

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 <sup>-1</sup> )	進給速度 Feed (mm/min)	加工深度(Aa) Depth of Cut	加工寬度(Ap) Width of Cut
DIE0404	28mm	50	4000	800~1000	0~0.1	4	溝銑(Slotting)
DIE0404	28mm	50	3800	1100~1300	0.1~0.2	4	溝銑(Slotting)
DIE0404	28mm	40	3200	300~500	4~8	0~0.1	側銑(Side milling)
DIE0404	28mm	40	3200	500~700	4	0.1~0.2	側銑(Side milling)
DIE0404	28mm	40	3200	400~600	4	0.2~0.3	側銑(Side milling)
DIE0404	40mm	40	3200	500~700	0~0.08	4	溝銑(Slotting)
DIE0404	40mm	40	3200	800~1000	0.08~0.15	4	溝銑(Slotting)
DIE0404	40mm	35	2800	250~450	4~8	0~0.08	側銑(Side milling)
DIE0404	40mm	35	2800	400~600	4	0.08~0.15	側銑(Side milling)
DIE0404	40mm	35	2800	300~500	4	0.15~0.2	側銑(Side milling)
DIE0604	30mm	90	4800	850~1100	0.05~0.15	6	溝銑(Slotting)
DIE0604	30mm	75	4000	1400~1600	0~1	6	溝銑(Slotting)
DIE0604	30mm	65	3400	450~650	6~12	0.05~0.15	側銑(Side milling)
DIE0604	30mm	70	3800	1400~1600	6	0~1	側銑(Side milling)
DIE0604	30mm	70	3800	1100~1300	6	1~2	側銑(Side milling)
DIE0604	50mm	55	2800	600~800	0.05~0.15	6	溝銑(Slotting)
DIE0604	50mm	55	3000	1200~1400	0.15~0.25	6	溝銑(Slotting)
DIE0604	50mm	45	2400	400~600	6~12	0.05~0.15	側銑(Side milling)
DIE0604	50mm	40	2100	500~700	6~12	0.15~0.25	側銑(Side milling)
DIE0604	50mm	40	2100	300~500	6~12	0.25~0.5	側銑(Side milling)
DIE0804	45mm	70	2700	700~900	0.05~0.15	8	溝銑(Slotting)
DIE0804	45mm	50	2000	900~1100	0~0.5	8	溝銑(Slotting)
DIE0804	45mm	65	2500	500~700	8~16	0.05~0.15	側銑(Side milling)
DIE0804	45mm	50	2000	800~1000	8	0~0.5	側銑(Side milling)
DIE0804	45mm	50	2000	700~900	8	0.5~1	側銑(Side milling)
DIE0804	60mm	55	2200	700~900	0.05~0.15	8	溝銑(Slotting)
DIE0804	60mm	40	1600	800~1000	0~0.5	8	溝銑(Slotting)
DIE0804	60mm	55	2000	400~600	8~16	0.05~0.15	側銑(Side milling)
DIE0804	60mm	40	1600	1000~1200	8	0~0.3	側銑(Side milling)
DIE0804	60mm	35	1400	600~800	8	0.3~0.6	側銑(Side milling)

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	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 <sup>-1</sup> )	進給速度 Feed (mm/min)	加工深度(Aa) Depth of Cut	加工寬度(Ap) Width of Cut
DIE1004	50mm	115	3600	900~1100	0.05~0.15	10	溝銑(Slotting)
DIE1004	50mm	65	2000	500~700	0~1	10	溝銑(Slotting)
DIE1004	50mm	90	2800	400~600	10	0.05~0.15	側銑(Side milling)
DIE1004	50mm	50	1650	700~900	10~20	0~1.5	側銑(Side milling)
DIE1004	50mm	50	1650	500~700	10~20	1.5~3	側銑(Side milling)
DIE1004	70mm	55	1700	500~700	0.05~0.15	10	溝銑(Slotting)
DIE1004	70mm	50	1600	700~900	0~0.5	10	溝銑(Slotting)
DIE1004	70mm	65	2000	350~550	10	0.05~0.15	側銑(Side milling)
DIE1004	70mm	50	1600	1100~1300	10	0~0.5	側銑(Side milling)
DIE1004	70mm	50	1600	1000~1200	10	0.5~0.8	側銑(Side milling)
DIE1204	50mm	115	3000	900~1100	0.05~0.2	12	溝銑(Slotting)
DIE1204	50mm	90	2400	1000~1200	0~0.5	12	溝銑(Slotting)
DIE1204	50mm	90	2400	400~600	12~24	0.05~0.2	側銑(Side milling)
DIE1204	50mm	90	2400	400~600	12~24	0~0.5	側銑(Side milling)
DIE1204	50mm	85	2200	300~500	12~24	0.5~1	側銑(Side milling)
DIE1204	70mm	75	2000	600~800	0.05~0.2	12	溝銑(Slotting)
DIE1204	70mm	55	1500	800~1000	0.2~0.4	12	溝銑(Slotting)
DIE1204	70mm	60	1600	300~500	12~24	0.05~0.2	側銑(Side milling)
DIE1204	70mm	55	1500	600~800	12~24	0.2~0.4	側銑(Side milling)
DIE1204	70mm	45	1200	300~500	12	0.4~0.8	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 <sup>-1</sup> )	進給速度 Feed (mm/min)	加工深度(Aa) Depth of Cut	加工寬度(Ap) Width of Cut
DIE0404	28mm	45	3600	700~900	0~0.1	4	溝銑(Slotting)
DIE0404	28mm	45	3600	900~1100	0.1~0.2	4	溝銑(Slotting)
DIE0404	28mm	35	3000	300~500	4~8	0~0.1	側銑(Side milling)
DIE0404	28mm	35	3000	400~600	4~8	0.1~0.2	側銑(Side milling)
DIE0404	28mm	35	3000	300~500	4~8	0.2~0.3	側銑(Side milling)
DIE0404	40mm	35	3000	300~500	0~0.07	4	溝銑(Slotting)
DIE0404	40mm	35	3000	500~700	0~0.1	4	溝銑(Slotting)
DIE0404	40mm	30	2600	200~400	4~8	0~0.08	側銑(Side milling)
DIE0404	40mm	30	2600	300~500	4	0~0.1	側銑(Side milling)
DIE0404	40mm	30	2400	200~400	4	0.1~0.15	側銑(Side milling)
DIE0604	30mm	90	4800	850~1100	0.05~0.15	6	溝銑(Slotting)
DIE0604	30mm	70	3800	1400~1600	0~0.5	6	溝銑(Slotting)
DIE0604	30mm	60	3200	450~650	6~12	0.05~0.15	側銑(Side milling)
DIE0604	30mm	65	3600	800~1000	6	0~0.5	側銑(Side milling)
DIE0604	30mm	65	3600	600~800	6	0.5~1	側銑(Side milling)
DIE0604	50mm	45	2500	400~600	0.05~0.1	6	溝銑(Slotting)
DIE0604	50mm	45	2500	700~900	0.1~0.15	6	溝銑(Slotting)
DIE0604	50mm	40	2000	250~400	6~12	0.05~0.1	側銑(Side milling)
DIE0604	50mm	35	1800	200~300	6~12	0.1~0.15	側銑(Side milling)
DIE0604	50mm	35	1800	200~250	6~12	0.15~0.2	側銑(Side milling)
DIE0804	45mm	60	2400	600~800	0.05~0.15	8	溝銑(Slotting)
DIE0804	45mm	50	2000	800~1000	0~0.5	8	溝銑(Slotting)
DIE0804	45mm	50	2000	400~600	8~16	0.05~0.15	側銑(Side milling)
DIE0804	45mm	45	1700	700~900	8	0~0.5	側銑(Side milling)
DIE0804	45mm	40	1600	600~750	8	0.5~1	側銑(Side milling)
DIE0804	60mm	50	2000	550~750	0.05~0.15	8	溝銑(Slotting)
DIE0804	60mm	45	1700	900~1100	0~0.3	8	溝銑(Slotting)
DIE0804	60mm	45	1700	300~450	8~16	0.05~0.15	側銑(Side milling)
DIE0804	60mm	40	1500	900~1100	8	0~0.3	側銑(Side milling)
DIE0804	60mm	40	1350	700~900	8	0.3~0.5	側銑(Side milling)

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DIE1004	50mm	100	3200	800~1000	0.05~0.15	10	溝銑(Slotting)
DIE1004	50mm	60	1900	600~800	0~0.5	10	溝銑(Slotting)
DIE1004	50mm	70	2000	400~600	10~20	0.05~0.15	側銑(Side milling)
DIE1004	50mm	45	1400	600~800	10~20	0~0.5	側銑(Side milling)
DIE1004	50mm	40	1250	450~650	10~20	0.5~1	側銑(Side milling)
DIE1004	70mm	50	1600	450~650	0.05~0.15	10	溝銑(Slotting)
DIE1004	70mm	45	1400	700~900	0.15~0.25	10	溝銑(Slotting)
DIE1004	70mm	50	1600	300~500	10~20	0.05~0.15	側銑(Side milling)
DIE1004	70mm	45	1400	500~700	10~20	0.15~0.3	側銑(Side milling)
DIE1004	70mm	45	1400	400~600	10~20	0.3~0.4	側銑(Side milling)
DIE1204	50mm	110	2900	900~1100	0.05~0.2	12	溝銑(Slotting)
DIE1204	50mm	80	2100	900~1100	0.2~0.4	12	溝銑(Slotting)
DIE1204	50mm	75	2000	400~600	12~24	0.05~0.2	側銑(Side milling)
DIE1204	50mm	75	2000	400~600	12~24	0.2~0.4	側銑(Side milling)
DIE1204	50mm	75	2000	300~450	12~24	0.4~0.8	側銑(Side milling)
DIE1204	70mm	70	1900	600~800	0.05~0.2	12	溝銑(Slotting)
DIE1204	70mm	50	1400	900~1100	0.2~0.3	12	溝銑(Slotting)
DIE1204	70mm	55	1500	250~450	12~24	0.05~0.2	側銑(Side milling)
DIE1204	70mm	55	1500	500~700	12~24	0.2~0.3	側銑(Side milling)
DIE1204	70mm	50	1400	400~600	12~24	0.3~0.4	側銑(Side milling)

附註 / Note :

建議冷卻方式為濕式。

Suggest to use Wet coolant.