

																							
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 (m/min) Cutting Speed	迴轉速度 Speed (mim ⁻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 (m/min) Cutting Speed	迴轉速度 Speed (mim ⁻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 (m/min) Cutting Speed	迴轉速度 Speed (mim ⁻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
WTB010	40mm	290	8700~9200	2200~2600	0.15~0.25	0.4~0.6	3D銑(3D milling)	WTB010	40mm	290	8700~9200	2000~2400	0.15~0.25	0.4~0.6	3D銑(3D milling)	WTB010	40mm	225	6700~7200	1600~2000	0.05~0.1	0.15~0.25	3D銑(3D milling)
WTB010	40mm	290	8700~9200	3000~3400	0.05~0.1	0.2~0.3	3D銑(3D milling)	WTB010	40mm	290	8700~9200	2800~3200	0.05~0.1	0.2~0.3	3D銑(3D milling)	WTB010	60mm	190	5800~6300	1200~1500	0.05~0.08	0.15~0.25	3D銑(3D milling)
WTB010	60mm	230	7000~7500	1600~2000	0.1~0.15	0.2~0.35	3D銑(3D milling)	WTB010	60mm	230	7000~7500	1400~1800	0.1~0.15	0.2~0.35	3D銑(3D milling)	WTB010	80mm	140	4200~4700	900~1200	0.04~0.07	0.15~0.25	3D銑(3D milling)
WTB010	60mm	230	7000~7500	2000~2400	0.05~0.1	0.12~0.2	3D銑(3D milling)	WTB010	60mm	230	7000~7500	1800~2200	0.05~0.1	0.12~0.2	3D銑(3D milling)	WTB012	40mm	260	6700~7200	1600~2000	0.05~0.1	0.15~0.25	3D銑(3D milling)
WTB010	100mm	180	5500~6000	1200~1500	0.05~0.1	0.12~0.2	3D銑(3D milling)	WTB010	100mm	180	5500~6000	1100~1500	0.05~0.1	0.12~0.2	3D銑(3D milling)	WTB012	60mm	220	5500~6000	1200~1600	0.05~0.08	0.15~0.25	3D銑(3D milling)
WTB012	40mm	325	8200~8600	2100~2500	0.2~0.3	0.4~0.6	3D銑(3D milling)	WTB012	40mm	325	8200~8600	2000~2400	0.2~0.3	0.4~0.6	3D銑(3D milling)	WTB012	100mm	160	4000~4500	900~1200	0.04~0.07	0.15~0.25	3D銑(3D milling)
WTB012	40mm	325	8200~8600	2800~3200	0.06~0.15	0.2~0.3	3D銑(3D milling)	WTB012	40mm	325	8200~8600	2800~3200	0.06~0.15	0.2~0.3	3D銑(3D milling)	WTB016	60mm	230	4000~4500	1600~2000	0.05~0.12	0.2~0.3	3D銑(3D milling)
WTB012	60mm	270	7000~7500	1600~2000	0.2~0.25	0.4~0.5	3D銑(3D milling)	WTB012	60mm	270	7000~7500	1600~2000	0.2~0.25	0.4~0.5	3D銑(3D milling)	WTB016	100mm	160	2800~3200	1200~1600	0.05~0.1	0.2~0.3	3D銑(3D milling)
WTB012	60mm	270	7000~7500	2200~2600	0.06~0.15	0.2~0.3	3D銑(3D milling)	WTB012	60mm	270	7000~7500	2200~2600	0.06~0.15	0.2~0.3	3D銑(3D milling)	WTB016	130mm	115	2000~2300	800~1200	0.05~0.08	0.2~0.3	3D銑(3D milling)
WTB012	100mm	200	5000~5500	800~1200	0.06~0.15	0.2~0.3	3D銑(3D milling)	WTB012	100mm	200	5000~5500	800~1200	0.06~0.15	0.2~0.3	3D銑(3D milling)	WTB020	80mm	315	4500~5000	1200~1600	0.05~0.15	0.2~0.3	3D銑(3D milling)
WTB016	60mm	230	4000~4500	1600~2000	0.2~0.35	0.4~0.6	3D銑(3D milling)	WTB016	60mm	230	4000~4500	1600~2000	0.2~0.35	0.4~0.6	3D銑(3D milling)	WTB020	130mm	190	2500~3000	800~1200	0.05~0.12	0.2~0.3	3D銑(3D milling)
WTB016	60mm	305	5500~6000	2600~3000	0.06~0.15	0.2~0.35	3D銑(3D milling)	WTB016	60mm	305	5500~6000	2600~3000	0.06~0.15	0.2~0.35	3D銑(3D milling)	WTB020	180mm	140	1700~2200	800~1000	0.05~0.1	0.2~0.3	3D銑(3D milling)
WTB016	100mm	175	3000~3500	1400~1800	0.2~0.3	0.35~0.55	3D銑(3D milling)	WTB016	100mm	175	3000~3500	1400~1800	0.2~0.3	0.35~0.55	3D銑(3D milling)	WTB025	80mm	315	3500~4000	1300~1700	0.05~0.15	0.2~0.3	3D銑(3D milling)
WTB016	100mm	230	4000~4500	2000~2400	0.06~0.15	0.2~0.35	3D銑(3D milling)	WTB016	100mm	230	4000~4500	1800~2200	0.06~0.15	0.2~0.35	3D銑(3D milling)	WTB025	130mm	240	2500~3000	1000~1400	0.05~0.15	0.2~0.3	3D銑(3D milling)
WTB016	140mm	140	2300~2800	1200~1500	0.06~0.15	0.2~0.3	3D銑(3D milling)	WTB016	140mm	140	2300~2800	1100~1500	0.06~0.15	0.2~0.3	3D銑(3D milling)	WTB025	180mm	200	2000~2500	800~1200	0.05~0.12	0.2~0.3	3D銑(3D milling)
WTB020	80mm	330	4700~5200	1600~2000	0.2~0.3	0.4~0.6	3D銑(3D milling)	WTB020	80mm	330	4700~5200	1600~2000	0.2~0.3	0.4~0.6	3D銑(3D milling)	WTB030	80mm	330	3200~3700	1300~1700	0.12~0.17	0.2~0.4	3D銑(3D milling)
WTB020	80mm	380	5500~6000	2000~2400	0.1~0.17	0.2~0.4	3D銑(3D milling)	WTB020	80mm	380	5500~6000	2000~2400	0.1~0.17	0.2~0.4	3D銑(3D milling)	WTB030	140mm	260	2700~3200	1000~1400	0.12~0.17	0.2~0.4	3D銑(3D milling)
WTB020	130mm	160	2000~2500	1100~1400	0.2~0.25	0.4~0.5	3D銑(3D milling)	WTB020	130mm	160	2000~2500	1100~1400	0.2~0.25	0.4~0.5	3D銑(3D milling)	WTB030	200mm	220	2100~2600	700~1000	0.1~0.15	0.2~0.4	3D銑(3D milling)
WTB020	130mm	220	3000~3500	1200~1600	0.1~0.17	0.2~0.35	3D銑(3D milling)	WTB020	130mm	220	3000~3500	1100~1500	0.1~0.17	0.2~0.35	3D銑(3D milling)	WTB032	80mm	330	3200~3700	1300~1700	0.05~0.17	0.2~0.4	3D銑(3D milling)
WTB020	180mm	140	1800~2200	1000~1300	0.1~0.15	0.2~0.3	3D銑(3D milling)	WTB020	180mm	140	1800~2200	900~1300	0.1~0.15	0.2~0.3	3D銑(3D milling)	WTB032	140mm	260	2700~3200	1000~1400	0.05~0.15	0.2~0.4	3D銑(3D milling)
WTB025	80mm	330	3500~4000	1300~1700	0.2~0.3	0.4~0.6	3D銑(3D milling)	WTB025	80mm	330	3500~4000	1300~1700	0.2~0.3	0.4~0.6	3D銑(3D milling)	WTB032	200mm	220	2000~2500	700~1000	0.05~0.12	0.2~0.4	3D銑(3D milling)
WTB025	80mm	350	4000~4500	1800~2200	0.1~0.17	0.2~0.35	3D銑(3D milling)	WTB025	80mm	350	4000~4500	1800~2200	0.1~0.17	0.2~0.35	3D銑(3D milling)	附註 / Note :							
WTB025	130mm	220	2400~2800	1000~1400	0.2~0.25	0.4~0.5	3D銑(3D milling)	WTB025	130mm	220	2400~2800	1000~1400	0.2~0.25	0.4~0.5	3D銑(3D milling)	建議冷卻方式為乾式。							
WTB025	130mm	300	3400~3800	1300~1700	0.1~0.17	0.2~0.35	3D銑(3D milling)	WTB025	130mm	300	3400~3800	1300~1700	0.1~0.17	0.2~0.35	3D銑(3D milling)	Suggest to use Dry coolant.							
WTB025	180mm	240	2500~3000	1100~1400	0.1~0.15	0.2~0.3	3D銑(3D milling)	WTB025	180mm	240	2500~3000	1000~1300	0.1~0.15	0.2~0.3	3D銑(3D milling)								
WTB030	80mm	330	2700~3200	1100~1500	0.23~0.28	0.4~0.6	3D銑(3D milling)	WTB030	80mm	330	2700~3200	1100~1500	0.23~0.28	0.4~0.6	3D銑(3D milling)								
WTB030	80mm	370	3500~4000	1500~1900	0.1~0.17	0.2~0.35	3D銑(3D milling)	WTB030	80mm	370	3500~4000	1500~1900	0.1~0.17	0.2~0.35	3D銑(3D milling)								
WTB030	140mm	280	2400~2800	900~1300	0.2~0.25	0.4~0.5	3D銑(3D milling)	WTB030	140mm	280	2400~2800	900~1300	0.2~0.25	0.4~0.5	3D銑(3D milling)								
WTB030	140mm	340	3200~3700	1200~1600	0.1~0.17	0.2~0.35	3D銑(3D milling)	WTB030	140mm	340	3200~3700	1200~1600	0.1~0.17	0.2~0.35	3D銑(3D milling)								
WTB030	200mm	250	2400~2900	800~1200	0.1~0.15	0.2~0.3	3D銑(3D milling)	WTB030	200mm	250	2400~2900	800~1200	0.1~0.15	0.2~0.3	3D銑(3D milling)								
WTB032	80mm	330	2700~3200	1100~1500	0.23~0.28	0.4~0.6	3D銑(3D milling)	WTB032	80mm	330	2700~3200	1100~1500	0.23~0.28	0.4~0.6	3D銑(3D milling)								
WTB032	80mm	370	3500~4000	1500~1900	0.1~0.17	0.2~0.35	3D銑(3D milling)	WTB032	80mm	370	3500~4000	1500~1900	0.1~0.17	0.2~0.35	3D銑(3D milling)								
WTB03																							