

| 被切削材 Work Material | 碳素鋼 : Carbon Steels S50C / SS400 : 1.1210 / 1.0036 : 1050 / A570 Gr.45 (~HRC22) | | | | | | |
|-----------------------|---|---------------------------|----------------------------------|---------------------------------------|--------------------------|--------------------------|--------------------------|
| | 型號 Type NO. | 刀具伸長量 Extension Length | 切削速度 Cutting Speed (m/min) | 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 |
| DE0102 | 12mm | 30 | 9000~10000 | 600~900 | 0.05~0.1 | 1 | 溝銑(Slotting) |
| DE0102 | 12mm | 30 | 9000~10000 | 700~1000 | 0.1~0.15 | 1 | 溝銑(Slotting) |
| DE0102 | 12mm | 30 | 9000~10000 | 400~700 | 1~2 | 0.05~0.1 | 側銑(Side milling) |
| DE0102 | 12mm | 30 | 9000~10000 | 300~600 | 1~2 | 0.1~0.15 | 側銑(Side milling) |
| DE0152 | 14mm | 45 | 9000~10000 | 600~900 | 0.05~0.1 | 1.5 | 溝銑(Slotting) |
| DE0152 | 14mm | 45 | 9000~10000 | 700~1000 | 0.15~0.2 | 1.5 | 溝銑(Slotting) |
| DE0152 | 14mm | 45 | 9000~10000 | 400~700 | 3 | 0.05~0.1 | 側銑(Side milling) |
| DE0152 | 14mm | 45 | 9000~10000 | 300~600 | 3 | 0.15~0.2 | 側銑(Side milling) |
| DE0202 | 16mm | 55 | 8700~9200 | 600~900 | 0.05~0.1 | 2 | 溝銑(Slotting) |
| DE0202 | 16mm | 55 | 8700~9200 | 700~1000 | 0.15~0.2 | 2 | 溝銑(Slotting) |
| DE0202 | 16mm | 55 | 8700~9200 | 400~700 | 4 | 0.05~0.1 | 側銑(Side milling) |
| DE0202 | 16mm | 55 | 8700~9200 | 300~600 | 4 | 0.15~0.2 | 側銑(Side milling) |
| DE0252 | 16mm | 65 | 8000~8500 | 600~900 | 0.05~0.1 | 2.5 | 溝銑(Slotting) |
| DE0252 | 16mm | 65 | 8000~8500 | 700~1000 | 0.15~0.2 | 2.5 | 溝銑(Slotting) |
| DE0252 | 16mm | 65 | 8000~8500 | 500~800 | 5 | 0.05~0.1 | 側銑(Side milling) |
| DE0252 | 16mm | 65 | 8000~8500 | 400~700 | 5 | 0.15~0.2 | 側銑(Side milling) |
| DE0302 | 18mm | 75 | 7500~8000 | 600~900 | 0.05~0.1 | 3 | 溝銑(Slotting) |
| DE0302 | 18mm | 75 | 7500~8000 | 700~1000 | 0.15~0.2 | 3 | 溝銑(Slotting) |
| DE0302 | 18mm | 75 | 7500~8000 | 500~800 | 6 | 0.05~0.1 | 側銑(Side milling) |
| DE0302 | 18mm | 75 | 7500~8000 | 400~700 | 6 | 0.15~0.2 | 側銑(Side milling) |
| DE0402 | 20mm | 75 | 5700~6200 | 600~900 | 0.05~0.1 | 4 | 溝銑(Slotting) |
| DE0402 | 20mm | 75 | 5700~6200 | 800~1100 | 0.2~0.3 | 4 | 溝銑(Slotting) |
| DE0402 | 20mm | 75 | 5700~6200 | 600~900 | 8 | 0.05~0.1 | 側銑(Side milling) |
| DE0402 | 20mm | 75 | 5700~6200 | 800~1100 | 8 | 0.2~0.3 | 側銑(Side milling) |
| DE0502 | 20mm | 80 | 4800~5300 | 600~900 | 0.05~0.1 | 5 | 溝銑(Slotting) |
| DE0502 | 20mm | 80 | 4800~5300 | 800~1100 | 0.2~0.3 | 5 | 溝銑(Slotting) |
| DE0502 | 20mm | 80 | 4800~5300 | 600~900 | 10 | 0.05~0.1 | 側銑(Side milling) |
| DE0502 | 20mm | 80 | 4800~5300 | 800~1100 | 10 | 0.2~0.3 | 側銑(Side milling) |

本切削條件由DHF應用技術中心提供。 / Above cutting data are issued by DHF Technical Applications Center.

| 被切削材 Work Material | 碳素鋼 : Carbon Steels S50C / SS400 : 1.1210 / 1.0036 : 1050 / A570 Gr.45 (~HRC22) | | | | | | |
|-----------------------|---|---------------------------|----------------------------------|---------------------------------------|--------------------------|--------------------------|--------------------------|
| | 型號 Type NO. | 刀具伸長量 Extension Length | 切削速度 Cutting Speed (m/min) | 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 |
| DE0602 | 23mm | 80 | 4000~4500 | 600~900 | 0.05~0.15 | 6 | 溝銑(Slotting) |
| DE0602 | 23mm | 80 | 4000~4500 | 800~1100 | 0.7~1 | 6 | 溝銑(Slotting) |
| DE0602 | 23mm | 80 | 4000~4500 | 600~900 | 12 | 0.05~0.15 | 側銑(Side milling) |
| DE0602 | 23mm | 80 | 4000~4500 | 800~1100 | 12 | 0.3~0.4 | 側銑(Side milling) |
| DE0802 | 30mm | 90 | 2700~3200 | 600~900 | 700~1000 | 8 | 溝銑(Slotting) |
| DE0802 | 30mm | 90 | 2700~3200 | 600~900 | 0.7~1 | 8 | 溝銑(Slotting) |
| DE0802 | 30mm | 90 | 2700~3200 | 500~800 | 16 | 0.05~0.15 | 側銑(Side milling) |
| DE0802 | 30mm | 90 | 2700~3200 | 900~1200 | 16 | 0.4~0.5 | 側銑(Side milling) |
| DE1002 | 35mm | 85 | 2500~3000 | 600~900 | 0.05~0.15 | 10 | 溝銑(Slotting) |
| DE1002 | 35mm | 85 | 2500~3000 | 700~1100 | 0.7~1 | 10 | 溝銑(Slotting) |
| DE1002 | 35mm | 70 | 2000~2500 | 400~700 | 20 | 0.05~0.15 | 側銑(Side milling) |
| DE1002 | 35mm | 70 | 2000~2500 | 700~1100 | 20 | 0.4~0.5 | 側銑(Side milling) |
| DE1202 | 37mm | 105 | 2500~3000 | 600~900 | 0.05~0.15 | 12 | 溝銑(Slotting) |
| DE1202 | 37mm | 85 | 2000~2500 | 400~600 | 0.7~1 | 12 | 溝銑(Slotting) |
| DE1202 | 37mm | 115 | 2800~3300 | 400~600 | 24 | 0.05~0.15 | 側銑(Side milling) |
| DE1202 | 37mm | 115 | 2800~3300 | 600~900 | 24 | 0.4~0.5 | 側銑(Side milling) |
| DE1602 | 50mm | 100 | 1800~2300 | 400~600 | 0.05~0.15 | 16 | 溝銑(Slotting) |
| DE1602 | 50mm | 85 | 1500~2000 | 400~600 | 0.9~1.2 | 16 | 溝銑(Slotting) |
| DE1602 | 50mm | 115 | 2000~2500 | 400~600 | 32 | 0.05~0.15 | 側銑(Side milling) |
| DE1602 | 50mm | 115 | 2000~2500 | 500~800 | 32 | 0.4~0.5 | 側銑(Side milling) |

附註 / Note :

建議冷卻方式為濕式。

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 | 切削速度 Cutting Speed (m/min) | 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 |
| DE0102 | 14mm | 30 | 9000~10000 | 500~800 | 0.05~0.1 | 1 | 溝銑(Slotting) |
| DE0102 | 14mm | 30 | 9000~10000 | 600~900 | 0.1~0.15 | 1 | 溝銑(Slotting) |
| DE0102 | 14mm | 30 | 9000~10000 | 300~600 | 1~2 | 0.05~0.1 | 側銑(Side milling) |
| DE0102 | 14mm | 30 | 9000~10000 | 300~500 | 1~2 | 0.1~0.15 | 側銑(Side milling) |
| DE0152 | 14mm | 45 | 9000~10000 | 500~800 | 0.05~0.1 | 1.5 | 溝銑(Slotting) |
| DE0152 | 14mm | 45 | 9000~10000 | 600~900 | 0.15~0.2 | 1.5 | 溝銑(Slotting) |
| DE0152 | 14mm | 45 | 9000~10000 | 300~600 | 3 | 0.05~0.1 | 側銑(Side milling) |
| DE0152 | 14mm | 45 | 9000~10000 | 300~500 | 3 | 0.15~0.2 | 側銑(Side milling) |
| DE0202 | 16mm | 55 | 8700~9200 | 500~800 | 0.05~0.1 | 2 | 溝銑(Slotting) |
| DE0202 | 16mm | 55 | 8700~9200 | 600~900 | 0.15~0.2 | 2 | 溝銑(Slotting) |
| DE0202 | 16mm | 55 | 8700~9200 | 300~600 | 4 | 0.05~0.1 | 側銑(Side milling) |
| DE0202 | 16mm | 55 | 8700~9200 | 300~500 | 4 | 0.15~0.2 | 側銑(Side milling) |
| DE0252 | 16mm | 65 | 8000~8500 | 500~800 | 0.05~0.1 | 2.5 | 溝銑(Slotting) |
| DE0252 | 16mm | 65 | 8000~8500 | 600~900 | 0.15~0.2 | 2.5 | 溝銑(Slotting) |
| DE0252 | 16mm | 65 | 8000~8500 | 300~600 | 5 | 0.05~0.1 | 側銑(Side milling) |
| DE0252 | 16mm | 65 | 8000~8500 | 300~500 | 5 | 0.15~0.2 | 側銑(Side milling) |
| DE0302 | 18mm | 75 | 7500~8000 | 500~800 | 0.05~0.1 | 3 | 溝銑(Slotting) |
| DE0302 | 18mm | 75 | 7500~8000 | 600~900 | 0.15~0.2 | 3 | 溝銑(Slotting) |
| DE0302 | 18mm | 75 | 7500~8000 | 400~700 | 6 | 0.05~0.1 | 側銑(Side milling) |
| DE0302 | 18mm | 75 | 7500~8000 | 400~700 | 6 | 0.15~0.2 | 側銑(Side milling) |
| DE0402 | 20mm | 75 | 5700~6200 | 500~800 | 0.05~0.1 | 4 | 溝銑(Slotting) |
| DE0402 | 20mm | 75 | 5700~6200 | 700~1000 | 0.2~0.3 | 4 | 溝銑(Slotting) |
| DE0402 | 20mm | 75 | 5700~6200 | 500~800 | 8 | 0.05~0.1 | 側銑(Side milling) |
| DE0402 | 20mm | 75 | 5700~6200 | 600~900 | 8 | 0.2~0.3 | 側銑(Side milling) |
| DE0502 | 20mm | 80 | 4800~5300 | 500~800 | 0.05~0.1 | 5 | 溝銑(Slotting) |
| DE0502 | 20mm | 80 | 4800~5300 | 700~1000 | 0.2~0.3 | 5 | 溝銑(Slotting) |
| DE0502 | 20mm | 80 | 4800~5300 | 500~800 | 10 | 0.05~0.1 | 側銑(Side milling) |
| DE0502 | 20mm | 80 | 4800~5300 | 600~900 | 10 | 0.2~0.3 | 側銑(Side milling) |

本切削條件由DHF應用技術中心提供。 / Above cutting data are issued by DHF Technical Applications Center.

| 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 | 切削速度 Cutting Speed (m/min) | 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 |
| DE0602 | 23mm | 80 | 4000~4500 | 500~800 | 0.05~0.15 | 6 | 溝銑(Slotting) |
| DE0602 | 23mm | 80 | 4000~4500 | 700~1000 | 0.7~1 | 6 | 溝銑(Slotting) |
| DE0602 | 23mm | 80 | 4000~4500 | 500~800 | 12 | 0.05~0.15 | 側銑(Side milling) |
| DE0602 | 23mm | 80 | 4000~4500 | 600~900 | 12 | 0.3~0.4 | 側銑(Side milling) |
| DE0802 | 30mm | 75 | 2700~3200 | 500~800 | 700~1000 | 8 | 溝銑(Slotting) |
| DE0802 | 30mm | 75 | 2700~3200 | 500~800 | 0.7~1 | 8 | 溝銑(Slotting) |
| DE0802 | 30mm | 75 | 2700~3200 | 400~700 | 16 | 0.05~0.15 | 側銑(Side milling) |
| DE0802 | 30mm | 75 | 2700~3200 | 700~1000 | 16 | 0.4~0.5 | 側銑(Side milling) |
| DE1002 | 35mm | 100 | 3000~3500 | 500~800 | 0.05~0.15 | 10 | 溝銑(Slotting) |
| DE1002 | 35mm | 75 | 2200~2700 | 600~900 | 0.7~1 | 10 | 溝銑(Slotting) |
| DE1002 | 35mm | 100 | 3000~3500 | 400~600 | 20 | 0.05~0.15 | 側銑(Side milling) |
| DE1002 | 35mm | 70 | 2000~2500 | 600~900 | 20 | 0.4~0.5 | 側銑(Side milling) |
| DE1202 | 37mm | 105 | 2500~3000 | 500~800 | 0.05~0.15 | 12 | 溝銑(Slotting) |
| DE1202 | 37mm | 85 | 2000~2500 | 300~500 | 0.7~1 | 12 | 溝銑(Slotting) |
| DE1202 | 37mm | 115 | 2800~3300 | 300~500 | 24 | 0.05~0.15 | 側銑(Side milling) |
| DE1202 | 37mm | 115 | 2800~3300 | 500~800 | 24 | 0.4~0.5 | 側銑(Side milling) |
| DE1602 | 50mm | 100 | 1800~2300 | 300~500 | 0.05~0.15 | 16 | 溝銑(Slotting) |
| DE1602 | 50mm | 85 | 1500~2000 | 300~500 | 0.9~1.2 | 16 | 溝銑(Slotting) |
| DE1602 | 50mm | 115 | 2000~2500 | 300~500 | 32 | 0.05~0.15 | 側銑(Side milling) |
| DE1602 | 50mm | 115 | 2000~2500 | 400~600 | 32 | 0.4~0.5 | 側銑(Side milling) |

附註 / Note :

建議冷卻方式為濕式。

Suggest to use Wet coolant.