

DHF									DHF									DHF									DHF								
被切削材 Work Material		碳素鋼 : Carbon Steels S50C / SS400 : 1.1210 / 1.0036 : 1050 / A570 Gr.45 (~HRc22)							被切削材 Work Material		鉻鉬合金鋼 (HRc25~28) SCM440 : 1.7225 : 4140 : 42CrMoA					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		沃斯田鐵系不銹鋼 : Stainless Steels 【Easy】 SUS304 : 1.4301 : AISI 304 (HRc28~32)								
型號 Type NO.	刀具伸長量 Extension Length	切削速度 Cutting Speed (m/min)	Speed	迴轉速度 (min <sup>-1</sup> )	進給速度 (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)	Speed	迴轉速度 (min <sup>-1</sup> )	進給速度 (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)	Speed	迴轉速度 (min <sup>-1</sup> )	進給速度 (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)	Speed	迴轉速度 (min <sup>-1</sup> )	進給速度 (mm/min)	加工深度(Aa) Depth of Cut	加工寬度(Ap) Width of Cut	加工方式 Milling Type
WWB0604	22mm	90	4500-5000	400-700	4	6	溝銑(Slotting)	WWB0604	22mm	85	4200-4700	300-500	2	6	溝銑(Slotting)	WWB0604	22mm	85	4200-4700	300-500	2	6	溝銑(Slotting)	WWB0604	22mm	80	4000-4500	400-550	1	6	溝銑(Slotting)				
WWB0604	22mm	90	4500-5000	400-700	4	6	溝銑(Slotting)	WWB0604	22mm	85	4200-4700	300-500	4	6	溝銑(Slotting)	WWB0604	22mm	85	4200-4700	300-500	4	6	溝銑(Slotting)	WWB0604	22mm	80	4000-4500	350-450	1.5	6	溝銑(Slotting)				
WWB0604	22mm	90	4500-5000	300-450	6	6	溝銑(Slotting)	WWB0604	22mm	85	4200-4700	150-300	6	6	溝銑(Slotting)	WWB0604	22mm	85	4200-4700	150-300	6	6	溝銑(Slotting)	WWB0604	22mm	80	4000-4500	300-420	3	6	溝銑(Slotting)				
WWB0604	22mm	90	4500-5000	200-400	12	6	溝銑(Slotting)	WWB0604	22mm	85	4200-4700	100-200	12	6	溝銑(Slotting)	WWB0604	22mm	85	4200-4700	100-200	9-12	6	溝銑(Slotting)	WWB0604	22mm	80	4000-4500	200-270	6	6	溝銑(Slotting)				
WWB0604	22mm	90	4500-5000	300-500	6	5.5	側銑(Side milling)	WWB0604	22mm	85	4200-4700	200-400	6	5.5	側銑(Side milling)	WWB0604	22mm	85	4200-4700	200-400	6	5.5	側銑(Side milling)	WWB0604	22mm	80	4000-4500	200-270	6	5.7	側銑(Side milling)				
WWB0804	30mm	100	3800-4300	400-700	2	8	溝銑(Slotting)	WWB0804	30mm	95	3500-4000	300-500	2	8	溝銑(Slotting)	WWB0804	30mm	95	3500-4000	300-500	2	8	溝銑(Slotting)	WWB0804	28mm	80	3000-3500	350-480	2	8	溝銑(Slotting)				
WWB0804	30mm	100	3800-4300	700-1000	4	8	溝銑(Slotting)	WWB0804	30mm	95	3500-4000	400-700	4	8	溝銑(Slotting)	WWB0804	30mm	95	3500-4000	400-700	4	8	溝銑(Slotting)	WWB0804	28mm	80	3000-3500	270-360	4	8	溝銑(Slotting)				
WWB0804	30mm	100	3800-4300	400-700	8	8	溝銑(Slotting)	WWB0804	30mm	95	3500-4000	300-500	8	8	溝銑(Slotting)	WWB0804	30mm	95	3500-4000	300-500	8	8	溝銑(Slotting)	WWB0804	28mm	80	3000-3500	240-320	6	8	溝銑(Slotting)				
WWB0804	30mm	100	3800-4300	300-500	16	8	溝銑(Slotting)	WWB0804	30mm	95	3500-4000	150-300	16	8	溝銑(Slotting)	WWB0804	30mm	95	3500-4000	150-300	12-16	8	溝銑(Slotting)	WWB0804	28mm	80	3000-3500	200-260	8	8	溝銑(Slotting)				
WWB0804	30mm	100	3700-4200	300-600	8	7.5	側銑(Side milling)	WWB0804	30mm	95	3500-4000	200-400	8	7.5	側銑(Side milling)	WWB0804	30mm	95	3500-4000	200-400	8	7.5	側銑(Side milling)	WWB0804	28mm	80	3000-3500	200-260	8	7.7	側銑(Side milling)				
WWB1004	33mm	95	2800-3300	400-700	2	10	溝銑(Slotting)	WWB1004	33mm	80	2400-2800	300-500	2	10	溝銑(Slotting)	WWB1004	33mm	80	2400-2800	300-500	2	10	溝銑(Slotting)	WWB1004	32mm	80	2400-2800	350-500	2	10	溝銑(Slotting)				
WWB1004	33mm	95	2800-3300	400-700	4	10	溝銑(Slotting)	WWB1004	33mm	80	2400-2800	300-600	4	10	溝銑(Slotting)	WWB1004	33mm	80	2400-2800	300-600	4	10	溝銑(Slotting)	WWB1004	32mm	80	2400-2800	300-400	3.5	10	溝銑(Slotting)				
WWB1004	33mm	95	2800-3300	500-800	8	10	溝銑(Slotting)	WWB1004	33mm	80	2400-2800	300-600	8	10	溝銑(Slotting)	WWB1004	33mm	80	2400-2800	300-600	8	10	溝銑(Slotting)	WWB1004	32mm	80	2400-2800	250-320	5	10	溝銑(Slotting)				
WWB1004	33mm	95	2800-3300	300-500	10	10	溝銑(Slotting)	WWB1004	33mm	80	2400-2800	200-350	10	10	溝銑(Slotting)	WWB1004	33mm	80	2400-2800	200-350	10	10	溝銑(Slotting)	WWB1004	32mm	80	2400-2800	200-260	10	10	溝銑(Slotting)				
WWB1004	33mm	95	2800-3300	300-600	20	10	溝銑(Slotting)	WWB1004	33mm	80	2400-2800	150-300	20	10	溝銑(Slotting)	WWB1004	33mm	80	2400-2800	150-300	15-20	10	溝銑(Slotting)	WWB1004	32mm	80	2400-2800	200-260	10	9.7	側銑(Side milling)				
WWB1004	33mm	95	2800-3300	300-600	10	9.5	側銑(Side milling)	WWB1004	33mm	80	2400-2800	200-400	10	9.5	側銑(Side milling)	WWB1004	33mm	80	2400-2800	200-400	10	9.5	側銑(Side milling)	WWB1204	38mm	80	1900-2300	260-420	2	12	溝銑(Slotting)				
WWB1204	40mm	90	2200-2600	400-700	3	12	溝銑(Slotting)	WWB1204	40mm	75	1800-2200	300-500	3	12	溝銑(Slotting)	WWB1204	40mm	80	1900-2300	300-500	3	12	溝銑(Slotting)	WWB1204	38mm	80	1900-2300	200-300	4	12	溝銑(Slotting)				
WWB1204	40mm	90	2200-2600	300-500	6	12	溝銑(Slotting)	WWB1204	40mm	75	1800-2200	200-400	6	12	溝銑(Slotting)	WWB1204	40mm	80	1900-2300	200-400	6	12	溝銑(Slotting)	WWB1204	38mm	80	1900-2300	180-260	6	12	溝銑(Slotting)				
WWB1204	40mm	90	2200-2600	300-500	9	12	溝銑(Slotting)	WWB1204	40mm	75	1800-2200	150-300	9	12	溝銑(Slotting)	WWB1204	40mm	80	1900-2300	150-300	9	12	溝銑(Slotting)	WWB1204	38mm	80	1900-2300	150-210	10	12	溝銑(Slotting)				
WWB1204	40mm	90	2200-2600	300-500	12	12	溝銑(Slotting)	WWB1204	40mm	75	1800-2200	150-300	12	12	溝銑(Slotting)	WWB1204	40mm	80	1900-2300	150-300	12	12	溝銑(Slotting)	WWB1204	38mm	80	1900-2300	120-200	12	12	溝銑(Slotting)				
WWB1204	40mm	90	2200-2600	200-400	18	12	溝銑(Slotting)	WWB1204	40mm	75	1800-2200	70-130	18	12	溝銑(Slotting)	WWB1204	40mm	80	1900-2300	70-130	14-18	12	溝銑(Slotting)	WWB1204	38mm	80	1900-2300	100-190	12	11.7	側銑(Side milling)				
WWB1204	40mm	90	2200-2600	300-500	12	11.5	側銑(Side milling)	WWB1204	40mm	75	1800-2200	100-200	12	11.5	側銑(Side milling)	WWB1204	40mm	80	1900-2300	100-200	12	11.5	側銑(Side milling)	WWB1404	42mm	80	1600-2000	200-360	1~2	14	溝銑(Slotting)				
WWB1404	45mm	90	1800-2200	300-400	5~6	14	溝銑(Slotting)	WWB1404	45mm	80	1600-2000	200-300	5~6	14	溝銑(Slotting)	WWB1404	45mm	80	1600-2000	200-300	5~6	14	溝銑(Slotting)	WWB1404	42mm	80	1600-2000	150-250	3-4	14	溝銑(Slotting)				
WWB1404	45mm	90	1800-2200	200-350	7~8	14	溝銑(Slotting)	WWB1404	45mm	80	1600-2000	150-250	7~8	14	溝銑(Slotting)	WWB1404	45mm	80	1600-2000	150-250	7-8	14	溝銑(Slotting)	WWB1404	42mm	80	1600-2000	120-200	5-6	14	溝銑(Slotting)				
WWB1404	45mm	90	1800-2200	250-400	14	5~6	側銑(Side milling)	WWB1404	45mm	80	1600-2000	200-300	14	5~6	側銑(Side milling)	WWB1404	45mm	80	1600-2000	200-300	14	5~6	側銑(Side milling)	WWB1404	42mm	80	1600-2000	100-150	14	3-4	溝銑(Slotting)				
WWB1404	45mm	90	1800-2200	200-300	14	7~8	側銑(Side milling)	WWB1404	45mm	80	1600-2000	150-250	14	7~8	側銑(Side milling)	WWB1404	45mm	80	1600-2000	150-250	14	7~8	側銑(Side milling)	WWB1404	42mm	80	1600-2000	70-130	14	5-6	側銑(Side milling)				
WWB1604	50mm	90	1600-2000	200-300	5~6	16	溝銑(Slotting)	WWB1604	50mm	80	1400-1800	170-270	5~6	16	溝銑(Slotting)	WWB1604	50mm	80	1400-1800	170-270	5-6	16	溝銑(Slotting)	WWB1604	47mm	80	1400-1800	200-280	1~2	16	溝銑(Slotting)				
WWB1604	50mm	90	1600-2000	150-250	7~8	16	溝銑(Slotting)	WWB1604	50mm	80	1400-1800	120-220	7~8	16	溝銑(Slotting)	WWB1604	50mm	80	1400-1800	120-220	7-8	16	溝銑(Slotting)	WWB1604	47mm	80	1400-1800	130-200	3-4	16	溝銑(Slotting)				
WWB1604	50mm	90	1600-2000	200-300	16	5~6	側銑(Side milling)	WWB1604	50mm	80	1400-1800	170-270	16	5~6	側銑(Side milling)	WWB1604	50mm	80	1400-1800	170-270	16	5~6	側銑(Side milling)	WWB1604	47mm	80	1400-1800	100-170	5-6	16	溝銑(Slotting)				
WWB1604	50mm	90	1600-2000	150-250	16	7~8	側銑(Side milling)	WWB1604	50mm	80	1400-1800	120-220	16	7~8	側銑(Side milling)	WWB1604	50mm	80	1400-1800	120-220	16	7~8	側銑(Side milling)	WWB1604	47mm	80	1400-1800	50-100	16	5-6	側銑(Side milling)				
WWB1804	50mm	90	1400-1800	180-250	4~5	18	溝銑(Slotting)	WWB1804	50mm	80	1200-1600	150-250	4-5	18	溝銑(Slotting)	WWB1804	50mm	80	1200-1600	150-250	4-5	18	溝銑(Slotting)	WWB1804	50mm	80	1200-1600	200-250	1-2	18	溝銑(Slotting)				
WWB1804	50mm	90	1400-1800	150-250	6~7	18	溝銑(Slotting)	WWB1804	50mm	80	1200-1600	100-200	6-7	18	溝銑(Slotting)	WWB1804	50mm	80	1200-1600	100-200	6-7	18	溝銑(Slotting)	WWB1804	50mm	80	1200-1600	130-180	3-4	18	溝銑(Slotting)				
WWB1804	50mm	90	1400-1800	180-250	18	4~5	側銑(Side milling)	WWB1804	50mm	80	1200-1600	150-250	18	4~5	側銑(Side milling)	WWB1804	50mm	80	1200-1600	150-250	18	4~5	側銑(Side milling)	WWB1804	50mm	80	1200-1600	100-150	5-6	18	溝銑(Slotting)				
WWB1804	50mm	90	1400-1800	130-200	18	6~7	側銑(Side milling)	WWB1804	50mm	80	1200-1600	100-200	18	6~7	側銑(Side milling)	WWB1804	50mm	80	1200-1600	100-200	18	6~7	側銑(Side milling)	WWB1804	50mm	80	1200-1600	50-100	18	5-6	側銑(Side milling)				
WWB2004	55mm	90	1200-1600	150-250	4~5	20	溝銑(Slotting)	WWB2004	55mm	80	1000-1400	120-220	4-5	20	溝銑(Slotting)	WWB2004	55mm	80	1000-1400	120-220	4-5	20	溝銑(Slotting)	WWB2004	50mm	80	1000-1400	180-230	1~2	20	溝銑(Slotting)				
WWB2004	55mm	90	1200-1600	120-200	6~7	20	溝銑(Slotting)	WWB2004	55mm	80	1000-1400	100-150	6-7	20	溝銑(Slotting)	WWB2004	55mm	80	1000-1400	100-150	6-7	20	溝銑(Slotting)	WWB2004	50mm	80	1000-1400	120-160	3-4	20	溝銑(Slotting)				
WWB2004	55mm	90	1200-1600	150-250	20	4~5	側銑(Side milling)	WWB2004	55mm	80	1000-1400	120-220	20																						