

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 Gr.45 (~HRc22)						
	型號 Type NO.	刀具伸長量 Extension Length(mm)	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) Depth of Cut	加工寬度(Ap) Width of Cut
BTH0204	14	120	18000~20000	1200~1600	0.08~0.1	0.16~0.2	3D銑(3D milling)
BTH0204	14	120	18000~20000	1800~2200	0.04~0.06	0.08~0.12	3D銑(3D milling)
BTH0304	14	150	16000~17000	1200~1600	0.1~0.12	0.2~0.24	3D銑(3D milling)
BTH0304	14	150	16000~17000	1800~2200	0.05~0.07	0.1~0.14	3D銑(3D milling)
BTH0404	20	190	15000~16000	1400~1800	0.11~0.13	0.22~0.26	3D銑(3D milling)
BTH0404	20	190	15000~16000	2200~2600	0.05~0.08	0.14~0.22	3D銑(3D milling)
BTH0504	20	220	14000~15000	1400~1800	0.13~0.16	0.26~0.32	3D銑(3D milling)
BTH0504	20	220	14000~15000	2400~2800	0.05~0.09	0.14~0.18	3D銑(3D milling)
BTH0604	20	245	13000~14000	1600~2000	0.15~0.2	0.3~0.4	3D銑(3D milling)
BTH0604	20	245	13000~14000	2600~3000	0.05~0.11	0.14~0.22	3D銑(3D milling)
BTH0804	30	305	12000~13000	2200~2600	0.2~0.25	0.4~0.5	3D銑(3D milling)
BTH0804	30	305	12000~13000	3000~3400	0.05~0.13	0.2~0.26	3D銑(3D milling)
BTH1004	35	285	8700~9200	2400~2800	0.23~0.28	0.46~0.56	3D銑(3D milling)
BTH1004	35	285	8700~9200	3000~3400	0.05~0.15	0.2~0.3	3D銑(3D milling)
BTH1204	40	265	7000~8000	2000~2400	0.27~0.32	0.54~0.64	3D銑(3D milling)
BTH1204	40	265	7000~8000	2800~3200	0.1~0.2	0.3~0.4	3D銑(3D milling)
BTH1604	50	255	5000~6000	1400~1800	0.35~0.4	0.7~0.8	3D銑(3D milling)
BTH1604	50	255	5000~6000	2400~2800	0.1~0.23	0.36~0.46	3D銑(3D milling)

附註 / Note :

二冷卻方式皆為濕式。

gest to use Wet coolant.

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)						
	型號 Type NO.	刀具伸長量 Extension Length(mm)	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) Depth of Cut	加工寬度(Ap) Width of Cut
BTH0204	14	110	16000~18000	1000~1200	0.08~0.1	0.16~0.2	3D銑(3D milling)
BTH0204	14	110	16000~18000	1600~2000	0.04~0.06	0.08~0.12	3D銑(3D milling)
BTH0304	14	145	15000~16000	1000~1400	0.1~0.12	0.2~0.24	3D銑(3D milling)
BTH0304	14	145	15000~16000	1600~2000	0.05~0.07	0.1~0.14	3D銑(3D milling)
BTH0404	20	175	14000~15000	1200~1600	0.11~0.13	0.22~0.26	3D銑(3D milling)
BTH0404	20	175	14000~15000	2000~2400	0.05~0.08	0.14~0.22	3D銑(3D milling)
BTH0504	20	205	13000~14000	1200~1600	0.13~0.16	0.26~0.32	3D銑(3D milling)
BTH0504	20	205	13000~14000	2200~2600	0.05~0.09	0.14~0.18	3D銑(3D milling)
BTH0604	20	230	12000~13000	1200~1600	0.15~0.2	0.3~0.4	3D銑(3D milling)
BTH0604	20	230	12000~13000	2400~2800	0.05~0.11	0.14~0.22	3D銑(3D milling)
BTH0804	30	255	10000~11000	2000~2400	0.18~0.23	0.36~0.46	3D銑(3D milling)
BTH0804	30	305	12000~13000	2800~3200	0.05~0.13	0.16~0.26	3D銑(3D milling)
BTH1004	35	285	8700~9200	2200~2600	0.2~0.25	0.4~0.5	3D銑(3D milling)
BTH1004	35	285	8700~9200	2800~3200	0.05~0.15	0.2~0.3	3D銑(3D milling)
BTH1204	40	225	5500~6500	1800~2200	0.23~0.28	0.46~0.56	3D銑(3D milling)
BTH1204	40	225	5500~6500	2600~3000	0.1~0.15	0.2~0.3	3D銑(3D milling)
BTH1604	50	200	4000~5000	1000~1400	0.27~0.32	0.54~0.64	3D銑(3D milling)
BTH1604	50	200	4000~5000	2000~2400	0.1~0.2	0.3~0.4	3D銑(3D milling)

附註 / Note :

以上冷卻方式皆為濕式。

Suggest to use Wet coolant.

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 Extension Length(mm)	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) Depth of Cut	加工寬度(Ap) Width of Cut
BTH0204	14	110	16000~18000	900~1100	0.08~0.1	0.16~0.2	3D銑(3D milling)
BTH0204	14	110	16000~18000	1400~1800	0.04~0.06	0.08~0.12	3D銑(3D milling)
BTH0304	14	145	15000~16000	900~1200	0.1~0.12	0.2~0.24	3D銑(3D milling)
BTH0304	14	145	15000~16000	1400~1800	0.05~0.07	0.1~0.14	3D銑(3D milling)
BTH0404	20	175	14000~15000	1200~1400	0.11~0.13	0.22~0.26	3D銑(3D milling)
BTH0404	20	175	14000~15000	1800~2200	0.05~0.08	0.14~0.22	3D銑(3D milling)
BTH0504	20	205	13000~14000	1200~1400	0.13~0.16	0.26~0.32	3D銑(3D milling)
BTH0504	20	205	13000~14000	2000~2400	0.05~0.09	0.14~0.18	3D銑(3D milling)
BTH0604	20	230	12000~13000	1200~1400	0.15~0.2	0.3~0.4	3D銑(3D milling)
BTH0604	20	230	12000~13000	2200~2600	0.05~0.11	0.14~0.22	3D銑(3D milling)
BTH0804	30	255	10000~11000	1800~2200	0.18~0.23	0.36~0.46	3D銑(3D milling)
BTH0804	30	305	12000~13000	2600~3000	0.05~0.13	0.16~0.26	3D銑(3D milling)
BTH1004	35	285	8700~9200	2000~2400	0.2~0.25	0.4~0.5	3D銑(3D milling)
BTH1004	35	285	8700~9200	2400~2800	0.05~0.15	0.2~0.3	3D銑(3D milling)
BTH1204	40	225	5500~6500	1600~2000	0.23~0.28	0.46~0.56	3D銑(3D milling)
BTH1204	40	225	5500~6500	2000~2400	0.1~0.15	0.2~0.3	3D銑(3D milling)
BTH1604	50	200	4000~5000	900~1200	0.27~0.32	0.54~0.64	3D銑(3D milling)
BTH1604	50	200	4000~5000	1600~2000	0.1~0.2	0.3~0.4	3D銑(3D milling)

附註 / Note :

以上冷卻方式皆為濕式。

Suggest to use Wet coolant.

被切削材 Work Material	沃斯田鐵系不銹鋼 : Stainless Steels SUS304 : 1.4301 : AISI 304 (HRC28~32)						
	型號 Type NO.	刀具伸長量 Extension Length(mm)	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) Depth of Cut	加工寬度(Ap) Width of Cut
BTH0204	14	110	16000~18000	900~1100	0.08~0.1	0.16~0.2	3D銑(3D milling)
BTH0204	14	110	16000~18000	1400~1800	0.04~0.06	0.08~0.12	3D銑(3D milling)
BTH0304	14	145	15000~16000	900~1200	0.1~0.12	0.2~0.24	3D銑(3D milling)
BTH0304	14	145	15000~16000	1400~1800	0.05~0.07	0.1~0.14	3D銑(3D milling)
BTH0404	20	175	14000~15000	1200~1400	0.11~0.13	0.22~0.26	3D銑(3D milling)
BTH0404	20	175	14000~15000	1800~2200	0.05~0.08	0.14~0.22	3D銑(3D milling)
BTH0504	20	205	13000~14000	1200~1400	0.13~0.16	0.26~0.32	3D銑(3D milling)
BTH0504	20	205	13000~14000	2000~2400	0.05~0.09	0.14~0.18	3D銑(3D milling)
BTH0604	20	230	12000~13000	1200~1400	0.15~0.2	0.3~0.4	3D銑(3D milling)
BTH0604	20	230	12000~13000	2200~2600	0.05~0.11	0.14~0.22	3D銑(3D milling)
BTH0804	30	255	10000~11000	1800~2200	0.18~0.23	0.36~0.46	3D銑(3D milling)
BTH0804	30	305	12000~13000	2600~3000	0.05~0.13	0.16~0.26	3D銑(3D milling)
BTH1004	35	285	8700~9200	2000~2400	0.2~0.25	0.4~0.5	3D銑(3D milling)
BTH1004	35	285	8700~9200	2400~2800	0.05~0.15	0.2~0.3	3D銑(3D milling)
BTH1204	40	225	5500~6500	1600~2000	0.23~0.28	0.46~0.56	3D銑(3D milling)
BTH1204	40	225	5500~6500	2000~2400	0.1~0.15	0.2~0.3	3D銑(3D milling)
BTH1604	50	200	4000~5000	900~1200	0.27~0.32	0.54~0.64	3D銑(3D milling)
BTH1604	50	200	4000~5000	1600~2000	0.1~0.2	0.3~0.4	3D銑(3D milling)

附註 / Note :

以上冷卻方式皆為濕式。

Suggest to use Wet coolant.