

被切削材 Work Material	碳素鋼 / 鑄鐵 : Carbon steels / Cast Iron S50C / Fc250 / SS440 : 1.1210 / 0.6025 / 1.0036 / 1050 / NO.35 / A570 GrA5 (~HRc22)						
型號 Type NO.	刀具伸長量 ExtenWion Length	切削速度 (m/min) Cutting Speed	迴轉速度 Speed (min ⁻¹)	進給速度 Feed (mm/min)	加工深度 (Aa) Cut of depth	加工寬度 (Ap) Cut of width	加工方式 Milling Type
WGB010	40mm	290	8700~9200	2200~2600	0.15~0.25	0.4~0.6	3D銑
WGB010	40mm	290	8700~9200	3200~3600	0.05~0.1	0.2~0.3	3D銑
WGB010	60mm	230	7000~7500	1600~2000	0.1~0.15	0.2~0.35	3D銑
WGB010	60mm	230	7000~7500	2000~2400	0.05~0.1	0.12~0.2	3D銑
WGB010	100mm	180	5500~6000	1200~1500	0.05~0.1	0.12~0.2	3D銑
WGB012	40mm	325	8200~8600	2100~2500	0.2~0.3	0.4~0.6	3D銑
WGB012	40mm	325	8200~8600	2800~3200	0.06~0.15	0.2~0.3	3D銑
WGB012	60mm	270	7000~7500	1600~2000	0.2~0.25	0.4~0.5	3D銑
WGB012	60mm	270	7000~7500	2200~2600	0.06~0.15	0.2~0.3	3D銑
WGB012	100mm	200	5000~5500	800~1200	0.06~0.15	0.2~0.3	3D銑
WGB016	60mm	230	4000~4500	1600~2000	0.2~0.35	0.4~0.6	3D銑
WGB016	60mm	305	5500~6000	2600~3000	0.06~0.15	0.2~0.35	3D銑
WGB016	100mm	175	3000~3500	1400~1800	0.2~0.3	0.35~0.55	3D銑
WGB016	100mm	230	4000~4500	2000~2400	0.06~0.15	0.2~0.35	3D銑
WGB016	140mm	140	2300~2800	1200~1500	0.06~0.15	0.2~0.3	3D銑
WGB020	80mm	330	4700~5200	1600~2000	0.2~0.3	0.4~0.6	3D銑
WGB020	80mm	380	5500~6000	2000~2400	0.1~0.17	0.2~0.4	3D銑
WGB020	130mm	160	2000~2500	1100~1400	0.2~0.25	0.4~0.5	3D銑
WGB020	130mm	220	3000~3500	1200~1600	0.1~0.17	0.2~0.35	3D銑
WGB020	180mm	140	1800~2200	1000~1300	0.1~0.15	0.2~0.3	3D銑
WGB025	80mm	330	3500~4000	1300~1700	0.2~0.3	0.4~0.6	3D銑
WGB025	80mm	350	4000~4500	1800~2200	0.1~0.17	0.2~0.35	3D銑
WGB025	130mm	220	2400~2800	1000~1400	0.2~0.25	0.4~0.5	3D銑
WGB025	130mm	300	3400~3800	1300~1700	0.1~0.17	0.2~0.35	3D銑
WGB025	180mm	240	2500~3000	1100~1400	0.1~0.15	0.2~0.3	3D銑
WGB030	80mm	330	2700~3200	1100~1500	0.23~0.28	0.4~0.6	3D銑
WGB030	80mm	370	3500~4000	1500~1900	0.1~0.17	0.2~0.35	3D銑
WGB030	140mm	280	2400~2800	900~1300	0.2~0.25	0.4~0.5	3D銑
WGB030	140mm	340	3200~3700	1200~1600	0.1~0.17	0.2~0.35	3D銑
WGB030	200mm	200	1800~2200	800~1200	0.1~0.15	0.2~0.3	3D銑
WGB032	80mm	330	2700~3200	1100~1500	0.23~0.28	0.4~0.6	3D銑
WGB032	80mm	370	3500~4000	1500~1900	0.1~0.17	0.2~0.35	3D銑
WGB032	140mm	280	2400~2800	900~1300	0.2~0.25	0.4~0.6	3D銑
WGB032	140mm	340	3200~3700	1200~1600	0.1~0.17	0.2~0.4	3D銑
WGB032	200mm	190	1800~2200	800~1200	0.1~0.15	0.2~0.3	3D銑

被切削材 Work Material	合金工具鋼 / 碳工具鋼 : Alloy Tool Steels / CarHon Tool Steels P20 / P5 / SK3 / SKD61 / SKD11 : 1.2311 / 1.1545 / 1.2379 / 1.2344 : H13 / D2 HRc(23~32)						
型號 Type NO.	刀具伸長量 ExtenWion Length	切削速度 (m/min) Cutting Speed	迴轉速度 Speed (min ⁻¹)	進給速度 Feed (mm/min)	加工深度 (Aa) Cut of depth	加工寬度 (Ap) Cut of width	加工方式 Milling Type
WGB010	40mm	290	8700~9200	2200~2600	0.15~0.25	0.4~0.6	3D銑
WGB010	40mm	290	8700~9200	3000~3400	0.05~0.1	0.2~0.3	3D銑
WGB010	60mm	230	7000~7500	1600~2000	0.1~0.15	0.2~0.35	3D銑
WGB010	60mm	230	7000~7500	2000~2400	0.05~0.1	0.12~0.2	3D銑
WGB010	100mm	180	5500~6000	1200~1500	0.05~0.1	0.12~0.2	3D銑
WGB012	40mm	325	8200~8600	2100~2500	0.2~0.3	0.4~0.6	3D銑
WGB012	40mm	325	8200~8600	2800~3200	0.06~0.15	0.2~0.3	3D銑
WGB012	60mm	270	7000~7500	1600~2000	0.2~0.25	0.4~0.5	3D銑
WGB012	60mm	270	7000~7500	2200~2600	0.06~0.15	0.2~0.3	3D銑
WGB012	100mm	200	5000~5500	800~1200	0.06~0.15	0.2~0.3	3D銑
WGB016	60mm	230	4000~4500	1600~2000	0.2~0.35	0.4~0.6	3D銑
WGB016	60mm	305	5500~6000	2600~3000	0.06~0.15	0.2~0.35	3D銑
WGB016	100mm	175	3000~3500	1400~1800	0.2~0.3	0.35~0.55	3D銑
WGB016	100mm	230	4000~4500	2000~2400	0.06~0.15	0.2~0.35	3D銑
WGB016	140mm	140	2300~2800	1200~1500	0.06~0.15	0.2~0.3	3D銑
WGB020	80mm	330	4700~5200	1600~2000	0.2~0.3	0.4~0.6	3D銑
WGB020	80mm	380	5500~6000	2000~2400	0.1~0.17	0.2~0.4	3D銑
WGB020	130mm	160	2000~2500	1100~1400	0.2~0.25	0.4~0.5	3D銑
WGB020	130mm	220	3000~3500	1200~1600	0.1~0.17	0.2~0.35	3D銑
WGB020	180mm	140	1800~2200	1000~1300	0.1~0.15	0.2~0.3	3D銑
WGB025	80mm	330	3500~4000	1300~1700	0.2~0.3	0.4~0.6	3D銑
WGB025	80mm	350	4000~4500	1800~2200	0.1~0.17	0.2~0.35	3D銑
WGB025	130mm	220	2400~2800	1000~1400	0.2~0.25	0.4~0.5	3D銑
WGB025	130mm	300	3400~3800	1300~1700	0.1~0.17	0.2~0.35	3D銑
WGB025	180mm	240	2500~3000	1100~1400	0.1~0.15	0.2~0.3	3D銑
WGB030	80mm	330	2700~3200	1100~1500	0.23~0.28	0.4~0.6	3D銑
WGB030	80mm	370	3500~4000	1500~1900	0.1~0.17	0.2~0.35	3D銑
WGB030	140mm	280	2400~2800	900~1300	0.2~0.25	0.4~0.5	3D銑
WGB030	140mm	340	3200~3700	1200~1600	0.1~0.17	0.2~0.35	3D銑
WGB030	200mm	200	1800~2200	800~1200	0.1~0.15	0.2~0.3	3D銑
WGB032	80mm	330	2700~3200	1100~1500	0.23~0.28	0.4~0.6	3D銑
WGB032	80mm	370	3500~4000	1500~1900	0.1~0.17	0.2~0.35	3D銑
WGB032	140mm	280	2400~2800	900~1300	0.2~0.25	0.4~0.6	3D銑
WGB032	140mm	340	3200~3700	1200~1600	0.1~0.17	0.2~0.4	3D銑
WGB032	200mm	190	1800~2200	800~1200	0.1~0.15	0.2~0.3	3D銑

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 ExtenWion Length	切削速度 (m/min) Cutting Speed	迴轉速度 Speed (min ⁻¹)	進給速度 Feed (mm/min)	加工深度 (Aa) Cut of depth	加工寬度 (Ap) Cut of width	加工方式 Milling Type
WGB010	40mm	290	8700~9200	2000~2400	0.15~0.25	0.4~0.6	3D銑
WGB010	40mm	290	8700~9200	2800~3200	0.05~0.1	0.2~0.3	3D銑
WGB010	60mm	230	7000~7500	1400~1800	0.1~0.15	0.2~0.35	3D銑
WGB010	60mm	230	7000~7500	1800~2200	0.05~0.1	0.12~0.2	3D銑
WGB010	100mm	180	5500~6000	1100~1500	0.05~0.1	0.12~0.2	3D銑
WGB012	40mm	325	8200~8600	2000~2400	0.2~0.3	0.4~0.6	3D銑
WGB012	40mm	325	8200~8600	2800~3200	0.06~0.15	0.2~0.3	3D銑
WGB012	60mm	270	7000~7500	1600~2000	0.2~0.25	0.4~0.5	3D銑
WGB012	60mm	270	7000~7500	2200~2600	0.06~0.15	0.2~0.3	3D銑
WGB012	100mm	200	5000~5500	800~1200	0.06~0.15	0.2~0.3	3D銑
WGB016	60mm	230	4000~4500	1600~2000	0.2~0.35	0.4~0.6	3D銑
WGB016	60mm	305	5500~6000	2600~3000	0.06~0.15	0.2~0.35	3D銑
WGB016	100mm	175	3000~3500	1400~1800	0.2~0.3	0.35~0.55	3D銑
WGB016	100mm	230	4000~4500	1800~2200	0.06~0.15	0.2~0.35	3D銑
WGB016	140mm	140	2300~2800	1100~1500	0.06~0.15	0.2~0.3	3D銑
WGB020	80mm	330	4700~5200	1600~2000	0.2~0.3	0.4~0.6	3D銑
WGB020	80mm	380	5500~6000	2000~2400	0.1~0.17	0.2~0.4	3D銑
WGB020	130mm	160	2000~2500	1100~1400	0.2~0.25	0.4~0.5	3D銑
WGB020	130mm	220	3000~3500	1100~1500	0.1~0.17	0.2~0.35	3D銑
WGB020	180mm	140	1800~2200	900~1300	0.1~0.15	0.2~0.3	3D銑
WGB025	80mm	330	3500~4000	1300~1700	0.2~0.3	0.4~0.6	3D銑
WGB025	80mm	350	4000~4500	1800~2200	0.1~0.17	0.2~0.35	3D銑
WGB025	130mm	220	2400~2800	1000~1400	0.2~0.25	0.4~0.5	3D銑
WGB025	130mm	300	3400~3800	1300~1700	0.1~0.17	0.2~0.35	3D銑
WGB025	180mm	240	2500~3000	1000~1300	0.1~0.15	0.2~0.3	3D銑
WGB030	80mm	330	2700~3200	1100~1500	0.23~0.28	0.4~0.6	3D銑
WGB030	80mm	370	3500~4000	1500~1900	0.1~0.17	0.2~0.35	3D銑
WGB030	140mm	280	2400~2800	900~1300	0.2~0.25	0.4~0.5	3D銑
WGB030	140mm	340	3200~3700	1200~1600	0.1~0.17	0.2~0.35	3D銑
WGB030	200mm	200	1800~2200	800~1200	0.1~0.15	0.2~0.3	3D銑
WGB032	80mm	330	2700~3200	1100~1500	0.23~0.28	0.4~0.6	3D銑
WGB032	80mm	370	3500~4000	1500~1900	0.1~0.17	0.2~0.35	3D銑
WGB032	140mm	280	2400~2800	900~1300	0.2~0.25	0.4~0.6	3D銑
WGB032	140mm	340	3200~3700	1200~1600	0.1~0.17	0.2~0.4	3D銑
WGB032	200mm	190	1800~2200	800~1200	0.1~0.15	0.2~0.3	3D銑

被切削材 Work Material	熱處理鋼 : Hardened Steels 1.2083 / 1.2344 / 1.4542 : H13 / 420 (SKD61/ STAVAX / 17-4PH : HRc48~52)						
型號 Type NO.	刀具伸長量 ExtenWion Length	切削速度 (m/min) Cutting Speed	迴轉速度 Speed (min ⁻¹)	進給速度 Feed (mm/min)	加工深度 (Aa) Cut of depth	加工寬度 (Ap) Cut of width	加工方式 Milling Type
WGB010	40mm	225	6700~7200	1600~2000	0.05~0.1	0.15~0.25	3D銑
WGB010	60mm	190	5800~6300	1200~1500	0.05~0.08	0.15~0.25	3D銑
WGB010	80mm	140	4200~4700	900~1200	0.04~0.07	0.15~0.25	3D銑
WGB012	40mm	260	6700~7200	1600~2000	0.05~0.1	0.15~0.25	3D銑
WGB012	60mm	220	5500~6000	1200~1600	0.05~0.08	0.15~0.25	3D銑
WGB012	100mm	160	4000~4500	900~1200	0.04~0.07	0.15~0.25	3D銑
WGB016	60mm	230	4000~4500	1600~2000	0.05~0.12	0.2~0.3	3D銑
WGB016	100mm	160	2800~3200	1200~1600	0.05~0.1	0.2~0.3	3D銑
WGB016	130mm	115	2000~2300	800~1200	0.05~0.08	0.2~0.3	3D銑
WGB020	80mm	315	4500~5000	1200~1600	0.05~0.15	0.2~0.3	3D銑
WGB020	130mm	190	2500~3000	800~1200	0.05~0.12	0.2~0.3	3D銑
WGB020	180mm	140	1700~2200	800~1000	0.05~0.1	0.2~0.3	3D銑
WGB025	80mm	315	3500~4000	1300~1700	0.05~0.15	0.2~0.3	3D銑
WGB025	130mm	240	2500~3000	1000~1400	0.05~0.15	0.2~0.3	3D銑

被切削材 Work Material	碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron S50C / Fc250 / SS400 : 1.1210 / 0.6025 / 1.0036 : 1050 / NO.35 / 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)							被切削材 Work Material	熱處理鋼 : Hardened Steels SKD61 / STAVAX / 17-4PH : 1.2083 / 1.2344 / 1.4542 : H13 / 420 (HRc48~54)						
	型號 Type NO.	刀具伸長量 Extension Length	切削速度 Cutting Speed	迴轉速度 Speed (min ⁻¹)	進給速度 Feed (mm/min)	加工深度 (Aa) Cut of depth	加工寬度 (Ap) Cut of width		加工方式 Milling Type	型號 Type NO.	刀具伸長量 Extension Length	切削速度 Cutting Speed	迴轉速度 Speed (min ⁻¹)	進給速度 Feed (mm/min)	加工深度 (Aa) Cut of depth		加工寬度 (Ap) Cut of width	加工方式 Milling Type	型號 Type NO.	刀具伸長量 Extension Length	切削速度 Cutting Speed	迴轉速度 Speed (min ⁻¹)	進給速度 Feed (mm/min)		加工深度 (Aa) Cut of depth	加工寬度 (Ap) Cut of width	加工方式 Milling Type	型號 Type NO.	刀具伸長量 Extension Length	切削速度 Cutting Speed	迴轉速度 Speed (min ⁻¹)
WGB010	40mm	290	8700~9200	2200~2600	0.15~0.25	0.4~0.6	3D銑(3D milling)	WGB010	40mm	290	8700~9200	2200~2600	0.15~0.25	0.4~0.6	3D銑(3D milling)	WGB010	40mm	290	8700~9200	2000~2400	0.15~0.25	0.4~0.6	3D銑(3D milling)	WGB010	40mm	225	6700~7200	1600~2000	0.05~0.1	0.15~0.25	3D銑(3D milling)
WGB010	40mm	290	8700~9200	3200~3600	0.05~0.1	0.2~0.3	3D銑(3D milling)	WGB010	40mm	290	8700~9200	3000~3400	0.05~0.1	0.2~0.3	3D銑(3D milling)	WGB010	40mm	290	8700~9200	2800~3200	0.05~0.1	0.2~0.3	3D銑(3D milling)	WGB010	60mm	190	5800~6300	1200~1500	0.05~0.08	0.15~0.25	3D銑(3D milling)
WGB010	60mm	230	7000~7500	1600~2000	0.1~0.15	0.2~0.35	3D銑(3D milling)	WGB010	60mm	230	7000~7500	1600~2000	0.1~0.15	0.2~0.35	3D銑(3D milling)	WGB010	60mm	230	7000~7500	1400~1800	0.1~0.15	0.2~0.35	3D銑(3D milling)	WGB010	80mm	140	4200~4700	900~1200	0.04~0.07	0.15~0.25	3D銑(3D milling)
WGB010	60mm	230	7000~7500	2000~2400	0.05~0.1	0.12~0.2	3D銑(3D milling)	WGB010	60mm	230	7000~7500	2000~2400	0.05~0.1	0.12~0.2	3D銑(3D milling)	WGB010	60mm	230	7000~7500	1800~2200	0.05~0.1	0.12~0.2	3D銑(3D milling)	WGB012	40mm	260	6700~7200	1600~2000	0.05~0.1	0.15~0.25	3D銑(3D milling)
WGB010	100mm	180	5500~6000	1200~1500	0.05~0.1	0.12~0.2	3D銑(3D milling)	WGB010	100mm	180	5500~6000	1200~1500	0.05~0.1	0.12~0.2	3D銑(3D milling)	WGB010	100mm	180	5500~6000	1100~1500	0.05~0.1	0.12~0.2	3D銑(3D milling)	WGB012	60mm	220	5500~6000	1200~1600	0.05~0.08	0.15~0.25	3D銑(3D milling)
WGB012	40mm	325	8200~8600	2100~2500	0.2~0.3	0.4~0.6	3D銑(3D milling)	WGB012	40mm	325	8200~8600	2100~2500	0.2~0.3	0.4~0.6	3D銑(3D milling)	WGB012	40mm	325	8200~8600	2000~2400	0.2~0.3	0.4~0.6	3D銑(3D milling)	WGB012	100mm	160	4000~4500	900~1200	0.04~0.07	0.15~0.25	3D銑(3D milling)
WGB012	40mm	325	8200~8600	2800~3200	0.06~0.15	0.2~0.3	3D銑(3D milling)	WGB012	40mm	325	8200~8600	2800~3200	0.06~0.15	0.2~0.3	3D銑(3D milling)	WGB012	40mm	325	8200~8600	2800~3200	0.06~0.15	0.2~0.3	3D銑(3D milling)	WGB016	60mm	230	4000~4500	1600~2000	0.05~0.12	0.2~0.3	3D銑(3D milling)
WGB012	60mm	270	7000~7500	1600~2000	0.2~0.25	0.4~0.5	3D銑(3D milling)	WGB012	60mm	270	7000~7500	1600~2000	0.2~0.25	0.4~0.5	3D銑(3D milling)	WGB012	60mm	270	7000~7500	1600~2000	0.2~0.25	0.4~0.5	3D銑(3D milling)	WGB016	100mm	160	2800~3200	1200~1600	0.05~0.1	0.2~0.3	3D銑(3D milling)
WGB012	60mm	270	7000~7500	2200~2600	0.06~0.15	0.2~0.3	3D銑(3D milling)	WGB012	60mm	270	7000~7500	2200~2600	0.06~0.15	0.2~0.3	3D銑(3D milling)	WGB012	60mm	270	7000~7500	2200~2600	0.06~0.15	0.2~0.3	3D銑(3D milling)	WGB016	130mm	115	2000~2300	800~1200	0.05~0.08	0.2~0.3	3D銑(3D milling)
WGB012	100mm	200	5000~5500	800~1200	0.06~0.15	0.2~0.3	3D銑(3D milling)	WGB012	100mm	200	5000~5500	800~1200	0.06~0.15	0.2~0.3	3D銑(3D milling)	WGB012	100mm	200	5000~5500	800~1200	0.06~0.15	0.2~0.3	3D銑(3D milling)	WGB020	80mm	315	4500~5000	1200~1600	0.05~0.15	0.2~0.3	3D銑(3D milling)
WGB016	60mm	230	4000~4500	1600~2000	0.2~0.35	0.4~0.6	3D銑(3D milling)	WGB016	60mm	230	4000~4500	1600~2000	0.2~0.35	0.4~0.6	3D銑(3D milling)	WGB016	60mm	230	4000~4500	1600~2000	0.2~0.35	0.4~0.6	3D銑(3D milling)	WGB020	130mm	190	2500~3000	800~1200	0.05~0.12	0.2~0.3	3D銑(3D milling)
WGB016	60mm	305	5500~6000	2600~3000	0.06~0.15	0.2~0.35	3D銑(3D milling)	WGB016	60mm	305	5500~6000	2600~3000	0.06~0.15	0.2~0.35	3D銑(3D milling)	WGB016	60mm	305	5500~6000	2600~3000	0.06~0.15	0.2~0.35	3D銑(3D milling)	WGB020	180mm	140	1700~2200	800~1000	0.05~0.1	0.2~0.3	3D銑(3D milling)
WGB016	100mm	175	3000~3500	1400~1800	0.2~0.3	0.35~0.55	3D銑(3D milling)	WGB016	100mm	175	3000~3500	1400~1800	0.2~0.3	0.35~0.55	3D銑(3D milling)	WGB016	100mm	175	3000~3500	1400~1800	0.2~0.3	0.35~0.55	3D銑(3D milling)	WGB025	80mm	315	3500~4000	1300~1700	0.05~0.15	0.2~0.3	3D銑(3D milling)
WGB016	100mm	230	4000~4500	2000~2400	0.06~0.15	0.2~0.35	3D銑(3D milling)	WGB016	100mm	230	4000~4500	2000~2400	0.06~0.15	0.2~0.35	3D銑(3D milling)	WGB016	100mm	230	4000~4500	1800~2200	0.06~0.15	0.2~0.35	3D銑(3D milling)	WGB025	130mm	240	2500~3000	1000~1400	0.05~0.15	0.2~0.3	3D銑(3D milling)
WGB016	140mm	140	2300~2800	1200~1500	0.06~0.15	0.2~0.3	3D銑(3D milling)	WGB016	140mm	140	2300~2800	1200~1500	0.06~0.15	0.2~0.3	3D銑(3D milling)	WGB016	140mm	140	2300~2800	1100~1500	0.06~0.15	0.2~0.3	3D銑(3D milling)	WGB025	180mm	200	2000~2500	800~1200	0.05~0.12	0.2~0.3	3D銑(3D milling)
WGB020	80mm	330	4700~5200	1600~2000	0.2~0.3	0.4~0.6	3D銑(3D milling)	WGB020	80mm	330	4700~5200	1600~2000	0.2~0.3	0.4~0.6	3D銑(3D milling)	WGB020	80mm	330	4700~5200	1600~2000	0.2~0.3	0.4~0.6	3D銑(3D milling)	WGB030	80mm	330	3200~3700	1300~1700	0.12~0.17	0.2~0.4	3D銑(3D milling)
WGB020	80mm	380	5500~6000	2000~2400	0.1~0.17	0.2~0.4	3D銑(3D milling)	WGB020	80mm	380	5500~6000	2000~2400	0.1~0.17	0.2~0.4	3D銑(3D milling)	WGB020	80mm	380	5500~6000	2000~2400	0.1~0.17	0.2~0.4	3D銑(3D milling)	WGB030	140mm	260	2700~3200	1000~1400	0.12~0.17	0.2~0.4	3D銑(3D milling)
WGB020	130mm	160	2000~2500	1100~1400	0.2~0.25	0.4~0.5	3D銑(3D milling)	WGB020	130mm	160	2000~2500	1100~1400	0.2~0.25	0.4~0.5	3D銑(3D milling)	WGB020	130mm	160	2000~2500	1100~1400	0.2~0.25	0.4~0.5	3D銑(3D milling)	WGB030	200mm	200	1600~2000	700~1000	0.1~0.15	0.2~0.4	3D銑(3D milling)
WGB020	130mm	220	3000~3500	1200~1600	0.1~0.17	0.2~0.35	3D銑(3D milling)	WGB020	130mm	220	3000~3500	1200~1600	0.1~0.17	0.2~0.35	3D銑(3D milling)	WGB020	130mm	220	3000~3500	1100~1500	0.1~0.17	0.2~0.35	3D銑(3D milling)	WGB032	80mm	330	3200~3700	1300~1700	0.05~0.17	0.2~0.4	3D銑(3D milling)
WGB020	180mm	140	1800~2200	1000~1300	0.1~0.15	0.2~0.3	3D銑(3D milling)	WGB020	180mm	140	1800~2200	1000~1300	0.1~0.15	0.2~0.3	3D銑(3D milling)	WGB020	180mm	140	1800~2200	900~1300	0.1~0.15	0.2~0.3	3D銑(3D milling)	WGB032	140mm	260	2700~3200	1000~1400	0.05~0.15	0.2~0.4	3D銑(3D milling)
WGB025	80mm	330	3500~4000	1300~1700	0.2~0.3	0.4~0.6	3D銑(3D milling)	WGB025	80mm	330	3500~4000	1300~1700	0.2~0.3	0.4~0.6	3D銑(3D milling)	WGB025	80mm	330	3500~4000	1300~1700	0.2~0.3	0.4~0.6	3D銑(3D milling)	WGB032	200mm	200	1600~2000	700~1000	0.05~0.12	0.2~0.4	3D銑(3D milling)
WGB025	80mm	350	4000~4500	1800~2200	0.1~0.17	0.2~0.35	3D銑(3D milling)	WGB025	80mm	350	4000~4500	1800~2200	0.1~0.17	0.2~0.35	3D銑(3D milling)	WGB025	80mm	350	4000~4500	1800~2200	0.1~0.17	0.2~0.35	3D銑(3D milling)	附註 / Note:							
WGB025	130mm	220	2400~2800	1000~1400	0.2~0.25	0.4~0.5	3D銑(3D milling)	WGB025	130mm	220	2400~2800	1000~1400	0.2~0.25	0.4~0.5	3D銑(3D milling)	WGB025	130mm	220	2400~2800	1000~1400	0.2~0.25	0.4~0.5	3D銑(3D milling)	建議冷卻方式為濕式。							
WGB025	130mm	300	3400~3800	1300~1700	0.1~0.17	0.2~0.35	3D銑(3D milling)	WGB025	130mm	300	3400~3800	1300~1700	0.1~0.17	0.2~0.35	3D銑(3D milling)	WGB025	130mm	300	3400~3800	1300~1700	0.1~0.17	0.2~0.35	3D銑(3D milling)	Suggest to use Wet coolant.							
WGB025	180mm	240	2500~3000	1100~1400	0.1~0.15	0.2~0.3	3D銑(3D milling)	WGB025	180mm	240	2500~3000	1100~1400	0.1~0.15	0.2~0.3	3D銑(3D milling)	WGB025	180mm	240	2500~3000	1000~1300	0.1~0.15	0.2~0.3	3D銑(3D milling)								
WGB030	80mm	330	2700~3200	1100~1500	0.23~0.28	0.4~0.6	3D銑(3D milling)	WGB030	80mm	330	2700~3200	1100~1500	0.23~0.28	0.4~0.6	3D銑(3D milling)	WGB030	80mm	330	2700~3200	1100~1500	0.23~0.28	0.4~0.6	3D銑(3D milling)								
WGB030	80mm	370	3500~4000	1500~1900	0.1~0.17	0.2~0.35	3D銑(3D milling)	WGB030	80mm	370	3500~4000	1500~1900	0.1~0.17	0.2~0.35	3D銑(3D milling)	WGB030	80mm	370	3500~4000	1500~1900	0.1~0.17	0.2~0.35	3D銑(3D milling)								
WGB030	140mm	280	2400~2800	900~1300	0.2~0.25	0.4~0.5	3D銑(3D milling)	WGB030	140mm	280	2400~2800	900~1300	0.2~0.25	0.4~0.5	3D銑(3D milling)	WGB030	140mm	280	2400~2800	900~1300	0.2~0.25	0.4~0.5	3D銑(3D milling)								
WGB030	140mm	340	3200~3700	1200~1600	0.1~0.17	0.2~0.35	3D銑(3D milling)	WGB030	140mm	340	3200~3700	1200~1600	0.1~0.17	0.2~0.35	3D銑(3D milling)	WGB030	140mm	340	3200~3700	1200~1600	0.1~0.17	0.2~0.35	3D銑(3D milling)								
WGB030	200mm	200	1800~2200	800~1200	0.1~0.15	0.2~0.3	3D銑(3D milling)	WGB030	200mm	200	1800~2200	800~1200	0.1~0.15	0.2~0.3	3D銑(3D milling)	WGB030	200mm	200	1800~2200	800~1200	0.1~0.15	0.2~0.3	3D銑(3D milling)								
WGB032	80mm	330	2700~3200	1100~1500	0.23~0.28	0.4~0.6	3D銑(3D milling)	WGB032	80mm	330	2700~3200	1100~1500	0.23~0.28	0.4~0.6	3D銑(3D milling)	WGB032	80mm	330	2700~3200	1100~1500	0.23~0.28	0.4~0.6	3D銑(3D milling)								
WGB032	80mm	370	3500~4000	1500~1900	0.1~0.17	0.2~0.35	3D銑(3D milling)	WGB032	80mm	370	3500~4000																				