting)		X-UPS1204	35	100	2400-2800	300-500	2-3	10-12	溝銼(Slotting)		X-UPS1204	35	100	2400-2800	300-500	2-3	10-12	溝銼(Slotting)										
X-UPS1204	35	120	3000-3400	600-800	0.1-0.15	10-12	溝銼(Slotting)		X-UPS1204	35	115	2800-3200	500-700	0.1-0.15	10-12	溝銼(Slotting)		X-UPS1204	35	115	2800-3200	500-700	0.1-0.15	10-12	溝銼(Slotting)										
X-UPS1204	35	120	3000-3400	1000-1200	12	0-0.5	側銼(Side milling)		X-UPS1204	35	115	2800-3200	1000-1200	12	0-0.5	側銼(Side milling)		X-UPS1204	35	115	2800-3200	1000-1200	12	0-0.5	側銼(Side milling)										
X-UPS1204	35	120	3000-3400	500-700	12	2-3	側銼(Side milling)		X-UPS1204	35	115	2800-3200	400-600	12	2-3	側銼(Side milling)		X-UPS1204	35	115	2800-3200	400-600	12	2-3	側銼(Side milling)										
X-UPS1204	35	120	3000-3400	500-700	12	0.1-0.15	側銼(Side milling)		X-UPS1204	35	115	2800-3200	400-600	12	0.1-0.15	側銼(Side milling)		X-UPS1204	35	115	2800-3200	400-600	12	0.1-0.15	側銼(Side milling)										
X-UPS1204	60	100	2400-2800	1000-1200	0-0.25	10-12	溝銼(Slotting)		X-UPS1204	60	80	2000-2400	800-1000	0-0.25	10-12	溝銼(Slotting)		X-UPS1204	60	80	2000-2400	800-1000	0-0.25	10-12	溝銼(Slotting)										
X-UPS1204	60	100	2400-2800	300-500	0.1-0.15	10-12	溝銼(Slotting)		X-UPS1204	60	100	2400-2800	300-500	0.1-0.15	10-12	溝銼(Slotting)		X-UPS1204	60	100	2400-2800	300-500	0.1-0.15	10-12	溝銼(Slotting)										
X-UPS1204	60	115	2800-3200	800-1200	12	0-0.25	側銼(Side milling)		X-UPS1204	60	115	2800-3200	800-1200	12	0-0.25	側銼(Side milling)		X-UPS1204	60	115	2800-3200	800-1200	12	0-0.25	側銼(Side milling)										
X-UPS1204	60	100	2400-2800	300-500	12	0.1-0.15	側銼(Side milling)		X-UPS1204	60	100	2400-2800	300-500	12	0.1-0.15	側銼(Side milling)		X-UPS1204	60	100	2400-2800	300-500	12	0.1-0.15	側銼(Side milling)										
X-UPS1204	80	50	1200-1600	400-500	0.05-0.1	10-12	溝銼(Slotting)		X-UPS1204	80	50	1200-1600	400-500	0.05-0.1	10-12	溝銼(Slotting)		X-UPS1204	80	50	1200-1600	400-500	0.05-0.1	10-12	溝銼(Slotting)										
X-UPS1204	80	50	1200-1600	400-500	12	0.05-0.1	側銼(Side milling)		X-UPS1204	80	50	1200-1600	400-500	12	0.05-0.1	側銼(Side milling)		X-UPS1204	80	50	1200-1600	400-500	12	0.05-0.1	側銼(Side milling)										
X-UPS1604	45	120	2200-2600	700-1000	0-0.5	14-16	溝銼(Slotting)		X-UPS1604	45	110	2000-2400	600-800	0-0.5	14-16	溝銼(Slotting)		X-UPS1604	45	110	2000-2400	600-800	0-0.5	14-16	溝銼(Slotting)										
X-UPS1604	45	120	2200-2600	400-500	1-1.5	14-16	溝銼(Slotting)		X-UPS1604	45	110	2000-2400	300-400	1-1.5	14-16	溝銼(Slotting)		X-UPS1604	45	110	2000-2400	300-400	1-1.5	14-16	溝銼(Slotting)										
X-UPS1604	45	120	2200-2600	500-700	0.1-0.15	14-16	溝銼(Slotting)		X-UPS1604	45	110	2000-2400	500-700	0.1-0.15	14-16	溝銼(Slotting)		X-UPS1604	45	110	2000-2400	500-700	0.1-0.15	14-16	溝銼(Slotting)										
X-UPS1604	45	120	2200-2600	600-800	16	0-0.5	側銼(Side milling)		X-UPS1604	45	110	2000-2400	600-800	16	0-0.5	側銼(Side milling)		X-UPS1604	45	110	2000-2400	600-800	16	0-0.5	側銼(Side milling)										
X-UPS1604	45	120	2200-2600	300-400	16	1-2	側銼(Side milling)		X-UPS1604	45	110	2000-2400	250-350	16	1-2	側銼(Side milling)		X-UPS1604	45	110	2000-2400	250-350	16	1-2	側銼(Side milling)										
X-UPS1604	45	120	2200-2600	450-650	16	0.1-0.15	側銼(Side milling)		X-UPS1604	45	110	2000-2400	400-600	16	0.1-0.15	側銼(Side milling)		X-UPS1604	45	110	2000-2400	400-600	16	0.1-0.15	側銼(Side milling)										
X-UPS1604	70	100	1800-2200	700-900	0-0.3	14-16	溝銼(Slotting)		X-UPS1604	70	100	1800-2200	700-900	0-0.3	14-16	溝銼(Slotting)		X-UPS1604	70	100	1800-2200	700-900	0-0.3	14-16	溝銼(Slotting)										
X-UPS1604	70	100	1800-2200	400-600	0.1-0.15	14-16	溝銼(Slotting)		X-UPS1604	70	90	1600-2000	350-550	0.1-0.15	14-16	溝銼(Slotting)		X-UPS1604	70	90	1600-2000	350-550	0.1-0.15	14-16	溝銼(Slotting)										
X-UPS1604	70	100	1800-2200	700-900	16	0-0.3	側銼(Side milling)		X-UPS1604	70	100	1800-2200	700-900	16	0-0.3	側銼(Side milling)		X-UPS1604	70	100	1800-2200	700-900	16	0-0.3	側銼(Side milling)										