

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
RTA0205	12mm	60	9000~9500	800~1000	0.11~0.14	1~2	溝銑(Slotting)
RTA0205	12mm	60	9000~9500	800~1000	0.05~0.07	1~2	溝銑(Slotting)
RTA0205	12mm	60	9000~9500	1000~1200	2~4	0.12~0.15	側銑(Side milling)
RTA0205	12mm	60	9000~9500	700~900	2~4	0.05~0.07	側銑(Side milling)
RTA0205	12mm	60	9000~9500	1200~1400	0.12~0.15	0.12~0.15	3D銑(3D milling)
RTA0205	12mm	60	9000~9500	1100~1300	0.05~0.07	0.05~0.07	3D銑(3D milling)
RTA0305	12mm	85	8800~9300	800~1000	0.12~0.15	1~3	溝銑(Slotting)
RTA0305	12mm	85	8800~9300	800~1000	0.06~0.08	1~3	溝銑(Slotting)
RTA0305	12mm	85	8800~9300	1000~1200	3~6	0.12~0.15	側銑(Side milling)
RTA0305	12mm	85	8800~9300	800~1000	3~6	0.06~0.08	側銑(Side milling)
RTA0305	12mm	85	8800~9300	1000~1200	0.12~0.15	0.12~0.15	3D銑(3D milling)
RTA0305	12mm	85	8800~9300	1000~1200	0.06~0.08	0.06~0.08	3D銑(3D milling)
RTA0405	14mm	100	8000~8400	600~800	0.12~0.15	2~4	溝銑(Slotting)
RTA0405	14mm	100	8000~8400	800~1000	0.06~0.08	2~4	溝銑(Slotting)
RTA0405	14mm	85	6500~7000	800~1000	4~8	0.12~0.15	側銑(Side milling)
RTA0405	14mm	85	6500~7000	600~800	4~8	0.06~0.08	側銑(Side milling)
RTA0405	14mm	110	8700~9200	800~1000	0.12~0.15	0.12~0.15	3D銑(3D milling)
RTA0405	14mm	110	8700~9200	600~800	0.06~0.08	0.06~0.08	3D銑(3D milling)
RTA0410	14mm	100	8000~8400	700~900	0.12~0.15	1~4	溝銑(Slotting)
RTA0410	14mm	100	8000~8400	800~1000	0.06~0.08	1~4	溝銑(Slotting)
RTA0410	14mm	85	6500~7000	800~1000	4~8	0.12~0.15	側銑(Side milling)
RTA0410	14mm	85	6500~7000	600~800	4~8	0.06~0.08	側銑(Side milling)
RTA0410	14mm	110	8700~9200	900~1100	0.12~0.15	0.12~0.15	3D銑(3D milling)
RTA0410	14mm	110	8700~9200	1100~1400	0.06~0.08	0.06~0.08	3D銑(3D milling)
RTA0505	17mm	95	5800~6300	900~1100	0.15~0.18	3~5	溝銑(Slotting)
RTA0505	17mm	120	7300~7800	800~1200	0.06~0.08	3~5	溝銑(Slotting)
RTA0505	17mm	95	5800~6300	800~1000	5~10	0.15~0.18	側銑(Side milling)
RTA0505	17mm	95	5800~6300	600~800	5~10	0.06~0.08	側銑(Side milling)
RTA0505	17mm	135	8300~8800	1400~1800	0.15~0.18	0.15~0.18	3D銑(3D milling)
RTA0505	17mm	135	8300~8800	1300~1700	0.06~0.08	0.06~0.08	3D銑(3D milling)
RTA0510	17mm	95	5800~6300	900~1100	0.15~0.18	2~5	溝銑(Slotting)
RTA0510	17mm	120	7300~7800	800~1200	0.06~0.08	2~5	溝銑(Slotting)
RTA0510	17mm	95	5800~6300	800~1000	5~10	0.15~0.18	側銑(Side milling)
RTA0510	17mm	95	5800~6300	600~800	5~10	0.06~0.08	側銑(Side milling)
RTA0510	17mm	135	8300~8800	1400~1800	0.15~0.18	0.15~0.18	3D銑(3D milling)
RTA0510	17mm	135	8300~8800	1300~1700	0.06~0.08	0.06~0.08	3D銑(3D milling)
RTA0605	20mm	95	4800~5200	900~1100	0.15~0.18	4~6	溝銑(Slotting)
RTA0605	20mm	120	6200~6600	800~1200	0.06~0.08	4~6	溝銑(Slotting)
RTA0605	20mm	95	4800~5200	800~1000	6~12	0.15~0.18	側銑(Side milling)
RTA0605	20mm	95	4800~5200	600~800	6~12	0.06~0.08	側銑(Side milling)
RTA0605	20mm	135	7200~7600	1400~1800	0.15~0.18	0.15~0.18	3D銑(3D milling)
RTA0605	20mm	135	7200~7600	1300~1700	0.06~0.08	0.06~0.08	3D銑(3D milling)

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	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
RTA0610	20mm	80	4200~4600	900~1100	0.15~0.18	3~6	溝銑(Slotting)
RTA0610	20mm	130	6800~7200	800~1200	0.06~0.08	3~6	溝銑(Slotting)
RTA0610	20mm	95	5000~5500	800~1000	6~12	0.15~0.18	側銑(Side milling)
RTA0610	20mm	95	5000~5500	600~800	6~12	0.06~0.08	側銑(Side milling)
RTA0610	20mm	135	7200~7600	1400~1800	0.15~0.18	0.15~0.18	3D銑(3D milling)
RTA0610	20mm	135	7200~7600	1300~1700	0.06~0.08	0.06~0.08	3D銑(3D milling)
RTA0805	30mm	125	5000~5600	900~1100	0.18~0.23	6~8	溝銑(Slotting)
RTA0805	30mm	135	5200~5600	600~800	0.07~0.1	6~8	溝銑(Slotting)
RTA0805	30mm	90	3500~4000	700~1000	8~16	0.18~0.23	側銑(Side milling)
RTA0805	30mm	90	3500~4000	600~800	8~16	0.07~0.1	側銑(Side milling)
RTA0805	30mm	150	6000~6600	1600~2000	0.18~0.23	0.18~0.23	3D銑(3D milling)
RTA0805	30mm	190	7500~8000	1100~1500	0.07~0.1	0.07~0.1	3D銑(3D milling)
RTA0810	30mm	125	5000~5600	900~1100	0.18~0.23	5~8	溝銑(Slotting)
RTA0810	30mm	135	5200~5600	600~800	0.07~0.1	5~8	溝銑(Slotting)
RTA0810	30mm	90	3500~4000	600~1000	8~16	0.18~0.23	側銑(Side milling)
RTA0810	30mm	90	3500~4000	600~800	8~16	0.07~0.1	側銑(Side milling)
RTA0810	30mm	150	6000~6600	1600~2000	0.18~0.23	0.18~0.23	3D銑(3D milling)
RTA0810	30mm	190	7500~8000	1000~1400	0.07~0.1	0.07~0.1	3D銑(3D milling)
RTA1005	35mm	125	4000~4500	800~1200	0.2~0.25	8~10	溝銑(Slotting)
RTA1005	35mm	135	4200~4600	600~800	0.07~0.1	8~10	溝銑(Slotting)
RTA1005	35mm	90	2800~3200	600~900	10~20	0.2~0.25	側銑(Side milling)
RTA1005	35mm	90	2800~3200	600~800	10~20	0.07~0.1	側銑(Side milling)
RTA1005	35mm	150	4800~5400	1600~2000	0.2~0.25	0.2~0.25	3D銑(3D milling)
RTA1005	35mm	190	6000~6500	1200~1600	0.07~0.1	0.07~0.1	3D銑(3D milling)
RTA1010	35mm	125	4000~4500	800~1200	0.2~0.25	7~10	溝銑(Slotting)
RTA1010	35mm	135	4200~4600	600~800	0.07~0.1	7~10	溝銑(Slotting)
RTA1010	35mm	90	2800~3200	600~900	10~20	0.2~0.25	側銑(Side milling)
RTA1010	35mm	90	2800~3200	600~800	10~20	0.07~0.1	側銑(Side milling)
RTA1010	35mm	150	4800~5400	1600~2000	0.2~0.25	0.2~0.25	3D銑(3D milling)
RTA1010	35mm	190	6000~6500	1200~1600	0.07~0.1	0.07~0.1	3D銑(3D milling)
RTA1015	35mm	125	4000~4500	800~1200	0.2~0.25	6~10	溝銑(Slotting)
RTA1015	35mm	135	4200~4600	600~800	0.07~0.1	6~10	溝銑(Slotting)
RTA1015	35mm	90	2800~3200	600~900	10~20	0.2~0.25	側銑(Side milling)
RTA1015	35mm	90	2800~3200	600~800	10~20	0.07~0.1	側銑(Side milling)
RTA1015	35mm	150	4800~5400	1600~2000	0.2~0.25	0.2~0.25	3D銑(3D milling)
RTA1015	35mm	190	6000~6500	1200~1600	0.07~0.1	0.07~0.1	3D銑(3D milling)
RTA1020	35mm	125	4000~4500	800~1200	0.2~0.25	5~10	溝銑(Slotting)
RTA1020	35mm	135	4200~4600	600~800	0.07~0.1	5~10	溝銑(Slotting)
RTA1020	35mm	90	2800~3200	600~900	10~20	0.2~0.25	側銑(Side milling)
RTA1020	35mm	90	2800~3200	600~800	10~20	0.07~0.1	側銑(Side milling)
RTA1020	35mm	150	4800~5400	1600~2000	0.2~0.25	0.2~0.25	3D銑(3D milling)
RTA1020	35mm	190	6000~6500	1200~1600	0.07~0.1	0.07~0.1	3D銑(3D milling)

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	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
RTA1210	40mm	75	2000~2500	800~1100	0.2~0.25	9~12	溝銑(Slotting)
RTA1210	40mm	150	4000~4500	800~1000	0.07~0.12	9~12	溝銑(Slotting)
RTA1210	40mm	105	2800~3200	600~800	12~24	0.2~0.25	側銑(Side milling)
RTA1210	40mm	105	2800~3200	400~600	12~24	0.07~0.12	側銑(Side milling)
RTA1210	40mm	150	4000~4500	1400~1600	0.2~0.25	0.2~0.25	3D銑(3D milling)
RTA1210	40mm	170	4500~5000	1300~1600	0.07~0.12	0.07~0.12	3D銑(3D milling)
RTA1220	40mm	75	2000~2500	800~1100	0.2~0.25	7~12	溝銑(Slotting)
RTA1220	40mm	150	4000~4500	800~1000	0.07~0.12	7~12	溝銑(Slotting)
RTA1220	40mm	105	2800~3200	600~800	12~24	0.2~0.25	側銑(Side milling)
RTA1220	40mm	105	2800~3200	400~600	12~24	0.07~0.12	側銑(Side milling)
RTA1220	40mm	150	4000~4500	1400~1600	0.2~0.25	0.2~0.25	3D銑(3D milling)
RTA1220	40mm	170	4500~5000	1300~1600	0.07~0.12	0.07~0.12	3D銑(3D milling)

附註 / Note :

建議冷卻方式為濕式。

Suggest to use Wet coolant.

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	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
RTA0205	12mm	100	15500~16500	1200~1400	0.11~0.14	1~2	溝銑(Slotting)
RTA0205	12mm	100	15500~16500	900~1100	0.05~0.07	1~2	溝銑(Slotting)
RTA0205	12mm	85	13500~14000	1100~1300	2~4	0.12~0.15	側銑(Side milling)
RTA0205	12mm	85	13500~14000	800~1000	2~4	0.05~0.07	側銑(Side milling)
RTA0205	12mm	150	23000~24000	1800~2200	0.12~0.15	0.12~0.15	3D銑(3D milling)
RTA0205	12mm	150	23000~24000	1800~2200	0.05~0.07	0.05~0.07	3D銑(3D milling)
RTA0305	12mm	100	10500~11000	1000~1200	0.12~0.15	1~3	溝銑(Slotting)
RTA0305	12mm	100	10500~11000	900~1100	0.06~0.08	1~3	溝銑(Slotting)
RTA0305	12mm	85	8800~9300	900~1100	3~6	0.12~0.15	側銑(Side milling)
RTA0305	12mm	85	8800~9300	800~1000	3~6	0.06~0.08	側銑(Side milling)
RTA0305	12mm	165	17000~18000	1800~2200	0.12~0.15	0.12~0.15	3D銑(3D milling)
RTA0305	12mm	165	17000~18000	1800~2200	0.06~0.08	0.06~0.08	3D銑(3D milling)
RTA0405	14mm	100	8000~8400	700~900	0.12~0.15	2~4	溝銑(Slotting)
RTA0405	14mm	100	8000~8400	800~1000	0.06~0.08	2~4	溝銑(Slotting)
RTA0405	14mm	85	6500~7000	800~1000	4~8	0.12~0.15	側銑(Side milling)
RTA0405	14mm	85	6500~7000	600~800	4~8	0.06~0.08	側銑(Side milling)
RTA0405	14mm	150	12000~13000	1200~1600	0.12~0.15	0.12~0.15	3D銑(3D milling)
RTA0405	14mm	165	13000~14000	1600~2000	0.06~0.08	0.06~0.08	3D銑(3D milling)
RTA0410	14mm	100	8000~8400	700~900	0.12~0.15	1~4	溝銑(Slotting)
RTA0410	14mm	100	8000~8400	800~1000	0.06~0.08	1~4	溝銑(Slotting)
RTA0410	14mm	85	6500~7000	800~1000	4~8	0.12~0.15	側銑(Side milling)
RTA0410	14mm	85	6500~7000	600~800	4~8	0.06~0.08	側銑(Side milling)
RTA0410	14mm	150	12000~13000	1200~1600	0.12~0.15	0.12~0.15	3D銑(3D milling)
RTA0410	14mm	165	13000~14000	1600~2000	0.06~0.08	0.06~0.08	3D銑(3D milling)
RTA0505	17mm	95	5800~6300	900~1100	0.15~0.18	3~5	溝銑(Slotting)
RTA0505	17mm	120	7300~7800	800~1200	0.06~0.08	3~5	溝銑(Slotting)
RTA0505	17mm	95	5800~6300	800~1000	5~10	0.15~0.18	側銑(Side milling)
RTA0505	17mm	95	5800~6300	600~800	5~10	0.06~0.08	側銑(Side milling)
RTA0505	17mm	165	10500~11000	1700~2100	0.15~0.18	0.15~0.18	3D銑(3D milling)
RTA0505	17mm	165	10500~11000	1600~2000	0.06~0.08	0.06~0.08	3D銑(3D milling)
RTA0510	17mm	95	5800~6300	900~1100	0.15~0.18	2~5	溝銑(Slotting)
RTA0510	17mm	120	7300~7800	800~1200	0.06~0.08	2~5	溝銑(Slotting)
RTA0510	17mm	95	5800~6300	800~1000	5~10	0.15~0.18	側銑(Side milling)
RTA0510	17mm	95	5800~6300	600~800	5~10	0.06~0.08	側銑(Side milling)
RTA0510	17mm	165	10500~11000	1700~2100	0.15~0.18	0.15~0.18	3D銑(3D milling)
RTA0510	17mm	165	10500~11000	1600~2000	0.06~0.08	0.06~0.08	3D銑(3D milling)
RTA0605	20mm	95	4800~5200	900~1100	0.15~0.18	4~6	溝銑(Slotting)
RTA0605	20mm	120	6200~6600	800~1200	0.06~0.08	4~6	溝銑(Slotting)
RTA0605	20mm	95	4800~5200	800~1000	6~12	0.15~0.18	側銑(Side milling)
RTA0605	20mm	95	4800~5200	600~800	6~12	0.06~0.08	側銑(Side milling)
RTA0605	20mm	135	7200~7600	1400~1800	0.15~0.18	0.15~0.18	3D銑(3D milling)
RTA0605	20mm	135	7200~7600	1300~1700	0.06~0.08	0.06~0.08	3D銑(3D milling)

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	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
RTA0610	20mm	95	4800~5200	900~1100	0.15~0.18	3~6	溝銑(Slotting)
RTA0610	20mm	120	6200~6600	800~1200	0.06~0.08	3~6	溝銑(Slotting)
RTA0610	20mm	95	5000~5500	800~1000	6~12	0.15~0.18	側銑(Side milling)
RTA0610	20mm	95	5000~5500	600~800	6~12	0.06~0.08	側銑(Side milling)
RTA0610	20mm	135	7200~7600	1400~1800	0.15~0.18	0.15~0.18	3D銑(3D milling)
RTA0610	20mm	135	7200~7600	1300~1700	0.06~0.08	0.06~0.08	3D銑(3D milling)
RTA0805	30mm	125	5000~5600	900~1100	0.18~0.23	6~8	溝銑(Slotting)
RTA0805	30mm	135	5200~5600	600~800	0.07~0.1	6~8	溝銑(Slotting)
RTA0805	30mm	90	3500~4000	700~1000	8~16	0.18~0.23	側銑(Side milling)
RTA0805	30mm	90	3500~4000	600~800	8~16	0.07~0.1	側銑(Side milling)
RTA0805	30mm	150	6000~6600	1600~2000	0.18~0.23	0.18~0.23	3D銑(3D milling)
RTA0805	30mm	190	7500~8000	1100~1500	0.07~0.1	0.07~0.1	3D銑(3D milling)
RTA0810	30mm	125	5000~5600	900~1100	0.18~0.23	5~8	溝銑(Slotting)
RTA0810	30mm	135	5200~5600	600~800	0.07~0.1	5~8	溝銑(Slotting)
RTA0810	30mm	90	3500~4000	600~1000	8~16	0.18~0.23	側銑(Side milling)
RTA0810	30mm	90	3500~4000	600~800	8~16	0.07~0.1	側銑(Side milling)
RTA0810	30mm	150	6000~6600	1600~2000	0.18~0.23	0.18~0.23	3D銑(3D milling)
RTA0810	30mm	190	7500~8000	1100~1500	0.07~0.1	0.07~0.1	3D銑(3D milling)
RTA1005	35mm	125	4000~4500	800~1200	0.2~0.25	8~10	溝銑(Slotting)
RTA1005	35mm	135	4200~4600	600~800	0.07~0.1	8~10	溝銑(Slotting)
RTA1005	35mm	90	2800~3200	600~900	10~20	0.2~0.25	側銑(Side milling)
RTA1005	35mm	90	2800~3200	600~800	10~20	0.07~0.1	側銑(Side milling)
RTA1005	35mm	150	4800~5400	1600~2000	0.2~0.25	0.2~0.25	3D銑(3D milling)
RTA1005	35mm	190	6000~6500	1200~1600	0.07~0.1	0.07~0.1	3D銑(3D milling)
RTA1010	35mm	125	4000~4500	800~1200	0.2~0.25	7~10	溝銑(Slotting)
RTA1010	35mm	135	4200~4600	600~800	0.07~0.1	7~10	溝銑(Slotting)
RTA1010	35mm	90	2800~3200	600~900	10~20	0.2~0.25	側銑(Side milling)
RTA1010	35mm	90	2800~3200	600~800	10~20	0.07~0.1	側銑(Side milling)
RTA1010	35mm	150	4800~5400	1600~2000	0.2~0.25	0.2~0.25	3D銑(3D milling)
RTA1010	35mm	190	6000~6500	1200~1600	0.07~0.1	0.07~0.1	3D銑(3D milling)
RTA1015	35mm	125	4000~4500	800~1200	0.2~0.25	6~10	溝銑(Slotting)
RTA1015	35mm	135	4200~4600	600~800	0.07~0.1	6~10	溝銑(Slotting)
RTA1015	35mm	90	2800~3200	600~900	10~20	0.2~0.25	側銑(Side milling)
RTA1015	35mm	90	2800~3200	600~800	10~20	0.07~0.1	側銑(Side milling)
RTA1015	35mm	150	4800~5400	1600~2000	0.2~0.25	0.2~0.25	3D銑(3D milling)
RTA1015	35mm	190	6000~6500	1200~1600	0.07~0.1	0.07~0.1	3D銑(3D milling)
RTA1020	35mm	125	4000~4500	800~1200	0.2~0.25	5~10	溝銑(Slotting)
RTA1020	35mm	135	4200~4600	600~800	0.07~0.1	5~10	溝銑(Slotting)
RTA1020	35mm	90	2800~3200	600~900	10~20	0.2~0.25	側銑(Side milling)
RTA1020	35mm	90	2800~3200	600~800	10~20	0.07~0.1	側銑(Side milling)
RTA1020	35mm	150	4800~5400	1600~2000	0.2~0.25	0.2~0.25	3D銑(3D milling)
RTA1020	35mm	190	6000~6500	1200~1600	0.07~0.1	0.07~0.1	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)						
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
RTA1210	40mm	75	2000~2500	800~1100	0.2~0.25	9~12	溝銑(Slotting)
RTA1210	40mm	150	4000~4500	800~1000	0.07~0.12	9~12	溝銑(Slotting)
RTA1210	40mm	105	2800~3200	600~800	12~24	0.2~0.25	側銑(Side milling)
RTA1210	40mm	105	2800~3200	400~600	12~24	0.07~0.12	側銑(Side milling)
RTA1210	40mm	150	4000~4500	1400~1600	0.2~0.25	0.2~0.25	3D銑(3D milling)
RTA1210	40mm	170	4500~5000	1300~1600	0.07~0.12	0.07~0.12	3D銑(3D milling)
RTA1220	40mm	75	2000~2500	800~1100	0.2~0.25	7~12	溝銑(Slotting)
RTA1220	40mm	150	4000~4500	800~1000	0.07~0.12	7~12	溝銑(Slotting)
RTA1220	40mm	105	2800~3200	600~800	12~24	0.2~0.25	側銑(Side milling)
RTA1220	40mm	105	2800~3200	400~600	12~24	0.07~0.12	側銑(Side milling)
RTA1220	40mm	150	4000~4500	1400~1600	0.2~0.25	0.2~0.25	3D銑(3D milling)
RTA1220	40mm	170	4500~5000	1300~1600	0.07~0.12	0.07~0.12	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)						
	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
RTA0205	12mm	60	9000~9500	700~900	0.11~0.14	1~2	溝銑(Slotting)
RTA0205	12mm	60	9000~9500	700~900	0.05~0.07	1~2	溝銑(Slotting)
RTA0205	12mm	60	9000~9500	900~1100	2~4	0.12~0.15	側銑(Side milling)
RTA0205	12mm	60	9000~9500	700~900	2~4	0.05~0.07	側銑(Side milling)
RTA0205	12mm	60	9000~9500	1000~1200	0.12~0.15	0.12~0.15	3D銑(3D milling)
RTA0205	12mm	60	9000~9500	1000~1200	0.05~0.07	0.05~0.07	3D銑(3D milling)
RTA0305	12mm	85	8800~9300	600~800	0.12~0.15	1~3	溝銑(Slotting)
RTA0305	12mm	85	8800~9300	700~900	0.06~0.08	1~3	溝銑(Slotting)
RTA0305	12mm	85	8800~9300	800~1000	3~6	0.12~0.15	側銑(Side milling)
RTA0305	12mm	85	8800~9300	700~900	3~6	0.06~0.08	側銑(Side milling)
RTA0305	12mm	85	8800~9300	1000~1200	0.12~0.15	0.12~0.15	3D銑(3D milling)
RTA0305	12mm	85	8800~9300	1000~1200	0.06~0.08	0.06~0.08	3D銑(3D milling)
RTA0405	14mm	95	7800~8200	600~800	0.12~0.15	2~4	溝銑(Slotting)
RTA0405	14mm	100	8000~8400	600~900	0.06~0.08	2~4	溝銑(Slotting)
RTA0405	14mm	85	6500~7000	700~900	4~8	0.12~0.15	側銑(Side milling)
RTA0405	14mm	85	6500~7000	400~600	4~8	0.06~0.08	側銑(Side milling)
RTA0405	14mm	110	8700~9200	800~1100	0.12~0.15	0.12~0.15	3D銑(3D milling)
RTA0405	14mm	110	8700~9200	1000~1300	0.06~0.08	0.06~0.08	3D銑(3D milling)
RTA0410	14mm	95	7800~8200	600~800	0.12~0.15	1~4	溝銑(Slotting)
RTA0410	14mm	100	8000~8400	600~900	0.06~0.08	1~4	溝銑(Slotting)
RTA0410	14mm	85	6500~7000	700~900	4~8	0.12~0.15	側銑(Side milling)
RTA0410	14mm	85	6500~7000	400~600	4~8	0.06~0.08	側銑(Side milling)
RTA0410	14mm	110	8700~9200	800~1100	0.12~0.15	0.12~0.15	3D銑(3D milling)
RTA0410	14mm	110	8700~9200	1000~1300	0.06~0.08	0.06~0.08	3D銑(3D milling)
RTA0505	17mm	85	5200~5700	900~1100	0.15~0.18	3~5	溝銑(Slotting)
RTA0505	17mm	120	7300~7800	800~1200	0.06~0.08	3~5	溝銑(Slotting)
RTA0505	17mm	85	5200~5700	800~1000	5~10	0.15~0.18	側銑(Side milling)
RTA0505	17mm	95	5800~6300	600~800	5~10	0.06~0.08	側銑(Side milling)
RTA0505	17mm	135	8300~8800	1300~1700	0.15~0.18	0.15~0.18	3D銑(3D milling)
RTA0505	17mm	135	8300~8800	1200~1600	0.06~0.08	0.06~0.08	3D銑(3D milling)
RTA0510	17mm	85	5200~5700	900~1100	0.15~0.18	2~5	溝銑(Slotting)
RTA0510	17mm	120	7300~7800	800~1200	0.06~0.08	2~5	溝銑(Slotting)
RTA0510	17mm	85	5200~5700	800~1000	5~10	0.15~0.18	側銑(Side milling)
RTA0510	17mm	95	5800~6300	600~800	5~10	0.06~0.08	側銑(Side milling)
RTA0510	17mm	135	8300~8800	1300~1700	0.15~0.18	0.15~0.18	3D銑(3D milling)
RTA0510	17mm	135	8300~8800	1200~1600	0.06~0.08	0.06~0.08	3D銑(3D milling)
RTA0605	20mm	85	4200~4700	800~1000	0.15~0.18	4~6	溝銑(Slotting)
RTA0605	20mm	115	5700~6200	800~1200	0.06~0.08	4~6	溝銑(Slotting)
RTA0605	20mm	85	4200~4600	700~900	6~12	0.15~0.18	側銑(Side milling)
RTA0605	20mm	90	4400~4800	500~700	6~12	0.06~0.08	側銑(Side milling)
RTA0605	20mm	135	7200~7600	1200~1600	0.15~0.18	0.15~0.18	3D銑(3D milling)
RTA0605	20mm	135	7200~7600	1200~1600	0.06~0.08	0.06~0.08	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)						
	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
RTA0610	20mm	85	4200~4700	800~1000	0.15~0.18	3~6	溝銑(Slotting)
RTA0610	20mm	115	5700~6200	800~1200	0.06~0.08	3~6	溝銑(Slotting)
RTA0610	20mm	85	4200~4600	700~900	6~12	0.15~0.18	側銑(Side milling)
RTA0610	20mm	90	4400~4800	500~700	6~12	0.06~0.08	側銑(Side milling)
RTA0610	20mm	135	7200~7600	1200~1600	0.15~0.18	0.15~0.18	3D銑(3D milling)
RTA0610	20mm	135	7200~7600	1200~1600	0.06~0.08	0.06~0.08	3D銑(3D milling)
RTA0805	30mm	100	3800~4300	800~1000	0.18~0.23	6~8	溝銑(Slotting)
RTA0805	30mm	135	5200~5600	600~800	0.07~0.1	6~8	溝銑(Slotting)
RTA0805	30mm	80	3000~3500	600~900	8~16	0.18~0.23	側銑(Side milling)
RTA0805	30mm	90	3400~3800	600~800	8~16	0.07~0.1	側銑(Side milling)
RTA0805	30mm	105	4000~4500	1600~1800	0.18~0.23	0.18~0.23	3D銑(3D milling)
RTA0805	30mm	185	7200~7700	1000~1400	0.07~0.1	0.07~0.1	3D銑(3D milling)
RTA0810	30mm	100	3800~4300	800~1000	0.18~0.23	5~8	溝銑(Slotting)
RTA0810	30mm	135	5200~5600	600~800	0.07~0.1	5~8	溝銑(Slotting)
RTA0810	30mm	80	3000~3500	600~900	8~16	0.18~0.23	側銑(Side milling)
RTA0810	30mm	90	3400~3800	600~800	8~16	0.07~0.1	側銑(Side milling)
RTA0810	30mm	105	4000~4500	1600~1800	0.18~0.23	0.18~0.23	3D銑(3D milling)
RTA0810	30mm	185	7200~7700	1000~1400	0.07~0.1	0.07~0.1	3D銑(3D milling)
RTA1005	35mm	100	3000~3400	700~1000	0.2~0.25	8~10	溝銑(Slotting)
RTA1005	35mm	135	4200~4600	600~800	0.07~0.1	8~10	溝銑(Slotting)
RTA1005	35mm	80	2400~2800	500~700	10~20	0.15~0.2	側銑(Side milling)
RTA1005	35mm	90	2800~3200	450~650	10~20	0.07~0.1	側銑(Side milling)
RTA1005	35mm	105	3200~3600	1200~1600	0.2~0.25	0.2~0.25	3D銑(3D milling)
RTA1005	35mm	185	5800~6200	1000~1400	0.07~0.1	0.07~0.1	3D銑(3D milling)
RTA1010	35mm	100	3000~3400	700~1000	0.2~0.25	7~10	溝銑(Slotting)
RTA1010	35mm	135	4200~4600	600~800	0.07~0.1	7~10	溝銑(Slotting)
RTA1010	35mm	80	2400~2800	500~700	10~20	0.15~0.2	側銑(Side milling)
RTA1010	35mm	90	2800~3200	450~650	10~20	0.07~0.1	側銑(Side milling)
RTA1010	35mm	105	3200~3600	1200~1600	0.2~0.25	0.2~0.25	3D銑(3D milling)
RTA1010	35mm	185	5800~6200	1000~1400	0.07~0.1	0.07~0.1	3D銑(3D milling)
RTA1015	35mm	100	3000~3400	700~1000	0.2~0.25	6~10	溝銑(Slotting)
RTA1015	35mm	135	4200~4600	600~800	0.07~0.1	6~10	溝銑(Slotting)
RTA1015	35mm	80	2400~2800	500~700	10~20	0.15~0.2	側銑(Side milling)
RTA1015	35mm	90	2800~3200	450~650	10~20	0.07~0.1	側銑(Side milling)
RTA1015	35mm	105	3200~3600	1200~1600	0.2~0.25	0.2~0.25	3D銑(3D milling)
RTA1015	35mm	185	5800~6200	1000~1400	0.07~0.1	0.07~0.1	3D銑(3D milling)
RTA1020	35mm	100	3000~3400	700~1000	0.2~0.25	5~10	溝銑(Slotting)
RTA1020	35mm	135	4200~4600	600~800	0.07~0.1	5~10	溝銑(Slotting)
RTA1020	35mm	80	2400~2800	500~700	10~20	0.15~0.2	側銑(Side milling)
RTA1020	35mm	90	2800~3200	450~650	10~20	0.07~0.1	側銑(Side milling)
RTA1020	35mm	105	3200~3600	1200~1600	0.2~0.25	0.2~0.25	3D銑(3D milling)
RTA1020	35mm	185	5800~6200	1000~1400	0.07~0.1	0.07~0.1	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)						
	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
RTA1210	40mm	75	2000~2400	600~900	0.2~0.25	9~12	溝銑(Slotting)
RTA1210	40mm	145	3800~4200	800~1000	0.07~0.12	9~12	溝銑(Slotting)
RTA1210	40mm	70	1800~2200	600~800	12~24	0.15~0.2	側銑(Side milling)
RTA1210	40mm	70	1800~2200	300~500	12~24	0.07~0.12	側銑(Side milling)
RTA1210	40mm	140	3600~4000	1000~1200	0.2~0.25	0.2~0.25	3D銑(3D milling)
RTA1210	40mm	150	4500~5000	1200~1500	0.07~0.12	0.07~0.12	3D銑(3D milling)
RTA1220	40mm	75	2000~2400	600~900	0.2~0.25	7~12	溝銑(Slotting)
RTA1220	40mm	145	3800~4200	800~1000	0.07~0.12	7~12	溝銑(Slotting)
RTA1220	40mm	70	1800~2200	600~800	12~24	0.15~0.2	側銑(Side milling)
RTA1220	40mm	70	1800~2200	300~500	12~24	0.07~0.12	側銑(Side milling)
RTA1220	40mm	140	3600~4000	1000~1200	0.2~0.25	0.2~0.25	3D銑(3D milling)
RTA1220	40mm	150	4500~5000	1200~1500	0.07~0.12	0.07~0.12	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)						
	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
RTA0205	12mm	90	14000~15000	1000~1200	0.11~0.14	1~2	溝銑(Slotting)
RTA0205	12mm	90	14000~15000	900~1100	0.05~0.07	1~2	溝銑(Slotting)
RTA0205	12mm	85	13500~14000	1100~1300	2~4	0.12~0.15	側銑(Side milling)
RTA0205	12mm	85	13500~14000	800~1000	2~4	0.05~0.07	側銑(Side milling)
RTA0205	12mm	140	22000~23000	1600~2000	0.12~0.15	0.12~0.15	3D銑(3D milling)
RTA0205	12mm	140	22000~23000	1600~2000	0.05~0.07	0.05~0.07	3D銑(3D milling)
RTA0305	12mm	100	10500~11000	1000~1200	0.12~0.15	1~3	溝銑(Slotting)
RTA0305	12mm	100	10500~11000	900~1100	0.06~0.08	1~3	溝銑(Slotting)
RTA0305	12mm	85	8800~9300	900~1100	3~6	0.12~0.15	側銑(Side milling)
RTA0305	12mm	85	8800~9300	800~1000	3~6	0.06~0.08	側銑(Side milling)
RTA0305	12mm	145	15000~16000	1700~2000	0.12~0.15	0.12~0.15	3D銑(3D milling)
RTA0305	12mm	155	16000~17000	1600~2000	0.06~0.08	0.06~0.08	3D銑(3D milling)
RTA0405	14mm	95	7800~8200	600~800	0.12~0.15	2~4	溝銑(Slotting)
RTA0405	14mm	100	8000~8400	600~900	0.06~0.08	2~4	溝銑(Slotting)
RTA0405	14mm	85	6500~7000	600~800	4~8	0.12~0.15	側銑(Side milling)
RTA0405	14mm	85	6500~7000	400~600	4~8	0.06~0.08	側銑(Side milling)
RTA0405	14mm	145	11000~12000	1200~1400	0.12~0.15	0.12~0.15	3D銑(3D milling)
RTA0405	14mm	155	12000~13000	1300~1700	0.06~0.08	0.06~0.08	3D銑(3D milling)
RTA0410	14mm	95	7800~8200	600~800	0.12~0.15	1~4	溝銑(Slotting)
RTA0410	14mm	100	8000~8400	600~900	0.06~0.08	1~4	溝銑(Slotting)
RTA0410	14mm	85	6500~7000	600~800	4~8	0.12~0.15	側銑(Side milling)
RTA0410	14mm	85	6500~7000	400~600	4~8	0.06~0.08	側銑(Side milling)
RTA0410	14mm	145	11000~12000	1200~1400	0.12~0.15	0.12~0.15	3D銑(3D milling)
RTA0410	14mm	155	12000~13000	1300~1700	0.06~0.08	0.06~0.08	3D銑(3D milling)
RTA0505	17mm	85	5200~5700	900~1100	0.15~0.18	3~5	溝銑(Slotting)
RTA0505	17mm	120	7300~7800	800~1200	0.06~0.08	3~5	溝銑(Slotting)
RTA0505	17mm	85	5200~5700	800~1000	5~10	0.15~0.18	側銑(Side milling)
RTA0505	17mm	95	5800~6300	600~800	5~10	0.06~0.08	側銑(Side milling)
RTA0505	17mm	160	10000~10500	1600~1900	0.15~0.18	0.15~0.18	3D銑(3D milling)
RTA0505	17mm	160	10000~10500	1500~1800	0.06~0.08	0.06~0.08	3D銑(3D milling)
RTA0510	17mm	85	5200~5700	900~1100	0.15~0.18	2~5	溝銑(Slotting)
RTA0510	17mm	120	7300~7800	800~1200	0.06~0.08	2~5	溝銑(Slotting)
RTA0510	17mm	85	5200~5700	800~1000	5~10	0.15~0.18	側銑(Side milling)
RTA0510	17mm	95	5800~6300	600~800	5~10	0.06~0.08	側銑(Side milling)
RTA0510	17mm	160	10000~10500	1600~1900	0.15~0.18	0.15~0.18	3D銑(3D milling)
RTA0510	17mm	160	10000~10500	1500~1800	0.06~0.08	0.06~0.08	3D銑(3D milling)
RTA0605	20mm	85	4200~4700	800~1000	0.15~0.18	4~6	溝銑(Slotting)
RTA0605	20mm	115	5700~6200	800~1200	0.06~0.08	4~6	溝銑(Slotting)
RTA0605	20mm	85	4200~4600	700~900	6~12	0.15~0.18	側銑(Side milling)
RTA0605	20mm	90	4400~4800	500~700	6~12	0.06~0.08	側銑(Side milling)
RTA0605	20mm	135	7200~7600	1200~1600	0.15~0.18	0.15~0.18	3D銑(3D milling)
RTA0605	20mm	135	7200~7600	1200~1600	0.06~0.08	0.06~0.08	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)						
	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
RTA0610	20mm	85	4200~4700	800~1000	0.15~0.18	3~6	溝銑(Slotting)
RTA0610	20mm	115	5700~6200	800~1200	0.06~0.08	3~6	溝銑(Slotting)
RTA0610	20mm	85	4200~4600	700~900	6~12	0.15~0.18	側銑(Side milling)
RTA0610	20mm	90	4400~4800	500~700	6~12	0.06~0.08	側銑(Side milling)
RTA0610	20mm	135	7200~7600	1200~1600	0.15~0.18	0.15~0.18	3D銑(3D milling)
RTA0610	20mm	135	7200~7600	1200~1600	0.06~0.08	0.06~0.08	3D銑(3D milling)
RTA0805	30mm	100	3800~4300	800~1000	0.18~0.23	6~8	溝銑(Slotting)
RTA0805	30mm	135	5200~5600	600~800	0.07~0.1	6~8	溝銑(Slotting)
RTA0805	30mm	80	3000~3500	600~900	8~16	0.18~0.23	側銑(Side milling)
RTA0805	30mm	90	3400~3800	600~800	8~16	0.07~0.1	側銑(Side milling)
RTA0805	30mm	105	4000~4500	1600~1800	0.18~0.23	0.18~0.23	3D銑(3D milling)
RTA0805	30mm	185	7200~7700	1000~1400	0.07~0.1	0.07~0.1	3D銑(3D milling)
RTA0810	30mm	100	3800~4300	800~1000	0.18~0.23	5~8	溝銑(Slotting)
RTA0810	30mm	135	5200~5600	600~800	0.07~0.1	5~8	溝銑(Slotting)
RTA0810	30mm	80	3000~3500	600~900	8~16	0.18~0.23	側銑(Side milling)
RTA0810	30mm	90	3400~3800	600~800	8~16	0.07~0.1	側銑(Side milling)
RTA0810	30mm	105	4000~4500	1600~1800	0.18~0.23	0.18~0.23	3D銑(3D milling)
RTA0810	30mm	185	7200~7700	1000~1400	0.07~0.1	0.07~0.1	3D銑(3D milling)
RTA1005	35mm	100	3000~3400	700~1000	0.2~0.25	8~10	溝銑(Slotting)
RTA1005	35mm	135	4200~4600	600~800	0.07~0.1	8~10	溝銑(Slotting)
RTA1005	35mm	80	2400~2800	500~700	10~20	0.15~0.2	側銑(Side milling)
RTA1005	35mm	90	2800~3200	450~650	10~20	0.07~0.1	側銑(Side milling)
RTA1005	35mm	105	3200~3600	1200~1600	0.2~0.25	0.2~0.25	3D銑(3D milling)
RTA1005	35mm	185	5800~6200	1000~1400	0.07~0.1	0.07~0.1	3D銑(3D milling)
RTA1010	35mm	100	3000~3400	700~1000	0.2~0.25	7~10	溝銑(Slotting)
RTA1010	35mm	135	4200~4600	600~800	0.07~0.1	7~10	溝銑(Slotting)
RTA1010	35mm	80	2400~2800	500~700	10~20	0.15~0.2	側銑(Side milling)
RTA1010	35mm	90	2800~3200	450~650	10~20	0.07~0.1	側銑(Side milling)
RTA1010	35mm	105	3200~3600	1200~1600	0.2~0.25	0.2~0.25	3D銑(3D milling)
RTA1010	35mm	185	5800~6200	1000~1400	0.07~0.1	0.07~0.1	3D銑(3D milling)
RTA1015	35mm	100	3000~3400	700~1000	0.2~0.25	6~10	溝銑(Slotting)
RTA1015	35mm	135	4200~4600	600~800	0.07~0.1	6~10	溝銑(Slotting)
RTA1015	35mm	80	2400~2800	500~700	10~20	0.15~0.2	側銑(Side milling)
RTA1015	35mm	90	2800~3200	450~650	10~20	0.07~0.1	側銑(Side milling)
RTA1015	35mm	105	3200~3600	1200~1600	0.2~0.25	0.2~0.25	3D銑(3D milling)
RTA1015	35mm	185	5800~6200	1000~1400	0.07~0.1	0.07~0.1	3D銑(3D milling)
RTA1020	35mm	100	3000~3400	700~1000	0.2~0.25	5~10	溝銑(Slotting)
RTA1020	35mm	135	4200~4600	600~800	0.07~0.1	5~10	溝銑(Slotting)
RTA1020	35mm	80	2400~2800	500~700	10~20	0.15~0.2	側銑(Side milling)
RTA1020	35mm	90	2800~3200	450~650	10~20	0.07~0.1	側銑(Side milling)
RTA1020	35mm	105	3200~3600	1200~1600	0.2~0.25	0.2~0.25	3D銑(3D milling)
RTA1020	35mm	185	5800~6200	1000~1400	0.07~0.1	0.07~0.1	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)						
	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
RTA1210	40mm	75	2000~2400	600~900	0.2~0.25	9~12	溝銑(Slotting)
RTA1210	40mm	145	3800~4200	800~1000	0.07~0.12	9~12	溝銑(Slotting)
RTA1210	40mm	70	1800~2200	600~800	12~24	0.15~0.2	側銑(Side milling)
RTA1210	40mm	70	1800~2200	300~500	12~24	0.07~0.12	側銑(Side milling)
RTA1210	40mm	140	3600~4000	1000~1200	0.2~0.25	0.2~0.25	3D銑(3D milling)
RTA1210	40mm	150	4500~5000	1200~1500	0.07~0.12	0.07~0.12	3D銑(3D milling)
RTA1220	40mm	75	2000~2400	600~900	0.2~0.25	7~12	溝銑(Slotting)
RTA1220	40mm	145	3800~4200	800~1000	0.07~0.12	7~12	溝銑(Slotting)
RTA1220	40mm	70	1800~2200	600~800	12~24	0.15~0.2	側銑(Side milling)
RTA1220	40mm	70	1800~2200	300~500	12~24	0.07~0.12	側銑(Side milling)
RTA1220	40mm	140	3600~4000	1000~1200	0.2~0.25	0.2~0.25	3D銑(3D milling)
RTA1220	40mm	150	4500~5000	1200~1500	0.07~0.12	0.07~0.12	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)						
	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
RTA0205	12mm	60	9000~9500	600~800	0.03~0.05	1~2	溝銑(Slotting)
RTA0205	12mm	60	9000~9500	300~500	2~4	0.03~0.05	側銑(Side milling)
RTA0205	12mm	60	9000~9500	600~800	0.03~0.05	0.03~0.05	3D銑(3D milling)
RTA0305	12mm	85	8800~9300	600~800	0.04~0.06	1~3	溝銑(Slotting)
RTA0305	12mm	75	8000~8500	300~500	3~6	0.04~0.06	側銑(Side milling)
RTA0305	12mm	85	8800~9300	600~800	0.04~0.06	0.04~0.06	3D銑(3D milling)
RTA0405	14mm	90	7200~7600	600~800	0.04~0.06	2~4	溝銑(Slotting)
RTA0405	14mm	75	6000~6400	300~500	4~8	0.04~0.06	側銑(Side milling)
RTA0405	14mm	110	8700~9200	600~800	0.04~0.06	0.04~0.06	3D銑(3D milling)
RTA0410	14mm	90	7200~7600	600~800	0.04~0.06	1~4	溝銑(Slotting)
RTA0410	14mm	75	6000~6400	300~500	4~8	0.04~0.06	側銑(Side milling)
RTA0410	14mm	110	8700~9200	600~800	0.04~0.06	0.04~0.06	3D銑(3D milling)
RTA0505	17mm	95	6000~6600	800~1000	0.05~0.07	3~5	溝銑(Slotting)
RTA0505	17mm	75	4800~5200	400~600	5~10	0.05~0.07	側銑(Side milling)
RTA0505	17mm	135	8600~9000	800~1000	0.05~0.07	0.05~0.07	3D銑(3D milling)
RTA0510	17mm	95	6000~6600	800~1000	0.05~0.07	2~5	溝銑(Slotting)
RTA0510	17mm	75	4800~5200	400~600	5~10	0.05~0.07	側銑(Side milling)
RTA0510	17mm	135	8600~9000	800~1000	0.05~0.07	0.05~0.07	3D銑(3D milling)
RTA0605	20mm	95	5000~5500	800~1000	0.05~0.07	4.5	溝銑(Slotting)
RTA0605	20mm	75	4000~4400	400~600	6~12	0.05~0.07	側銑(Side milling)
RTA0605	20mm	135	7200~7600	1000~1200	0.05~0.07	0.05~0.07	3D銑(3D milling)
RTA0610	20mm	95	5000~5500	800~1000	0.05~0.07	3~6	溝銑(Slotting)
RTA0610	20mm	75	4000~4400	400~600	6~12	0.05~0.07	側銑(Side milling)
RTA0610	20mm	135	7200~7600	1000~1200	0.05~0.07	0.05~0.07	3D銑(3D milling)
RTA0805	30mm	135	5200~5700	600~800	0.06~0.08	6~8	溝銑(Slotting)
RTA0805	30mm	85	3200~3700	400~600	8~16	0.06~0.08	側銑(Side milling)
RTA0805	30mm	150	6000~6500	800~1000	0.06~0.08	0.06~0.08	3D銑(3D milling)
RTA0810	30mm	135	5200~5700	600~800	0.06~0.08	5~8	溝銑(Slotting)
RTA0810	30mm	85	3200~3700	400~600	8~16	0.06~0.08	側銑(Side milling)
RTA0810	30mm	150	6000~6500	800~1000	0.06~0.08	0.06~0.08	3D銑(3D milling)
RTA1005	35mm	135	4200~4600	600~800	0.07~0.1	8.5	溝銑(Slotting)
RTA1005	35mm	85	2600~3000	400~600	10~20	0.07~0.1	側銑(Side milling)
RTA1005	35mm	150	4800~5200	800~1000	0.07~0.1	0.07~0.1	3D銑(3D milling)
RTA1010	35mm	135	4200~4600	600~800	0.07~0.1	7~10	溝銑(Slotting)
RTA1010	35mm	85	2600~3000	400~600	10~20	0.07~0.1	側銑(Side milling)
RTA1010	35mm	150	4800~5200	800~1000	0.07~0.1	0.07~0.1	3D銑(3D milling)
RTA1015	35mm	135	4200~4600	600~800	0.07~0.1	6~10	溝銑(Slotting)
RTA1015	35mm	85	2600~3000	400~600	10~20	0.07~0.1	側銑(Side milling)
RTA1015	35mm	150	4800~5200	800~1000	0.07~0.1	0.07~0.1	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)					
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
RTA1020	35mm	135	4200~4600	600~800	0.07~0.1	5~10	溝銑(Slotting)
RTA1020	35mm	85	2600~3000	400~600	10~20	0.07~0.1	側銑(Side milling)
RTA1020	35mm	150	4800~5200	800~1000	0.07~0.1	0.07~0.1	3D銑(3D milling)
RTA1210	40mm	100	2600~3000	600~800	0.07~0.12	9~12	溝銑(Slotting)
RTA1210	40mm	60	1600~2000	300~400	12~24	0.07~0.12	側銑(Side milling)
RTA1210	40mm	130	3400~3800	600~800	0.07~0.12	0.07~0.12	3D銑(3D milling)
RTA1220	40mm	100	2600~3000	600~800	0.07~0.12	7~12	溝銑(Slotting)
RTA1220	40mm	60	1600~2000	300~400	12~24	0.07~0.12	側銑(Side milling)
RTA1220	40mm	130	3400~3800	600~800	0.07~0.12	0.07~0.12	3D銑(3D milling)

附註 / Note :

建議冷卻方式為乾式。

Suggest to use Dry 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)						
	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
RTA0205	12mm	60	9000~9500	600~800	0.03~0.05	1~2	溝銑(Slotting)
RTA0205	12mm	60	9000~9500	300~500	2~4	0.03~0.05	側銑(Side milling)
RTA0205	12mm	140	22000~23000	1400~1600	0.03~0.05	0.03~0.05	3D銑(3D milling)
RTA0305	12mm	85	8800~9300	600~800	0.04~0.06	1~3	溝銑(Slotting)
RTA0305	12mm	75	8000~8500	300~500	3~6	0.04~0.06	側銑(Side milling)
RTA0305	12mm	145	15000~16000	1400~1600	0.04~0.06	0.04~0.06	3D銑(3D milling)
RTA0405	14mm	90	7200~7600	600~800	0.04~0.06	2~4	溝銑(Slotting)
RTA0405	14mm	75	6000~6400	300~500	4~8	0.04~0.06	側銑(Side milling)
RTA0405	14mm	140	11000~12000	1000~1200	0.04~0.06	0.04~0.06	3D銑(3D milling)
RTA0410	14mm	90	7200~7600	600~800	0.04~0.06	1~4	溝銑(Slotting)
RTA0410	14mm	75	6000~6400	300~500	4~8	0.04~0.06	側銑(Side milling)
RTA0410	14mm	140	11000~12000	1000~1200	0.04~0.06	0.04~0.06	3D銑(3D milling)
RTA0505	17mm	95	6000~6600	800~1000	0.05~0.07	3~5	溝銑(Slotting)
RTA0505	17mm	75	4800~5200	400~600	5~10	0.05~0.07	側銑(Side milling)
RTA0505	17mm	145	9000~10000	1200~1400	0.05~0.07	0.05~0.07	3D銑(3D milling)
RTA0510	17mm	95	6000~6600	800~1000	0.05~0.07	2~5	溝銑(Slotting)
RTA0510	17mm	75	4800~5200	400~600	5~10	0.05~0.07	側銑(Side milling)
RTA0510	17mm	145	9000~10000	1200~1400	0.05~0.07	0.05~0.07	3D銑(3D milling)
RTA0605	20mm	95	5000~5500	800~1000	0.05~0.07	4.5	溝銑(Slotting)
RTA0605	20mm	75	4000~4400	400~600	6~12	0.05~0.07	側銑(Side milling)
RTA0605	20mm	135	7200~7600	1000~1200	0.05~0.07	0.05~0.07	3D銑(3D milling)
RTA0610	20mm	95	5000~5500	800~1000	0.05~0.07	3~6	溝銑(Slotting)
RTA0610	20mm	75	4000~4400	400~600	6~12	0.05~0.07	側銑(Side milling)
RTA0610	20mm	135	7200~7600	1000~1200	0.05~0.07	0.05~0.07	3D銑(3D milling)
RTA0805	30mm	135	5200~5700	600~800	0.06~0.08	6~8	溝銑(Slotting)
RTA0805	30mm	85	3200~3700	400~600	8~16	0.06~0.08	側銑(Side milling)
RTA0805	30mm	150	6000~6500	800~1000	0.06~0.08	0.06~0.08	3D銑(3D milling)
RTA0810	30mm	135	5200~5700	600~800	0.06~0.08	5~8	溝銑(Slotting)
RTA0810	30mm	85	3200~3700	400~600	8~16	0.06~0.08	側銑(Side milling)
RTA0810	30mm	150	6000~6500	800~1000	0.06~0.08	0.06~0.08	3D銑(3D milling)
RTA1005	35mm	135	4200~4600	600~800	0.07~0.1	8.5	溝銑(Slotting)
RTA1005	35mm	85	2600~3000	400~600	10~20	0.07~0.1	側銑(Side milling)
RTA1005	35mm	150	4800~5200	800~1000	0.07~0.1	0.07~0.1	3D銑(3D milling)
RTA1010	35mm	135	4200~4600	600~800	0.07~0.1	7~10	溝銑(Slotting)
RTA1010	35mm	85	2600~3000	400~600	10~20	0.07~0.1	側銑(Side milling)
RTA1010	35mm	150	4800~5200	800~1000	0.07~0.1	0.07~0.1	3D銑(3D milling)
RTA1015	35mm	135	4200~4600	600~800	0.07~0.1	6~10	溝銑(Slotting)
RTA1015	35mm	85	2600~3000	400~600	10~20	0.07~0.1	側銑(Side milling)
RTA1015	35mm	150	4800~5200	800~1000	0.07~0.1	0.07~0.1	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)					
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
RTA1020	35mm	135	4200~4600	600~800	0.07~0.1	5~10	溝銑(Slotting)
RTA1020	35mm	85	2600~3000	400~600	10~20	0.07~0.1	側銑(Side milling)
RTA1020	35mm	150	4800~5200	800~1000	0.07~0.1	0.07~0.1	3D銑(3D milling)
RTA1210	40mm	100	2600~3000	600~800	0.07~0.12	9~12	溝銑(Slotting)
RTA1210	40mm	60	1600~2000	300~400	12~24	0.07~0.12	側銑(Side milling)
RTA1210	40mm	130	3400~3800	600~800	0.07~0.12	0.07~0.12	3D銑(3D milling)
RTA1220	40mm	100	2600~3000	600~800	0.07~0.12	7~12	溝銑(Slotting)
RTA1220	40mm	60	1600~2000	300~400	12~24	0.07~0.12	側銑(Side milling)
RTA1220	40mm	130	3400~3800	600~800	0.07~0.12	0.07~0.12	3D銑(3D milling)

附註 / Note :

建議冷卻方式為乾式。

Suggest to use Dry coolant.

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
RTA0205	12	60	9000~9500	800~1000	0.11~0.14	1~2	溝銑 SLOTTING
RTA0205	12	60	9000~9500	800~1000	0.05~0.07	1~2	溝銑 SLOTTING
RTA0205	12	100	15500~16500	1200~1400	0.11~0.14	1~2	溝銑 SLOTTING
RTA0205	12	100	15500~16500	900~1100	0.05~0.07	1~2	溝銑 SLOTTING
RTA0205	12	60	9000~9500	1000~1200	2~4	0.12~0.15	側銑 SIDE MILLING
RTA0205	12	60	9000~9500	700~900	2~4	0.05~0.07	側銑 SIDE MILLING
RTA0205	12	85	13500~14000	1100~1300	2~4	0.12~0.15	側銑 SIDE MILLING
RTA0205	12	85	13500~14000	800~1000	2~4	0.05~0.07	側銑 SIDE MILLING
RTA0205	12	60	9000~9500	1200~1400	0.12~0.15	0.12~0.15	3D銑 3D MILLING
RTA0205	12	60	9000~9500	1100~1300	0.05~0.07	0.05~0.07	3D銑 3D MILLING
RTA0205	12	150	23000~24000	1800~2200	0.12~0.15	0.12~0.15	3D銑 3D MILLING
RTA0205	12	150	23000~24000	1800~2200	0.05~0.07	0.05~0.07	3D銑 3D MILLING
RTA0305	12	85	8800~9300	800~1000	0.12~0.15	1~3	溝銑 SLOTTING
RTA0305	12	85	8800~9300	800~1000	0.06~0.08	1~3	溝銑 SLOTTING
RTA0305	12	100	10500~11000	1000~1200	0.12~0.15	1~3	溝銑 SLOTTING
RTA0305	12	100	10500~11000	900~1100	0.06~0.08	1~3	溝銑 SLOTTING
RTA0305	12	85	8800~9300	1000~1200	3~6	0.12~0.15	側銑 SIDE MILLING
RTA0305	12	85	8800~9300	800~1000	3~6	0.06~0.08	側銑 SIDE MILLING
RTA0305	12	85	8800~9300	1000~1200	0.12~0.15	0.12~0.15	3D銑 3D MILLING
RTA0305	12	85	8800~9300	1000~1200	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0305	12	165	17000~18000	1800~2200	0.12~0.15	0.12~0.15	3D銑 3D MILLING
RTA0305	12	165	17000~18000	1800~2200	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0405	14	100	8000~8400	600~800	0.12~0.15	2~4	溝銑 SLOTTING
RTA0405	14	100	8000~8400	800~1000	0.06~0.08	2~4	溝銑 SLOTTING
RTA0405	14	85	6500~7000	800~1000	4~8	0.12~0.15	側銑 SIDE MILLING
RTA0405	14	85	6500~7000	600~800	4~8	0.06~0.08	側銑 SIDE MILLING
RTA0405	14	110	8700~9200	800~1000	0.12~0.15	0.12~0.15	3D銑 3D MILLING
RTA0405	14	110	8700~9200	600~800	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0405	14	150	12000~13000	1200~1600	0.12~0.15	0.12~0.15	3D銑 3D MILLING
RTA0405	14	165	13000~14000	1600~2000	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0410	14	100	8000~8400	700~900	0.12~0.15	1~4	溝銑 SLOTTING
RTA0410	14	100	8000~8400	800~1000	0.06~0.08	1~4	溝銑 SLOTTING
RTA0410	14	85	6500~7000	800~1000	4~8	0.12~0.15	側銑 SIDE MILLING
RTA0410	14	85	6500~7000	600~800	4~8	0.06~0.08	側銑 SIDE MILLING
RTA0410	14	110	8700~9200	900~1100	0.12~0.15	0.12~0.15	3D銑 3D MILLING
RTA0410	14	110	8700~9200	1100~1400	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0410	14	150	12000~13000	1200~1600	0.12~0.15	0.12~0.15	3D銑 3D MILLING
RTA0410	14	165	13000~14000	1600~2000	0.06~0.08	0.06~0.08	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
RTA0505	17	95	5800~6300	900~1100	0.15~0.18	3~5	溝銑 SLOTTING
RTA0505	17	120	7300~7800	800~1200	0.06~0.08	3~5	溝銑 SLOTTING
RTA0505	17	95	5800~6300	800~1000	5~10	0.15~0.18	側銑 SIDE MILLING
RTA0505	17	95	5800~6300	600~800	5~10	0.06~0.08	側銑 SIDE MILLING
RTA0505	17	135	8300~8800	1400~1800	0.15~0.18	0.15~0.18	3D銑 3D MILLING
RTA0505	17	135	8300~8800	1300~1700	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0505	17	165	10500~11000	1700~2100	0.15~0.18	0.15~0.18	3D銑 3D MILLING
RTA0505	17	165	10500~11000	1600~2000	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0510	17	95	5800~6300	900~1100	0.15~0.18	2~5	溝銑 SLOTTING
RTA0510	17	120	7300~7800	800~1200	0.06~0.08	2~5	溝銑 SLOTTING
RTA0510	17	95	5800~6300	800~1000	5~10	0.15~0.18	側銑 SIDE MILLING
RTA0510	17	95	5800~6300	600~800	5~10	0.06~0.08	側銑 SIDE MILLING
RTA0510	17	135	8300~8800	1400~1800	0.15~0.18	0.15~0.18	3D銑 3D MILLING
RTA0510	17	135	8300~8800	1300~1700	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0510	17	165	10500~11000	1700~2100	0.15~0.18	0.15~0.18	3D銑 3D MILLING
RTA0510	17	165	10500~11000	1600~2000	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0605	20	95	4800~5200	900~1100	0.15~0.18	4~6	溝銑 SLOTTING
RTA0605	20	120	6200~6600	800~1200	0.06~0.08	4~6	溝銑 SLOTTING
RTA0605	20	95	4800~5200	800~1000	6~12	0.15~0.18	側銑 SIDE MILLING
RTA0605	20	95	4800~5200	600~800	6~12	0.06~0.08	側銑 SIDE MILLING
RTA0605	20	135	7200~7600	1400~1800	0.15~0.18	0.15~0.18	3D銑 3D MILLING
RTA0605	20	135	7200~7600	1300~1700	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0610	20	80	4200~4600	900~1100	0.15~0.18	3~6	溝銑 SLOTTING
RTA0610	20	130	6800~7200	800~1200	0.06~0.08	3~6	溝銑 SLOTTING
RTA0610	20	95	5000~5500	800~1000	6~12	0.15~0.18	側銑 SIDE MILLING
RTA0610	20	95	5000~5500	600~800	6~12	0.06~0.08	側銑 SIDE MILLING
RTA0610	20	135	7200~7600	1400~1800	0.15~0.18	0.15~0.18	3D銑 3D MILLING
RTA0610	20	135	7200~7600	1300~1700	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0805	30	125	5000~5600	900~1100	0.18~0.23	6~8	溝銑 SLOTTING
RTA0805	30	135	5200~5600	600~800	0.07~0.1	6~8	溝銑 SLOTTING
RTA0805	30	90	3500~4000	700~1000	8~16	0.18~0.23	側銑 SIDE MILLING
RTA0805	30	90	3500~4000	600~800	8~16	0.07~0.1	側銑 SIDE MILLING
RTA0805	30	150	6000~6600	1600~2000	0.18~0.23	0.18~0.23	3D銑 3D MILLING
RTA0805	30	190	7500~8000	1100~1500	0.07~0.1	0.07~0.1	3D銑 3D MILLING
RTA0810	30	125	5000~5600	900~1100	0.18~0.23	5~8	溝銑 SLOTTING
RTA0810	30	135	5200~5600	600~800	0.07~0.1	5~8	溝銑 SLOTTING
RTA0810	30	90	3500~4000	600~1000	8~16	0.18~0.23	側銑 SIDE MILLING
RTA0810	30	90	3500~4000	600~800	8~16	0.07~0.1	側銑 SIDE MILLING
RTA0810	30	150	6000~6600	1600~2000	0.18~0.23	0.18~0.23	3D銑 3D MILLING
RTA0810	30	190	7500~8000	1000~1400	0.07~0.1	0.07~0.1	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
RTA1005	35	125	4000~4500	800~1200	0.2~0.25	8~10	溝銑 SLOTTING
RTA1005	35	135	4200~4600	600~800	0.07~0.1	8~10	溝銑 SLOTTING
RTA1005	35	90	2800~3200	600~900	10~20	0.2~0.25	側銑 SIDE MILLING
RTA1005	35	90	2800~3200	600~800	10~20	0.07~0.1	側銑 SIDE MILLING
RTA1005	35	150	4800~5400	1600~2000	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTA1005	35	190	6000~6500	1200~1600	0.07~0.1	0.07~0.1	3D銑 3D MILLING
RTA1010	35	125	4000~4500	800~1200	0.2~0.25	7~10	溝銑 SLOTTING
RTA1010	35	135	4200~4600	600~800	0.07~0.1	7~10	溝銑 SLOTTING
RTA1010	35	90	2800~3200	600~900	10~20	0.2~0.25	側銑 SIDE MILLING
RTA1010	35	90	2800~3200	600~800	10~20	0.07~0.1	側銑 SIDE MILLING
RTA1010	35	150	4800~5400	1600~2000	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTA1010	35	190	6000~6500	1200~1600	0.07~0.1	0.07~0.1	3D銑 3D MILLING
RTA1015	35	125	4000~4500	800~1200	0.2~0.25	6~10	溝銑 SLOTTING
RTA1015	35	135	4200~4600	600~800	0.07~0.1	6~10	溝銑 SLOTTING
RTA1015	35	90	2800~3200	600~900	10~20	0.2~0.25	側銑 SIDE MILLING
RTA1015	35	90	2800~3200	600~800	10~20	0.07~0.1	側銑 SIDE MILLING
RTA1015	35	150	4800~5400	1600~2000	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTA1015	35	190	6000~6500	1200~1600	0.07~0.1	0.07~0.1	3D銑 3D MILLING
RTA1020	35	125	4000~4500	800~1200	0.2~0.25	5~10	溝銑 SLOTTING
RTA1020	35	135	4200~4600	600~800	0.07~0.1	5~10	溝銑 SLOTTING
RTA1020	35	90	2800~3200	600~900	10~20	0.2~0.25	側銑 SIDE MILLING
RTA1020	35	90	2800~3200	600~800	10~20	0.07~0.1	側銑 SIDE MILLING
RTA1020	35	150	4800~5400	1600~2000	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTA1020	35	190	6000~6500	1200~1600	0.07~0.1	0.07~0.1	3D銑 3D MILLING
RTA1210	40	75	2000~2500	800~1100	0.2~0.25	9~12	溝銑 SLOTTING
RTA1210	40	150	4000~4500	800~1000	0.07~0.12	9~12	溝銑 SLOTTING
RTA1210	40	105	2800~3200	600~800	12~24	0.2~0.25	側銑 SIDE MILLING
RTA1210	40	105	2800~3200	400~600	12~24	0.07~0.12	側銑 SIDE MILLING
RTA1210	40	150	4000~4500	1400~1600	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTA1210	40	170	4500~5000	1300~1600	0.07~0.12	0.07~0.12	3D銑 3D MILLING
RTA1220	40	75	2000~2500	800~1100	0.2~0.25	7~12	溝銑 SLOTTING
RTA1220	40	150	4000~4500	800~1000	0.07~0.12	7~12	溝銑 SLOTTING
RTA1220	40	105	2800~3200	600~800	12~24	0.2~0.25	側銑 SIDE MILLING
RTA1220	40	105	2800~3200	400~600	12~24	0.07~0.12	側銑 SIDE MILLING
RTA1220	40	150	4000~4500	1400~1600	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTA1220	40	170	4500~5000	1300~1600	0.07~0.12	0.07~0.12	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
RTA0205	12	60	9000~9500	700~900	0.11~0.14	1~2	溝銑 SLOTTING
RTA0205	12	60	9000~9500	700~900	0.05~0.07	1~2	溝銑 SLOTTING
RTA0205	12	90	14000~15000	1000~1200	0.11~0.14	1~2	溝銑 SLOTTING
RTA0205	12	90	14000~15000	900~1100	0.05~0.07	1~2	溝銑 SLOTTING
RTA0205	12	60	9000~9500	900~1100	2~4	0.12~0.15	側銑 SIDE MILLING
RTA0205	12	60	9000~9500	700~900	2~4	0.05~0.07	側銑 SIDE MILLING
RTA0205	12	85	13500~14000	1100~1300	2~4	0.12~0.15	側銑 SIDE MILLING
RTA0205	12	85	13500~14000	800~1000	2~4	0.05~0.07	側銑 SIDE MILLING
RTA0205	12	60	9000~9500	1000~1200	0.12~0.15	0.12~0.15	3D銑 3D MILLING
RTA0205	12	60	9000~9500	1000~1200	0.05~0.07	0.05~0.07	3D銑 3D MILLING
RTA0205	12	140	22000~23000	1600~2000	0.12~0.15	0.12~0.15	3D銑 3D MILLING
RTA0205	12	140	22000~23000	1600~2000	0.05~0.07	0.05~0.07	3D銑 3D MILLING
RTA0305	12	85	8800~9300	600~800	0.12~0.15	1~3	溝銑 SLOTTING
RTA0305	12	85	8800~9300	700~900	0.06~0.08	1~3	溝銑 SLOTTING
RTA0305	12	100	10500~11000	1000~1200	0.12~0.15	1~3	溝銑 SLOTTING
RTA0305	12	100	10500~11000	900~1100	0.06~0.08	1~3	溝銑 SLOTTING
RTA0305	12	85	8800~9300	800~1000	3~6	0.12~0.15	側銑 SIDE MILLING
RTA0305	12	85	8800~9300	700~900	3~6	0.06~0.08	側銑 SIDE MILLING
RTA0305	12	85	8800~9300	1000~1200	0.12~0.15	0.12~0.15	3D銑 3D MILLING
RTA0305	12	85	8800~9300	1000~1200	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0305	12	145	15000~16000	1700~2000	0.12~0.15	0.12~0.15	3D銑 3D MILLING
RTA0305	12	155	16000~17000	1600~2000	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0405	14	95	7800~8200	600~800	0.12~0.15	2~4	溝銑 SLOTTING
RTA0405	14	100	8000~8400	600~900	0.06~0.08	2~4	溝銑 SLOTTING
RTA0405	14	85	6500~7000	700~900	4~8	0.12~0.15	側銑 SIDE MILLING
RTA0405	14	85	6500~7000	400~600	4~8	0.06~0.08	側銑 SIDE MILLING
RTA0405	14	110	8700~9200	800~1100	0.12~0.15	0.12~0.15	3D銑 3D MILLING
RTA0405	14	110	8700~9200	1000~1300	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0405	14	145	11000~12000	1200~1400	0.12~0.15	0.12~0.15	3D銑 3D MILLING
RTA0405	14	155	12000~13000	1300~1700	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0410	14	95	7800~8200	600~800	0.12~0.15	1~4	溝銑 SLOTTING
RTA0410	14	100	8000~8400	600~900	0.06~0.08	1~4	溝銑 SLOTTING
RTA0410	14	85	6500~7000	700~900	4~8	0.12~0.15	側銑 SIDE MILLING
RTA0410	14	85	6500~7000	400~600	4~8	0.06~0.08	側銑 SIDE MILLING
RTA0410	14	110	8700~9200	800~1100	0.12~0.15	0.12~0.15	3D銑 3D MILLING
RTA0410	14	110	8700~9200	1000~1300	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0410	14	145	11000~12000	1200~1400	0.12~0.15	0.12~0.15	3D銑 3D MILLING
RTA0410	14	155	12000~13000	1300~1700	0.06~0.08	0.06~0.08	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
RTA0505	17	85	5200~5700	900~1100	0.15~0.18	3~5	溝銑 SLOTTING
RTA0505	17	120	7300~7800	800~1200	0.06~0.08	3~5	溝銑 SLOTTING
RTA0505	17	85	5200~5700	800~1000	5~10	0.15~0.18	側銑 SIDE MILLING
RTA0505	17	95	5800~6300	600~800	5~10	0.06~0.08	側銑 SIDE MILLING
RTA0505	17	135	8300~8800	1300~1700	0.15~0.18	0.15~0.18	3D銑 3D MILLING
RTA0505	17	135	8300~8800	1200~1600	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0505	17	160	10000~10500	1600~1900	0.15~0.18	0.15~0.18	3D銑 3D MILLING
RTA0505	17	160	10000~10500	1500~1800	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0510	17	85	5200~5700	900~1100	0.15~0.18	2~5	溝銑 SLOTTING
RTA0510	17	120	7300~7800	800~1200	0.06~0.08	2~5	溝銑 SLOTTING
RTA0510	17	85	5200~5700	800~1000	5~10	0.15~0.18	側銑 SIDE MILLING
RTA0510	17	95	5800~6300	600~800	5~10	0.06~0.08	側銑 SIDE MILLING
RTA0510	17	135	8300~8800	1300~1700	0.15~0.18	0.15~0.18	3D銑 3D MILLING
RTA0510	17	135	8300~8800	1200~1600	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0510	17	160	10000~10500	1600~1900	0.15~0.18	0.15~0.18	3D銑 3D MILLING
RTA0510	17	160	10000~10500	1500~1800	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0605	20	85	4200~4700	800~1000	0.15~0.18	4~6	溝銑 SLOTTING
RTA0605	20	115	5700~6200	800~1200	0.06~0.08	4~6	溝銑 SLOTTING
RTA0605	20	85	4200~4600	700~900	6~12	0.15~0.18	側銑 SIDE MILLING
RTA0605	20	90	4400~4800	500~700	6~12	0.06~0.08	側銑 SIDE MILLING
RTA0605	20	135	7200~7600	1200~1600	0.15~0.18	0.15~0.18	3D銑 3D MILLING
RTA0605	20	135	7200~7600	1200~1600	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0610	20	85	4200~4700	800~1000	0.15~0.18	3~6	溝銑 SLOTTING
RTA0610	20	115	5700~6200	800~1200	0.06~0.08	3~6	溝銑 SLOTTING
RTA0610	20	85	4200~4600	700~900	6~12	0.15~0.18	側銑 SIDE MILLING
RTA0610	20	90	4400~4800	500~700	6~12	0.06~0.08	側銑 SIDE MILLING
RTA0610	20	135	7200~7600	1200~1600	0.15~0.18	0.15~0.18	3D銑 3D MILLING
RTA0610	20	135	7200~7600	1200~1600	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0805	30	100	3800~4300	800~1000	0.18~0.23	6~8	溝銑 SLOTTING
RTA0805	30	135	5200~5600	600~800	0.07~0.1	6~8	溝銑 SLOTTING
RTA0805	30	80	3000~3500	600~900	8~16	0.18~0.23	側銑 SIDE MILLING
RTA0805	30	90	3400~3800	600~800	8~16	0.07~0.1	側銑 SIDE MILLING
RTA0805	30	105	4000~4500	1600~1800	0.18~0.23	0.18~0.23	3D銑 3D MILLING
RTA0805	30	185	7200~7700	1000~1400	0.07~0.1	0.07~0.1	3D銑 3D MILLING
RTA0810	30	100	3800~4300	800~1000	0.18~0.23	5~8	溝銑 SLOTTING
RTA0810	30	135	5200~5600	600~800	0.07~0.1	5~8	溝銑 SLOTTING
RTA0810	30	80	3000~3500	600~900	8~16	0.18~0.23	側銑 SIDE MILLING
RTA0810	30	90	3400~3800	600~800	8~16	0.07~0.1	側銑 SIDE MILLING
RTA0810	30	105	4000~4500	1600~1800	0.18~0.23	0.18~0.23	3D銑 3D MILLING
RTA0810	30	185	7200~7700	1000~1400	0.07~0.1	0.07~0.1	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
RTA1005	35	100	3000~3400	700~1000	0.2~0.25	8~10	溝銑 SLOTTING
RTA1005	35	135	4200~4600	600~800	0.07~0.1	8~10	溝銑 SLOTTING
RTA1005	35	80	2400~2800	500~700	10~20	0.15~0.2	側銑 SIDE MILLING
RTA1005	35	90	2800~3200	450~650	10~20	0.07~0.1	側銑 SIDE MILLING
RTA1005	35	105	3200~3600	1200~1600	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTA1005	35	185	5800~6200	1000~1400	0.07~0.1	0.07~0.1	3D銑 3D MILLING
RTA1010	35	100	3000~3400	700~1000	0.2~0.25	7~10	溝銑 SLOTTING
RTA1010	35	135	4200~4600	600~800	0.07~0.1	7~10	溝銑 SLOTTING
RTA1010	35	80	2400~2800	500~700	10~20	0.15~0.2	側銑 SIDE MILLING
RTA1010	35	90	2800~3200	450~650	10~20	0.07~0.1	側銑 SIDE MILLING
RTA1010	35	105	3200~3600	1200~1600	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTA1010	35	185	5800~6200	1000~1400	0.07~0.1	0.07~0.1	3D銑 3D MILLING
RTA1015	35	100	3000~3400	700~1000	0.2~0.25	6~10	溝銑 SLOTTING
RTA1015	35	135	4200~4600	600~800	0.07~0.1	6~10	溝銑 SLOTTING
RTA1015	35	80	2400~2800	500~700	10~20	0.15~0.2	側銑 SIDE MILLING
RTA1015	35	90	2800~3200	450~650	10~20	0.07~0.1	側銑 SIDE MILLING
RTA1015	35	105	3200~3600	1200~1600	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTA1015	35	185	5800~6200	1000~1400	0.07~0.1	0.07~0.1	3D銑 3D MILLING
RTA1020	35	100	3000~3400	700~1000	0.2~0.25	5~10	溝銑 SLOTTING
RTA1020	35	135	4200~4600	600~800	0.07~0.1	5~10	溝銑 SLOTTING
RTA1020	35	80	2400~2800	500~700	10~20	0.15~0.2	側銑 SIDE MILLING
RTA1020	35	90	2800~3200	450~650	10~20	0.07~0.1	側銑 SIDE MILLING
RTA1020	35	105	3200~3600	1200~1600	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTA1020	35	185	5800~6200	1000~1400	0.07~0.1	0.07~0.1	3D銑 3D MILLING
RTA1210	40	75	2000~2400	600~900	0.2~0.25	9~12	溝銑 SLOTTING
RTA1210	40	145	3800~4200	800~1000	0.07~0.12	9~12	溝銑 SLOTTING
RTA1210	40	70	1800~2200	600~800	12~24	0.15~0.2	側銑 SIDE MILLING
RTA1210	40	70	1800~2200	300~500	12~24	0.07~0.12	側銑 SIDE MILLING
RTA1210	40	140	3600~4000	1000~1200	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTA1210	40	150	4500~5000	1200~1500	0.07~0.12	0.07~0.12	3D銑 3D MILLING
RTA1220	40	75	2000~2400	600~900	0.2~0.25	7~12	溝銑 SLOTTING
RTA1220	40	145	3800~4200	800~1000	0.07~0.12	7~12	溝銑 SLOTTING
RTA1220	40	70	1800~2200	600~800	12~24	0.15~0.2	側銑 SIDE MILLING
RTA1220	40	70	1800~2200	300~500	12~24	0.07~0.12	側銑 SIDE MILLING
RTA1220	40	140	3600~4000	1000~1200	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTA1220	40	150	4500~5000	1200~1500	0.07~0.12	0.07~0.12	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
RTA0205	12	60	9000~9500	700~900	0.11~0.14	1~2	溝銑 SLOTTING
RTA0205	12	60	9000~9500	700~900	0.05~0.07	1~2	溝銑 SLOTTING
RTA0205	12	90	14000~15000	1000~1200	0.11~0.14	1~2	溝銑 SLOTTING
RTA0205	12	90	14000~15000	900~1100	0.05~0.07	1~2	溝銑 SLOTTING
RTA0205	12	60	9000~9500	900~1100	2~4	0.12~0.15	側銑 SIDE MILLING
RTA0205	12	60	9000~9500	700~900	2~4	0.05~0.07	側銑 SIDE MILLING
RTA0205	12	85	13500~14000	1100~1300	2~4	0.12~0.15	側銑 SIDE MILLING
RTA0205	12	85	13500~14000	800~1000	2~4	0.05~0.07	側銑 SIDE MILLING
RTA0205	12	60	9000~9500	1000~1200	0.12~0.15	0.12~0.15	3D銑 3D MILLING
RTA0205	12	60	9000~9500	1000~1200	0.05~0.07	0.05~0.07	3D銑 3D MILLING
RTA0205	12	140	22000~23000	1600~2000	0.12~0.15	0.12~0.15	3D銑 3D MILLING
RTA0205	12	140	22000~23000	1600~2000	0.05~0.07	0.05~0.07	3D銑 3D MILLING
RTA0305	12	85	8800~9300	600~800	0.12~0.15	1~3	溝銑 SLOTTING
RTA0305	12	85	8800~9300	700~900	0.06~0.08	1~3	溝銑 SLOTTING
RTA0305	12	100	10500~11000	1000~1200	0.12~0.15	1~3	溝銑 SLOTTING
RTA0305	12	100	10500~11000	900~1100	0.06~0.08	1~3	溝銑 SLOTTING
RTA0305	12	85	8800~9300	800~1000	3~6	0.12~0.15	側銑 SIDE MILLING
RTA0305	12	85	8800~9300	700~900	3~6	0.06~0.08	側銑 SIDE MILLING
RTA0305	12	85	8800~9300	1000~1200	0.12~0.15	0.12~0.15	3D銑 3D MILLING
RTA0305	12	85	8800~9300	1000~1200	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0305	12	145	15000~16000	1700~2000	0.12~0.15	0.12~0.15	3D銑 3D MILLING
RTA0305	12	155	16000~17000	1600~2000	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0405	14	95	7800~8200	600~800	0.12~0.15	2~4	溝銑 SLOTTING
RTA0405	14	100	8000~8400	600~900	0.06~0.08	2~4	溝銑 SLOTTING
RTA0405	14	85	6500~7000	700~900	4~8	0.12~0.15	側銑 SIDE MILLING
RTA0405	14	85	6500~7000	400~600	4~8	0.06~0.08	側銑 SIDE MILLING
RTA0405	14	110	8700~9200	800~1100	0.12~0.15	0.12~0.15	3D銑 3D MILLING
RTA0405	14	110	8700~9200	1000~1300	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0405	14	145	11000~12000	1200~1400	0.12~0.15	0.12~0.15	3D銑 3D MILLING
RTA0405	14	155	12000~13000	1300~1700	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0410	14	95	7800~8200	600~800	0.12~0.15	1~4	溝銑 SLOTTING
RTA0410	14	100	8000~8400	600~900	0.06~0.08	1~4	溝銑 SLOTTING
RTA0410	14	85	6500~7000	700~900	4~8	0.12~0.15	側銑 SIDE MILLING
RTA0410	14	85	6500~7000	400~600	4~8	0.06~0.08	側銑 SIDE MILLING
RTA0410	14	110	8700~9200	800~1100	0.12~0.15	0.12~0.15	3D銑 3D MILLING
RTA0410	14	110	8700~9200	1000~1300	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0410	14	145	11000~12000	1200~1400	0.12~0.15	0.12~0.15	3D銑 3D MILLING
RTA0410	14	155	12000~13000	1300~1700	0.06~0.08	0.06~0.08	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
RTA0505	17	85	5200~5700	900~1100	0.15~0.18	3~5	溝銑 SLOTTING
RTA0505	17	120	7300~7800	800~1200	0.06~0.08	3~5	溝銑 SLOTTING
RTA0505	17	85	5200~5700	800~1000	5~10	0.15~0.18	側銑 SIDE MILLING
RTA0505	17	95	5800~6300	600~800	5~10	0.06~0.08	側銑 SIDE MILLING
RTA0505	17	135	8300~8800	1300~1700	0.15~0.18	0.15~0.18	3D銑 3D MILLING
RTA0505	17	135	8300~8800	1200~1600	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0505	17	160	10000~10500	1600~1900	0.15~0.18	0.15~0.18	3D銑 3D MILLING
RTA0505	17	160	10000~10500	1500~1800	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0510	17	85	5200~5700	900~1100	0.15~0.18	2~5	溝銑 SLOTTING
RTA0510	17	120	7300~7800	800~1200	0.06~0.08	2~5	溝銑 SLOTTING
RTA0510	17	85	5200~5700	800~1000	5~10	0.15~0.18	側銑 SIDE MILLING
RTA0510	17	95	5800~6300	600~800	5~10	0.06~0.08	側銑 SIDE MILLING
RTA0510	17	135	8300~8800	1300~1700	0.15~0.18	0.15~0.18	3D銑 3D MILLING
RTA0510	17	135	8300~8800	1200~1600	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0510	17	160	10000~10500	1600~1900	0.15~0.18	0.15~0.18	3D銑 3D MILLING
RTA0510	17	160	10000~10500	1500~1800	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0605	20	85	4200~4700	800~1000	0.15~0.18	4~6	溝銑 SLOTTING
RTA0605	20	115	5700~6200	800~1200	0.06~0.08	4~6	溝銑 SLOTTING
RTA0605	20	85	4200~4600	700~900	6~12	0.15~0.18	側銑 SIDE MILLING
RTA0605	20	90	4400~4800	500~700	6~12	0.06~0.08	側銑 SIDE MILLING
RTA0605	20	135	7200~7600	1200~1600	0.15~0.18	0.15~0.18	3D銑 3D MILLING
RTA0605	20	135	7200~7600	1200~1600	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0610	20	85	4200~4700	800~1000	0.15~0.18	3~6	溝銑 SLOTTING
RTA0610	20	115	5700~6200	800~1200	0.06~0.08	3~6	溝銑 SLOTTING
RTA0610	20	85	4200~4600	700~900	6~12	0.15~0.18	側銑 SIDE MILLING
RTA0610	20	90	4400~4800	500~700	6~12	0.06~0.08	側銑 SIDE MILLING
RTA0610	20	135	7200~7600	1200~1600	0.15~0.18	0.15~0.18	3D銑 3D MILLING
RTA0610	20	135	7200~7600	1200~1600	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0805	30	100	3800~4300	800~1000	0.18~0.23	6~8	溝銑 SLOTTING
RTA0805	30	135	5200~5600	600~800	0.07~0.1	6~8	溝銑 SLOTTING
RTA0805	30	80	3000~3500	600~900	8~16	0.18~0.23	側銑 SIDE MILLING
RTA0805	30	90	3400~3800	600~800	8~16	0.07~0.1	側銑 SIDE MILLING
RTA0805	30	105	4000~4500	1600~1800	0.18~0.23	0.18~0.23	3D銑 3D MILLING
RTA0805	30	185	7200~7700	1000~1400	0.07~0.1	0.07~0.1	3D銑 3D MILLING
RTA0810	30	100	3800~4300	800~1000	0.18~0.23	5~8	溝銑 SLOTTING
RTA0810	30	135	5200~5600	600~800	0.07~0.1	5~8	溝銑 SLOTTING
RTA0810	30	80	3000~3500	600~900	8~16	0.18~0.23	側銑 SIDE MILLING
RTA0810	30	90	3400~3800	600~800	8~16	0.07~0.1	側銑 SIDE MILLING
RTA0810	30	105	4000~4500	1600~1800	0.18~0.23	0.18~0.23	3D銑 3D MILLING
RTA0810	30	185	7200~7700	1000~1400	0.07~0.1	0.07~0.1	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
RTA1005	35	100	3000~3400	700~1000	0.2~0.25	8~10	溝銑 SLOTTING
RTA1005	35	135	4200~4600	600~800	0.07~0.1	8~10	溝銑 SLOTTING
RTA1005	35	80	2400~2800	500~700	10~20	0.15~0.2	側銑 SIDE MILLING
RTA1005	35	90	2800~3200	450~650	10~20	0.07~0.1	側銑 SIDE MILLING
RTA1005	35	105	3200~3600	1200~1600	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTA1005	35	185	5800~6200	1000~1400	0.07~0.1	0.07~0.1	3D銑 3D MILLING
RTA1010	35	100	3000~3400	700~1000	0.2~0.25	7~10	溝銑 SLOTTING
RTA1010	35	135	4200~4600	600~800	0.07~0.1	7~10	溝銑 SLOTTING
RTA1010	35	80	2400~2800	500~700	10~20	0.15~0.2	側銑 SIDE MILLING
RTA1010	35	90	2800~3200	450~650	10~20	0.07~0.1	側銑 SIDE MILLING
RTA1010	35	105	3200~3600	1200~1600	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTA1010	35	185	5800~6200	1000~1400	0.07~0.1	0.07~0.1	3D銑 3D MILLING
RTA1015	35	100	3000~3400	700~1000	0.2~0.25	6~10	溝銑 SLOTTING
RTA1015	35	135	4200~4600	600~800	0.07~0.1	6~10	溝銑 SLOTTING
RTA1015	35	80	2400~2800	500~700	10~20	0.15~0.2	側銑 SIDE MILLING
RTA1015	35	90	2800~3200	450~650	10~20	0.07~0.1	側銑 SIDE MILLING
RTA1015	35	105	3200~3600	1200~1600	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTA1015	35	185	5800~6200	1000~1400	0.07~0.1	0.07~0.1	3D銑 3D MILLING
RTA1020	35	100	3000~3400	700~1000	0.2~0.25	5~10	溝銑 SLOTTING
RTA1020	35	135	4200~4600	600~800	0.07~0.1	5~10	溝銑 SLOTTING
RTA1020	35	80	2400~2800	500~700	10~20	0.15~0.2	側銑 SIDE MILLING
RTA1020	35	90	2800~3200	450~650	10~20	0.07~0.1	側銑 SIDE MILLING
RTA1020	35	105	3200~3600	1200~1600	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTA1020	35	185	5800~6200	1000~1400	0.07~0.1	0.07~0.1	3D銑 3D MILLING
RTA1210	40	75	2000~2400	600~900	0.2~0.25	9~12	溝銑 SLOTTING
RTA1210	40	145	3800~4200	800~1000	0.07~0.12	9~12	溝銑 SLOTTING
RTA1210	40	70	1800~2200	600~800	12~24	0.15~0.2	側銑 SIDE MILLING
RTA1210	40	70	1800~2200	300~500	12~24	0.07~0.12	側銑 SIDE MILLING
RTA1210	40	140	3600~4000	1000~1200	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTA1210	40	150	4500~5000	1200~1500	0.07~0.12	0.07~0.12	3D銑 3D MILLING
RTA1220	40	75	2000~2400	600~900	0.2~0.25	7~12	溝銑 SLOTTING
RTA1220	40	145	3800~4200	800~1000	0.07~0.12	7~12	溝銑 SLOTTING
RTA1220	40	70	1800~2200	600~800	12~24	0.15~0.2	側銑 SIDE MILLING
RTA1220	40	70	1800~2200	300~500	12~24	0.07~0.12	側銑 SIDE MILLING
RTA1220	40	140	3600~4000	1000~1200	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTA1220	40	150	4500~5000	1200~1500	0.07~0.12	0.07~0.12	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
RTA0205	12	60	9000~9500	600~800	0.03~0.05	1~2	溝銑 SLOTTING
RTA0205	12	60	9000~9500	300~500	2~4	0.03~0.05	側銑 SIDE MILLING
RTA0205	12	60	9000~9500	600~800	0.03~0.05	0.03~0.05	3D銑 3D MILLING
RTA0205	12	140	22000~23000	1400~1600	0.03~0.05	0.03~0.05	3D銑 3D MILLING
RTA0305	12	85	8800~9300	600~800	0.04~0.06	1~3	溝銑 SLOTTING
RTA0305	12	75	8000~8500	300~500	3~6	0.04~0.06	側銑 SIDE MILLING
RTA0305	12	85	8800~9300	600~800	0.04~0.06	0.04~0.06	3D銑 3D MILLING
RTA0305	12	145	15000~16000	1400~1600	0.04~0.06	0.04~0.06	3D銑 3D MILLING
RTA0405	14	90	7200~7600	600~800	0.04~0.06	2~4	溝銑 SLOTTING
RTA0405	14	75	6000~6400	300~500	4~8	0.04~0.06	側銑 SIDE MILLING
RTA0405	14	110	8700~9200	600~800	0.04~0.06	0.04~0.06	3D銑 3D MILLING
RTA0405	14	140	11000~12000	1000~1200	0.04~0.06	0.04~0.06	3D銑 3D MILLING
RTA0410	14	90	7200~7600	600~800	0.04~0.06	1~4	溝銑 SLOTTING
RTA0410	14	75	6000~6400	300~500	4~8	0.04~0.06	側銑 SIDE MILLING
RTA0410	14	110	8700~9200	600~800	0.04~0.06	0.04~0.06	3D銑 3D MILLING
RTA0410	14	140	11000~12000	1000~1200	0.04~0.06	0.04~0.06	3D銑 3D MILLING
RTA0505	17	95	6000~6600	800~1000	0.05~0.07	3~5	溝銑 SLOTTING
RTA0505	17	75	4800~5200	400~600	5~10	0.05~0.07	側銑 SIDE MILLING
RTA0505	17	135	8600~9000	800~1000	0.05~0.07	0.05~0.07	3D銑 3D MILLING
RTA0505	17	145	9000~10000	1200~1400	0.05~0.07	0.05~0.07	3D銑 3D MILLING
RTA0510	17	95	6000~6600	800~1000	0.05~0.07	2~5	溝銑 SLOTTING
RTA0510	17	75	4800~5200	400~600	5~10	0.05~0.07	側銑 SIDE MILLING
RTA0510	17	135	8600~9000	800~1000	0.05~0.07	0.05~0.07	3D銑 3D MILLING
RTA0510	17	145	9000~10000	1200~1400	0.05~0.07	0.05~0.07	3D銑 3D MILLING
RTA0605	20	95	5000~5500	800~1000	0.05~0.07	4.5	溝銑 SLOTTING
RTA0605	20	75	4000~4400	400~600	6~12	0.05~0.07	側銑 SIDE MILLING
RTA0605	20	135	7200~7600	1000~1200	0.05~0.07	0.05~0.07	3D銑 3D MILLING
RTA0610	20	95	5000~5500	800~1000	0.05~0.07	3~6	溝銑 SLOTTING
RTA0610	20	75	4000~4400	400~600	6~12	0.05~0.07	側銑 SIDE MILLING
RTA0610	20	135	7200~7600	1000~1200	0.05~0.07	0.05~0.07	3D銑 3D MILLING
RTA0805	30	135	5200~5700	600~800	0.06~0.08	6~8	溝銑 SLOTTING
RTA0805	30	85	3200~3700	400~600	8~16	0.06~0.08	側銑 SIDE MILLING
RTA0805	30	150	6000~6500	800~1000	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA0810	30	135	5200~5700	600~800	0.06~0.08	5~8	溝銑 SLOTTING
RTA0810	30	85	3200~3700	400~600	8~16	0.06~0.08	側銑 SIDE MILLING
RTA0810	30	150	6000~6500	800~1000	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTA1005	35	135	4200~4600	600~800	0.07~0.1	8.5	溝銑 SLOTTING
RTA1005	35	85	2600~3000	400~600	10~20	0.07~0.1	側銑 SIDE MILLING
RTA1005	35	150	4800~5200	800~1000	0.07~0.1	0.07~0.1	3D銑 3D MILLING
RTA1010	35	135	4200~4600	600~800	0.07~0.1	7~10	溝銑 SLOTTING
RTA1010	35	85	2600~3000	400~600	10~20	0.07~0.1	側銑 SIDE MILLING
RTA1010	35	150	4800~5200	800~1000	0.07~0.1	0.07~0.1	3D銑 3D MILLING
RTA1015	35	135	4200~4600	600~800	0.07~0.1	6~10	溝銑 SLOTTING
RTA1015	35	85	2600~3000	400~600	10~20	0.07~0.1	側銑 SIDE MILLING
RTA1015	35	150	4800~5200	800~1000	0.07~0.1	0.07~0.1	3D銑 3D 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		熱處理鋼 <i>Hardened Steels</i> 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
RTA1020	35	135	4200~4600	600~800	0.07~0.1	5~10	溝銑 SLOTTING
RTA1020	35	85	2600~3000	400~600	10~20	0.07~0.1	側銑 SIDE MILLING
RTA1020	35	150	4800~5200	800~1000	0.07~0.1	0.07~0.1	3D銑 3D MILLING
RTA1210	40	100	2600~3000	600~800	0.07~0.12	9~12	溝銑 SLOTTING
RTA1210	40	60	1600~2000	300~400	12~24	0.07~0.12	側銑 SIDE MILLING
RTA1210	40	130	3400~3800	600~800	0.07~0.12	0.07~0.12	3D銑 3D MILLING
RTA1220	40	100	2600~3000	600~800	0.07~0.12	7~12	溝銑 SLOTTING
RTA1220	40	60	1600~2000	300~400	12~24	0.07~0.12	側銑 SIDE MILLING
RTA1220	40	130	3400~3800	600~800	0.07~0.12	0.07~0.12	3D銑 3D MILLING