

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
DHB0202	40mm	100	15000~16000	900~1200	0.03~0.05	0.06~0.1	3D銑(3D milling)
DHB0252	40mm	125	15000~16000	1000~1300	0.03~0.05	0.06~0.1	3D銑(3D milling)
DHB0302	40mm	130	13000~14000	1000~1300	0.04~0.05	0.08~0.1	3D銑(3D milling)
DHB0402	40mm	150	11500~12500	1000~1300	0.04~0.08	0.12~0.16	3D銑(3D milling)
DHB0502	40mm	175	10000~11000	1100~1400	0.04~0.08	0.12~0.16	3D銑(3D milling)
DHB0602	40mm	160	7800~8300	1300~1700	0.1~0.15	0.24~0.3	3D銑(3D milling)
DHB0602	40mm	175	8800~9300	1400~1800	0.05~0.09	0.14~0.18	3D銑(3D milling)
DHB0802	40mm	235	8700~9200	1300~1700	0.12~0.2	0.32~0.4	3D銑(3D milling)
DHB0802	40mm	265	9500~10500	1400~1800	0.05~0.1	0.16~0.2	3D銑(3D milling)

DIB0202	50mm	150	11500~12000	700~1000	0.04~0.06	0.08~0.12	3D銑(3D milling)
DIB0302	50mm	150	11500~12000	800~1100	0.04~0.06	0.08~0.12	3D銑(3D milling)
DIB0402	50mm	150	11500~12000	900~1200	0.04~0.06	0.08~0.12	3D銑(3D milling)
DIB0602	50mm	230	11000~12000	900~1200	0.06~0.08	0.12~0.16	3D銑(3D milling)
DIB0802	50mm	185	6700~7300	900~1200	0.15~0.2	0.3~0.4	3D銑(3D milling)
DIB0802	50mm	225	8300~8800	1000~1400	0.06~0.1	0.16~0.2	3D銑(3D milling)
DIB1002	60mm	290	8700~9200	1000~1400	0.09~0.14	0.18~0.28	3D銑(3D milling)
DIB1202	60mm	325	8200~8600	900~1200	0.2~0.25	0.4~0.5	3D銑(3D milling)
DIB1202	60mm	325	8200~8600	1000~1400	0.1~0.15	0.2~0.3	3D銑(3D milling)

附註 / Note :

建議冷卻方式為濕式。

Suggest to use Wet coolant.