

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)					
冷卻方式 Coolant Type		濕式切削 Wet coolant					
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
LRTD0405	40	70	5400~5800	1000~1200	0.07~0.1	2~4	溝銑 SLOTTING
LRTD0405	40	115	9000~10000	1200~1600	0.07~0.1	0.07~0.1	3D銑 3D MILLING
LRTD0410	40	70	5400~5800	1000~1200	0.07~0.1	1~4	溝銑 SLOTTING
LRTD0410	40	115	9000~10000	1200~1600	0.07~0.1	0.07~0.1	3D銑 3D MILLING
LRTD0602	40	75	4000~4600	600~800	0.15~0.2	5~6	溝銑 SLOTTING
LRTD0602	40	95	5000~5500	1200~1400	0.07~0.1	5~6	溝銑 SLOTTING
LRTD0602	40	60	3200~3600	1000~1200	6~12	0.15~0.2	側銑 SIDE MILLING
LRTD0602	40	60	3200~3600	600~800	6~12	0.07~0.1	側銑 SIDE MILLING
LRTD0602	40	90	4800~5400	1800~2200	0.15~0.2	0.15~0.2	3D銑 3D MILLING
LRTD0602	40	135	7200~7600	1200~1600	0.07~0.1	0.07~0.1	3D銑 3D MILLING
LRTD0603	40	75	4000~4600	600~800	0.15~0.2	5~6	溝銑 SLOTTING
LRTD0603	40	95	5000~5500	1200~1400	0.07~0.1	5~6	溝銑 SLOTTING
LRTD0603	40	60	3200~3600	1000~1200	6~12	0.15~0.2	側銑 SIDE MILLING
LRTD0603	40	60	3200~3600	600~800	6~12	0.07~0.1	側銑 SIDE MILLING
LRTD0603	40	90	4800~5400	1800~2200	0.15~0.2	0.15~0.2	3D銑 3D MILLING
LRTD0603	40	135	7200~7600	1200~1600	0.07~0.1	0.07~0.1	3D銑 3D MILLING
LRTD0605	40	75	4000~4600	600~800	0.15~0.2	4~6	溝銑 SLOTTING
LRTD0605	40	95	5000~5500	1200~1400	0.07~0.1	4~6	溝銑 SLOTTING
LRTD0605	40	60	3200~3600	1000~1200	6~12	0.15~0.2	側銑 SIDE MILLING
LRTD0605	40	60	3200~3600	600~800	6~12	0.07~0.1	側銑 SIDE MILLING
LRTD0605	40	90	4800~5400	1800~2200	0.15~0.2	0.15~0.2	3D銑 3D MILLING
LRTD0605	40	135	7200~7600	1200~1600	0.07~0.1	0.07~0.1	3D銑 3D MILLING
LRTD0610	40	75	4000~4600	600~800	0.15~0.2	3~6	溝銑 SLOTTING
LRTD0610	40	95	5000~5500	1200~1400	0.07~0.1	3~6	溝銑 SLOTTING
LRTD0610	40	60	3200~3600	1000~1200	6~12	0.15~0.2	側銑 SIDE MILLING
LRTD0610	40	60	3200~3600	600~800	6~12	0.07~0.1	側銑 SIDE MILLING
LRTD0610	40	90	4800~5400	1800~2200	0.15~0.2	0.15~0.2	3D銑 3D MILLING
LRTD0610	40	135	7200~7600	1200~1600	0.07~0.1	0.07~0.1	3D銑 3D MILLING
LRTD0803	50	65	2500~3000	800~1000	0.2~0.25	7~8	溝銑 SLOTTING
LRTD0803	50	75	3000~3500	600~800	0.08~0.12	7~8	溝銑 SLOTTING
LRTD0803	50	90	3500~4000	500~800	8~16	0.2~0.25	側銑 SIDE MILLING
LRTD0803	50	65	2500~3000	500~800	8~16	0.08~0.12	側銑 SIDE MILLING
LRTD0803	50	115	4500~5200	1000~1400	0.2~0.25	0.2~0.25	3D銑 3D MILLING
LRTD0803	50	165	6500~7000	1000~1400	0.08~0.12	0.08~0.12	3D銑 3D MILLING
LRTD0805	50	65	2500~3000	800~1000	0.2~0.25	6~8	溝銑 SLOTTING
LRTD0805	50	75	3000~3500	600~800	0.08~0.12	6~8	溝銑 SLOTTING
LRTD0805	50	90	3500~4000	500~800	8~16	0.2~0.25	側銑 SIDE MILLING
LRTD0805	50	65	2500~3000	500~800	8~16	0.08~0.12	側銑 SIDE MILLING
LRTD0805	50	115	4500~5200	1000~1400	0.2~0.25	0.2~0.25	3D銑 3D MILLING
LRTD0805	50	165	6500~7000	1000~1400	0.08~0.12	0.08~0.12	3D銑 3D MILLING

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)					
冷卻方式 Coolant Type		濕式切削 Wet coolant					
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
LRTD0810	50	65	2500~3000	800~1000	0.2~0.25	5~8	溝銑 SLOTTING
LRTD0810	50	75	3000~3500	600~800	0.08~0.12	5~8	溝銑 SLOTTING
LRTD0810	50	90	3500~4000	500~800	8~16	0.2~0.25	側銑 SIDE MILLING
LRTD0810	50	65	2500~3000	500~800	8~16	0.08~0.12	側銑 SIDE MILLING
LRTD0810	50	115	4500~5200	1000~1400	0.2~0.25	0.2~0.25	3D銑 3D MILLING
LRTD0810	50	165	6500~7000	1000~1400	0.08~0.12	0.08~0.12	3D銑 3D MILLING
LRTD1002	60	65	2000~2400	800~1000	0.25~0.3	9~10	溝銑 SLOTTING
LRTD1002	60	75	2400~2800	500~800	0.08~0.13	9~10	溝銑 SLOTTING
LRTD1002	60	90	2800~3200	500~800	10~20	0.25~0.3	側銑 SIDE MILLING
LRTD1002	60	65	2000~2400	500~800	10~20	0.1~0.15	側銑 SIDE MILLING
LRTD1002	60	115	3600~4200	1000~1400	0.25~0.3	0.25~0.3	3D銑 3D MILLING
LRTD1002	60	165	5200~5600	1000~1400	0.08~0.13	0.08~0.13	3D銑 3D MILLING
LRTD1003	60	65	2000~2400	800~1000	0.25~0.3	9~10	溝銑 SLOTTING
LRTD1003	60	75	2400~2800	500~800	0.08~0.13	9~10	溝銑 SLOTTING
LRTD1003	60	90	2800~3200	500~800	10~20	0.25~0.3	側銑 SIDE MILLING
LRTD1003	60	65	2000~2400	500~800	10~20	0.1~0.15	側銑 SIDE MILLING
LRTD1003	60	115	3600~4200	1000~1400	0.25~0.3	0.25~0.3	3D銑 3D MILLING
LRTD1003	60	165	5200~5600	1000~1400	0.08~0.13	0.08~0.13	3D銑 3D MILLING
LRTD1005	60	65	2000~2400	800~1000	0.25~0.3	10~20	溝銑 SLOTTING
LRTD1005	60	75	2400~2800	500~800	0.08~0.13	10~20	溝銑 SLOTTING
LRTD1005	60	90	2800~3200	500~800	10~20	0.25~0.3	側銑 SIDE MILLING
LRTD1005	60	65	2000~2400	500~800	10~20	0.08~0.13	側銑 SIDE MILLING
LRTD1005	60	115	3600~4200	1000~1400	0.25~0.3	0.25~0.3	3D銑 3D MILLING
LRTD1005	60	165	5200~5600	1000~1400	0.08~0.13	0.08~0.13	3D銑 3D MILLING
LRTD1010	60	65	2000~2400	800~1000	0.25~0.3	7~10	溝銑 SLOTTING
LRTD1010	60	75	2400~2800	500~800	0.08~0.13	7~10	溝銑 SLOTTING
LRTD1010	60	90	2800~3200	500~800	10~20	0.25~0.3	側銑 SIDE MILLING
LRTD1010	60	65	2000~2400	500~800	10~20	0.1~0.15	側銑 SIDE MILLING
LRTD1010	60	115	3600~4200	1000~1400	0.25~0.3	0.25~0.3	3D銑 3D MILLING
LRTD1010	60	165	5200~5600	1000~1400	0.08~0.13	0.08~0.13	3D銑 3D MILLING
LRTD1020	60	65	2000~2400	800~1000	0.25~0.3	5~10	溝銑 SLOTTING
LRTD1020	60	75	2400~2800	500~800	0.08~0.13	5~10	溝銑 SLOTTING
LRTD1020	60	90	2800~3200	500~800	10~20	0.25~0.3	側銑 SIDE MILLING
LRTD1020	60	65	2000~2400	500~800	10~20	0.1~0.15	側銑 SIDE MILLING
LRTD1020	60	115	3600~4200	1000~1400	0.25~0.3	0.25~0.3	3D銑 3D MILLING
LRTD1020	60	165	5200~5600	1000~1400	0.08~0.13	0.08~0.13	3D銑 3D MILLING
LRTD1205	60	75	2000~2400	800~1200	0.25~0.3	10~12	溝銑 SLOTTING
LRTD1205	60	105	2800~3200	800~1000	0.1~0.15	10~12	溝銑 SLOTTING
LRTD1205	60	80	1900~2300	800~1000	12~24	0.2~0.3	側銑 SIDE MILLING
LRTD1205	60	80	1900~2300	400~600	12~24	0.1~0.15	側銑 SIDE MILLING
LRTD1205	60	150	4000~4500	1400~1800	0.25~0.3	0.25~0.3	3D銑 3D MILLING
LRTD1205	60	170	4500~5000	1200~1600	0.1~0.15	0.1~0.15	3D銑 3D MILLING

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)					
冷卻方式 Coolant Type		濕式切削 Wet coolant					
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
LRTD1210	60	75	2000~2400	800~1200	0.25~0.3	9~12	溝銑 SLOTTING
LRTD1210	60	105	2800~3200	800~1000	0.1~0.15	9~12	溝銑 SLOTTING
LRTD1210	60	80	1900~2300	800~1000	12~24	0.25~0.3	側銑 SIDE MILLING
LRTD1210	60	80	1900~2300	400~600	12~24	0.1~0.15	側銑 SIDE MILLING
LRTD1210	60	150	4000~4500	1400~1800	0.25~0.3	0.25~0.3	3D銑 3D MILLING
LRTD1210	60	170	4500~5000	1200~1600	0.1~0.15	0.1~0.15	3D銑 3D MILLING
LRTD1220	60	75	2000~2400	800~1200	0.25~0.3	7~12	溝銑 SLOTTING
LRTD1220	60	105	2800~3200	800~1000	0.1~0.15	7~12	溝銑 SLOTTING
LRTD1220	60	80	1900~2300	800~1000	12~24	0.25~0.3	側銑 SIDE MILLING
LRTD1220	60	80	1900~2300	400~600	12~24	0.1~0.15	側銑 SIDE MILLING
LRTD1220	60	150	4000~4500	1400~1800	0.25~0.3	0.25~0.3	3D銑 3D MILLING
LRTD1220	60	170	4500~5000	1200~1600	0.1~0.15	0.1~0.15	3D銑 3D MILLING
LRTD1610	100	75	1500~1800	700~1100	0.3~0.35	13~16	溝銑 SLOTTING
LRTD1610	100	90	1800~2100	400~600	0.12~0.17	13~16	溝銑 SLOTTING
LRTD1610	100	75	1500~1800	600~800	16~32	0.3~0.35	側銑 SIDE MILLING
LRTD1610	100	75	1500~1800	400~600	16~32	0.12~0.17	側銑 SIDE MILLING
LRTD1610	100	150	3000~3400	1400~1800	0.3~0.35	0.3~0.35	3D銑 3D MILLING
LRTD1610	100	170	3400~3800	800~1200	0.12~0.17	0.12~0.17	3D銑 3D MILLING
LRTD1620	100	75	1500~1800	700~1100	0.3~0.35	11~16	溝銑 SLOTTING
LRTD1620	100	90	1800~2100	400~600	0.12~0.17	11~16	溝銑 SLOTTING
LRTD1620	100	75	1500~1800	600~800	16~32	0.3~0.35	側銑 SIDE MILLING
LRTD1620	100	75	1500~1800	400~600	16~32	0.12~0.17	側銑 SIDE MILLING
LRTD1620	100	150	3000~3400	1400~1800	0.3~0.35	0.3~0.35	3D銑 3D MILLING
LRTD1620	100	170	3400~3800	800~1200	0.12~0.17	0.12~0.17	3D銑 3D 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)					
冷卻方式 Coolant Type		濕式切削 Wet coolant					
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
LRTD0405	40	65	5000~5500	800~1000	0.07~0.1	1~4	溝銑 SLOTTING
LRTD0405	40	115	9000~10000	1000~1400	0.07~0.1	0.07~0.1	3D銑 3D MILLING
LRTD0410	40	65	5000~5500	800~1000	0.07~0.1	1~4	溝銑 SLOTTING
LRTD0410	40	115	9000~10000	1000~1400	0.07~0.1	0.07~0.1	3D銑 3D MILLING
LRTD0602	40	70	3600~4000	600~800	0.15~0.2	5~6	溝銑 SLOTTING
LRTD0602	40	85	4500~5000	1000~1200	0.07~0.1	5~6	溝銑 SLOTTING
LRTD0602	40	30	1600~2000	200~400	6~12	0.15~0.2	側銑 SIDE MILLING
LRTD0602	40	50	2700~3200	400~600	6~12	0.07~0.1	側銑 SIDE MILLING
LRTD0602	40	90	4800~5400	1000~1400	0.15~0.2	0.15~0.2	3D銑 3D MILLING
LRTD0602	40	130	6800~7200	1200~1600	0.07~0.1	0.07~0.1	3D銑 3D MILLING
LRTD0603	40	70	3600~4000	600~800	0.15~0.2	5~6	溝銑 SLOTTING
LRTD0603	40	85	4500~5000	1000~1200	0.07~0.1	5~6	溝銑 SLOTTING
LRTD0603	40	30	1600~2000	200~400	6~12	0.15~0.2	側銑 SIDE MILLING
LRTD0603	40	50	2700~3200	400~600	6~12	0.07~0.1	側銑 SIDE MILLING
LRTD0603	40	90	4800~5400	1000~1400	0.15~0.2	0.15~0.2	3D銑 3D MILLING
LRTD0603	40	130	6800~7200	1200~1600	0.07~0.1	0.07~0.1	3D銑 3D MILLING
LRTD0605	40	70	3600~4000	600~800	0.15~0.2	4~6	溝銑 SLOTTING
LRTD0605	40	85	4500~5000	1000~1200	0.07~0.1	4~6	溝銑 SLOTTING
LRTD0605	40	30	1600~2000	200~400	6~12	0.15~0.2	側銑 SIDE MILLING
LRTD0605	40	50	2700~3200	400~600	6~12	0.07~0.1	側銑 SIDE MILLING
LRTD0605	40	90	4800~5400	1000~1400	0.15~0.2	0.15~0.2	3D銑 3D MILLING
LRTD0605	40	130	6800~7200	1200~1600	0.07~0.1	0.07~0.1	3D銑 3D MILLING
LRTD0610	40	70	3600~4000	600~800	0.15~0.2	3~6	溝銑 SLOTTING
LRTD0610	40	85	4500~5000	1000~1200	0.07~0.1	3~6	溝銑 SLOTTING
LRTD0610	40	30	1600~2000	200~400	6~12	0.15~0.2	側銑 SIDE MILLING
LRTD0610	40	50	2700~3200	400~600	6~12	0.07~0.1	側銑 SIDE MILLING
LRTD0610	40	90	4800~5400	1000~1400	0.15~0.2	0.15~0.2	3D銑 3D MILLING
LRTD0610	40	130	6800~7200	1200~1600	0.07~0.1	0.07~0.1	3D銑 3D MILLING
LRTD0803	50	65	2400~2800	600~800	0.2~0.25	7~8	溝銑 SLOTTING
LRTD0803	50	90	3500~4000	500~700	0.08~0.12	7~8	溝銑 SLOTTING
LRTD0803	50	35	1200~1600	250~350	8~16	0.2~0.25	側銑 SIDE MILLING
LRTD0803	50	50	1800~2200	400~600	8~16	0.08~0.12	側銑 SIDE MILLING
LRTD0803	50	115	4500~5200	800~1000	0.2~0.25	0.2~0.25	3D銑 3D MILLING
LRTD0803	50	150	5700~6300	800~1200	0.08~0.12	0.08~0.12	3D銑 3D MILLING
LRTD0805	50	65	2400~2800	600~800	0.2~0.25	6~8	溝銑 SLOTTING
LRTD0805	50	90	3500~4000	500~700	0.08~0.12	6~8	溝銑 SLOTTING
LRTD0805	50	35	1200~1600	250~350	8~16	0.2~0.25	側銑 SIDE MILLING
LRTD0805	50	50	1800~2200	400~600	8~16	0.08~0.12	側銑 SIDE MILLING
LRTD0805	50	115	4500~5200	800~1000	0.2~0.25	0.2~0.25	3D銑 3D MILLING
LRTD0805	50	150	5700~6300	800~1200	0.08~0.12	0.08~0.12	3D銑 3D MILLING

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)					
冷卻方式 Coolant Type		濕式切削 Wet coolant					
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
LRTD0810	50	65	2400~2800	600~800	0.2~0.25	5~8	溝銑 SLOTTING
LRTD0810	50	90	3500~4000	500~700	0.08~0.12	5~8	溝銑 SLOTTING
LRTD0810	50	35	1200~1600	250~350	8~16	0.2~0.25	側銑 SIDE MILLING
LRTD0810	50	50	1800~2200	400~600	8~16	0.08~0.12	側銑 SIDE MILLING
LRTD0810	50	115	4500~5200	800~1000	0.2~0.25	0.2~0.25	3D銑 3D MILLING
LRTD0810	50	150	5700~6300	800~1200	0.08~0.12	0.08~0.12	3D銑 3D MILLING
LRTD1002	60	65	2000~2400	600~800	0.25~0.3	9~10	溝銑 SLOTTING
LRTD1002	60	90	2800~3200	500~700	0.08~0.13	9~10	溝銑 SLOTTING
LRTD1002	60	35	1000~1300	200~300	10~20	0.2~0.25	側銑 SIDE MILLING
LRTD1002	60	40	1200~1600	400~600	10~20	0.08~0.13	側銑 SIDE MILLING
LRTD1002	60	115	3600~4000	800~1000	0.25~0.3	0.25~0.3	3D銑 3D MILLING
LRTD1002	60	150	4800~5200	800~1200	0.08~0.13	0.08~0.13	3D銑 3D MILLING
LRTD1003	60	65	2000~2400	600~800	0.25~0.3	8~10	溝銑 SLOTTING
LRTD1003	60	90	2800~3200	500~700	0.08~0.13	8~10	溝銑 SLOTTING
LRTD1003	60	35	1000~1300	200~300	10~20	0.2~0.25	側銑 SIDE MILLING
LRTD1003	60	40	1200~1600	400~600	10~20	0.08~0.13	側銑 SIDE MILLING
LRTD1003	60	115	3600~4000	800~1000	0.25~0.3	0.25~0.3	3D銑 3D MILLING
LRTD1003	60	150	4800~5200	800~1200	0.08~0.13	0.08~0.13	3D銑 3D MILLING
LRTD1005	60	65	2000~2400	600~800	0.25~0.3	8~10	溝銑 SLOTTING
LRTD1005	60	90	2800~3200	500~700	0.08~0.13	8~10	溝銑 SLOTTING
LRTD1005	60	35	1000~1300	200~300	10~20	0.2~0.25	側銑 SIDE MILLING
LRTD1005	60	40	1200~1600	400~600	10~20	0.08~0.13	側銑 SIDE MILLING
LRTD1005	60	115	3600~4000	800~1000	0.25~0.3	0.25~0.3	3D銑 3D MILLING
LRTD1005	60	150	4800~5200	800~1200	0.08~0.13	0.08~0.13	3D銑 3D MILLING
LRTD1010	60	65	2000~2400	600~800	0.25~0.3	7~10	溝銑 SLOTTING
LRTD1010	60	90	2800~3200	500~700	0.08~0.13	7~10	溝銑 SLOTTING
LRTD1010	60	35	1000~1300	200~300	10~20	0.2~0.25	側銑 SIDE MILLING
LRTD1010	60	40	1200~1600	400~600	10~20	0.08~0.13	側銑 SIDE MILLING
LRTD1010	60	115	3600~4000	800~1000	0.25~0.3	0.25~0.3	3D銑 3D MILLING
LRTD1010	60	150	4800~5200	800~1200	0.08~0.13	0.08~0.13	3D銑 3D MILLING
LRTD1020	60	65	2000~2400	600~800	0.25~0.3	5~10	溝銑 SLOTTING
LRTD1020	60	90	2800~3200	500~700	0.08~0.13	5~10	溝銑 SLOTTING
LRTD1020	60	35	1000~1300	200~300	10~20	0.2~0.25	側銑 SIDE MILLING
LRTD1020	60	40	1200~1600	400~600	10~20	0.08~0.13	側銑 SIDE MILLING
LRTD1020	60	115	3600~4000	800~1000	0.25~0.3	0.25~0.3	3D銑 3D MILLING
LRTD1020	60	150	4800~5200	800~1200	0.08~0.13	0.08~0.13	3D銑 3D MILLING
LRTD1205	60	70	1800~2200	800~1000	0.25~0.3	10~12	溝銑 SLOTTING
LRTD1205	60	95	2500~2800	600~800	0.1~0.15	10~12	溝銑 SLOTTING
LRTD1205	60	30	700~1000	200~300	12~24	0.15~0.25	側銑 SIDE MILLING
LRTD1205	60	45	1100~1400	300~450	12~24	0.1~0.15	側銑 SIDE MILLING
LRTD1205	60	150	4000~4500	800~1000	0.25~0.3	0.25~0.3	3D銑 3D MILLING
LRTD1205	60	150	4000~4500	1000~1400	0.1~0.15	0.1~0.15	3D銑 3D MILLING

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)					
冷卻方式 Coolant Type		濕式切削 Wet coolant					
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
LRTD1210	60	70	1800~2200	800~1000	0.25~0.3	9~12	溝銑 SLOTTING
LRTD1210	60	95	2500~2800	600~800	0.1~0.15	9~12	溝銑 SLOTTING
LRTD1210	60	30	700~1000	200~300	12~24	0.15~0.25	側銑 SIDE MILLING
LRTD1210	60	45	1100~1400	300~450	12~24	0.1~0.15	側銑 SIDE MILLING
LRTD1210	60	150	4000~4500	800~1000	0.25~0.3	0.25~0.3	3D銑 3D MILLING
LRTD1210	60	150	4000~4500	1000~1400	0.1~0.15	0.1~0.15	3D銑 3D MILLING
LRTD1220	60	70	1800~2200	800~1000	0.25~0.3	7~12	溝銑 SLOTTING
LRTD1220	60	95	2500~2800	600~800	0.1~0.15	7~12	溝銑 SLOTTING
LRTD1220	60	30	700~1000	200~300	12~24	0.15~0.25	側銑 SIDE MILLING
LRTD1220	60	45	1100~1400	300~450	12~24	0.1~0.15	側銑 SIDE MILLING
LRTD1220	60	150	4000~4500	800~1000	0.25~0.3	0.25~0.3	3D銑 3D MILLING
LRTD1220	60	150	4000~4500	1000~1400	0.1~0.15	0.1~0.15	3D銑 3D MILLING
LRTD1610	100	70	1200~1600	600~900	0.3~0.35	13~16	溝銑 SLOTTING
LRTD1610	100	85	1500~1800	300~500	0.12~0.17	13~16	溝銑 SLOTTING
LRTD1610	100	30	500~800	200~350	16~32	0.3~0.35	側銑 SIDE MILLING
LRTD1610	100	45	800~1100	200~350	16~32	0.12~0.17	側銑 SIDE MILLING
LRTD1610	100	150	3000~3400	1200~1600	0.3~0.35	0.3~0.35	3D銑 3D MILLING
LRTD1610	100	150	3000~3400	700~1000	0.12~0.17	0.12~0.17	3D銑 3D MILLING
LRTD1620	100	70	1200~1600	600~900	0.3~0.35	11~16	溝銑 SLOTTING
LRTD1620	100	85	1500~1800	300~500	0.12~0.17	11~16	溝銑 SLOTTING
LRTD1620	100	30	500~800	200~350	16~32	0.3~0.35	側銑 SIDE MILLING
LRTD1620	100	45	800~1100	200~350	16~32	0.12~0.17	側銑 SIDE MILLING
LRTD1620	100	150	3000~3400	1200~1600	0.3~0.35	0.3~0.35	3D銑 3D MILLING
LRTD1620	100	150	3000~3400	700~1000	0.12~0.17	0.12~0.17	3D銑 3D MILLING

附註 / Note :

建議冷卻方式為濕式。

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)					
冷卻方式 Coolant Type		濕式切削 Wet coolant					
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
LRTD0405	40	65	5000~5500	800~1000	0.07~0.1	1~4	溝銑 SLOTTING
LRTD0405	40	115	9000~10000	1000~1400	0.07~0.1	0.07~0.1	3D銑 3D MILLING
LRTD0410	40	65	5000~5500	800~1000	0.07~0.1	1~4	溝銑 SLOTTING
LRTD0410	40	115	9000~10000	1000~1400	0.07~0.1	0.07~0.1	3D銑 3D MILLING
LRTD0602	40	70	3600~4000	600~800	0.15~0.2	5~6	溝銑 SLOTTING
LRTD0602	40	85	4500~5000	1000~1200	0.07~0.1	5~6	溝銑 SLOTTING
LRTD0602	40	30	1600~2000	200~400	6~12	0.15~0.2	側銑 SIDE MILLING
LRTD0602	40	50	2700~3200	400~600	6~12	0.07~0.1	側銑 SIDE MILLING
LRTD0602	40	90	4800~5400	1000~1400	0.15~0.2	0.15~0.2	3D銑 3D MILLING
LRTD0602	40	130	6800~7200	1200~1600	0.07~0.1	0.07~0.1	3D銑 3D MILLING
LRTD0603	40	70	3600~4000	600~800	0.15~0.2	5~6	溝銑 SLOTTING
LRTD0603	40	85	4500~5000	1000~1200	0.07~0.1	5~6	溝銑 SLOTTING
LRTD0603	40	30	1600~2000	200~400	6~12	0.15~0.2	側銑 SIDE MILLING
LRTD0603	40	50	2700~3200	400~600	6~12	0.07~0.1	側銑 SIDE MILLING
LRTD0603	40	90	4800~5400	1000~1400	0.15~0.2	0.15~0.2	3D銑 3D MILLING
LRTD0603	40	130	6800~7200	1200~1600	0.07~0.1	0.07~0.1	3D銑 3D MILLING
LRTD0605	40	70	3600~4000	600~800	0.15~0.2	4~6	溝銑 SLOTTING
LRTD0605	40	85	4500~5000	1000~1200	0.07~0.1	4~6	溝銑 SLOTTING
LRTD0605	40	30	1600~2000	200~400	6~12	0.15~0.2	側銑 SIDE MILLING
LRTD0605	40	50	2700~3200	400~600	6~12	0.07~0.1	側銑 SIDE MILLING
LRTD0605	40	90	4800~5400	1000~1400	0.15~0.2	0.15~0.2	3D銑 3D MILLING
LRTD0605	40	130	6800~7200	1200~1600	0.07~0.1	0.07~0.1	3D銑 3D MILLING
LRTD0610	40	70	3600~4000	600~800	0.15~0.2	3~6	溝銑 SLOTTING
LRTD0610	40	85	4500~5000	1000~1200	0.07~0.1	3~6	溝銑 SLOTTING
LRTD0610	40	30	1600~2000	200~400	6~12	0.15~0.2	側銑 SIDE MILLING
LRTD0610	40	50	2700~3200	400~600	6~12	0.07~0.1	側銑 SIDE MILLING
LRTD0610	40	90	4800~5400	1000~1400	0.15~0.2	0.15~0.2	3D銑 3D MILLING
LRTD0610	40	130	6800~7200	1200~1600	0.07~0.1	0.07~0.1	3D銑 3D MILLING
LRTD0803	50	65	2400~2800	600~800	0.2~0.25	7~8	溝銑 SLOTTING
LRTD0803	50	90	3500~4000	500~700	0.08~0.12	7~8	溝銑 SLOTTING
LRTD0803	50	35	1200~1600	250~350	8~16	0.2~0.25	側銑 SIDE MILLING
LRTD0803	50	50	1800~2200	400~600	8~16	0.08~0.12	側銑 SIDE MILLING
LRTD0803	50	115	4500~5200	800~1000	0.2~0.25	0.2~0.25	3D銑 3D MILLING
LRTD0803	50	150	5700~6300	800~1200	0.08~0.12	0.08~0.12	3D銑 3D MILLING
LRTD0805	50	65	2400~2800	600~800	0.2~0.25	6~8	溝銑 SLOTTING
LRTD0805	50	90	3500~4000	500~700	0.08~0.12	6~8	溝銑 SLOTTING
LRTD0805	50	35	1200~1600	250~350	8~16	0.2~0.25	側銑 SIDE MILLING
LRTD0805	50	50	1800~2200	400~600	8~16	0.08~0.12	側銑 SIDE MILLING
LRTD0805	50	115	4500~5200	800~1000	0.2~0.25	0.2~0.25	3D銑 3D MILLING
LRTD0805	50	150	5700~6300	800~1200	0.08~0.12	0.08~0.12	3D銑 3D MILLING

被切削材 Work Material		調質鋼 / 預硬鋼 Prehardened Steels NAK80 : 1.2083 : AISI420 : M310 (HRC36~45)					
冷卻方式 Coolant Type		濕式切削 Wet coolant					
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
LRTD0810	50	65	2400~2800	600~800	0.2~0.25	5~8	溝銑 SLOTTING
LRTD0810	50	90	3500~4000	500~700	0.08~0.12	5~8	溝銑 SLOTTING
LRTD0810	50	35	1200~1600	250~350	8~16	0.2~0.25	側銑 SIDE MILLING
LRTD0810	50	50	1800~2200	400~600	8~16	0.08~0.12	側銑 SIDE MILLING
LRTD0810	50	115	4500~5200	800~1000	0.2~0.25	0.2~0.25	3D銑 3D MILLING
LRTD0810	50	150	5700~6300	800~1200	0.08~0.12	0.08~0.12	3D銑 3D MILLING
LRTD1002	60	65	2000~2400	600~800	0.25~0.3	9~10	溝銑 SLOTTING
LRTD1002	60	90	2800~3200	500~700	0.08~0.13	9~10	溝銑 SLOTTING
LRTD1002	60	35	1000~1300	200~300	10~20	0.2~0.25	側銑 SIDE MILLING
LRTD1002	60	40	1200~1600	400~600	10~20	0.08~0.13	側銑 SIDE MILLING
LRTD1002	60	115	3600~4000	800~1000	0.25~0.3	0.25~0.3	3D銑 3D MILLING
LRTD1002	60	150	4800~5200	800~1200	0.08~0.13	0.08~0.13	3D銑 3D MILLING
LRTD1003	60	65	2000~2400	600~800	0.25~0.3	8~10	溝銑 SLOTTING
LRTD1003	60	90	2800~3200	500~700	0.08~0.13	8~10	溝銑 SLOTTING
LRTD1003	60	35	1000~1300	200~300	10~20	0.2~0.25	側銑 SIDE MILLING
LRTD1003	60	40	1200~1600	400~600	10~20	0.08~0.13	側銑 SIDE MILLING
LRTD1003	60	115	3600~4000	800~1000	0.25~0.3	0.25~0.3	3D銑 3D MILLING
LRTD1003	60	150	4800~5200	800~1200	0.08~0.13	0.08~0.13	3D銑 3D MILLING
LRTD1005	60	65	2000~2400	600~800	0.25~0.3	8~10	溝銑 SLOTTING
LRTD1005	60	90	2800~3200	500~700	0.08~0.13	8~10	溝銑 SLOTTING
LRTD1005	60	35	1000~1300	200~300	10~20	0.2~0.25	側銑 SIDE MILLING
LRTD1005	60	40	1200~1600	400~600	10~20	0.08~0.13	側銑 SIDE MILLING
LRTD1005	60	115	3600~4000	800~1000	0.25~0.3	0.25~0.3	3D銑 3D MILLING
LRTD1005	60	150	4800~5200	800~1200	0.08~0.13	0.08~0.13	3D銑 3D MILLING
LRTD1010	60	65	2000~2400	600~800	0.25~0.3	7~10	溝銑 SLOTTING
LRTD1010	60	90	2800~3200	500~700	0.08~0.13	7~10	溝銑 SLOTTING
LRTD1010	60	35	1000~1300	200~300	10~20	0.2~0.25	側銑 SIDE MILLING
LRTD1010	60	40	1200~1600	400~600	10~20	0.08~0.13	側銑 SIDE MILLING
LRTD1010	60	115	3600~4000	800~1000	0.25~0.3	0.25~0.3	3D銑 3D MILLING
LRTD1010	60	150	4800~5200	800~1200	0.08~0.13	0.08~0.13	3D銑 3D MILLING
LRTD1020	60	65	2000~2400	600~800	0.25~0.3	5~10	溝銑 SLOTTING
LRTD1020	60	90	2800~3200	500~700	0.08~0.13	5~10	溝銑 SLOTTING
LRTD1020	60	35	1000~1300	200~300	10~20	0.2~0.25	側銑 SIDE MILLING
LRTD1020	60	40	1200~1600	400~600	10~20	0.08~0.13	側銑 SIDE MILLING
LRTD1020	60	115	3600~4000	800~1000	0.25~0.3	0.25~0.3	3D銑 3D MILLING
LRTD1020	60	150	4800~5200	800~1200	0.08~0.13	0.08~0.13	3D銑 3D MILLING
LRTD1205	60	70	1800~2200	800~1000	0.25~0.3	10~12	溝銑 SLOTTING
LRTD1205	60	95	2500~2800	600~800	0.1~0.15	10~12	溝銑 SLOTTING
LRTD1205	60	30	700~1000	200~300	12~24	0.15~0.25	側銑 SIDE MILLING
LRTD1205	60	45	1100~1400	300~450	12~24	0.1~0.15	側銑 SIDE MILLING
LRTD1205	60	150	4000~4500	800~1000	0.25~0.3	0.25~0.3	3D銑 3D MILLING
LRTD1205	60	150	4000~4500	1000~1400	0.1~0.15	0.1~0.15	3D銑 3D MILLING

被切削材 Work Material		調質鋼 / 預硬鋼 Prehardened Steels NAK80 : 1.2083 : AISI420 : M310 (HRc36~45)					
冷卻方式 Coolant Type		濕式切削 Wet coolant					
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
LRTD1210	60	70	1800~2200	800~1000	0.25~0.3	9~12	溝銑 SLOTTING
LRTD1210	60	95	2500~2800	600~800	0.1~0.15	9~12	溝銑 SLOTTING
LRTD1210	60	30	700~1000	200~300	12~24	0.15~0.25	側銑 SIDE MILLING
LRTD1210	60	45	1100~1400	300~450	12~24	0.1~0.15	側銑 SIDE MILLING
LRTD1210	60	150	4000~4500	800~1000	0.25~0.3	0.25~0.3	3D銑 3D MILLING
LRTD1210	60	150	4000~4500	1000~1400	0.1~0.15	0.1~0.15	3D銑 3D MILLING
LRTD1220	60	70	1800~2200	800~1000	0.25~0.3	7~12	溝銑 SLOTTING
LRTD1220	60	95	2500~2800	600~800	0.1~0.15	7~12	溝銑 SLOTTING
LRTD1220	60	30	700~1000	200~300	12~24	0.15~0.25	側銑 SIDE MILLING
LRTD1220	60	45	1100~1400	300~450	12~24	0.1~0.15	側銑 SIDE MILLING
LRTD1220	60	150	4000~4500	800~1000	0.25~0.3	0.25~0.3	3D銑 3D MILLING
LRTD1220	60	150	4000~4500	1000~1400	0.1~0.15	0.1~0.15	3D銑 3D MILLING
LRTD1610	100	70	1200~1600	600~900	0.3~0.35	13~16	溝銑 SLOTTING
LRTD1610	100	85	1500~1800	300~500	0.12~0.17	13~16	溝銑 SLOTTING
LRTD1610	100	30	500~800	200~350	16~32	0.3~0.35	側銑 SIDE MILLING
LRTD1610	100	45	800~1100	200~350	16~32	0.12~0.17	側銑 SIDE MILLING
LRTD1610	100	150	3000~3400	1200~1600	0.3~0.35	0.3~0.35	3D銑 3D MILLING
LRTD1610	100	150	3000~3400	700~1000	0.12~0.17	0.12~0.17	3D銑 3D MILLING
LRTD1620	100	70	1200~1600	600~900	0.3~0.35	11~16	溝銑 SLOTTING
LRTD1620	100	85	1500~1800	300~500	0.12~0.17	11~16	溝銑 SLOTTING
LRTD1620	100	30	500~800	200~350	16~32	0.3~0.35	側銑 SIDE MILLING
LRTD1620	100	45	800~1100	200~350	16~32	0.12~0.17	側銑 SIDE MILLING
LRTD1620	100	150	3000~3400	1200~1600	0.3~0.35	0.3~0.35	3D銑 3D MILLING
LRTD1620	100	150	3000~3400	700~1000	0.12~0.17	0.12~0.17	3D銑 3D MILLING

附註 / Note :

建議冷卻方式為濕式。

Suggest to use Wet coolant.

被切削材 Work Material		熱處理鋼 Hardened Steels SKD61/ STAVAX / 17-4PH : 1.2083 / 1.2344 / 1.4542 : H13 / 420 (HRc48~54)					
冷卻方式 Coolant Type		乾式切削 Dry coolant					
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
LRTD0405	40	60	4500~5000	600~800	0.05~0.07	2~4	溝銑 SLOTTING
LRTD0405	40	100	8000~9000	600~800	0.05~0.07	0.05~0.07	3D銑 3D MILLING
LRTD0410	40	60	4500~5000	600~800	0.05~0.07	2~4	溝銑 SLOTTING
LRTD0410	40	100	8000~9000	600~800	0.05~0.07	0.05~0.07	3D銑 3D MILLING
LRTD0602	40	85	4500~5000	600~800	0.06~0.08	5~6	溝銑 SLOTTING
LRTD0602	40	50	2700~3200	400~600	6~12	0.06~0.08	側銑 SIDE MILLING
LRTD0602	40	120	6200~6600	800~1000	0.06~0.08	0.06~0.08	3D銑 3D MILLING
LRTD0603	40	85	4500~5000	600~800	0.06~0.08	5~6	溝銑 SLOTTING
LRTD0603	40	50	2700~3200	400~600	6~12	0.06~0.08	側銑 SIDE MILLING
LRTD0603	40	120	6200~6600	800~1000	0.06~0.08	0.06~0.08	3D銑 3D MILLING
LRTD0605	40	85	4500~5000	600~800	0.06~0.08	4~6	溝銑 SLOTTING
LRTD0605	40	50	2700~3200	400~600	6~12	0.06~0.08	側銑 SIDE MILLING
LRTD0605	40	120	6200~6600	800~1000	0.06~0.08	0.06~0.08	3D銑 3D MILLING
LRTD0610	40	85	4500~5000	600~800	0.06~0.08	3~6	溝銑 SLOTTING
LRTD0610	40	50	2700~3200	400~600	6~12	0.06~0.08	側銑 SIDE MILLING
LRTD0610	40	120	6200~6600	800~1000	0.06~0.08	0.06~0.08	3D銑 3D MILLING
LRTD0803	50	90	3500~4000	450~650	0.08~0.12	7~8	溝銑 SLOTTING
LRTD0803	50	50	1800~2200	300~500	8~16	0.08~0.12	側銑 SIDE MILLING
LRTD0803	50	120	4600~5000	800~1100	0.08~0.12	0.08~0.12	3D銑 3D MILLING
LRTD0805	50	90	3500~4000	450~650	0.08~0.12	6~8	溝銑 SLOTTING
LRTD0805	50	50	1800~2200	300~500	8~16	0.08~0.12	側銑 SIDE MILLING
LRTD0805	50	120	4600~5000	800~1100	0.08~0.12	0.08~0.12	3D銑 3D MILLING
LRTD0810	50	90	3500~4000	450~650	0.08~0.12	5~8	溝銑 SLOTTING
LRTD0810	50	50	1800~2200	300~500	8~16	0.08~0.12	側銑 SIDE MILLING
LRTD0810	50	120	4600~5000	800~1100	0.08~0.12	0.08~0.12	3D銑 3D MILLING
LRTD1002	60	90	2800~3200	400~600	0.08~0.12	9~10	溝銑 SLOTTING
LRTD1002	60	60	1800~2200	400~600	10~20	0.08~0.12	側銑 SIDE MILLING
LRTD1002	60	125	4000~4500	800~1000	0.08~0.12	0.08~0.12	3D銑 3D MILLING
LRTD1003	60	90	2800~3200	400~600	0.08~0.12	8~10	溝銑 SLOTTING
LRTD1003	60	60	1800~2200	400~600	10~20	0.08~0.12	側銑 SIDE MILLING
LRTD1003	60	125	4000~4500	800~1000	0.08~0.12	0.08~0.12	3D銑 3D MILLING
LRTD1005	60	90	2800~3200	400~600	0.08~0.12	8~10	溝銑 SLOTTING
LRTD1005	60	60	1800~2200	400~600	10~20	0.08~0.12	側銑 SIDE MILLING
LRTD1005	60	125	4000~4500	800~1000	0.08~0.12	0.08~0.12	3D銑 3D MILLING
LRTD1010	60	90	2800~3200	400~600	0.08~0.12	7~10	溝銑 SLOTTING
LRTD1010	60	60	1800~2200	400~600	10~20	0.08~0.12	側銑 SIDE MILLING
LRTD1010	60	125	4000~4500	800~1000	0.08~0.12	0.08~0.12	3D銑 3D MILLING
LRTD1020	60	90	2800~3200	400~600	0.08~0.12	5~10	溝銑 SLOTTING
LRTD1020	60	60	1800~2200	400~600	10~20	0.08~0.12	側銑 SIDE MILLING
LRTD1020	60	125	4000~4500	800~1000	0.08~0.12	0.08~0.12	3D銑 3D MILLING
LRTD1205	60	75	2000~2400	400~600	0.1~0.15	10~12	溝銑 SLOTTING
LRTD1205	60	70	1800~2200	350~500	12~24	0.1~0.15	側銑 SIDE MILLING
LRTD1205	60	120	3200~3600	600~800	0.1~0.15	0.1~0.15	3D銑 3D MILLING

被切削材 Work Material		熱處理鋼 Hardened Steels SKD61/ STAVAX / 17-4PH : 1.2083 / 1.2344 / 1.4542 : H13 / 420 (HRc48~54)					
冷卻方式 Coolant Type		乾式切削 Dry coolant					
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
LRTD1210	60	75	2000~2400	400~600	0.1~0.15	9~12	溝銑 SLOTTING
LRTD1210	60	70	1800~2200	350~500	12~24	0.1~0.15	側銑 SIDE MILLING
LRTD1210	60	120	3200~3600	600~800	0.1~0.15	0.1~0.15	3D銑 3D MILLING
LRTD1210	60	75	2000~2400	400~600	0.1~0.15	7~12	溝銑 SLOTTING
LRTD1210	60	70	1800~2200	350~500	12~24	0.1~0.15	側銑 SIDE MILLING
LRTD1210	60	120	3200~3600	600~800	0.1~0.15	0.1~0.15	3D銑 3D MILLING
LRTD1610	100	75	1300~1700	300~500	0.12~0.17	13~16	溝銑 SLOTTING
LRTD1610	100	60	1000~1300	200~350	16~32	0.12~0.17	側銑 SIDE MILLING
LRTD1610	100	120	2200~2600	700~900	0.12~0.17	0.12~0.17	3D銑 3D MILLING
LRTD1620	100	75	1300~1700	300~500	0.12~0.17	11~16	溝銑 SLOTTING
LRTD1620	100	60	1000~1300	200~350	16~32	0.12~0.17	側銑 SIDE MILLING
LRTD1620	100	120	2200~2600	700~900	0.12~0.17	0.12~0.17	3D銑 3D MILLING

附註 / Note :

建議冷卻方式為乾式。

Suggest to use Dry coolant.