



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)

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
CRD0305	12	85	9000~10000	900~1100	0.1~0.15	1~3	溝銑(Slotting)
CRD0305	12	85	9000~10000	800~1000	0.05~0.08	1~3	溝銑(Slotting)
CRD0305	12	80	8500~9000	1100~1300	3~6	0.1~0.15	側銑(Side milling)
CRD0305	12	80	8500~9000	800~1000	3~6	0.06~0.08	側銑(Side milling)
CRD0305	12	85	9000~10000	1100~1400	0.1~0.15	0.1~0.15	3D銑(3D milling)
CRD0305	12	85	9000~10000	1100~1400	0.05~0.08	0.05~0.08	3D銑(3D milling)
CRD0405	14	100	8000~8400	1000~1200	0.12~0.17	2~4	溝銑(Slotting)
CRD0405	14	100	8000~8400	1000~1200	0.05~0.1	2~4	溝銑(Slotting)
CRD0405	14	85	6800~7200	1000~1200	4~8	0.12~0.17	側銑(Side milling)
CRD0405	14	85	6500~7500	800~1000	4~8	0.05~0.1	側銑(Side milling)
CRD0405	14	110	8700~9200	1000~1200	0.12~0.17	0.12~0.17	3D銑(3D milling)
CRD0405	14	110	8700~9200	1200~1600	0.05~0.1	0.05~0.1	3D銑(3D milling)
CRD0505	17	90	5800~6400	1200~1400	0.12~0.17	3~5	溝銑(Slotting)
CRD0505	17	130	8000~8500	1000~1400	0.05~0.1	3~5	溝銑(Slotting)
CRD0505	17	95	6000~7000	1000~1200	5~10	0.12~0.17	側銑(Side milling)
CRD0505	17	95	6000~7000	800~1000	5~10	0.05~0.1	側銑(Side milling)
CRD0505	17	135	8500~9000	1400~1800	0.12~0.17	0.12~0.17	3D銑(3D milling)
CRD0505	17	135	8500~9000	1300~1600	0.05~0.1	0.05~0.1	3D銑(3D milling)
CRD0510	17	90	5800~6400	1200~1400	0.12~0.17	2~5	溝銑(Slotting)
CRD0510	17	130	8000~8500	1000~1400	0.05~0.1	2~5	溝銑(Slotting)
CRD0510	17	95	6000~7000	1000~1200	5~10	0.12~0.17	側銑(Side milling)
CRD0510	17	95	6000~7000	800~1000	5~10	0.05~0.1	側銑(Side milling)
CRD0510	17	135	8500~9000	1400~1800	0.12~0.17	0.12~0.17	3D銑(3D milling)
CRD0510	17	135	8500~9000	1300~1600	0.05~0.1	0.05~0.1	3D銑(3D milling)
CRD0605	20	90	4800~5400	1200~1400	0.15~0.2	4~6	溝銑(Slotting)
CRD0605	20	130	6800~7200	1400~1600	0.05~0.1	4~6	溝銑(Slotting)
CRD0605	20	95	5000~6000	1000~1200	6~12	0.15~0.2	側銑(Side milling)
CRD0605	20	95	5000~6000	800~1000	6~12	0.05~0.1	側銑(Side milling)
CRD0605	20	160	8500~9000	1600~2000	0.15~0.2	0.15~0.2	3D銑(3D milling)
CRD0605	20	160	8500~9000	1600~2000	0.05~0.1	0.05~0.1	3D銑(3D milling)
CRD0610	20	90	4800~5400	1400~1600	0.15~0.2	3~6	溝銑(Slotting)
CRD0610	20	130	6800~7200	1400~1600	0.05~0.1	3~6	溝銑(Slotting)
CRD0610	20	95	5000~6000	1000~1200	6~12	0.15~0.2	側銑(Side milling)
CRD0610	20	95	5000~6000	800~1000	6~12	0.05~0.1	側銑(Side milling)
CRD0610	20	160	8500~9000	1600~2000	0.15~0.2	0.15~0.2	3D銑(3D milling)
CRD0610	20	160	8500~9000	1600~2000	0.05~0.1	0.05~0.1	3D銑(3D milling)
CRD0805	30	135	5200~5800	1000~1400	0.2~0.25	6~8	溝銑(Slotting)
CRD0805	30	145	5800~6200	1000~1200	0.06~0.11	6~8	溝銑(Slotting)
CRD0805	30	90	3500~4000	1000~1200	8~16	0.2~0.25	側銑(Side milling)
CRD0805	30	90	3500~4000	700~1000	8~16	0.06~0.11	側銑(Side milling)
CRD0805	30	190	7500~8500	1600~2000	0.2~0.25	0.2~0.25	3D銑(3D milling)
CRD0805	30	190	7500~8500	1400~1800	0.06~0.11	0.06~0.11	3D銑(3D milling)
CRD0810	30	135	5200~5800	1000~1400	0.2~0.25	5~8	溝銑(Slotting)
CRD0810	30	145	5800~6200	1000~1200	0.06~0.11	5~8	溝銑(Slotting)
CRD0810	30	90	3500~4000	1000~1200	8~16	0.2~0.25	側銑(Side milling)
CRD0810	30	90	3500~4000	700~1000	8~16	0.06~0.11	側銑(Side milling)
CRD0810	30	190	7500~8500	1600~2000	0.2~0.25	0.2~0.25	3D銑(3D milling)
CRD0810	30	190	7500~8500	1400~1800	0.06~0.11	0.06~0.11	3D銑(3D milling)
CRD1010	35	135	4200~4700	1200~1600	0.2~0.3	7~10	溝銑(Slotting)
CRD1010	35	145	4500~5000	800~1000	0.05~0.12	7~10	溝銑(Slotting)
CRD1010	35	90	2800~3200	800~1200	10~20	0.2~0.3	側銑(Side milling)
CRD1010	35	90	2800~3200	700~900	10~20	0.05~0.12	側銑(Side milling)
CRD1010	35	190	6000~7000	1600~2000	0.2~0.3	0.2~0.3	3D銑(3D milling)
CRD1010	35	190	6000~7000	1400~1800	0.05~0.12	0.05~0.12	3D銑(3D milling)
CRD1020	35	135	4200~4700	1200~1600	0.2~0.3	5~10	溝銑(Slotting)
CRD1020	35	145	4500~5000	800~1000	0.05~0.12	5~10	溝銑(Slotting)
CRD1020	35	90	2800~3200	800~1200	10~20	0.2~0.3	側銑(Side milling)
CRD1020	35	90	2800~3200	700~900	10~20	0.05~0.12	側銑(Side milling)
CRD1020	35	190	6000~7000	1600~2000	0.2~0.3	0.2~0.3	3D銑(3D milling)
CRD1020	35	190	6000~7000	1400~1800	0.05~0.12	0.05~0.12	3D銑(3D milling)
CRD1030	35	135	4200~4700	1200~1600	0.2~0.3	3~10	溝銑(Slotting)
CRD1030	35	145	4500~5000	800~1000	0.05~0.12	3~10	溝銑(Slotting)
CRD1030	35	90	2800~3200	800~1200	10~20	0.2~0.3	側銑(Side milling)
CRD1030	35	90	2800~3200	700~900	10~20	0.05~0.12	側銑(Side milling)
CRD1030	35	190	6000~7000	1600~2000	0.2~0.3	0.2~0.3	3D銑(3D milling)
CRD1030	35	190	6000~7000	1400~1800	0.05~0.12	0.05~0.12	3D銑(3D milling)
CRD1210	40	145	3800~4200	1200~1600	0.2~0.3	9~12	溝銑(Slotting)
CRD1210	40	150	4000~4500	1400~1600	0.1~0.15	9~12	溝銑(Slotting)
CRD1210	40	105	2800~3200	1000~1200	12~24	0.2~0.3	側銑(Side milling)
CRD1210	40	105	2800~3200	600~800	12~24	0.1~0.15	側銑(Side milling)
CRD1210	40	170	4500~5000	1600~2000	0.2~0.3	0.2~0.3	3D銑(3D milling)
CRD1210	40	190	5000~5500	1400~1800	0.1~0.15	0.1~0.15	3D銑(3D milling)
CRD1220	40	145	3800~4200	1200~1600	0.25~0.3	7~12	溝銑(Slotting)
CRD1220	40	150	4000~4500	1400~1600	0.1~0.15	7~12	溝銑(Slotting)
CRD1220	40	105	2800~3200	1000~1200	12~24	0.25~0.3	側銑(Side milling)
CRD1220	40	105	2800~3200	600~800	12~24	0.1~0.15	側銑(Side milling)
CRD1220	40	170	4500~5000	1600~2000	0.25~0.3	0.25~0.3	3D銑(3D milling)
CRD1220	40	190	5000~5500	1400~1800	0.1~0.15	0.1~0.15	3D銑(3D milling)
CRD1230	40	145	3800~4200	1200~1600	0.25~0.3	5~12	溝銑(Slotting)
CRD1230	40	150	4000~4500	1400~1600	0.1~0.15	5~12	溝銑(Slotting)
CRD1230	40	105	2800~3200	1000~1200	12~24	0.25~0.3	側銑(Side milling)
CRD1230	40	105	2800~3200	600~800	12~24	0.1~0.15	側銑(Side milling)
CRD1230	40	170	4500~5000	1600~2000	0.25~0.3	0.25~0.3	3D銑(3D milling)
CRD1230	40	190	5000~5500	1400~1800	0.1~0.15	0.1~0.15	3D銑(3D milling)

附註 / Note :

建議冷卻方式為濕式。

Suggest to use Wet coolant.