



被切削材 Work Material	熱處理調：Hardened Steels SKD61 / STAVAX / 17-4PH / 1.2083 / 1.2344 / 1.4542 : H13 / 420 (HRc48-54)										被切削材 Work Material	熱處理調：Hardened Steels SKD11 / SKH9 : 1.2379 / 1.3342 : B2 / 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				
	X-UEXR0803	30mm	200	7700-8200	2400-2800	0.15-0.18	7-8	溝銼(Slotting)	X-UEXR0803	30		125	4500-5000	1000-1400	0.07-0.09	7-8	溝銼(Slotting)				
X-UEXR0803	30mm	200	7700-8200	2400-2800	0.08-0.11	7-8	溝銼(Slotting)	X-UEXR0803	30	125	4500-5000	1000-1400	0.07-0.09	0.07-0.09	溝銼(Slotting)						
X-UEXR0803	30mm	200	7700-8200	2600-3000	0.15-0.18	0.15-0.18	3D銼(3D milling)	X-UEXR0803	50	80	2700-3200	600-1000	0.06-0.08	7-8	溝銼(Slotting)						
X-UEXR0803	30mm	200	7700-8200	2600-3000	0.08-0.11	0.08-0.11	3D銼(3D milling)	X-UEXR0803	50	80	2700-3200	1000-1400	0.06-0.08	0.06-0.08	3D銼(3D milling)						
X-UEXR0803	50mm	150	5500-6000	600-1000	0.07-0.1	7-8	溝銼(Slotting)	X-UEXR0803	70	55	1800-2200	400-800	0.06-0.08	7-8	溝銼(Slotting)						
X-UEXR0803	50mm	150	5500-6000	1200-1600	0.08-0.11	0.08-0.11	3D銼(3D milling)	X-UEXR0803	70	55	1800-2200	600-1000	0.06-0.08	0.06-0.08	3D銼(3D milling)						
X-UEXR0803	70mm	70	2400-2700	400-800	0.07-0.1	7-8	溝銼(Slotting)	X-UEXR0805	30	125	4500-5000	1000-1400	0.07-0.09	6-8	溝銼(Slotting)						
X-UEXR0803	70mm	90	3000-3500	800-1200	0.07-0.1	0.07-0.1	3D銼(3D milling)	X-UEXR0805	30	125	4500-5000	1600-2000	0.07-0.09	0.07-0.09	3D銼(3D milling)						
X-UEXR0805	30mm	200	7700-8200	2400-2800	0.15-0.18	6-8	溝銼(Slotting)	X-UEXR0805	50	80	2700-3200	600-1000	0.06-0.08	6-8	溝銼(Slotting)						
X-UEXR0805	30mm	200	7700-8200	1200-1600	0.08-0.11	6-8	溝銼(Slotting)	X-UEXR0805	50	80	2700-3200	1000-1400	0.06-0.08	0.06-0.08	3D銼(3D milling)						
X-UEXR0805	30mm	200	7700-8200	2600-3000	0.15-0.18	0.15-0.18	3D銼(3D milling)	X-UEXR0805	70	55	1800-2200	400-800	0.06-0.08	6-8	溝銼(Slotting)						
X-UEXR0805	30mm	200	7700-8200	2600-3000	0.08-0.11	0.08-0.11	3D銼(3D milling)	X-UEXR0805	70	55	1800-2200	600-1000	0.06-0.08	0.06-0.08	3D銼(3D milling)						
X-UEXR0805	50mm	150	5500-6000	600-1000	0.07-0.1	6-8	溝銼(Slotting)	X-UEXR0810	30	125	4500-5000	1000-1400	0.07-0.09	5-8	溝銼(Slotting)						
X-UEXR0805	50mm	150	5500-6000	1200-1600	0.08-0.11	0.08-0.11	3D銼(3D milling)	X-UEXR0810	30	125	4500-5000	1600-2000	0.07-0.09	0.07-0.09	3D銼(3D milling)						
X-UEXR0805	70mm	70	2400-2700	400-800	0.07-0.1	6-8	溝銼(Slotting)	X-UEXR0810	50	80	2700-3200	600-1000	0.06-0.08	5-8	溝銼(Slotting)						
X-UEXR0805	70mm	90	3000-3500	800-1200	0.07-0.1	0.07-0.1	3D銼(3D milling)	X-UEXR0810	50	80	2700-3200	1000-1400	0.06-0.08	0.06-0.08	3D銼(3D milling)						
X-UEXR0810	30mm	200	7700-8200	2400-2800	0.15-0.18	5-8	溝銼(Slotting)	X-UEXR0810	70	55	1800-2200	400-800	0.06-0.08	5-8	溝銼(Slotting)						
X-UEXR0810	30mm	200	7700-8200	1200-1600	0.08-0.11	5-8	溝銼(Slotting)	X-UEXR0810	70	55	1800-2200	600-1000	0.06-0.08	0.06-0.08	3D銼(3D milling)						
X-UEXR0810	30mm	200	7700-8200	2600-3000	0.15-0.18	0.15-0.18	3D銼(3D milling)	X-UEXR1005	35	110	3000-3400	1000-1400	0.07-0.09	8-10	溝銼(Slotting)						
X-UEXR0810	30mm	200	7700-8200	2600-3000	0.08-0.11	0.08-0.11	3D銼(3D milling)	X-UEXR1005	35	110	3000-3400	1000-1400	0.07-0.09	0.07-0.09	3D銼(3D milling)						
X-UEXR0810	50mm	150	5500-6000	600-1000	0.07-0.1	5-8	溝銼(Slotting)	X-UEXR1005	50	100	2700-3200	800-1200	0.07-0.09	8-10	溝銼(Slotting)						
X-UEXR0810	50mm	150	5500-6000	1200-1600	0.08-0.11	0.08-0.11	3D銼(3D milling)	X-UEXR1005	50	100	2700-3200	1600-2000	0.07-0.09	0.07-0.09	3D銼(3D milling)						
X-UEXR0810	70mm	70	2400-2700	400-800	0.07-0.1	5-8	溝銼(Slotting)	X-UEXR1005	70	70	1700-2200	400-800	0.07-0.09	8-10	溝銼(Slotting)						
X-UEXR0810	70mm	90	3000-3500	800-1200	0.07-0.1	0.07-0.1	3D銼(3D milling)	X-UEXR1005	70	70	1700-2200	600-1000	0.07-0.09	0.07-0.09	3D銼(3D milling)						
X-UEXR1005	35mm	200	6000-6500	1800-2200	0.15-0.18	8-10	溝銼(Slotting)	X-UEXR1010	35	110	3000-3400	1000-1400	0.07-0.09	7-10	溝銼(Slotting)						
X-UEXR1005	35mm	200	6000-6500	1000-1400	0.08-0.11	8-10	溝銼(Slotting)	X-UEXR1010	35	110	3000-3400	1000-1400	0.07-0.09	0.07-0.09	3D銼(3D milling)						
X-UEXR1005	35mm	200	6000-6500	2400-2800	0.15-0.18	0.15-0.18	3D銼(3D milling)	X-UEXR1010	50	100	2700-3200	800-1200	0.07-0.09	7-10	溝銼(Slotting)						
X-UEXR1005	35mm	200	6000-6500	2400-2800	0.08-0.11	0.08-0.11	3D銼(3D milling)	X-UEXR1010	50	100	2700-3200	800-1200	0.07-0.09	0.07-0.09	3D銼(3D milling)						
X-UEXR1005	50mm	145	4000-4500	800-1200	0.08-0.11	8-10	溝銼(Slotting)	X-UEXR1010	70	70	1700-2200	400-800	0.07-0.09	7-10	溝銼(Slotting)						
X-UEXR1005	50mm	145	4000-4500	1400-1800	0.08-0.11	0.08-0.11	3D銼(3D milling)	X-UEXR1010	70	70	1700-2200	600-1000	0.07-0.09	0.07-0.09	3D銼(3D milling)						
X-UEXR1005	70mm	100	2700-3200	600-1000	0.07-0.11	8-10	溝銼(Slotting)	X-UEXR1205	40	120	2700-3200	1000-1400	0.09-0.11	10-12	溝銼(Slotting)						
X-UEXR1005	70mm	100	2700-3200	800-1200	0.07-0.11	0.07-0.11	3D銼(3D milling)	X-UEXR1205	40	120	2700-3200	1000-1400	0.09-0.11	0.09-0.11	3D銼(3D milling)						
X-UEXR1010	35mm	200	6000-6500	1800-2200	0.15-0.18	7-10	溝銼(Slotting)	X-UEXR1205	60	105	2300-2800	600-1000	0.09-0.11	10-12	溝銼(Slotting)						
X-UEXR1010	35mm	200	6000-6500	1000-1400	0.08-0.11	7-10	溝銼(Slotting)	X-UEXR1205	60	105	2300-2800	800-1200	0.09-0.11	0.09-0.11	3D銼(3D milling)						
X-UEXR1010	35mm	200	6000-6500	2400-2800	0.15-0.18	0.15-0.18	3D銼(3D milling)	X-UEXR1205	100	85	1700-2200	400-700	0.07-0.1	10-12	溝銼(Slotting)						
X-UEXR1010	35mm	200	6000-6500	2400-2800	0.08-0.11	0.08-0.11	3D銼(3D milling)	X-UEXR1205	100	85	1700-2200	600-1000	0.07-0.1	0.07-0.1	3D銼(3D milling)						
X-UEXR1010	50mm	145	4000-4500	800-1200	0.08-0.11	7-10	溝銼(Slotting)	X-UEXR1210	40	120	2700-3200	1000-1400	0.09-0.11	9-12	溝銼(Slotting)						
X-UEXR1010	50mm	145	4000-4500	1400-1800	0.08-0.11	0.08-0.11	3D銼(3D milling)	X-UEXR1210	40	120	2700-3200	1000-1400	0.09-0.11	0.09-0.11	3D銼(3D milling)						
X-UEXR1010	70mm	100	2700-3200	600-1000	0.07-0.11	7-10	溝銼(Slotting)	X-UEXR1210	60	105	2300-2800	600-1000	0.09-0.11	9-12	溝銼(Slotting)						
X-UEXR1010	70mm	100	2700-3200	800-1200	0.07-0.11	0.07-0.11	3D銼(3D milling)	X-UEXR1210	60	105	2300-2800	800-1200	0.09-0.11	0.09-0.11	3D銼(3D milling)						
X-UEXR1205	40mm	130	3000-3400	1400-1800	0.15-0.2	10-12	溝銼(Slotting)	X-UEXR1210	100	85	1700-2200	400-700	0.07-0.1	9-12	溝銼(Slotting)						
X-UEXR1205	40mm	170	4000-4500	1000-1400	0.1-0.13	10-12	溝銼(Slotting)	X-UEXR1210	100	85	1700-2200	600-1000	0.07-0.1	0.07-0.1	3D銼(3D milling)						
X-UEXR1205	40mm	130	3000-3400	2000-2400	0.15-0.2	0.15-0.2	3D銼(3D milling)	X-UEXR1220	40	120	2700-3200	1000-1400	0.09-0.11	7-12	溝銼(Slotting)						
X-UEXR1205	40mm	170	4000-4500	1400-1800	0.1-0.13	0.1-0.13	3D銼(3D milling)	X-UEXR1220	40	120	2700-3200	1000-1400	0.09-0.11	0.09-0.11	3D銼(3D milling)						
X-UEXR1205	60mm	120	2700-3200	800-1200	0.1-0.13	10-12	溝銼(Slotting)	X-UEXR1220	60	105	2300-2800	600-1000	0.09-0.11	7-12	溝銼(Slotting)						
X-UEXR1205	60mm	120	2700-3200	1000-1400	0.1-0.13	0.1-0.13	3D銼(3D milling)	X-UEXR1220	60	105	2300-2800	800-1200	0.09-0.11	0.09-0.11	3D銼(3D milling)						
X-UEXR1205	100mm	85	1700-2200	600-1000	0.07-0.1	10-12	溝銼(Slotting)	X-UEXR1220	100	85	1700-2200	400-700	0.07-0.1	7-12	溝銼(Slotting)						
X-UEXR1205	100mm	85	1700-2200	800-1200	0.07-0.1	0.07-0.1	3D銼(3D milling)	X-UEXR1220	100	85	1700-2200	600-1000	0.07-0.1	0.07-0.1	3D銼(3D milling)						
X-UEXR1210	40mm	130	3000-3400	1400-1800	0.15-0.2	9-12	溝銼(Slotting)	X-UEXR1610	60	120	2000-2400	600-1000	0.1-0.13	13-16	溝銼(Slotting)						
X-UEXR1210	40mm	170	4000-4500	1000-1400	0.1-0.13	9-12	溝銼(Slotting)	X-UEXR1610	60	140	2400-2800	800-1200	0.1-0.13	0.1-0.13	3D銼(3D milling)						
X-UEXR1210	40mm	130	3000-3400	2000-2400	0.15-0.2	0.15-0.2	3D銼(3D milling)	X-UEXR1610	100	100	1700-2100	600-800	0.1-0.13	13-16	溝銼(Slotting)						
X-UEXR1210	40mm	170	4000-4500	1400-1800	0.1-0.13	0.1-0.13	3D銼(3D milling)	X-UEXR1610	100	100	1700-2100	600-1000	0.1-0.13	0.1-0.13	3D銼(3D milling)						
X-UEXR1210	60mm	120	2700-3200	800-1200	0.1-0.13	9-12	溝銼(Slotting)	X-UEXR1610	130	90	1400-1800	400-700	0.1-0.13	13-16	溝銼(Slotting)						
X-UEXR1210	60mm	120	2700-3200	1000-1400	0.1-0.13	0.1-0.13	3D銼(3D milling)	X-UEXR1610	130	90	1400-1800	400-700	0.1-0.13	0.1-0.13	3D銼(3D milling)						
X-UEXR1210	100mm	85	1700-2200	600-1000	0.07-0.1	9-12	溝銼(Slotting)	X-UEXR1620	60	120	2000-2400	600-1000	0.1-0.13	11-16	溝銼(Slotting)						
X-UEXR1210	100mm	85	1700-2200	800-1200	0.07-0.1	0.07-0.1	3D銼(3D milling)	X-UEXR1620	60	140	2400-2800	800-1200	0.1-0.13	0.1-0.13	3D銼(3D milling)						
X-UEXR1220	40mm	130	3000-3400	1400-1800	0.15-0.2	7-12	溝銼(Slotting)	X-UEXR1620	100	100	1700-2100	600-800	0.1-0.13	11-16	溝銼(Slotting)						
X-UEXR1220	40mm	170	4000-4500	1000-1400	0.1-0.13	7-12	溝銼(Slotting)	X-UEXR1620	100	100	1700-2100	600-1000	0.1-0.13	0.1-0.13	3D銼(3D milling)						
X-UEXR1220	40mm	130	3000-3400	2000-2400	0.15-0.2	0.15-0.2	3D銼(3D milling)	X-UEXR1620	130	90	1400-1800	400-700	0.1-0.13	11-16	溝銼(Slotting)						
X-UEXR1220	40mm	170	4000-4500	1400-1800	0.1-0.13	0.1-0.13	3D銼(3D milling)	X-UEXR1620	130	90	1400-1800	400-700	0.1-0.13	0.1-0.13	3D銼(3D milling)						
X-UEXR1220	60mm	120	2700-3200	800-1200	0.1-0.13	7-12	溝銼(Slotting)	X-UEXR1630	60	120	2000-2400	600-1000	0.1-0.13	9-16	溝銼(Slotting)						
X-UEXR1220	60mm	120	2700-3200	1000-1400	0.1-0.13	0.1-0.13	3D銼(3D milling)	X-UEXR1630	60	140	2400-2800	800-1200	0.1-0.13	0.1-0.13	3D銼(3D milling)						