

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
BTH0102	10	60	18000~20000	800~1000	0.08~0.1	0.16~0.2	3D銑(3D milling)
BTH0102	10	60	18000~20000	1000~1400	0.06~0.08	0.12~0.16	3D銑(3D milling)
BTH0102	10	60	18000~20000	1400~1800	0.02~0.04	0.04~0.08	3D銑(3D milling)
BTH0152	12	90	18000~20000	800~1000	0.1~0.12	0.2~0.24	3D銑(3D milling)
BTH0152	12	90	18000~20000	1000~1400	0.07~0.09	0.14~0.18	3D銑(3D milling)
BTH0152	12	90	18000~20000	1600~2000	0.03~0.05	0.06~0.1	3D銑(3D milling)
BTH0202	14	120	18000~20000	800~1000	0.1~0.12	0.2~0.24	3D銑(3D milling)
BTH0202	14	120	18000~20000	1000~1400	0.07~0.09	0.14~0.18	3D銑(3D milling)
BTH0202	14	120	18000~20000	1600~2000	0.03~0.05	0.06~0.1	3D銑(3D milling)
BTH0252	16	135	17000~18000	800~1000	0.12~0.14	0.24~0.28	3D銑(3D milling)
BTH0252	16	135	17000~18000	1000~1400	0.08~0.1	0.16~0.2	3D銑(3D milling)
BTH0252	16	135	17000~18000	1600~2000	0.04~0.06	0.08~0.12	3D銑(3D milling)
BTH0302	18	150	16000~17000	800~1000	0.15~0.18	0.3~0.36	3D銑(3D milling)
BTH0302	18	150	16000~17000	1000~1400	0.1~0.12	0.2~0.24	3D銑(3D milling)
BTH0302	18	150	16000~17000	1600~2000	0.05~0.07	0.1~0.14	3D銑(3D milling)
BTH0402	20	190	15000~16000	800~1000	0.18~0.22	0.36~0.44	3D銑(3D milling)
BTH0402	20	190	15000~16000	1100~1500	0.11~0.13	0.22~0.26	3D銑(3D milling)
BTH0402	20	190	15000~16000	1600~2000	0.05~0.08	0.14~0.22	3D銑(3D milling)
BTH0502	20	220	14000~15000	800~1200	0.2~0.25	0.4~0.5	3D銑(3D milling)
BTH0502	20	220	14000~15000	1100~1500	0.13~0.16	0.26~0.32	3D銑(3D milling)
BTH0502	20	220	14000~15000	1600~2000	0.05~0.09	0.14~0.18	3D銑(3D milling)
BTH0602	20	230	12000~13000	800~1200	0.28~0.33	0.56~0.66	3D銑(3D milling)
BTH0602	20	245	13000~14000	1300~1700	0.15~0.2	0.3~0.4	3D銑(3D milling)
BTH0602	20	245	13000~14000	1800~2200	0.05~0.11	0.14~0.22	3D銑(3D milling)
BTH0802	30	255	10000~11000	800~1200	0.3~0.35	0.6~0.7	3D銑(3D milling)
BTH0802	30	305	12000~13000	1900~2300	0.2~0.25	0.4~0.5	3D銑(3D milling)
BTH0802	30	305	12000~13000	1800~2200	0.05~0.13	0.2~0.26	3D銑(3D milling)
BTH1002	35	285	8700~9200	1200~1600	0.35~0.45	0.7~0.9	3D銑(3D milling)
BTH1002	35	285	8700~9200	2100~2500	0.23~0.28	0.46~0.56	3D銑(3D milling)
BTH1002	35	285	8700~9200	2000~2400	0.05~0.15	0.2~0.3	3D銑(3D milling)
BTH1202	40	265	7000~8000	1000~1400	0.4~0.5	0.8~1	3D銑(3D milling)
BTH1202	40	265	7000~8000	1700~2100	0.27~0.32	0.54~0.64	3D銑(3D milling)
BTH1202	40	265	7000~8000	2000~2400	0.1~0.2	0.3~0.4	3D銑(3D milling)
BTH1602	50	275	5000~6000	800~1000	0.6~0.65	1.2~1.3	3D銑(3D milling)
BTH1602	50	275	5000~6000	1200~1600	0.35~0.4	0.7~0.8	3D銑(3D milling)
BTH1602	50	275	5000~6000	2000~2400	0.1~0.23	0.36~0.46	3D銑(3D milling)
BTH2002	60	280	4000~5000	800~1200	0.7~0.8	1.4~1.6	3D銑(3D milling)
BTH2002	60	280	4000~5000	1400~1800	0.4~0.45	0.8~0.9	3D銑(3D milling)
BTH2002	60	280	4000~5000	1400~1800	0.1~0.25	0.4~0.5	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	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
BTH0102	10	60	18000~20000	900~1300	0.06~0.08	0.12~0.16	3D銑(3D milling)
BTH0102	10	60	18000~20000	1200~1600	0.02~0.04	0.04~0.08	3D銑(3D milling)
BTH0152	12	90	18000~20000	900~1300	0.07~0.09	0.14~0.18	3D銑(3D milling)
BTH0152	12	90	18000~20000	1200~1600	0.03~0.05	0.06~0.1	3D銑(3D milling)
BTH0202	14	110	16000~18000	800~1200	0.07~0.09	0.14~0.18	3D銑(3D milling)
BTH0202	14	110	16000~18000	1200~1600	0.03~0.05	0.06~0.1	3D銑(3D milling)
BTH0252	16	120	15000~16000	800~1200	0.07~0.09	0.14~0.18	3D銑(3D milling)
BTH0252	16	120	15000~16000	1200~1600	0.03~0.05	0.06~0.1	3D銑(3D milling)
BTH0302	18	145	15000~16000	800~1200	0.09~0.11	0.18~0.22	3D銑(3D milling)
BTH0302	18	145	15000~16000	1200~1600	0.04~0.06	0.08~0.12	3D銑(3D milling)
BTH0402	20	175	14000~15000	900~1300	0.11~0.13	0.22~0.26	3D銑(3D milling)
BTH0402	20	175	14000~15000	1400~1800	0.05~0.08	0.14~0.22	3D銑(3D milling)
BTH0502	20	205	13000~14000	900~1300	0.13~0.16	0.26~0.32	3D銑(3D milling)
BTH0502	20	205	13000~14000	1400~1800	0.05~0.09	0.14~0.18	3D銑(3D milling)
BTH0602	20	230	12000~13000	900~1300	0.15~0.2	0.3~0.4	3D銑(3D milling)
BTH0602	20	230	12000~13000	1600~2000	0.05~0.11	0.14~0.22	3D銑(3D milling)
BTH0802	30	255	10000~11000	600~1000	0.25~0.3	0.5~0.6	3D銑(3D milling)
BTH0802	30	255	10000~11000	1700~2100	0.18~0.23	0.36~0.46	3D銑(3D milling)
BTH0802	30	305	12000~13000	1600~2000	0.05~0.13	0.16~0.26	3D銑(3D milling)
BTH1002	35	285	8700~9200	800~1200	0.3~0.35	0.6~0.7	3D銑(3D milling)
BTH1002	35	285	8700~9200	1800~2200	0.23~0.28	0.46~0.56	3D銑(3D milling)
BTH1002	35	285	8700~9200	1600~2000	0.05~0.15	0.2~0.3	3D銑(3D milling)
BTH1202	40	260	6500~7500	800~1100	0.35~0.4	0.7~0.8	3D銑(3D milling)
BTH1202	40	260	6500~7500	1500~1900	0.23~0.28	0.46~0.56	3D銑(3D milling)
BTH1202	40	260	6500~7500	1600~2000	0.05~0.15	0.2~0.3	3D銑(3D milling)
BTH1602	50	275	5000~6000	700~900	0.5~0.55	1~1.1	3D銑(3D milling)
BTH1602	50	275	5000~6000	1000~1400	0.27~0.32	0.54~0.64	3D銑(3D milling)
BTH1602	50	275	5000~6000	1600~2000	0.1~0.2	0.3~0.4	3D銑(3D milling)
BTH2002	60	280	4000~5000	600~1000	0.6~0.65	1.2~1.3	3D銑(3D milling)
BTH2002	60	280	4000~5000	1000~1400	0.3~0.35	0.6~0.7	3D銑(3D milling)
BTH2002	60	280	4000~5000	1300~1700	0.1~0.23	0.36~0.46	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
BTH0102	10	60	18000~20000	900~1300	0.06~0.08	0.12~0.16	3D銑(3D milling)
BTH0102	10	60	18000~20000	1100~1400	0.02~0.04	0.04~0.08	3D銑(3D milling)
BTH0152	12	90	18000~20000	900~1300	0.07~0.09	0.14~0.18	3D銑(3D milling)
BTH0152	12	90	18000~20000	1100~1400	0.03~0.05	0.06~0.1	3D銑(3D milling)
BTH0202	14	110	16000~18000	800~1200	0.07~0.09	0.14~0.18	3D銑(3D milling)
BTH0202	14	110	16000~18000	1100~1400	0.03~0.05	0.06~0.1	3D銑(3D milling)
BTH0252	16	120	15000~16000	800~1200	0.07~0.09	0.14~0.18	3D銑(3D milling)
BTH0252	16	120	15000~16000	1100~1400	0.03~0.05	0.06~0.1	3D銑(3D milling)
BTH0302	18	145	15000~16000	800~1200	0.09~0.11	0.18~0.22	3D銑(3D milling)
BTH0302	18	145	15000~16000	1100~1400	0.04~0.06	0.08~0.12	3D銑(3D milling)
BTH0402	20	175	14000~15000	900~1300	0.11~0.13	0.22~0.26	3D銑(3D milling)
BTH0402	20	175	14000~15000	1200~1600	0.05~0.08	0.14~0.22	3D銑(3D milling)
BTH0502	20	205	13000~14000	900~1300	0.13~0.16	0.26~0.32	3D銑(3D milling)
BTH0502	20	205	13000~14000	1200~1600	0.05~0.09	0.14~0.18	3D銑(3D milling)
BTH0602	20	230	12000~13000	900~1300	0.15~0.2	0.3~0.4	3D銑(3D milling)
BTH0602	20	230	12000~13000	1400~1800	0.05~0.11	0.14~0.22	3D銑(3D milling)
BTH0802	30	255	10000~11000	600~1000	0.25~0.3	0.5~0.6	3D銑(3D milling)
BTH0802	30	255	10000~11000	1700~2100	0.18~0.23	0.36~0.46	3D銑(3D milling)
BTH0802	30	305	12000~13000	1400~1800	0.05~0.13	0.16~0.26	3D銑(3D milling)
BTH1002	35	285	8700~9200	800~1200	0.3~0.35	0.6~0.7	3D銑(3D milling)
BTH1002	35	285	8700~9200	1800~2200	0.23~0.28	0.46~0.56	3D銑(3D milling)
BTH1002	35	285	8700~9200	1400~1800	0.05~0.15	0.2~0.3	3D銑(3D milling)
BTH1202	40	260	6500~7500	800~1100	0.35~0.4	0.7~0.8	3D銑(3D milling)
BTH1202	40	260	6500~7500	1500~1900	0.23~0.28	0.46~0.56	3D銑(3D milling)
BTH1202	40	260	6500~7500	1400~1800	0.05~0.15	0.2~0.3	3D銑(3D milling)
BTH1602	50	275	5000~6000	700~900	0.5~0.55	1~1.1	3D銑(3D milling)
BTH1602	50	275	5000~6000	1000~1400	0.27~0.32	0.54~0.64	3D銑(3D milling)
BTH1602	50	275	5000~6000	1400~1800	0.1~0.2	0.3~0.4	3D銑(3D milling)
BTH2002	60	280	4000~5000	600~1000	0.6~0.65	1.2~1.3	3D銑(3D milling)
BTH2002	60	280	4000~5000	1000~1400	0.3~0.35	0.6~0.7	3D銑(3D milling)
BTH2002	60	280	4000~5000	1200~1600	0.1~0.23	0.36~0.46	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
BTH0102	10mm	60	18000~20000	900~1300	0.06~0.08	0.12~0.16	3D銑(3D milling)
BTH0102	10mm	60	18000~20000	1100~1400	0.02~0.04	0.04~0.08	3D銑(3D milling)
BTH0152	12mm	90	18000~20000	900~1300	0.07~0.09	0.14~0.18	3D銑(3D milling)
BTH0152	12mm	90	18000~20000	1100~1400	0.03~0.05	0.06~0.1	3D銑(3D milling)
BTH0202	14mm	110	16000~18000	800~1200	0.07~0.09	0.14~0.18	3D銑(3D milling)
BTH0202	14mm	110	16000~18000	1100~1400	0.03~0.05	0.06~0.1	3D銑(3D milling)
BTH0252	16mm	120	15000~16000	800~1200	0.07~0.09	0.14~0.18	3D銑(3D milling)
BTH0252	16mm	120	15000~16000	1100~1400	0.03~0.05	0.06~0.1	3D銑(3D milling)
BTH0302	18mm	145	15000~16000	800~1200	0.09~0.11	0.18~0.22	3D銑(3D milling)
BTH0302	18mm	145	15000~16000	1100~1400	0.04~0.06	0.08~0.12	3D銑(3D milling)
BTH0402	20mm	175	14000~15000	900~1300	0.11~0.13	0.22~0.26	3D銑(3D milling)
BTH0402	20mm	175	14000~15000	1200~1600	0.05~0.08	0.14~0.22	3D銑(3D milling)
BTH0502	20mm	205	13000~14000	900~1300	0.13~0.16	0.26~0.32	3D銑(3D milling)
BTH0502	20mm	205	13000~14000	1200~1600	0.05~0.09	0.14~0.18	3D銑(3D milling)
BTH0602	20mm	230	12000~13000	900~1300	0.15~0.2	0.3~0.4	3D銑(3D milling)
BTH0602	20mm	230	12000~13000	1400~1800	0.05~0.11	0.14~0.22	3D銑(3D milling)
BTH0802	30mm	255	10000~11000	600~1000	0.25~0.3	0.5~0.6	3D銑(3D milling)
BTH0802	30mm	255	10000~11000	1700~2100	0.18~0.23	0.36~0.46	3D銑(3D milling)
BTH0802	30mm	305	12000~13000	1400~1800	0.05~0.13	0.16~0.26	3D銑(3D milling)
BTH1002	35mm	285	8700~9200	800~1200	0.3~0.35	0.6~0.7	3D銑(3D milling)
BTH1002	35mm	285	8700~9200	1800~2200	0.23~0.28	0.46~0.56	3D銑(3D milling)
BTH1002	35mm	285	8700~9200	1400~1800	0.05~0.15	0.2~0.3	3D銑(3D milling)
BTH1202	40mm	260	6500~7500	800~1100	0.35~0.4	0.7~0.8	3D銑(3D milling)
BTH1202	40mm	260	6500~7500	1500~1900	0.23~0.28	0.46~0.56	3D銑(3D milling)
BTH1202	40mm	260	6500~7500	1400~1800	0.05~0.15	0.2~0.3	3D銑(3D milling)
BTH1602	50mm	275	5000~6000	700~900	0.5~0.55	1~1.1	3D銑(3D milling)
BTH1602	50mm	275	5000~6000	1000~1400	0.27~0.32	0.54~0.64	3D銑(3D milling)
BTH1602	50mm	275	5000~6000	1400~1800	0.1~0.2	0.3~0.4	3D銑(3D milling)
BTH2002	60mm	280	4000~5000	600~1000	0.6~0.65	1.2~1.3	3D銑(3D milling)
BTH2002	60mm	280	4000~5000	1000~1400	0.3~0.35	0.6~0.7	3D銑(3D milling)
BTH2002	60mm	280	4000~5000	1200~1600	0.1~0.23	0.36~0.46	3D銑(3D milling)

附註 / Note :

以上冷卻方式皆為濕式。

Suggest to use Wet coolant.