

被切劑材 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
RTB0305	12	90	9500~10000	800~1200	0.15~0.2	3	溝銑 SLOTTING
RTB0305	12	90	9500~10000	800~1200	0.05~0.1	3	溝銑 SLOTTING
RTB0305	12	90	9500~10000	700~1100	6	0.05~0.1	側銑 SIDE MILLING
RTB0305	12	90	9500~10000	800~1200	6	0.15~0.2	側銑 SIDE MILLING
RTB0305	12	90	9500~10000	1400~1800	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0305	12	90	9500~10000	1200~1600	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTB0305	12	145	15000~16000	1800~2200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0305	12	145	15000~16000	1600~2000	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTB0405	12	100	7500~8000	800~1200	0.05~0.1	4	溝銑 SLOTTING
RTB0405	12	100	7500~8000	1000~1400	0.15~0.2	4	溝銑 SLOTTING
RTB0405	12	100	7500~8000	700~1000	0.3	4	溝銑 SLOTTING
RTB0405	12	95	7200~7700	700~1100	8	0.05~0.1	側銑 SIDE MILLING
RTB0405	12	95	7200~7700	1000~1400	8	0.15~0.2	側銑 SIDE MILLING
RTB0405	12	95	7200~7700	700~1000	8	0.3	側銑 SIDE MILLING
RTB0405	12	120	9500~10000	1400~1800	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0405	12	120	9500~10000	1400~1800	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTB0405	12	160	12000~13000	2000~2400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0405	12	160	12000~13000	1800~2200	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTB0505	17	115	7200~7700	800~1200	0.05~0.1	5	溝銑 SLOTTING
RTB0505	17	115	7200~7700	1000~1400	0.15~0.25	5	溝銑 SLOTTING
RTB0505	17	115	7200~7700	700~1000	0.35	5	溝銑 SLOTTING
RTB0505	17	100	6200~6700	700~1100	10	0.05~0.1	側銑 SIDE MILLING
RTB0505	17	100	6200~6700	1000~1400	10	0.15~0.25	側銑 SIDE MILLING
RTB0505	17	100	6200~6700	700~1000	10	0.4	側銑 SIDE MILLING
RTB0505	17	150	9200~9700	1400~1800	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0505	17	150	9200~9700	1400~1800	0.15~0.25	0.15~0.25	3D銑 3D MILLING
RTB0505	17	165	10000~11000	1800~2200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0505	17	165	10000~11000	1800~2200	0.15~0.25	0.15~0.25	3D銑 3D MILLING
RTB0510	17	115	7200~7700	800~1200	0.05~0.1	5	溝銑 SLOTTING
RTB0510	17	115	7200~7700	1000~1400	0.15~0.25	5	溝銑 SLOTTING
RTB0510	17	115	7200~7700	700~1000	0.35	5	溝銑 SLOTTING
RTB0510	17	100	6200~6700	700~1100	10	0.05~0.1	側銑 SIDE MILLING
RTB0510	17	100	6200~6700	1000~1400	10	0.15~0.25	側銑 SIDE MILLING
RTB0510	17	100	6200~6700	700~1000	10	0.4	側銑 SIDE MILLING
RTB0510	17	150	9200~9700	1400~1800	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0510	17	150	9200~9700	1400~1800	0.15~0.25	0.15~0.25	3D銑 3D MILLING
RTB0510	17	165	10000~11000	1800~2200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0510	17	165	10000~11000	1800~2200	0.15~0.25	0.15~0.25	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
RTB0605	20	120	6200~6700	800~1200	0.05~0.1	6	溝銑 SLOTTING
RTB0605	20	120	6200~6700	1000~1400	0.15~0.25	6	溝銑 SLOTTING
RTB0605	20	120	6200~6700	700~1100	0.4	6	溝銑 SLOTTING
RTB0605	20	100	5200~5700	700~1000	12	0.05~0.1	側銑 SIDE MILLING
RTB0605	20	95	4800~5300	1000~1400	12	0.15~0.25	側銑 SIDE MILLING
RTB0605	20	100	5200~5700	700~1100	12	0.4	側銑 SIDE MILLING
RTB0605	20	170	8700~9200	1600~2000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0605	20	170	8700~9200	1800~2200	0.15~0.25	0.15~0.25	3D銑 3D MILLING
RTB0610	20	120	6200~6700	800~1200	0.05~0.1	6	溝銑 SLOTTING
RTB0610	20	120	6200~6700	1000~1400	0.15~0.25	6	溝銑 SLOTTING
RTB0610	20	120	6200~6700	700~1100	0.4	6	溝銑 SLOTTING
RTB0610	20	100	5200~5700	700~1000	12	0.05~0.1	側銑 SIDE MILLING
RTB0610	20	95	4800~5300	1000~1400	12	0.15~0.25	側銑 SIDE MILLING
RTB0610	20	100	5200~5700	700~1100	12	0.4	側銑 SIDE MILLING
RTB0610	20	170	8700~9200	1600~2000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0610	20	170	8700~9200	1800~2200	0.15~0.25	0.15~0.25	3D銑 3D MILLING
RTB0805	25	130	5000~5500	800~1200	0.05~0.1	8	溝銑 SLOTTING
RTB0805	25	130	5000~5500	1200~1600	0.2~0.3	8	溝銑 SLOTTING
RTB0805	25	130	5000~5500	700~1100	0.5	8	溝銑 SLOTTING
RTB0805	25	95	3500~4000	700~1000	16	0.05~0.1	側銑 SIDE MILLING
RTB0805	25	95	3500~4000	1200~1600	16	0.2~0.3	側銑 SIDE MILLING
RTB0805	25	95	3500~4000	800~1200	16	0.5	側銑 SIDE MILLING
RTB0805	25	200	7700~8200	2000~2400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0805	25	200	7700~8200	2400~2800	0.2~0.3	0.2~0.3	3D銑 3D MILLING
RTB0810	25	130	5000~5500	800~1200	0.05~0.1	8	溝銑 SLOTTING
RTB0810	25	130	5000~5500	1200~1600	0.2~0.3	8	溝銑 SLOTTING
RTB0810	25	130	5000~5500	700~1100	0.5	8	溝銑 SLOTTING
RTB0810	25	95	3500~4000	700~1000	16	0.05~0.1	側銑 SIDE MILLING
RTB0810	25	95	3500~4000	1200~1600	16	0.2~0.3	側銑 SIDE MILLING
RTB0810	25	95	3500~4000	800~1200	16	0.5	側銑 SIDE MILLING
RTB0810	25	200	7700~8200	2000~2400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0810	25	200	7700~8200	2400~2800	0.2~0.3	0.2~0.3	3D銑 3D MILLING
RTB1005Z	35	135	4000~4500	700~1100	0.05~0.1	10	溝銑 SLOTTING
RTB1005Z	35	135	4000~4500	1400~1800	0.2~0.3	10	溝銑 SLOTTING
RTB1005Z	35	135	4000~4500	800~1200	0.5	10	溝銑 SLOTTING
RTB1005Z	35	75	2200~2700	400~700	20	0.05~0.1	側銑 SIDE MILLING
RTB1005Z	35	95	2800~3300	1600~2000	20	0.2~0.3	側銑 SIDE MILLING
RTB1005Z	35	95	2800~3300	1000~1400	20	0.5	側銑 SIDE MILLING
RTB1005Z	35	220	6700~7200	2000~2400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1005Z	35	220	6700~7200	2400~2800	0.2~0.3	0.2~0.3	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
RTB1005	35	135	4000~4500	700~1100	0.05~0.1	10	溝銑 SLOTTING
RTB1005	35	135	4000~4500	1400~1800	0.2~0.3	10	溝銑 SLOTTING
RTB1005	35	135	4000~4500	800~1200	0.5	10	溝銑 SLOTTING
RTB1005	35	75	2200~2700	400~700	20	0.05~0.1	側銑 SIDE MILLING
RTB1005	35	95	2800~3300	1600~2000	20	0.2~0.3	側銑 SIDE MILLING
RTB1005	35	95	2800~3300	1000~1400	20	0.5	側銑 SIDE MILLING
RTB1005	35	220	6700~7200	2000~2400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1005	35	220	6700~7200	2400~2800	0.2~0.3	0.2~0.3	3D銑 3D MILLING
RTB1010Z	35	135	4000~4500	700~1100	0.05~0.1	10	溝銑 SLOTTING
RTB1010Z	35	135	4000~4500	1400~1800	0.2~0.3	10	溝銑 SLOTTING
RTB1010Z	35	135	4000~4500	800~1200	0.5	10	溝銑 SLOTTING
RTB1010Z	35	75	2200~2700	400~700	20	0.05~0.1	側銑 SIDE MILLING
RTB1010Z	35	95	2800~3300	1600~2000	20	0.2~0.3	側銑 SIDE MILLING
RTB1010Z	35	95	2800~3300	1000~1400	20	0.5	側銑 SIDE MILLING
RTB1010Z	35	220	6700~7200	2000~2400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1010Z	35	220	6700~7200	2400~2800	0.2~0.3	0.2~0.3	3D銑 3D MILLING
RTB1010	35	135	4000~4500	700~1100	0.05~0.1	10	溝銑 SLOTTING
RTB1010	35	135	4000~4500	1400~1800	0.2~0.3	10	溝銑 SLOTTING
RTB1010	35	135	4000~4500	800~1200	0.5	10	溝銑 SLOTTING
RTB1010	35	75	2200~2700	400~700	20	0.05~0.1	側銑 SIDE MILLING
RTB1010	35	95	2800~3300	1600~2000	20	0.2~0.3	側銑 SIDE MILLING
RTB1010	35	95	2800~3300	1000~1400	20	0.5	側銑 SIDE MILLING
RTB1010	35	220	6700~7200	2000~2400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1010	35	220	6700~7200	2400~2800	0.2~0.3	0.2~0.3	3D銑 3D MILLING
RTB1020Z	35	135	4000~4500	700~1100	0.05~0.1	10	溝銑 SLOTTING
RTB1020Z	35	135	4000~4500	1400~1800	0.2~0.3	10	溝銑 SLOTTING
RTB1020Z	35	135	4000~4500	800~1200	0.5	10	溝銑 SLOTTING
RTB1020Z	35	75	2200~2700	400~700	20	0.05~0.1	側銑 SIDE MILLING
RTB1020Z	35	95	2800~3300	1600~2000	20	0.2~0.3	側銑 SIDE MILLING
RTB1020Z	35	95	2800~3300	1000~1400	20	0.5	側銑 SIDE MILLING
RTB1020Z	35	220	6700~7200	2000~2400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1020Z	35	220	6700~7200	2400~2800	0.2~0.3	0.2~0.3	3D銑 3D MILLING
RTB1020	35	135	4000~4500	700~1100	0.05~0.1	10	溝銑 SLOTTING
RTB1020	35	135	4000~4500	1400~1800	0.2~0.3	10	溝銑 SLOTTING
RTB1020	35	135	4000~4500	800~1200	0.5	10	溝銑 SLOTTING
RTB1020	35	75	2200~2700	400~700	20	0.05~0.1	側銑 SIDE MILLING
RTB1020	35	95	2800~3300	1600~2000	20	0.2~0.3	側銑 SIDE MILLING
RTB1020	35	95	2800~3300	1000~1400	20	0.5	側銑 SIDE MILLING
RTB1020	35	220	6700~7200	2000~2400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1020	35	220	6700~7200	2400~2800	0.2~0.3	0.2~0.3	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
RTB1030Z	35	135	4000~4500	700~1100	0.05~0.1	10	溝銑 SLOTTING
RTB1030Z	35	135	4000~4500	1400~1800	0.2~0.3	10	溝銑 SLOTTING
RTB1030Z	35	135	4000~4500	800~1200	0.5	10	溝銑 SLOTTING
RTB1030Z	35	75	2200~2700	400~700	20	0.05~0.1	側銑 SIDE MILLING
RTB1030Z	35	95	2800~3300	1600~2000	20	0.2~0.3	側銑 SIDE MILLING
RTB1030Z	35	95	2800~3300	1000~1400	20	0.5	側銑 SIDE MILLING
RTB1030Z	35	220	6700~7200	2000~2400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1030Z	35	220	6700~7200	2400~2800	0.2~0.3	0.2~0.3	3D銑 3D MILLING
RTB1030	35	135	4000~4500	700~1100	0.05~0.1	10	溝銑 SLOTTING
RTB1030	35	135	4000~4500	1400~1800	0.2~0.3	10	溝銑 SLOTTING
RTB1030	35	135	4000~4500	800~1200	0.5	10	溝銑 SLOTTING
RTB1030	35	75	2200~2700	400~700	20	0.05~0.1	側銑 SIDE MILLING
RTB1030	35	95	2800~3300	1600~2000	20	0.2~0.3	側銑 SIDE MILLING
RTB1030	35	95	2800~3300	1000~1400	20	0.5	側銑 SIDE MILLING
RTB1030	35	220	6700~7200	2000~2400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1030	35	220	6700~7200	2400~2800	0.2~0.3	0.2~0.3	3D銑 3D MILLING
RTB1210	37	150	3700~4200	800~1200	0.05~0.1	12	溝銑 SLOTTING
RTB1210	37	150	3700~4200	1400~1800	0.2~0.3	12	溝銑 SLOTTING
RTB1210	37	150	3700~4200	1000~1400	0.5	12	溝銑 SLOTTING
RTB1210	37	115	2800~3300	500~800	24	0.05~0.1	側銑 SIDE MILLING
RTB1210	37	115	2800~3300	1200~1600	24	0.2~0.3	側銑 SIDE MILLING
RTB1210	37	115	2800~3300	800~1100	24	0.5	側銑 SIDE MILLING
RTB1210	37	185	4700~5200	1600~2000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1210	37	185	4700~5200	2000~2400	0.2~0.3	0.2~0.3	3D銑 3D MILLING
RTB1220	37	150	3700~4200	800~1200	0.05~0.1	12	溝銑 SLOTTING
RTB1220	37	150	3700~4200	1400~1800	0.2~0.3	12	溝銑 SLOTTING
RTB1220	37	150	3700~4200	1000~1400	0.5	12	溝銑 SLOTTING
RTB1220	37	115	2800~3300	500~800	24	0.05~0.1	側銑 SIDE MILLING
RTB1220	37	115	2800~3300	1200~1600	24	0.2~0.3	側銑 SIDE MILLING
RTB1220	37	115	2800~3300	800~1100	24	0.5	側銑 SIDE MILLING
RTB1220	37	185	4700~5200	1600~2000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1220	37	185	4700~5200	2000~2400	0.2~0.3	0.2~0.3	3D銑 3D MILLING
RTB1230	37	150	3700~4200	800~1200	0.05~0.1	12	溝銑 SLOTTING
RTB1230	37	150	3700~4200	1400~1800	0.2~0.3	12	溝銑 SLOTTING
RTB1230	37	150	3700~4200	1000~1400	0.5	12	溝銑 SLOTTING
RTB1230	37	115	2800~3300	500~800	24	0.05~0.1	側銑 SIDE MILLING
RTB1230	37	115	2800~3300	1200~1600	24	0.2~0.3	側銑 SIDE MILLING
RTB1230	37	115	2800~3300	800~1100	24	0.5	側銑 SIDE MILLING
RTB1230	37	185	4700~5200	1600~2000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1230	37	185	4700~5200	2000~2400	0.2~0.3	0.2~0.3	3D銑 3D MILLING

附註 / Note :

建議冷卻方式為濕式。

Suggest to use Wet coolant.

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
RTB0305	12	90	9500~10000	800~1200	0.15~0.2	3	溝銑 SLOTTING
RTB0305	12	90	9500~10000	800~1200	0.05~0.1	3	溝銑 SLOTTING
RTB0305	12	90	9500~10000	700~1100	6	0.05~0.1	側銑 SIDE MILLING
RTB0305	12	90	9500~10000	800~1200	6	0.15~0.2	側銑 SIDE MILLING
RTB0305	12	90	9500~10000	1400~1800	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0305	12	90	9500~10000	1200~1600	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTB0305	12	145	15000~16000	1800~2200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0305	12	145	15000~16000	1600~2000	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTB0405	12	100	7500~8000	800~1200	0.05~0.1	4	溝銑 SLOTTING
RTB0405	12	100	7500~8000	1000~1400	0.15~0.2	4	溝銑 SLOTTING
RTB0405	12	95	7200~7700	700~1100	8	0.05~0.1	側銑 SIDE MILLING
RTB0405	12	95	7200~7700	800~1200	8	0.15~0.2	側銑 SIDE MILLING
RTB0405	12	120	9500~10000	1400~1800	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0405	12	120	9500~10000	1400~1800	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTB0405	12	160	12000~13000	2000~2400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0405	12	160	12000~13000	1800~2200	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTB0505	17	115	7200~7700	800~1200	0.05~0.1	5	溝銑 SLOTTING
RTB0505	17	115	7200~7700	1000~1400	0.15~0.25	5	溝銑 SLOTTING
RTB0505	17	95	5700~6200	700~1100	10	0.05~0.1	側銑 SIDE MILLING
RTB0505	17	95	5700~6200	800~1200	10	0.15~0.25	側銑 SIDE MILLING
RTB0505	17	150	9200~9700	1400~1800	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0505	17	150	9200~9700	1400~1800	0.15~0.25	0.15~0.25	3D銑 3D MILLING
RTB0505	17	165	10000~11000	1800~2200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0505	17	165	10000~11000	1800~2200	0.15~0.25	0.15~0.25	3D銑 3D MILLING
RTB0510	17	115	7200~7700	800~1200	0.05~0.1	5	溝銑 SLOTTING
RTB0510	17	115	7200~7700	1000~1400	0.15~0.25	5	溝銑 SLOTTING
RTB0510	17	95	5700~6200	700~1100	10	0.05~0.1	側銑 SIDE MILLING
RTB0510	17	95	5700~6200	800~1200	10	0.15~0.25	側銑 SIDE MILLING
RTB0510	17	150	9200~9700	1400~1800	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0510	17	150	9200~9700	1400~1800	0.15~0.25	0.15~0.25	3D銑 3D MILLING
RTB0510	17	165	10000~11000	1800~2200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0510	17	165	10000~11000	1800~2200	0.15~0.25	0.15~0.25	3D銑 3D MILLING
RTB0605	20	120	6200~6700	800~1200	0.05~0.1	6	溝銑 SLOTTING
RTB0605	20	120	6200~6700	1000~1400	0.15~0.25	6	溝銑 SLOTTING
RTB0605	20	95	4800~5300	700~1000	12	0.05~0.1	側銑 SIDE MILLING
RTB0605	20	95	4800~5300	800~1200	12	0.15~0.25	側銑 SIDE MILLING
RTB0605	20	170	8700~9200	1600~2000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0605	20	170	8700~9200	1600~2000	0.15~0.25	0.15~0.25	3D銑 3D MILLING
RTB0610	20	120	6200~6700	800~1200	0.05~0.1	6	溝銑 SLOTTING
RTB0610	20	120	6200~6700	1000~1400	0.15~0.25	6	溝銑 SLOTTING
RTB0610	20	95	4800~5300	700~1000	12	0.05~0.1	側銑 SIDE MILLING
RTB0610	20	95	4800~5300	800~1200	12	0.15~0.25	側銑 SIDE MILLING
RTB0610	20	170	8700~9200	1600~2000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0610	20	170	8700~9200	1600~2000	0.15~0.25	0.15~0.25	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		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
RTB0805	25	130	5000~5500	700~1100	0.05~0.1	8	溝銑 SLOTTING
RTB0805	25	130	5000~5500	1000~1400	0.2~0.3	8	溝銑 SLOTTING
RTB0805	25	95	3500~4000	700~1000	16	0.05~0.1	側銑 SIDE MILLING
RTB0805	25	95	3500~4000	800~1200	16	0.2~0.3	側銑 SIDE MILLING
RTB0805	25	200	7700~8200	2000~2400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0805	25	200	7700~8200	2200~2600	0.2~0.3	0.2~0.3	3D銑 3D MILLING
RTB0810	25	130	5000~5500	700~1100	0.05~0.1	8	溝銑 SLOTTING
RTB0810	25	130	5000~5500	1000~1400	0.2~0.3	8	溝銑 SLOTTING
RTB0810	25	95	3500~4000	700~1000	16	0.05~0.1	側銑 SIDE MILLING
RTB0810	25	95	3500~4000	800~1200	16	0.2~0.3	側銑 SIDE MILLING
RTB0810	25	200	7700~8200	2000~2400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0810	25	200	7700~8200	2200~2600	0.2~0.3	0.2~0.3	3D銑 3D MILLING
RTB1005Z	35	135	4000~4500	700~1000	0.05~0.1	10	溝銑 SLOTTING
RTB1005Z	35	135	4000~4500	800~1200	0.2~0.3	10	溝銑 SLOTTING
RTB1005Z	35	95	2800~3300	500~800	20	0.05~0.1	側銑 SIDE MILLING
RTB1005Z	35	95	2800~3300	1200~1600	20	0.2~0.3	側銑 SIDE MILLING
RTB1005Z	35	220	6700~7200	2000~2400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1005Z	35	220	6700~7200	2200~2600	0.2~0.3	0.2~0.3	3D銑 3D MILLING
RTB1005	35	135	4000~4500	700~1000	0.05~0.1	10	溝銑 SLOTTING
RTB1005	35	135	4000~4500	800~1200	0.2~0.3	10	溝銑 SLOTTING
RTB1005	35	95	2800~3300	500~800	20	0.05~0.1	側銑 SIDE MILLING
RTB1005	35	95	2800~3300	1200~1600	20	0.2~0.3	側銑 SIDE MILLING
RTB1005	35	220	6700~7200	2000~2400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1005	35	220	6700~7200	2200~2600	0.2~0.3	0.2~0.3	3D銑 3D MILLING
RTB1010Z	35	135	4000~4500	700~1000	0.05~0.1	10	溝銑 SLOTTING
RTB1010Z	35	135	4000~4500	800~1200	0.2~0.3	10	溝銑 SLOTTING
RTB1010Z	35	95	2800~3300	500~800	20	0.05~0.1	側銑 SIDE MILLING
RTB1010Z	35	95	2800~3300	1200~1600	20	0.2~0.3	側銑 SIDE MILLING
RTB1010Z	35	220	6700~7200	2000~2400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1010Z	35	220	6700~7200	2200~2600	0.2~0.3	0.2~0.3	3D銑 3D MILLING
RTB1010	35	135	4000~4500	700~1000	0.05~0.1	10	溝銑 SLOTTING
RTB1010	35	135	4000~4500	800~1200	0.2~0.3	10	溝銑 SLOTTING
RTB1010	35	95	2800~3300	500~800	20	0.05~0.1	側銑 SIDE MILLING
RTB1010	35	95	2800~3300	1200~1600	20	0.2~0.3	側銑 SIDE MILLING
RTB1010	35	220	6700~7200	2000~2400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1010	35	220	6700~7200	2200~2600	0.2~0.3	0.2~0.3	3D銑 3D MILLING
RTB1020Z	35	135	4000~4500	700~1000	0.05~0.1	10	溝銑 SLOTTING
RTB1020Z	35	135	4000~4500	800~1200	0.2~0.3	10	溝銑 SLOTTING
RTB1020Z	35	95	2800~3300	500~800	20	0.05~0.1	側銑 SIDE MILLING
RTB1020Z	35	95	2800~3300	1200~1600	20	0.2~0.3	側銑 SIDE MILLING
RTB1020Z	35	220	6700~7200	2000~2400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1020Z	35	220	6700~7200	2200~2600	0.2~0.3	0.2~0.3	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
RTB1020	35	135	4000~4500	700~1000	0.05~0.1	10	溝銑 SLOTTING
RTB1020	35	135	4000~4500	800~1200	0.2~0.3	10	溝銑 SLOTTING
RTB1020	35	95	2800~3300	500~800	20	0.05~0.1	側銑 SIDE MILLING
RTB1020	35	95	2800~3300	1200~1600	20	0.2~0.3	側銑 SIDE MILLING
RTB1020	35	220	6700~7200	2000~2400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1020	35	220	6700~7200	2200~2600	0.2~0.3	0.2~0.3	3D銑 3D MILLING
RTB1030Z	35	135	4000~4500	700~1000	0.05~0.1	10	溝銑 SLOTTING
RTB1030Z	35	135	4000~4500	800~1200	0.2~0.3	10	溝銑 SLOTTING
RTB1030Z	35	95	2800~3300	500~800	20	0.05~0.1	側銑 SIDE MILLING
RTB1030Z	35	95	2800~3300	1200~1600	20	0.2~0.3	側銑 SIDE MILLING
RTB1030Z	35	220	6700~7200	2000~2400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1030Z	35	220	6700~7200	2200~2600	0.2~0.3	0.2~0.3	3D銑 3D MILLING
RTB1030	35	135	4000~4500	700~1000	0.05~0.1	10	溝銑 SLOTTING
RTB1030	35	135	4000~4500	800~1200	0.2~0.3	10	溝銑 SLOTTING
RTB1030	35	95	2800~3300	500~800	20	0.05~0.1	側銑 SIDE MILLING
RTB1030	35	95	2800~3300	1200~1600	20	0.2~0.3	側銑 SIDE MILLING
RTB1030	35	220	6700~7200	2000~2400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1030	35	220	6700~7200	2200~2600	0.2~0.3	0.2~0.3	3D銑 3D MILLING
RTB1210	37	150	3700~4200	700~1100	0.05~0.1	12	溝銑 SLOTTING
RTB1210	37	150	3700~4200	800~1200	0.2~0.3	12	溝銑 SLOTTING
RTB1210	37	115	2800~3300	500~800	24	0.05~0.1	側銑 SIDE MILLING
RTB1210	37	115	2800~3300	1000~1400	24	0.2~0.3	側銑 SIDE MILLING
RTB1210	37	185	4700~5200	1400~1800	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1210	37	185	4700~5200	1800~2200	0.2~0.3	0.2~0.3	3D銑 3D MILLING
RTB1220	37	150	3700~4200	700~1100	0.05~0.1	12	溝銑 SLOTTING
RTB1220	37	150	3700~4200	800~1200	0.2~0.3	12	溝銑 SLOTTING
RTB1220	37	115	2800~3300	500~800	24	0.05~0.1	側銑 SIDE MILLING
RTB1220	37	115	2800~3300	1000~1400	24	0.2~0.3	側銑 SIDE MILLING
RTB1220	37	185	4700~5200	1400~1800	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1220	37	185	4700~5200	1800~2200	0.2~0.3	0.2~0.3	3D銑 3D MILLING
RTB1230	37	150	3700~4200	700~1100	0.05~0.1	12	溝銑 SLOTTING
RTB1230	37	150	3700~4200	800~1200	0.2~0.3	12	溝銑 SLOTTING
RTB1230	37	115	2800~3300	500~800	24	0.05~0.1	側銑 SIDE MILLING
RTB1230	37	115	2800~3300	1000~1400	24	0.2~0.3	側銑 SIDE MILLING
RTB1230	37	185	4700~5200	1400~1800	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1230	37	185	4700~5200	1800~2200	0.2~0.3	0.2~0.3	3D銑 3D MILLING

附註 / Note :

建議冷卻方式為濕式。

Suggest to use Wet coolant.

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		乾式/油霧切劑 Dry/MQL 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
RTB0305	12	85	9000~10000	800~1000	0.12~0.15	1~3	溝銑 SLOTTING
RTB0305	12	85	9000~10000	800~1000	0.06~0.08	1~3	溝銑 SLOTTING
RTB0305	12	80	8500~9000	1000~1200	3~6	0.12~0.15	側銑 SIDE MILLING
RTB0305	12	80	8500~9000	700~900	3~6	0.06~0.08	側銑 SIDE MILLING
RTB0305	12	85	9000~10000	1000~1200	0.12~0.15	0.12~0.15	3D銑 3D MILLING
RTB0305	12	85	9000~10000	1000~1200	0.06~0.08	0.06~0.08	3D銑 3D MILLING
RTB0405	14	100	8000~8400	800~1000	0.15~0.18	2~4	溝銑 SLOTTING
RTB0405	14	100	8000~8400	800~1000	0.07~0.1	2~4	溝銑 SLOTTING
RTB0405	14	85	6800~7200	800~1000	4~8	0.15~0.18	側銑 SIDE MILLING
RTB0405	14	85	6500~7000	500~700	4~8	0.07~0.1	側銑 SIDE MILLING
RTB0405	14	110	8700~9200	800~1000	0.15~0.18	0.15~0.18	3D銑 3D MILLING
RTB0405	14	110	8700~9200	1000~1200	0.07~0.1	0.07~0.1	3D銑 3D MILLING
RTB0505	17	90	5800~6400	800~1000	0.15~0.18	3~5	溝銑 SLOTTING
RTB0505	17	115	7200~7600	1000~1200	0.07~0.1	3~5	溝銑 SLOTTING
RTB0505	17	85	5400~6000	800~1000	5~10	0.15~0.18	側銑 SIDE MILLING
RTB0505	17	90	5800~6400	600~800	5~10	0.07~0.1	側銑 SIDE MILLING
RTB0505	17	130	8000~8500	800~1200	0.15~0.18	0.15~0.18	3D銑 3D MILLING
RTB0505	17	130	8000~8500	1000~1400	0.07~0.1	0.07~0.1	3D銑 3D MILLING
RTB0510	17	90	5800~6400	800~1000	0.15~0.18	2~5	溝銑 SLOTTING
RTB0510	17	115	7200~7600	1000~1200	0.07~0.1	2~5	溝銑 SLOTTING
RTB0510	17	85	5400~6000	800~1000	5~10	0.15~0.18	側銑 SIDE MILLING
RTB0510	17	90	5800~6400	600~800	5~10	0.07~0.1	側銑 SIDE MILLING
RTB0510	17	130	8000~8500	800~1200	0.15~0.18	0.15~0.18	3D銑 3D MILLING
RTB0510	17	130	8000~8500	1000~1400	0.07~0.1	0.07~0.1	3D銑 3D MILLING
RTB0605	20	90	4800~5400	1000~1400	0.15~0.2	4~6	溝銑 SLOTTING
RTB0605	20	115	6000~6400	1200~1400	0.07~0.1	4~6	溝銑 SLOTTING
RTB0605	20	85	4500~5000	800~1000	6~12	0.15~0.2	側銑 SIDE MILLING
RTB0605	20	90	4800~5200	600~800	6~12	0.07~0.1	側銑 SIDE MILLING
RTB0605	20	160	8500~9000	1000~1400	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTB0605	20	160	8500~9000	1400~1800	0.07~0.1	0.07~0.1	3D銑 3D MILLING
RTB0610	20	90	4800~5400	1000~1400	0.15~0.2	3~6	溝銑 SLOTTING
RTB0610	20	115	6000~6400	1200~1400	0.07~0.1	3~6	溝銑 SLOTTING
RTB0610	20	85	4500~5000	800~1000	6~12	0.15~0.2	側銑 SIDE MILLING
RTB0610	20	90	4800~5200	600~800	6~12	0.07~0.1	側銑 SIDE MILLING
RTB0610	20	160	8500~9000	1000~1400	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTB0610	20	160	8500~9000	1400~1800	0.07~0.1	0.07~0.1	3D銑 3D MILLING
RTB0805	30	100	4000~4500	700~1000	0.2~0.25	6~8	溝銑 SLOTTING
RTB0805	30	140	5500~6000	800~1000	0.07~0.11	6~8	溝銑 SLOTTING
RTB0805	30	90	3500~4000	700~900	8~16	0.2~0.25	側銑 SIDE MILLING
RTB0805	30	90	3500~4000	600~800	8~16	0.07~0.11	側銑 SIDE MILLING
RTB0805	30	100	4000~4500	1400~1800	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTB0805	30	185	7200~7700	1200~1600	0.07~0.11	0.07~0.11	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		乾式/油霧切劑 Dry/MQL 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
RTB0810	30	100	4000~4500	700~1000	0.2~0.25	5~8	溝銑 SLOTTING
RTB0810	30	140	5500~6000	800~1000	0.07~0.11	5~8	溝銑 SLOTTING
RTB0810	30	90	3500~4000	700~900	8~16	0.2~0.25	側銑 SIDE MILLING
RTB0810	30	90	3500~4000	600~800	8~16	0.07~0.11	側銑 SIDE MILLING
RTB0810	30	100	4000~4500	1400~1800	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTB0810	30	185	7200~7700	1200~1600	0.07~0.11	0.07~0.11	3D銑 3D MILLING
RTB1005Z	30	100	3200~3600	800~1100	0.25~0.3	8~10	溝銑 SLOTTING
RTB1005Z	30	140	4400~4800	800~1000	0.08~0.13	8~10	溝銑 SLOTTING
RTB1005Z	30	90	2800~3200	700~1000	10~20	0.25~0.3	側銑 SIDE MILLING
RTB1005Z	30	90	2800~3200	600~800	10~20	0.08~0.13	側銑 SIDE MILLING
RTB1005Z	30	100	3200~3600	1600~2000	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTB1005Z	30	185	5800~6200	1300~1700	0.08~0.13	0.08~0.13	3D銑 3D MILLING
RTB1005	35	100	3200~3600	800~1100	0.25~0.3	8~10	溝銑 SLOTTING
RTB1005	35	140	4400~4800	800~1000	0.08~0.13	8~10	溝銑 SLOTTING
RTB1005	35	90	2800~3200	700~1000	10~20	0.25~0.3	側銑 SIDE MILLING
RTB1005	35	90	2800~3200	600~800	10~20	0.08~0.13	側銑 SIDE MILLING
RTB1005	35	100	3200~3600	1600~2000	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTB1005	35	185	5800~6200	1300~1700	0.08~0.13	0.08~0.13	3D銑 3D MILLING
RTB1010Z	30	100	3200~3600	800~1100	0.25~0.3	7~10	溝銑 SLOTTING
RTB1010Z	30	140	4400~4800	800~1000	0.08~0.13	7~10	溝銑 SLOTTING
RTB1010Z	30	90	2800~3200	700~1000	10~20	0.25~0.3	側銑 SIDE MILLING
RTB1010Z	30	90	2800~3200	600~800	10~20	0.08~0.13	側銑 SIDE MILLING
RTB1010Z	30	100	3200~3600	1600~2000	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTB1010Z	30	185	5800~6200	1300~1700	0.08~0.13	0.08~0.13	3D銑 3D MILLING
RTB1010	35	100	3200~3600	800~1100	0.25~0.3	7~10	溝銑 SLOTTING
RTB1010	35	140	4400~4800	800~1000	0.08~0.13	7~10	溝銑 SLOTTING
RTB1010	35	90	2800~3200	700~1000	10~20	0.25~0.3	側銑 SIDE MILLING
RTB1010	35	90	2800~3200	600~800	10~20	0.08~0.13	側銑 SIDE MILLING
RTB1010	35	100	3200~3600	1600~2000	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTB1010	35	185	5800~6200	1300~1700	0.08~0.13	0.08~0.13	3D銑 3D MILLING
RTB1020Z	30	100	3200~3600	800~1100	0.25~0.3	5~10	溝銑 SLOTTING
RTB1020Z	30	140	4400~4800	800~1000	0.08~0.13	5~10	溝銑 SLOTTING
RTB1020Z	30	90	2800~3200	700~1000	10~20	0.25~0.3	側銑 SIDE MILLING
RTB1020Z	30	90	2800~3200	600~800	10~20	0.08~0.13	側銑 SIDE MILLING
RTB1020Z	30	100	3200~3600	1600~2000	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTB1020Z	30	185	5800~6200	1300~1700	0.08~0.13	0.08~0.13	3D銑 3D MILLING
RTB1020	35	100	3200~3600	800~1100	0.25~0.3	5~10	溝銑 SLOTTING
RTB1020	35	140	4400~4800	800~1000	0.08~0.13	5~10	溝銑 SLOTTING
RTB1020	35	90	2800~3200	700~1000	10~20	0.25~0.3	側銑 SIDE MILLING
RTB1020	35	90	2800~3200	600~800	10~20	0.08~0.13	側銑 SIDE MILLING
RTB1020	35	100	3200~3600	1600~2000	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTB1020	35	185	5800~6200	1300~1700	0.08~0.13	0.08~0.13	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		乾式/油霧切劑 Dry/MQL 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
RTB1030Z	30	100	3200~3600	800~1100	0.25~0.3	3~10	溝銑 SLOTTING
RTB1030Z	30	140	4400~4800	800~1000	0.08~0.13	3~10	溝銑 SLOTTING
RTB1030Z	30	90	2800~3200	700~1000	10~20	0.25~0.3	側銑 SIDE MILLING
RTB1030Z	30	90	2800~3200	600~800	10~20	0.08~0.13	側銑 SIDE MILLING
RTB1030Z	30	100	3200~3600	1600~2000	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTB1030Z	30	185	5800~6200	1300~1700	0.08~0.13	0.08~0.13	3D銑 3D MILLING
RTB1030	35	100	3200~3600	800~1100	0.25~0.3	3~10	溝銑 SLOTTING
RTB1030	35	140	4400~4800	800~1000	0.08~0.13	3~10	溝銑 SLOTTING
RTB1030	35	90	2800~3200	700~1000	10~20	0.25~0.3	側銑 SIDE MILLING
RTB1030	35	90	2800~3200	600~800	10~20	0.08~0.13	側銑 SIDE MILLING
RTB1030	35	100	3200~3600	1600~2000	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTB1030	35	185	5800~6200	1300~1700	0.08~0.13	0.08~0.13	3D銑 3D MILLING
RTB1210	40	90	2400~2800	800~1000	0.25~0.3	9~12	溝銑 SLOTTING
RTB1210	40	145	3800~4200	1200~1400	0.1~0.15	9~12	溝銑 SLOTTING
RTB1210	40	70	1800~2200	600~800	12~24	0.25~0.3	側銑 SIDE MILLING
RTB1210	40	75	1900~2300	400~600	12~24	0.1~0.15	側銑 SIDE MILLING
RTB1210	40	150	4000~4400	1200~1400	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTB1210	40	180	4700~5200	1400~1800	0.1~0.15	0.1~0.15	3D銑 3D MILLING
RTB1220	40	90	2400~2800	800~1000	0.25~0.3	7~12	溝銑 SLOTTING
RTB1220	40	145	3800~4200	1200~1400	0.1~0.15	7~12	溝銑 SLOTTING
RTB1220	40	70	1800~2200	600~800	12~24	0.25~0.3	側銑 SIDE MILLING
RTB1220	40	75	1900~2300	400~600	12~24	0.1~0.15	側銑 SIDE MILLING
RTB1220	40	150	4000~4400	1200~1400	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTB1220	40	180	4700~5200	1400~1800	0.1~0.15	0.1~0.15	3D銑 3D MILLING
RTB1230	40	90	2400~2800	800~1000	0.25~0.3	5~12	溝銑 SLOTTING
RTB1230	40	145	3800~4200	1200~1400	0.1~0.15	5~12	溝銑 SLOTTING
RTB1230	40	70	1800~2200	600~800	12~24	0.25~0.3	側銑 SIDE MILLING
RTB1230	40	75	1900~2300	400~600	12~24	0.1~0.15	側銑 SIDE MILLING
RTB1230	40	150	4000~4400	1200~1400	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTB1230	40	180	4700~5200	1400~1800	0.1~0.15	0.1~0.15	3D銑 3D MILLING

附註 / Note :

建議冷卻方式為乾式/油霧。

Suggest to use Dry/MQL 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/油霧切劑 Dry/MQL 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
RTB0305	12	90	9500~10000	700~1100	0.05~0.1	3	溝銑 SLOTTING
RTB0305	12	80	8000~8500	700~1100	6	0.05~0.1	側銑 SIDE MILLING
RTB0305	12	90	9500~10000	700~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0305	12	135	14000~15000	900~1300	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0405	12	95	7200~7700	700~1100	0.05~0.1	4	溝銑 SLOTTING
RTB0405	12	80	6000~6500	700~1000	8	0.05~0.1	側銑 SIDE MILLING
RTB0405	12	110	8700~9200	700~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0405	12	145	11000~12000	1200~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0505	17	110	6800~7300	700~1100	0.05~0.1	5	溝銑 SLOTTING
RTB0505	17	80	4800~5300	700~1000	10	0.05~0.1	側銑 SIDE MILLING
RTB0505	17	150	9200~9700	700~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0510	17	110	6800~7300	700~1100	0.05~0.1	5	溝銑 SLOTTING
RTB0510	17	80	4800~5300	700~1000	10	0.05~0.1	側銑 SIDE MILLING
RTB0510	17	150	9200~9700	700~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0605	20	110	5700~6200	700~1000	0.05~0.1	6	溝銑 SLOTTING
RTB0605	20	80	4000~4500	500~800	12	0.05~0.1	側銑 SIDE MILLING
RTB0605	20	150	7700~8200	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0610	20	110	5700~6200	700~1000	0.05~0.1	6	溝銑 SLOTTING
RTB0610	20	80	4000~4500	500~800	12	0.05~0.1	側銑 SIDE MILLING
RTB0610	20	150	7700~8200	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0805	25	110	4200~4700	700~1000	0.05~0.1	8	溝銑 SLOTTING
RTB0805	25	85	3200~3700	500~800	16	0.05~0.1	側銑 SIDE MILLING
RTB0805	25	155	6000~6500	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB0810	25	110	4200~4700	700~1000	0.05~0.1	8	溝銑 SLOTTING
RTB0810	25	85	3200~3700	500~800	16	0.05~0.1	側銑 SIDE MILLING
RTB0810	25	155	6000~6500	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1005Z	35	125	3800~4300	700~1000	0.05~0.1	10	溝銑 SLOTTING
RTB1005Z	35	75	2200~2700	500~800	20	0.05~0.1	側銑 SIDE MILLING
RTB1005Z	35	155	4700~5200	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1005	35	125	3800~4300	700~1000	0.05~0.1	10	溝銑 SLOTTING
RTB1005	35	75	2200~2700	500~800	20	0.05~0.1	側銑 SIDE MILLING
RTB1005	35	155	4700~5200	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1010Z	35	125	3800~4300	700~1000	0.05~0.1	10	溝銑 SLOTTING
RTB1010Z	35	75	2200~2700	500~800	20	0.05~0.1	側銑 SIDE MILLING
RTB1010Z	35	155	4700~5200	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1010	35	125	3800~4300	700~1000	0.05~0.1	10	溝銑 SLOTTING
RTB1010	35	75	2200~2700	500~800	20	0.05~0.1	側銑 SIDE MILLING
RTB1010	35	155	4700~5200	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1020Z	35	125	3800~4300	700~1000	0.05~0.1	10	溝銑 SLOTTING
RTB1020Z	35	75	2200~2700	500~800	20	0.05~0.1	側銑 SIDE MILLING
RTB1020Z	35	155	4700~5200	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1020	35	125	3800~4300	700~1000	0.05~0.1	10	溝銑 SLOTTING
RTB1020	35	75	2200~2700	500~800	20	0.05~0.1	側銑 SIDE MILLING
RTB1020	35	155	4700~5200	800~1200	0.05~0.1	0.05~0.1	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 Hardened Steels SKD61/ STAVAX / 17-4PH : 1.2083 / 1.2344 / 1.4542 : H13 / 420 (HRc48~54)					
冷卻方式 Coolant Type		乾式/油霧切劑 Dry/MQL 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
RTB1030Z	35	125	3800~4300	700~1000	0.05~0.1	10	溝銑 SLOTTING
RTB1030Z	35	75	2200~2700	500~800	20	0.05~0.1	側銑 SIDE MILLING
RTB1030Z	35	155	4700~5200	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1030	35	125	3800~4300	700~1000	0.05~0.1	10	溝銑 SLOTTING
RTB1030	35	75	2200~2700	500~800	20	0.05~0.1	側銑 SIDE MILLING
RTB1030	35	155	4700~5200	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1210	37	110	2700~3200	700~1100	0.05~0.1	12	溝銑 SLOTTING
RTB1210	37	75	1800~2300	400~700	24	0.05~0.1	側銑 SIDE MILLING
RTB1210	37	130	3200~3700	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1220	37	110	2700~3200	700~1100	0.05~0.1	12	溝銑 SLOTTING
RTB1220	37	75	1800~2300	400~700	24	0.05~0.1	側銑 SIDE MILLING
RTB1220	37	130	3200~3700	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTB1230	37	110	2700~3200	700~1100	0.05~0.1	12	溝銑 SLOTTING
RTB1230	37	75	1800~2300	400~700	24	0.05~0.1	側銑 SIDE MILLING
RTB1230	37	130	3200~3700	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING

附註 / Note :

建議冷卻方式為乾式/油霧。

Suggest to use Dry/MQL coolant.