



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)						
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	加工方式 Milling Type
CDE0204	11	90	14000~15000	1000~1300	0.03~0.05	2	溝銑(Slotting)
CDE0204	11	90	14000~15000	500~700	0.1~0.15	2	溝銑(Slotting)
CDE0204	11	90	14000~15000	500~800	2~4	0.03~0.05	側銑(Side milling)
CDE0204	11	90	14000~15000	700~900	2~4	0.1~0.15	側銑(Side milling)
CDE0204	11	90	14000~15000	500~700	2~4	0.2~0.3	側銑(Side milling)
CDE0254	12	100	12000~13000	1000~1300	0.04~0.06	2,5	溝銑(Slotting)
CDE0254	12	100	12000~13000	500~700	0.4~0.5	2,5	溝銑(Slotting)
CDE0254	12	100	12000~13000	500~800	2.5~5	0.04~0.06	側銑(Side milling)
CDE0254	12	100	12000~13000	700~900	2.5~5	0.2~0.3	側銑(Side milling)
CDE0254	12	100	12000~13000	500~700	2.5~5	0.4~0.5	側銑(Side milling)
CDE0304	15	100	10000~11000	1000~1300	0.04~0.06	3	溝銑(Slotting)
CDE0304	15	100	10000~11000	500~700	0.8~0.9	3	溝銑(Slotting)
CDE0304	15	100	10000~11000	500~800	3~6	0.04~0.06	側銑(Side milling)
CDE0304	15	100	10000~11000	700~900	3~6	0.4~0.6	側銑(Side milling)
CDE0304	15	100	10000~11000	500~700	3~6	0.8~0.9	側銑(Side milling)
CDE0404	16	110	8500~9000	1000~1300	0.04~0.07	4	溝銑(Slotting)
CDE0404	16	110	8500~9000	500~700	1~1.2	4	溝銑(Slotting)
CDE0404	16	110	8500~9000	500~800	4~8	0.04~0.07	側銑(Side milling)
CDE0404	16	110	8500~9000	800~1100	4~8	0.6~0.7	側銑(Side milling)
CDE0404	16	110	8500~9000	500~700	4~8	1~1.2	側銑(Side milling)
CDE0504	19	110	6800~7300	1000~1300	0.05~0.08	5	溝銑(Slotting)
CDE0504	19	110	6800~7300	500~700	1.3~1.5	5	溝銑(Slotting)
CDE0504	19	110	6800~7300	500~800	5~10	0.05~0.08	側銑(Side milling)
CDE0504	19	110	6800~7300	800~1100	5~10	0.8~1	側銑(Side milling)
CDE0504	19	110	6800~7300	500~700	5~10	1.3~1.5	側銑(Side milling)
CDE0604	21	110	5500~6000	1000~1300	0.05~0.1	6	溝銑(Slotting)
CDE0604	21	110	5500~6000	600~800	1.5~1.8	6	溝銑(Slotting)
CDE0604	21	110	5500~6000	500~800	6~12	0.05~0.1	側銑(Side milling)
CDE0604	21	110	5500~6000	800~1100	6~12	0.8~1.2	側銑(Side milling)
CDE0604	21	110	5500~6000	600~800	6~12	1.5~1.8	側銑(Side milling)
CDE0804	27	110	4000~4500	900~1200	0.05~0.12	8	溝銑(Slotting)
CDE0804	27	110	4000~4500	600~800	2~2.4	8	溝銑(Slotting)
CDE0804	27	110	4000~4500	500~700	8~16	0.05~0.12	側銑(Side milling)
CDE0804	27	110	4000~4500	800~1100	8~16	1~1.5	側銑(Side milling)
CDE0804	27	110	4000~4500	600~800	8~16	2~2.4	側銑(Side milling)
CDE1004	34	110	3200~3700	800~1100	0.05~0.15	10	溝銑(Slotting)
CDE1004	34	110	3200~3700	700~900	2~3	10	溝銑(Slotting)
CDE1004	34	110	3200~3700	500~700	10~20	0.05~0.2	側銑(Side milling)
CDE1004	34	110	3200~3700	900~1200	10~20	1.3~1.5	側銑(Side milling)
CDE1004	34	110	3200~3700	700~900	10~20	2~3	側銑(Side milling)
CDE1204	37	100	2300~2800	700~1000	0.05~0.15	12	溝銑(Slotting)
CDE1204	37	100	2300~2800	500~700	3~3.6	12	溝銑(Slotting)
CDE1204	37	100	2300~2800	400~600	12~24	0.05~0.15	側銑(Side milling)
CDE1204	37	100	2300~2800	700~900	12~24	1.5~2	側銑(Side milling)
CDE1204	37	100	2300~2800	500~700	12~24	3~3.6	側銑(Side milling)
CDE1604	50	100	1800~2300	500~800	0.05~0.2	16	溝銑(Slotting)
CDE1604	50	100	1800~2300	200~350	3~4	16	溝銑(Slotting)
CDE1604	50	100	1800~2300	350~550	16~32	0.05~0.2	側銑(Side milling)
CDE1604	50	100	1800~2300	600~800	16~32	1~2	側銑(Side milling)
CDE1604	50	100	1800~2300	200~400	16~32	3~4	側銑(Side milling)

附註 / Note:

建議冷卻方式為濕式。
Suggest to use Wet coolant.