

被切削材 Work Material	碳素鋼 / 鑄鐵 : Carbon steels / Cast Iron S50C / Fc250 / SS440 : 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
HBH0202	40	105	15500~16500	1600~2000	0.03~0.05	0.06~0.1	3D銑(3D milling)
HBH0252	40	115	15500~16500	1600~2000	0.03~0.05	0.06~0.1	3D銑(3D milling)
HBH0302	40	135	13000~14000	1800~2200	0.04~0.05	0.08~0.1	3D銑(3D milling)
HBH0402	40	160	11500~12500	1800~2200	0.06~0.08	0.12~0.16	3D銑(3D milling)
HBH0502	40	175	10000~11000	1800~2200	0.06~0.08	0.12~0.16	3D銑(3D milling)
HBH0602	40	175	8800~9300	1600~2000	0.07~0.09	0.14~0.18	3D銑(3D milling)
HBH0802	40	265	9500~10500	1600~2000	0.08~0.1	0.16~0.2	3D銑(3D milling)

IBH0202	60	80	12000~13000	1200~1600	0.03~0.05	0.08~0.12	3D銑(3D milling)
IBH0302	60	120	12000~13000	1300~1700	0.03~0.06	0.08~0.12	3D銑(3D milling)
IBH0402	60	150	11000~12000	1400~1800	0.04~0.06	0.08~0.12	3D銑(3D milling)
IBH0602	60	200	10000~11000	1600~2000	0.06~0.08	0.12~0.16	3D銑(3D milling)
IBH0802	60	225	8300~8800	1400~1800	0.06~0.1	0.16~0.2	3D銑(3D milling)
IBH1002	60	290	8700~9200	1400~1800	0.05~0.14	0.18~0.28	3D銑(3D milling)
IBH1202	60	325	8200~8600	1400~1800	0.05~0.15	0.2~0.3	3D銑(3D milling)

附註 / Note :

二冷卻方式皆為濕式。

gest 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(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
HBH0202	40	105	15500~16500	1400~1800	0.03~0.05	0.06~0.1	3D銑(3D milling)
HBH0252	40	115	15500~16500	1400~1800	0.03~0.05	0.06~0.1	3D銑(3D milling)
HBH0302	40	135	13000~14000	1600~2000	0.04~0.05	0.08~0.1	3D銑(3D milling)
HBH0402	40	160	11500~12500	1600~2000	0.06~0.08	0.12~0.16	3D銑(3D milling)
HBH0502	40	175	10000~11000	1600~2000	0.06~0.08	0.12~0.16	3D銑(3D milling)
HBH0602	40	175	8800~9300	1400~1800	0.07~0.09	0.14~0.18	3D銑(3D milling)
HBH0802	40	265	9500~10500	1400~1800	0.08~0.1	0.16~0.2	3D銑(3D milling)

IBH0202	60	75	11000~12000	1200~1600	0.04~0.06	0.08~0.12	3D銑(3D milling)
IBH0302	60	110	11000~12000	1200~1600	0.04~0.06	0.08~0.12	3D銑(3D milling)
IBH0402	60	130	10000~11000	1200~1600	0.04~0.06	0.08~0.12	3D銑(3D milling)
IBH0602	60	180	9000~10000	1400~1800	0.05~0.08	0.12~0.16	3D銑(3D milling)
IBH0802	60	210	8000~8500	1200~1600	0.05~0.1	0.16~0.2	3D銑(3D milling)
IBH1002	60	260	8000~8500	1200~1600	0.05~0.14	0.18~0.28	3D銑(3D milling)
IBH1202	60	270	7000~7500	1200~1600	0.05~0.15	0.2~0.3	3D銑(3D milling)

附註 / Note :

以上冷卻方式皆為濕式。

Suggest to use Wet coolant.

被切削材 Work Material	調質鋼 / 預硬鋼 : Prehardened Steels NAK80 : 1.2083 : AISI420 : M310 (HRC36~45)						
	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
HBH0202	40	105	15500~16500	1200~1600	0.03~0.05	0.06~0.1	3D銑(3D milling)
HBH0252	40	115	15500~16500	1200~1600	0.03~0.05	0.06~0.1	3D銑(3D milling)
HBH0302	40	135	13000~14000	1400~1800	0.04~0.05	0.08~0.1	3D銑(3D milling)
HBH0402	40	160	11500~12500	1400~1800	0.06~0.08	0.12~0.16	3D銑(3D milling)
HBH0502	40	175	10000~11000	1400~1800	0.06~0.08	0.12~0.16	3D銑(3D milling)
HBH0602	40	175	8800~9300	1300~1700	0.07~0.09	0.14~0.18	3D銑(3D milling)
HBH0802	40	265	9500~10500	1300~1700	0.08~0.1	0.16~0.2	3D銑(3D milling)

IBH0202	60	75	11000~12000	1000~1400	0.04~0.06	0.08~0.12	3D銑(3D milling)
IBH0302	60	110	11000~12000	1000~1400	0.04~0.06	0.08~0.12	3D銑(3D milling)
IBH0402	60	130	10000~11000	1000~1400	0.04~0.06	0.08~0.12	3D銑(3D milling)
IBH0602	60	180	9000~10000	1200~1600	0.05~0.08	0.12~0.16	3D銑(3D milling)
IBH0802	60	200	7500~8000	1000~1400	0.05~0.1	0.16~0.2	3D銑(3D milling)
IBH1002	60	230	7000~7500	1000~1400	0.05~0.14	0.18~0.28	3D銑(3D milling)
IBH1202	60	250	6500~7000	1000~1400	0.05~0.15	0.2~0.3	3D銑(3D milling)

附註 / Note :

以上冷卻方式皆為濕式。

Suggest to use Wet coolant.