

被切削材 Work Material		熱處理鋼 Hardened Steels: SKD61,STAVAX,1.2083 ,17-4PH (HRc52)						被切削材 Work Material	調質鋼,預硬鋼 Prehardened Steel: NAK80 , 1.2083 (HRc38)						被切削材 Work Material	耐蝕不銹鋼 Hardened Steels:(SUS316、1.4401)、(SUS304、1.4301) (HRc30)						被切削材 Work Material	耐蝕不銹鋼 Hardened Steels:(SUS316、1.4401)、(SUS304、1.4301) (HRc30)								
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	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	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	
UME0022	12mm	15	18000~20000	150~300	0.005~0.008	0.2	溝銑(Slotting)																	溝銑(Slotting)	MBTA0032	10mm	17000~18000	200~300	0.01~0.015	0.3	溝銑(Slotting)
UME0022	12mm	15	18000~20000	150~300	0.005~0.008	0.2	溝銑(Slotting)																	溝銑(Slotting)	MBTA0032	10mm	17000~18000	250~350	0.005~0.01	0.3	溝銑(Slotting)
UME0032	12mm	20	18000~20000	150~300	0.005~0.01	0.3	溝銑(Slotting)																	3D銑(3D milling)	MBTA0032	10mm	17000~18000	300~400	0.01~0.015	0.03	3D銑(3D milling)
UME0032	12mm	20	18000~20000	150~300	0.005~0.01	0.3	溝銑(Slotting)																	3D銑(3D milling)	MBTA0032	10mm	17000~18000	350~450	0.005~0.01	0.02	3D銑(3D milling)
UME0042	12mm	25	18000~20000	200~400	0.008~0.015	0.4	溝銑(Slotting)																	溝銑(Slotting)	MBTA0042	10mm	17000~18000	300~400	0.01~0.02	0.4	溝銑(Slotting)
UME0042	12mm	25	18000~20000	200~400	0.008~0.015	0.4	溝銑(Slotting)																	溝銑(Slotting)	MBTA0042	10mm	17000~18000	350~450	0.01~0.015	0.4	溝銑(Slotting)
UME0052	12mm	30	18000~20000	200~400	0.015~0.025	0.5	溝銑(Slotting)																	3D銑(3D milling)	MBTA0042	10mm	17000~18000	400~500	0.01~0.02	0.06	3D銑(3D milling)
UME0052	12mm	30	18000~20000	400~600	0.01~0.015	0.5	溝銑(Slotting)																	3D銑(3D milling)	MBTA0042	10mm	17000~18000	500~600	0.01~0.015	0.03	3D銑(3D milling)
UME0062	12mm	35	16000~18000	200~400	0.02~0.04	0.6	溝銑(Slotting)																	溝銑(Slotting)	MBTA0052	10mm	17000~18000	300~500	0.02~0.03	0.5	溝銑(Slotting)
UME0062	12mm	35	16000~18000	400~600	0.015~0.025	0.6	溝銑(Slotting)																	溝銑(Slotting)	MBTA0052	10mm	17000~18000	500~600	0.015~0.025	0.5	溝銑(Slotting)
UME0072	12mm	40	16000~18000	300~500	0.03~0.05	0.7	溝銑(Slotting)																	3D銑(3D milling)	MBTA0052	10mm	17000~18000	400~600	0.02~0.03	0.06	3D銑(3D milling)
UME0072	12mm	40	16000~18000	600~800	0.015~0.025	0.7	溝銑(Slotting)																	3D銑(3D milling)	MBTA0052	10mm	17000~18000	600~800	0.015~0.025	0.06	3D銑(3D milling)
UME0082	12mm	45	16000~18000	400~600	0.04~0.06	0.8	溝銑(Slotting)																	溝銑(Slotting)	MBTA0062	10mm	17000~18000	400~600	0.03~0.04	0.6	溝銑(Slotting)
UME0082	12mm	45	16000~18000	800~1000	0.015~0.03	0.8	溝銑(Slotting)																	溝銑(Slotting)	MBTA0062	10mm	17000~18000	600~900	0.02~0.03	0.6	溝銑(Slotting)
UME0102	12mm	50	16000~18000	400~600	0.04~0.06	1	溝銑(Slotting)																	3D銑(3D milling)	MBTA0062	10mm	17000~18000	500~600	0.03~0.04	0.08	3D銑(3D milling)
UME0102	12mm	50	16000~18000	800~1000	0.015~0.03	1	溝銑(Slotting)																	3D銑(3D milling)	MBTA0062	10mm	17000~18000	600~800	0.02~0.03	0.06	3D銑(3D milling)
UME0122	12mm	60	16000~18000	400~600	0.04~0.06	1.2	溝銑(Slotting)																	溝銑(Slotting)	MBTA0072	10mm	17000~18000	500~700	0.04~0.06	0.7	溝銑(Slotting)
UME0122	12mm	60	16000~18000	800~1000	0.015~0.03	1.2	溝銑(Slotting)																	溝銑(Slotting)	MBTA0072	10mm	17000~18000	800~1000	0.03~0.04	0.7	溝銑(Slotting)
UME0152	12mm	75	15000~16000	600~800	0.05~0.07	1.5	溝銑(Slotting)																	3D銑(3D milling)	MBTA0072	10mm	17000~18000	600~800	0.04~0.06	0.12	3D銑(3D milling)
UME0152	12mm	75	15000~16000	1000~1200	0.015~0.035	1.5	溝銑(Slotting)																	3D銑(3D milling)	MBTA0072	10mm	17000~18000	900~1200	0.03~0.04	0.08	3D銑(3D milling)
UME0162	13mm	80	15000~16000	600~800	0.06~0.08	1.6	溝銑(Slotting)																	溝銑(Slotting)	MBTA0082	10mm	17000~18000	600~800	0.05~0.06	0.8	溝銑(Slotting)
UME0162	13mm	80	15000~16000	1000~1200	0.015~0.035	1.6	溝銑(Slotting)																	溝銑(Slotting)	MBTA0082	10mm	17000~18000	1000~1200	0.03~0.04	0.8	溝銑(Slotting)
UME0182	13mm	90	15000~16000	600~800	0.07~0.09	1.8	溝銑(Slotting)																	3D銑(3D milling)	MBTA0082	10mm	17000~18000	700~900	0.05~0.06	0.12	3D銑(3D milling)
UME0182	13mm	90	15000~16000	1200~1600	0.02~0.04	1.8	溝銑(Slotting)																	3D銑(3D milling)	MBTA0082	10mm	17000~18000	1000~1300	0.03~0.04	0.08	3D銑(3D milling)
UME0202	15mm	95	13000~15000	600~800	0.08~0.1	2	溝銑(Slotting)																	溝銑(Slotting)	MBTA0102	10mm	16000~17000	700~800	0.05~0.06	1	溝銑(Slotting)
UME0202	15mm	95	13000~15000	1200~1600	0.02~0.045	2	溝銑(Slotting)																	溝銑(Slotting)	MBTA0102	10mm	16000~17000	1200~1400	0.04~0.05	1	溝銑(Slotting)
UME0252	15mm	105	11000~13000	800~1000	0.08~0.1	2.5	溝銑(Slotting)																	3D銑(3D milling)	MBTA0102	10mm	16000~17000	900~1100	0.05~0.07	0.14	3D銑(3D milling)
UME0252	15mm	105	11000~13000	1400~1800	0.02~0.05	2.5	溝銑(Slotting)																	3D銑(3D milling)	MBTA0102	10mm	16000~17000	1300~1500	0.04~0.05	0.1	3D銑(3D milling)
UME0302	14mm	105	9000~11000	1000~1200	0.09~0.11	3	溝銑(Slotting)																	溝銑(Slotting)	MBTA0122	10mm	16000~17000	700~800	0.05~0.06	1.2	溝銑(Slotting)
UME0302	14mm	105	9000~11000	1600~2000	0.025~0.06	3	溝銑(Slotting)																	溝銑(Slotting)	MBTA0122	10mm	16000~17000	1300~1500	0.04~0.05	1.2	溝銑(Slotting)
UME0402	15mm	115	7000~9000	1400~1600	0.12~0.14	4	溝銑(Slotting)																	3D銑(3D milling)	MBTA0122	10mm	16000~17000	900~1100	0.05~0.07	0.14	3D銑(3D milling)
UME0402	15mm	115	7000~9000	2000~2400	0.03~0.08	4	溝銑(Slotting)																	3D銑(3D milling)	MBTA0122	10mm	16000~17000	1400~1600	0.04~0.05	0.1	3D銑(3D milling)

附註 / Note:

- 以上冷卻方式皆為油霧。
Suggest to use MQL coolant.
- UME不適用於SKD11(HRc62)溝銑或面銑，可用於清角。
UME is not good at slotting or surfacing on material SKD11 (HRc62), it is suitable for Corner Finishing Milling.