

																			
被切削材 Work Material	碳素鋼：Carbon steels S50C / SS400：1.1210 / 1.0036：1050 / A570 Gr.45 (~HRC 22)							被切削材 Work Material	調質鋼 / 預硬鋼：Prehardened Steels NAK80：1.2083：AISI420：M310 (HRC 36~45)										
型號 Type NO.	刀具伸 長量 Extension	切削速度 Cutting Speed (m/min)	迴轉速 度 Speed	進給速 度 Feed	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	切削速度 Cutting Speed (m/	迴轉速 度 Speed	進給速 度 Feed	加工深度 (Aa) Depth of	加工寬度 (Ap) Width of Cut	加工方式 Milling Type				
DRD0305	12mm	85	000~1000	000~1100	0.1~0.15	1~3	溝銑(Slotting)	DRD0305	12mm	85	000~1000	000~1000	0.1~0.15	1~3	溝銑(Slotting)				
DRD0305	12mm	85	000~1000	000~1000	0.05~0.08	1~3	溝銑(Slotting)	DRD0305	12mm	85	000~1000	000~1000	0.05~0.0	1~3	溝銑(Slotting)				
DRD0305	12mm	80	500~900	100~130	3~6	0.1~0.15	側銑(Side millin	DRD0305	12mm	80	500~900	000~120	3~6	0.1~0.15	側銑(Side milling)				
DRD0305	12mm	80	500~900	000~1000	3~6	0.06~0.0	側銑(Side millin	DRD0305	12mm	80	500~900	700~900	3~6	0.06~0.0	側銑(Side milling)				
DRD0305	12mm	85	000~1000	100~140	0.1~0.15	0.1~0.15	3D銑(3D millir	DRD0305	12mm	85	000~1000	000~1200	0.1~0.15	0.1~0.15	3D銑(3D milling)				
DRD0305	12mm	85	000~1000	100~140	0.05~0.08	0.05~0.0	3D銑(3D millir	DRD0305	12mm	85	000~1000	000~120	0.05~0.0	0.05~0.0	3D銑(3D milling)				
DRD0405	14mm	100	000~840	000~1200	0.12~0.17	2~4	溝銑(Slotting)	DRD0405	14mm	100	000~840	000~1000	0.12~0.1	2~4	溝銑(Slotting)				
DRD0405	14mm	100	000~840	000~120	0.05~0.1	2~4	溝銑(Slotting)	DRD0405	14mm	100	000~840	000~1000	0.05~0.1	2~4	溝銑(Slotting)				
DRD0405	14mm	85	000~720	000~120	4~8	0.12~0.1	側銑(Side millin	DRD0405	14mm	85	000~720	000~1000	4~8	0.12~0.1	側銑(Side milling)				
DRD0405	14mm	85	500~750	000~1000	4~8	0.05~0.1	側銑(Side millin	DRD0405	14mm	85	500~700	500~700	4~8	0.05~0.1	側銑(Side milling)				
DRD0405	14mm	110	700~920	000~1200	0.12~0.17	0.12~0.1	3D銑(3D millir	DRD0405	14mm	110	700~920	000~1000	0.12~0.1	0.12~0.1	3D銑(3D milling)				
DRD0405	14mm	110	700~920	200~160	0.05~0.1	0.05~0.1	3D銑(3D millir	DRD0405	14mm	110	700~920	000~1200	0.05~0.1	0.05~0.1	3D銑(3D milling)				
DRD0505	17mm	90	000~640	200~1400	0.12~0.17	3~5	溝銑(Slotting)	DRD0505	17mm	90	000~640	000~1000	0.12~0.1	3~5	溝銑(Slotting)				
DRD0505	17mm	130	000~850	000~140	0.05~0.1	3~5	溝銑(Slotting)	DRD0505	17mm	115	200~760	000~1200	0.05~0.1	3~5	溝銑(Slotting)				
DRD0505	17mm	95	000~700	000~120	5~10	0.12~0.1	側銑(Side millin	DRD0505	17mm	85	400~600	000~1000	5~10	0.12~0.1	側銑(Side milling)				
DRD0505	17mm	95	000~700	000~1000	5~10	0.05~0.1	側銑(Side millin	DRD0505	17mm	90	000~640	600~800	5~10	0.05~0.1	側銑(Side milling)				
DRD0505	17mm	135	500~900	400~1800	0.12~0.17	0.12~0.1	3D銑(3D millir	DRD0505	17mm	130	000~850	000~1200	0.12~0.1	0.12~0.1	3D銑(3D milling)				
DRD0505	17mm	135	500~900	300~160	0.05~0.1	0.05~0.1	3D銑(3D millir	DRD0505	17mm	130	000~850	000~1400	0.05~0.1	0.05~0.1	3D銑(3D milling)				
DRD0510	17mm	90	000~640	200~1400	0.12~0.17	2~5	溝銑(Slotting)	DRD0510	17mm	90	000~640	000~1000	0.12~0.1	2~5	溝銑(Slotting)				
DRD0510	17mm	130	000~850	000~140	0.05~0.1	2~5	溝銑(Slotting)	DRD0510	17mm	115	200~760	000~1200	0.05~0.1	2~5	溝銑(Slotting)				
DRD0510	17mm	95	000~700	000~120	5~10	0.12~0.1	側銑(Side millin	DRD0510	17mm	85	400~600	000~1000	5~10	0.12~0.1	側銑(Side milling)				
DRD0510	17mm	95	000~700	000~1000	5~10	0.05~0.1	側銑(Side millin	DRD0510	17mm	90	000~640	600~800	5~10	0.05~0.1	側銑(Side milling)				
DRD0510	17mm	135	500~900	400~1800	0.12~0.17	0.12~0.1	3D銑(3D millir	DRD0510	17mm	130	000~850	000~1200	0.12~0.1	0.12~0.1	3D銑(3D milling)				
DRD0510	17mm	135	500~900	300~160	0.05~0.1	0.05~0.1	3D銑(3D millir	DRD0510	17mm	130	000~850	000~1400	0.05~0.1	0.05~0.1	3D銑(3D milling)				
DRD0605	20mm	90	000~540	200~140	0.15~0.2	4~6	溝銑(Slotting)	DRD0605	20mm	90	000~540	000~1400	0.15~0.2	4~6	溝銑(Slotting)				
DRD0605	20mm	130	000~720	400~160	0.05~0.1	4~6	溝銑(Slotting)	DRD0605	20mm	115	000~640	200~1400	0.05~0.1	4~6	溝銑(Slotting)				
DRD0605	20mm	95	000~600	000~120	6~12	0.15~0.2	側銑(Side millin	DRD0605	20mm	85	500~500	000~1000	6~12	0.15~0.2	側銑(Side milling)				
DRD0605	20mm	95	000~600	000~1000	6~12	0.05~0.1	側銑(Side millin	DRD0605	20mm	90	000~520	600~800	6~12	0.05~0.1	側銑(Side milling)				
DRD0605	20mm	160	500~900	600~200	0.15~0.2	0.15~0.2	3D銑(3D millir	DRD0605	20mm	160	500~900	000~1400	0.15~0.2	0.15~0.2	3D銑(3D milling)				
DRD0605	20mm	160	500~900	600~200	0.05~0.1	0.05~0.1	3D銑(3D millir	DRD0605	20mm	160	500~900	400~1800	0.05~0.1	0.05~0.1	3D銑(3D milling)				
DRD0610	20mm	90	000~540	400~160	0.15~0.2	3~6	溝銑(Slotting)	DRD0610	20mm	90	000~540	000~1400	0.15~0.2	3~6	溝銑(Slotting)				
DRD0610	20mm	130	000~720	400~160	0.05~0.1	3~6	溝銑(Slotting)	DRD0610	20mm	115	000~640	200~1400	0.05~0.1	3~6	溝銑(Slotting)				
DRD0610	20mm	95	000~600	000~120	6~12	0.15~0.2	側銑(Side millin	DRD0610	20mm	85	500~500	000~1000	6~12	0.15~0.2	側銑(Side milling)				
DRD0610	20mm	95	000~600	000~1000	6~12	0.05~0.1	側銑(Side millin	DRD0610	20mm	90	000~520	600~800	6~12	0.05~0.1	側銑(Side milling)				
DRD0610	20mm	160	500~900	600~200	0.15~0.2	0.15~0.2	3D銑(3D millir	DRD0610	20mm	160	500~900	000~1400	0.15~0.2	0.15~0.2	3D銑(3D milling)				
DRD0610	20mm	160	500~900	600~200	0.05~0.1	0.05~0.1	3D銑(3D millir	DRD0610	20mm	160	500~900	400~1800	0.05~0.1	0.05~0.1	3D銑(3D milling)				
DRD0805	30mm	135	000~580	000~140	0.2~0.25	6~8	溝銑(Slotting)	DRD0805	30mm	100	000~450	700~1000	0.2~0.25	6~8	溝銑(Slotting)				
DRD0805	30mm	145	000~620	000~1200	0.06~0.11	6~8	溝銑(Slotting)	DRD0805	30mm	140	500~600	000~1000	0.06~0.1	6~8	溝銑(Slotting)				
DRD0805	30mm	90	500~400	000~120	8~16	0.2~0.25	側銑(Side millin	DRD0805	30mm	90	500~400	700~900	8~16	0.2~0.25	側銑(Side milling)				
DRD0805	30mm	90	500~400	700~1000	8~16	0.06~0.1	側銑(Side millin	DRD0805	30mm	90	500~400	600~800	8~16	0.06~0.1	側銑(Side milling)				
DRD0805	30mm	190	500~850	600~200	0.2~0.25	0.2~0.25	3D銑(3D millir	DRD0805	30mm	100	000~450	400~1800	0.2~0.25	0.2~0.25	3D銑(3D milling)				
DRD0805	30mm	190	500~850	400~1800	0.06~0.11	0.06~0.1	3D銑(3D millir	DRD0805	30mm	185	200~770	200~160	0.06~0.1	0.06~0.1	3D銑(3D milling)				
DRD0810	30mm	135	000~580	000~140	0.2~0.25	5~8	溝銑(Slotting)	DRD0810	30mm	100	000~450	700~1000	0.2~0.25	5~8	溝銑(Slotting)				
DRD0810	30mm	145	000~620	000~1200	0.06~0.11	5~8	溝銑(Slotting)	DRD0810	30mm	140	500~600	000~1000	0.06~0.1	5~8	溝銑(Slotting)				
DRD0810	30mm	90	500~400	000~120	8~16	0.2~0.25	側銑(Side millin	DRD0810	30mm	90	500~400	700~900	8~16	0.2~0.25	側銑(Side milling)				
DRD0810	30mm	90	500~400	700~1000	8~16	0.06~0.1	側銑(Side millin	DRD0810	30mm	90	500~400	600~800	8~16	0.06~0.1	側銑(Side milling)				
DRD0810	30mm	190	500~850	600~200	0.2~0.25	0.2~0.25	3D銑(3D millir	DRD0810	30mm	100	000~450	400~1800	0.2~0.25	0.2~0.25	3D銑(3D milling)				
DRD0810	30mm	190	500~850	400~1800	0.06~0.11	0.06~0.1	3D銑(3D millir	DRD0810	30mm	185	200~770	200~160	0.06~0.1	0.06~0.1	3D銑(3D milling)				
DRD1010	35mm	135	000~470	200~160	0.2~0.3	7~10	溝銑(Slotting)	DRD1010	35mm	100	200~360	000~1100	0.2~0.3	7~10	溝銑(Slotting)				
DRD1010	35mm	145	500~500	000~1000	0.05~0.12	7~10	溝銑(Slotting)	DRD1010	35mm	140	400~480	000~1000	0.05~0.1	7~10	溝銑(Slotting)				
DRD1010	35mm	90	000~320	000~1200	10~20	0.2~0.3	側銑(Side millin	DRD1010	35mm	90	000~320	700~1000	10~20	0.2~0.3	側銑(Side milling)				
DRD1010	35mm	90	000~320	700~900	10~20	0.05~0.1	側銑(Side millin	DRD1010	35mm	90	000~320	600~800	10~20	0.05~0.1	側銑(Side milling)				
DRD1010	35mm	190	000~700	600~200	0.2~0.3	0.2~0.3	3D銑(3D millir	DRD1010	35mm	100	200~360	400~180	0.2~0.3	0.2~0.3	3D銑(3D milling)				
DRD1010	35mm	190	000~700	400~1800	0.05~0.12	0.05~0.1	3D銑(3D millir	DRD1010	35mm	185	000~620	200~160	0.05~0.1	0.05~0.1	3D銑(3D milling)				
DRD1020	35mm	135	000~470	200~160	0.2~0.3	5~10	溝銑(Slotting)	DRD1020	35mm	100	200~360	000~1100	0.2~0.3	5~10	溝銑(Slotting)				
DRD1020	35mm	145	500~500	000~1000	0.05~0.12	5~10	溝銑(Slotting)	DRD1020	35mm	140	400~480	000~1000	0.05~0.1	5~10	溝銑(Slotting)				
DRD1020	35mm	90	000~320	000~1200	10~20	0.2~0.3	側銑(Side millin	DRD1020	35mm	90	000~320	700~1000	10~20	0.2~0.3	側銑(Side milling)				
DRD1020	35mm	90	000~320	700~900	10~20	0.05~0.1	側銑(Side millin	DRD1020	35mm	90	000~320	600~800	10~20	0.05~0.1	側銑(Side milling)				
DRD1020	35mm	190	000~700	600~200	0.2~0.3	0.2~0.3	3D銑(3D millir	DRD1020	35mm	100	200~360	400~180	0.2~0.3	0.2~0.3	3D銑(3D milling)				
DRD1020	35mm	190	000~700	400~1800	0.05~0.12	0.05~0.1	3D銑(3D millir	DRD1020	35mm	185	000~620	200~160	0.05~0.1	0.05~0.1	3D銑(3D milling)				
DRD1030	35mm	135	000~470	200~160	0.2~0.3	3~10	溝銑(Slotting)	DRD1030	35mm	100	200~360	000~1100	0.2~0.3						