DHF

被切削材 Work Material	熱處理鋼 Hardened Steels:SKD61,STAVAX,1.2083 ,17-4PH (HRc52)						
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
UNBX100404	11mm	60	17000~18000	600~800	0.015~0.035	1	溝銑(Slotting)
UNBX100404	11mm	60	17000~18000	900~1100	0.02~0.04	0.04~0.08	3D銑(3D milling)
UNBX100604	13mm	60	17000~18000	500~700	0.015~0.035	1	溝銑(Slotting)
UNBX100604	13mm	60	17000~18000	800~1000	0.02~0.04	0.04~0.08	3D銑(3D milling)
UNBX100804	15mm	60	17000~18000	400~600	0.015~0.035	1	溝銑(Slotting)
UNBX100804	15mm	60	17000~18000	700~900	0.02~0.04	0.04~0.08	3D銑(3D milling)
UNBX101004	17mm	60	17000~18000	300~500	0.01~0.025	1	溝銑(Slotting)
UNBX101004	17mm	60	17000~18000	600~800	0.02~0.03	0.04~0.06	3D銑(3D milling)
UNBX101204	19mm	60	17000~18000	300~500	0.01~0.025	1	溝銑(Slotting)
UNBX101204	19mm	60	17000~18000	600~800	0.01~0.025	0.02~0.05	3D銑(3D milling)
UNBX150604	13mm	80	16000~17000	600~800	0.02~0.04	1,5	溝銑(Slotting)
UNBX150604	13mm	80	16000~17000	900~1100	0.03~0.05	0.06~0.1	3D銑(3D milling)
UNBX150804	15mm	80	16000~17000	500~700	0.02~0.04	1,5	溝銑(Slotting)
UNBX150804	15mm	80	16000~17000	800~1000	0.03~0.05	0.06~0.1	3D銑(3D milling)
UNBX151004	17mm	80	16000~17000	400~600	0.015~0.035	1,5	溝銑(Slotting)
UNBX151004	17mm	80	16000~17000	700~900	0.02~0.04	0.04~0.08	3D銑(3D milling)
UNBX151204	19mm	80	16000~17000	300~500	0.015~0.035	1,5	溝銑(Slotting)
UNBX151204	19mm	80	16000~17000	600~800	0.02~0.04	0.04~0.08	3D銑(3D milling)
UNBX151604	23mm	80	16000~17000	200~400	0.015~0.035	1,5	溝銑(Slotting)
UNBX151604	23mm	80	16000~17000	500~700	0.02~0.04	0.04~0.08	3D銑(3D milling)
UNBX200804	14mm	100	15000~16000	600~800	0.03~0.06	2	溝銑(Slotting)
UNBX200804	14mm	100	15000~16000	1000~1400	0.03~0.06	0.06~0.12	3D銑(3D milling)
UNBX201004	16mm	100	15000~16000	600~800	0.03~0.06	2	溝銑(Slotting)
UNBX201004	16mm	100	15000~16000	1000~1200	0.03~0.06	0.06~0.12	3D銑(3D milling)
UNBX201204	18mm	100	15000~16000	500~700	0.03~0.06	2	溝銑(Slotting)
UNBX201204	18mm	100	15000~16000	900~1100	0.03~0.06	0.06~0.12	3D銑(3D milling)
UNBX201604	22mm	100	15000~16000	500~700	0.02~0.05	2	溝銑(Slotting)
UNBX201604	22mm	100	15000~16000	900~1100	0.02~0.04	0.04~0.08	3D銑(3D milling)
UNBX202004	26mm	100	15000~16000	400~600	0.02~0.05	2	溝銑(Slotting)
UNBX202004	26mm	100	15000~16000	700~900	0.02~0.04	0.04~0.08	3D銑(3D milling)
UNBX300804	19mm	145	14000~15000	900~1100	0.04~0.08	3	溝銑(Slotting)
UNBX300804	19mm	145	14000~15000	1400~1800	0.04~0.08	0.08~0.16	3D銑(3D milling)
UNBX301004	21mm	145	14000~15000	900~1100	0.04~0.08	3	溝銑(Slotting)
UNBX301004	21mm	145	14000~15000	1400~1800	0.04~0.08	0.08~0.16	3D銑(3D milling)
UNBX301204	23mm	145	14000~15000	800~1000	0.04~0.08	3	溝銑(Slotting)
UNBX301204	23mm	145	14000~15000	1300~1700	0.04~0.08	0.08~0.16	3D銑(3D milling)
UNBX301604	27mm	145	14000~15000	700~900	0.03~0.06	3	溝銑(Slotting)
UNBX301604	27mm	145	14000~15000	1200~1600	0.03~0.07	0.06~0.14	3D銑(3D milling)
UNBX302004	31mm	145	14000~15000	700~900	0.02~0.05	3	溝銑(Slotting)
UNBX302004	31mm	145	14000~15000	1200~1600	0.02~0.06	0.04~0.12	3D銑(3D milling)
UNBX302504	36mm	145	14000~15000	600~800	0.01~0.03	3	溝銑(Slotting)
UNBX302504	36mm	145	14000~15000	1100~1500	0.02~0.05	0.04~0.1	3D銑(3D milling)
UNBX401004	26mm	165	11000~13000	1100~1500	0.04~0.08	4	溝銑(Slotting)
UNBX401004	26mm	165	11000~13000	1600~2000	0.04~0.09	0.08~0.18	3D銑(3D milling)
UNBX401204	28mm	165	11000~13000	1100~1500	0.04~0.08	4	溝銑(Slotting)
UNBX401204	28mm	165	11000~13000	1600~2000	0.04~0.09	0.08~0.18	3D銑(3D milling)
UNBX401604	32mm	165	11000~13000	1000~1400	0.03~0.06	4	溝銑(Slotting)
UNBX401604	32mm	165	11000~13000	1600~2000	0.03~0.08	0.06~0.16	3D銑(3D milling)
UNBX402004	36mm	165	11000~13000	1000~1200	0.03~0.06	4	溝銑(Slotting)
UNBX402004	36mm	165	11000~13000	1400~1800	0.02~0.05	0.04~0.1	3D銑(3D milling)
UNBX402504	41mm	165	11000~13000	800~1000	0.03~0.06	4	溝銑(Slotting)
UNBX402504	41mm	165	11000~13000	1200~1600	0.02~0.05	0.04~0.1	3D銑(3D milling)

附註 / Note:

以上冷卻方式皆為油霧。

Suggest to use MQL coolant.

DHF

被切削材 Work Material	熱處理鋼 Hardened Steels: SKD11 (HRc62)						
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
UNBX100404	11mm	50	15000~16000	400~600	0.01~0.025	1	溝銑(Slotting)
UNBX100404	11mm	50	15000~16000	700~900	0.01~0.03	0.02~0.06	3D銑(3D milling)
UNBX100604	13mm	50	15000~16000	400~600	0.01~0.025	1	溝銑(Slotting)
UNBX100604	13mm	50	15000~16000	700~900	0.01~0.03	0.02~0.06	3D銑(3D milling)
UNBX100804	15mm	50	15000~16000	300~500	0.01~0.025	1	溝銑(Slotting)
UNBX100804	15mm	50	15000~16000	600~800	0.01~0.03	0.02~0.06	3D銑(3D milling)
UNBX101004	17mm	50	15000~16000	200~400	0.01~0.02	1	溝銑(Slotting)
UNBX101004	17mm	50	15000~16000	400~600	0.008~0.015	0.016~0.03	3D銑(3D milling)
UNBX101204	19mm	50	15000~16000	200~400	0.01~0.02	1	溝銑(Slotting)
UNBX101204	19mm	50	15000~16000	400~600	0.008~0.015	0.016~0.03	3D銑(3D milling)
UNBX150604	13mm	65	13000~14000	500~700	0.01~0.03	1,5	溝銑(Slotting)
UNBX150604	13mm	65	13000~14000	800~1000	0.02~0.04	0.04~0.08	3D銑(3D milling)
UNBX150804	15mm	65	13000~14000	400~600	0.01~0.03	1,5	溝銑(Slotting)
UNBX150804	15mm	65	13000~14000	700~900	0.02~0.04	0.04~0.08	3D銑(3D milling)
UNBX151004	17mm	65	13000~14000	300~500	0.01~0.02	1,5	溝銑(Slotting)
UNBX151004	17mm	65	13000~14000	600~800	0.02~0.03	0.04~0.06	3D銑(3D milling)
UNBX151204	19mm	65	13000~14000	300~500	0.01~0.02	1,5	溝銑(Slotting)
UNBX151204	19mm	65	13000~14000	600~800	0.02~0.03	0.04~0.06	3D銑(3D milling)
UNBX151604	23mm	65	13000~14000	200~400	0.01~0.02	1,5	溝銑(Slotting)
UNBX151604	23mm	65	13000~14000	500~700	0.01~0.02	0.02~0.04	3D銑(3D milling)
UNBX200804	14mm	85	12000~13000	500~700	0.02~0.05	2	溝銑(Slotting)
UNBX200804	14mm	85	12000~13000	700~1100	0.02~0.05	0.04~0.1	3D銑(3D milling)
UNBX201004	16mm	85	12000~13000	500~700	0.02~0.05	2	溝銑(Slotting)
UNBX201004	16mm	85	12000~13000	700~1100	0.02~0.05	0.04~0.1	3D銑(3D milling)
UNBX201204	18mm	85	12000~13000	400~600	0.02~0.04	2	溝銑(Slotting)
UNBX201204	18mm	85	12000~13000	600~1000	0.02~0.05	0.04~0.1	3D銑(3D milling)
UNBX201604	22mm	85	12000~13000	300~500	0.01~0.03	2	溝銑(Slotting)
UNBX201604	22mm	85	12000~13000	500~900	0.01~0.04	0.02~0.08	3D銑(3D milling)
UNBX202004	26mm	85	12000~13000	200~400	0.01~0.02	2	溝銑(Slotting)
UNBX202004	26mm	85	12000~13000	400~800	0.01~0.03	0.02~0.06	3D銑(3D milling)
UNBX300804	19mm	115	10000~12000	800~1000	0.03~0.06	3	溝銑(Slotting)
UNBX300804	19mm	115	10000~12000	1300~1700	0.03~0.07	0.06~0.14	3D銑(3D milling)
UNBX301004	21mm	115	10000~12000	800~1000	0.03~0.06	3	溝銑(Slotting)
UNBX301004	21mm	115	10000~12000	1300~1700	0.03~0.07	0.06~0.14	3D銑(3D milling)
UNBX301204	23mm	115	10000~12000	700~900	0.03~0.06	3	溝銑(Slotting)
UNBX301204	23mm	115	10000~12000	1200~1600	0.03~0.07	0.06~0.14	3D銑(3D milling)
UNBX301604	27mm	115	10000~12000	600~800	0.02~0.05	3	溝銑(Slotting)
UNBX301604	27mm	115	10000~12000	1000~1400	0.02~0.05	0.04~0.1	3D銑(3D milling)
UNBX302004	31mm	115	10000~12000	500~700	0.02~0.04	3	溝銑(Slotting)
UNBX302004	31mm	115	10000~12000	1000~1400	0.02~0.04	0.04~0.08	3D銑(3D milling)
UNBX302504	36mm	115	10000~12000	400~600	0.02~0.04	3	溝銑(Slotting)
UNBX302504	36mm	115	10000~12000	600~1000	0.02~0.04	0.04~0.08	3D銑(3D milling)
UNBX401004	26mm	115	7000~9000	800~1200	0.03~0.07	4	溝銑(Slotting)
UNBX401004	26mm	115	7000~9000	1200~1600	0.04~0.08	0.08~0.16	3D銑(3D milling)
UNBX401204	28mm	115	7000~9000	800~1200	0.03~0.07	4	溝銑(Slotting)
UNBX401204	28mm	115	7000~9000	1200~1600	0.04~0.08	0.08~0.16	3D銑(3D milling)
UNBX401604	32mm	115	7000~9000	600~1000	0.02~0.06	4	溝銑(Slotting)
UNBX401604	32mm	115	7000~9000	1000~1400	0.03~0.07	0.06~0.14	3D銑(3D milling)
UNBX402004	36mm	115	7000~9000	600~800	0.02~0.05	4	溝銑(Slotting)
UNBX402004	36mm	115	7000~9000	800~1200	0.02~0.06	0.04~0.12	3D銑(3D milling)
UNBX402504	41mm	115	7000~9000	500~700	0.02~0.05	4	溝銑(Slotting)
UNBX402504	41mm	115	7000~9000	600~1000	0.02~0.06	0.04~0.12	3D銑(3D milling)

附註 / Note:

以上冷卻方式皆為油霧。

Suggest to use MQL coolant.

DHF

被切削材 Work Material	熱處理鋼 Hardened Steels: SKD11 (Hrc62)						
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
UNBX0201	12mm	15	16000~18000	100~200	0.003~0.006	0,2	溝銑(Slotting)
UNBX0201	12mm	15	16000~18000	100~200	0.005~0.008	0.01~0.016	3D銑(3D milling)
UNBX0202	13mm	15	16000~18000	100~200	0.003~0.006	0,2	溝銑(Slotting)
UNBX0202	13mm	15	16000~18000	100~200	0.005~0.008	0.01~0.016	3D銑(3D milling)
UNBX0301	13mm	15	15000~16000	100~200	0.003~0.006	0,3	溝銑(Slotting)
UNBX0301	13mm	15	15000~16000	100~200	0.005~0.01	0.01~0.02	3D銑(3D milling)
UNBX0302	14mm	15	15000~16000	100~200	0.003~0.006	0,3	溝銑(Slotting)
UNBX0302	14mm	15	15000~16000	100~200	0.005~0.01	0.01~0.02	3D銑(3D milling)
UNBX0303	15mm	15	15000~16000	100~200	0.003~0.006	0,3	溝銑(Slotting)
UNBX0303	15mm	15	15000~16000	100~200	0.005~0.01	0.01~0.02	3D銑(3D milling)
UNBX0402	14mm	20	15000~16000	100~200	0.005~0.008	0,4	溝銑(Slotting)
UNBX0402	14mm	20	15000~16000	150~300	0.005~0.01	0.01~0.02	3D銑(3D milling)
UNBX0403	15mm	20	15000~16000	100~200	0.005~0.008	0,4	溝銑(Slotting)
UNBX0403	15mm	20	15000~16000	150~300	0.005~0.01	0.01~0.02	3D銑(3D milling)
UNBX0404	16mm	20	15000~16000	100~200	0.005~0.008	0,4	溝銑(Slotting)
UNBX0404	16mm	20	15000~16000	100~200	0.005~0.01	0.01~0.02	3D銑(3D milling)
UNBX0502	15mm	25	15000~16000	150~300	0.005~0.01	0,5	溝銑(Slotting)
UNBX0502	15mm	25	15000~16000	150~300	0.005~0.01	0.01~0.02	3D銑(3D milling)
UNBX0504	17mm	25	15000~16000	100~200	0.005~0.01	0,5	溝銑(Slotting)
UNBX0504	17mm	25	15000~16000	100~200	0.005~0.01	0.01~0.02	3D銑(3D milling)
UNBX0506	19mm	25	15000~16000	100~200	0.005~0.01	0,5	溝銑(Slotting)
UNBX0506	19mm	25	15000~16000	100~200	0.005~0.01	0.01~0.02	3D銑(3D milling)
UNBX0602	16mm	30	14000~15000	150~300	0.005~0.01	0,6	溝銑(Slotting)
UNBX0602	16mm	30	14000~15000	150~300	0.005~0.01	0.01~0.02	3D銑(3D milling)
UNBX0604	18mm	30	14000~15000	100~200	0.005~0.01	0,6	溝銑(Slotting)
UNBX0604	18mm	30	14000~15000	100~200	0.005~0.01	0.01~0.02	3D銑(3D milling)
UNBX0606	20mm	30	14000~15000	100~200	0.005~0.01	0,6	溝銑(Slotting)
UNBX0606	20mm	30	14000~15000	100~200	0.005~0.01	0.01~0.02	3D銑(3D milling)
UMBX0804	15mm	40	14000~15000	200~400	0.01~0.02	0,8	溝銑(Slotting)
UMBX0804	15mm	40	14000~15000	200~400	0.008~0.015	0.016~0.03	3D銑(3D milling)
UMBX0804	15mm	40	14000~15000	200~400	0.008~0.015	0.016~0.03	3D銑(3D milling)
UNBX0806	17mm	40	14000~15000	150~300	0.01~0.02	0,8	溝銑(Slotting)
UNBX0806	17mm	40	14000~15000	150~300	0.005~0.015	0.01~0.03	3D銑(3D milling)
UNBX0806	17mm	40	14000~15000	150~300	0.005~0.015	0.01~0.03	3D銑(3D milling)
UNBX0808	19mm	40	14000~15000	150~300	0.01~0.02	0,8	溝銑(Slotting)
UNBX0808	19mm	40	14000~15000	150~300	0.005~0.015	0.01~0.03	3D銑(3D milling)
UNBX0808	19mm	40	14000~15000	150~300	0.005~0.015	0.01~0.03	3D銑(3D milling)
UNBX1004	11mm	45	13000~14000	200~400	0.01~0.02	1	溝銑(Slotting)
UNBX1004	11mm	45	13000~14000	300~500	0.02~0.04	0.04~0.08	3D銑(3D milling)
UNBX1004	11mm	45	13000~14000	500~700	0.008~0.015	0.016~0.03	3D銑(3D milling)
UNBX1006	13mm	45	13000~14000	200~400	0.01~0.02	1	溝銑(Slotting)
UNBX1006	13mm	45	13000~14000	300~500	0.02~0.04	0.04~0.08	3D銑(3D milling)
UNBX1006	13mm	45	13000~14000	500~700	0.008~0.015	0.016~0.03	3D銑(3D milling)
UNBX1008	15mm	45	13000~14000	200~400	0.01~0.02	1	溝銑(Slotting)
UNBX1008	15mm	45	13000~14000	200~400	0.02~0.04	0.04~0.08	3D銑(3D milling)
UNBX1008	15mm	45	13000~14000	500~700	0.008~0.015	0.016~0.03	3D銑(3D milling)
UNBX1010	17mm	45	13000~14000	200~400	0.01~0.02	1	溝銑(Slotting)
UNBX1010	17mm	45	13000~14000	200~400	0.02~0.04	0.04~0.08	3D銑(3D milling)
UNBX1010	17mm	45	13000~14000	500~700	0.008~0.015	0.016~0.03	3D銑(3D milling)
UNBX1012	19mm	45	13000~14000	150~300	0.01~0.02	1	溝銑(Slotting)
UNBX1012	19mm	45	13000~14000	150~300	0.015~0.025	0.03~0.05	3D銑(3D milling)
UNBX1012	19mm	45	13000~14000	300~400	0.008~0.015	0.016~0.03	3D銑(3D milling)

附註 / Note:

以上冷卻方式皆為油霧。

Suggest to use MQL coolant.

耐蝕不銹鋼 Stainless Steel: SUS316/1.4401 , SUS304/1.4301 (HRc30)					
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