

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
RTG0102	12	30	9000~10000	700~1100	0.05~0.1	1	溝銑 SLOTTING
RTG0102	12	30	9000~10000	500~800	0.2	1	溝銑 SLOTTING
RTG0102	12	30	9000~10000	700~1100	1~2	0.05~0.1	側銑 SIDE MILLING
RTG0102	12	30	9000~10000	500~800	1~2	0.2	側銑 SIDE MILLING
RTG0102	12	30	9000~10000	700~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0102	12	30	9000~10000	800~1200	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0102	12	60	18000~20000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0102	12	60	18000~20000	1200~1600	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0152	12	45	9000~10000	700~1100	0.05~0.1	1.5	溝銑 SLOTTING
RTG0152	12	45	9000~10000	500~800	0.2	1.5	溝銑 SLOTTING
RTG0152	12	45	9000~10000	700~1100	1.5~3	0.05~0.1	側銑 SIDE MILLING
RTG0152	12	45	9000~10000	500~800	1.5~3	0.2	側銑 SIDE MILLING
RTG0152	12	45	9000~10000	700~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0152	12	45	9000~10000	800~1200	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0152	12	90	18000~20000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0152	12	90	18000~20000	1200~1600	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0202	12	60	9000~9500	700~1100	0.05~0.1	2	溝銑 SLOTTING
RTG0202	12	60	9000~9500	700~1100	0.2	2	溝銑 SLOTTING
RTG0202	12	60	9000~9500	700~1100	2~4	0.05~0.1	側銑 SIDE MILLING
RTG0202	12	60	9000~9500	700~1100	2~4	0.2	側銑 SIDE MILLING
RTG0202	12	60	9000~10000	700~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0202	12	60	9000~10000	1000~1400	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0202	12	105	16000~18000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0202	12	105	16000~18000	1400~1800	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0205	12	60	9000~9500	700~1100	0.05~0.1	2	溝銑 SLOTTING
RTG0205	12	60	9000~9500	700~1100	0.2	2	溝銑 SLOTTING
RTG0205	12	60	9000~9500	700~1100	2~4	0.05~0.1	側銑 SIDE MILLING
RTG0205	12	60	9000~9500	700~1100	2~4	0.2	側銑 SIDE MILLING
RTG0205	12	60	9000~10000	700~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0205	12	60	9000~10000	1000~1400	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0205	12	105	16000~18000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0205	12	105	16000~18000	1400~1800	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0252	12	70	9000~9500	700~1100	0.05~0.1	2.5	溝銑 SLOTTING
RTG0252	12	70	9000~9500	700~1100	0.2	2.5	溝銑 SLOTTING
RTG0252	12	70	9000~9500	700~1100	2.5~5	0.05~0.1	側銑 SIDE MILLING
RTG0252	12	70	9000~9500	700~1100	2.5~5	0.2	側銑 SIDE MILLING
RTG0252	12	75	9000~10000	700~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0252	12	75	9000~10000	1000~1400	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0252	12	135	16000~18000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0252	12	135	16000~18000	1400~1800	0.15~0.2	0.15~0.2	3D銑 3D MILLING

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
RTG0255	12	70	9000~9500	700~1100	0.05~0.1	2.5	溝銑 SLOTTING
RTG0255	12	70	9000~9500	700~1100	0.2	2.5	溝銑 SLOTTING
RTG0255	12	70	9000~9500	700~1100	2.5~5	0.05~0.1	側銑 SIDE MILLING
RTG0255	12	70	9000~9500	700~1100	2.5~5	0.2	側銑 SIDE MILLING
RTG0255	12	75	9000~10000	700~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0255	12	75	9000~10000	1000~1400	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0255	12	135	16000~18000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0255	12	135	16000~18000	1400~1800	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0302	12	80	8500~9000	800~1200	0.05~0.1	3	溝銑 SLOTTING
RTG0302	12	80	8500~9000	1000~1400	0.2	3	溝銑 SLOTTING
RTG0302	12	80	8500~9000	800~1200	3~6	0.05~0.1	側銑 SIDE MILLING
RTG0302	12	80	8500~9000	1000~1400	3~6	0.2	側銑 SIDE MILLING
RTG0302	12	90	9000~10000	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0302	12	90	9000~10000	1000~1400	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0302	12	160	16000~18000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0302	12	160	16000~18000	1400~1800	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0303	12	80	8500~9000	800~1200	0.05~0.1	3	溝銑 SLOTTING
RTG0303	12	80	8500~9000	1000~1400	0.2	3	溝銑 SLOTTING
RTG0303	12	80	8500~9000	800~1200	3~6	0.05~0.1	側銑 SIDE MILLING
RTG0303	12	80	8500~9000	1000~1400	3~6	0.2	側銑 SIDE MILLING
RTG0303	12	90	9000~10000	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0303	12	90	9000~10000	1000~1400	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0303	12	160	16000~18000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0303	12	160	16000~18000	1400~1800	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0305	12	80	8500~9000	800~1200	0.05~0.1	3	溝銑 SLOTTING
RTG0305	12	80	8500~9000	1000~1400	0.2	3	溝銑 SLOTTING
RTG0305	12	80	8500~9000	800~1200	3~6	0.05~0.1	側銑 SIDE MILLING
RTG0305	12	80	8500~9000	1000~1400	3~6	0.2	側銑 SIDE MILLING
RTG0305	12	90	9000~10000	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0305	12	90	9000~10000	1000~1400	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0305	12	160	16000~18000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0305	12	160	16000~18000	1400~1800	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0402	15	90	7000~7500	700~1100	0.05~0.1	4	溝銑 SLOTTING
RTG0402	15	90	7000~7500	800~1200	0.2~0.3	4	溝銑 SLOTTING
RTG0402	15	90	7000~7500	700~1000	4~8	0.05~0.1	側銑 SIDE MILLING
RTG0402	15	90	7000~7500	1000~1400	4~8	0.2~0.3	側銑 SIDE MILLING
RTG0402	15	120	9000~10000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0402	15	120	9000~10000	1200~1600	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0402	15	180	14000~15000	1200~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0402	15	180	14000~15000	1600~2000	0.15~0.2	0.15~0.2	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
RTG0403	15	90	7000~7500	700~1100	0.05~0.1	4	溝銑 SLOTTING
RTG0403	15	90	7000~7500	800~1200	0.2~0.3	4	溝銑 SLOTTING
RTG0403	15	90	7000~7500	700~1000	4~8	0.05~0.1	側銑 SIDE MILLING
RTG0403	15	90	7000~7500	1000~1400	4~8	0.2~0.3	側銑 SIDE MILLING
RTG0403	15	120	9000~10000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0403	15	120	9000~10000	1200~1600	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0403	15	180	14000~15000	1200~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0403	15	180	14000~15000	1600~2000	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0405	15	90	7000~7500	700~1100	0.05~0.1	4	溝銑 SLOTTING
RTG0405	15	90	7000~7500	800~1200	0.2~0.3	4	溝銑 SLOTTING
RTG0405	15	90	7000~7500	700~1000	4~8	0.05~0.1	側銑 SIDE MILLING
RTG0405	15	90	7000~7500	1000~1400	4~8	0.2~0.3	側銑 SIDE MILLING
RTG0405	15	120	9000~10000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0405	15	120	9000~10000	1200~1600	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0405	15	180	14000~15000	1200~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0405	15	180	14000~15000	1600~2000	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0503	17	95	5700~6200	700~1100	0.05~0.1	5	溝銑 SLOTTING
RTG0503	17	95	5700~6200	800~1200	0.2~0.3	5	溝銑 SLOTTING
RTG0503	17	95	5700~6200	700~1000	5~10	0.05~0.1	側銑 SIDE MILLING
RTG0503	17	95	5700~6200	1000~1400	5~10	0.2~0.3	側銑 SIDE MILLING
RTG0503	17	150	9000~10000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0503	17	150	9000~10000	1200~1600	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0503	17	180	11000~12000	1200~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0503	17	180	11000~12000	1600~2000	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0505	17	95	5700~6200	700~1100	0.05~0.1	5	溝銑 SLOTTING
RTG0505	17	95	5700~6200	800~1200	0.2~0.3	5	溝銑 SLOTTING
RTG0505	17	95	5700~6200	700~1000	5~10	0.05~0.1	側銑 SIDE MILLING
RTG0505	17	95	5700~6200	1000~1400	5~10	0.2~0.3	側銑 SIDE MILLING
RTG0505	17	150	9000~10000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0505	17	150	9000~10000	1200~1600	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0505	17	180	11000~12000	1200~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0505	17	180	11000~12000	1600~2000	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0602	20	95	4700~5200	700~1100	0.05~0.1	6	溝銑 SLOTTING
RTG0602	20	95	4700~5200	800~1200	0.2~0.3	6	溝銑 SLOTTING
RTG0602	20	95	4700~5200	700~1000	6~12	0.05~0.1	側銑 SIDE MILLING
RTG0602	20	95	4700~5200	1000~1400	6~12	0.2~0.3	側銑 SIDE MILLING
RTG0602	20	180	9000~10000	1400~1800	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0602	20	180	9000~10000	1800~2200	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTG0603	20	95	4700~5200	700~1100	0.05~0.1	6	溝銑 SLOTTING
RTG0603	20	95	4700~5200	800~1200	0.2~0.3	6	溝銑 SLOTTING
RTG0603	20	95	4700~5200	700~1000	6~12	0.05~0.1	側銑 SIDE MILLING
RTG0603	20	95	4700~5200	1000~1400	6~12	0.2~0.3	側銑 SIDE MILLING
RTG0603	20	180	9000~10000	1400~1800	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0603	20	180	9000~10000	1800~2200	0.2~0.25	0.2~0.25	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
RTG0605	20	95	4700~5200	700~1100	0.05~0.1	6	溝銑 SLOTTING
RTG0605	20	95	4700~5200	800~1200	0.2~0.3	6	溝銑 SLOTTING
RTG0605	20	95	4700~5200	700~1000	6~12	0.05~0.1	側銑 SIDE MILLING
RTG0605	20	95	4700~5200	1000~1400	6~12	0.2~0.3	側銑 SIDE MILLING
RTG0605	20	180	9000~10000	1400~1800	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0605	20	180	9000~10000	1800~2200	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTG0610	20	95	4700~5200	700~1100	0.05~0.1	6	溝銑 SLOTTING
RTG0610	20	95	4700~5200	800~1200	0.2~0.3	6	溝銑 SLOTTING
RTG0610	20	95	4700~5200	700~1000	6~12	0.05~0.1	側銑 SIDE MILLING
RTG0610	20	95	4700~5200	1000~1400	6~12	0.2~0.3	側銑 SIDE MILLING
RTG0610	20	180	9000~10000	1400~1800	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0610	20	180	9000~10000	1800~2200	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTG0803	30	100	3800~4300	700~1000	0.05~0.1	8	溝銑 SLOTTING
RTG0803	30	100	3800~4300	800~1200	0.25~0.35	8	溝銑 SLOTTING
RTG0803	30	100	3800~4300	700~1000	8~16	0.05~0.1	側銑 SIDE MILLING
RTG0803	30	100	3800~4300	1000~1400	8~16	0.25~0.35	側銑 SIDE MILLING
RTG0803	30	185	7200~7700	1600~2000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0803	30	185	7200~7700	2000~2400	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG0805	30	100	3800~4300	700~1000	0.05~0.1	8	溝銑 SLOTTING
RTG0805	30	100	3800~4300	800~1200	0.25~0.35	8	溝銑 SLOTTING
RTG0805	30	100	3800~4300	700~1000	8~16	0.05~0.1	側銑 SIDE MILLING
RTG0805	30	100	3800~4300	1000~1400	8~16	0.25~0.35	側銑 SIDE MILLING
RTG0805	30	185	7200~7700	1600~2000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0805	30	185	7200~7700	2000~2400	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1002	30	95	2800~3300	700~1000	0.05~0.1	10	溝銑 SLOTTING
RTG1002	30	95	2800~3300	1000~1400	0.25~0.35	10	溝銑 SLOTTING
RTG1002	30	95	2800~3300	700~1000	10~20	0.05~0.1	側銑 SIDE MILLING
RTG1002	30	95	2800~3300	1200~1600	10~20	0.25~0.35	側銑 SIDE MILLING
RTG1002	30	190	5800~6300	1200~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1002	30	190	5800~6300	1800~2200	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1003	30	95	2800~3300	700~1000	0.05~0.1	10	溝銑 SLOTTING
RTG1003	30	95	2800~3300	1000~1400	0.25~0.35	10	溝銑 SLOTTING
RTG1003	30	95	2800~3300	700~1000	10~20	0.05~0.1	側銑 SIDE MILLING
RTG1003	30	95	2800~3300	1200~1600	10~20	0.25~0.35	側銑 SIDE MILLING
RTG1003	30	190	5800~6300	1200~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1003	30	190	5800~6300	1800~2200	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1005	30	95	2800~3300	700~1000	0.05~0.1	10	溝銑 SLOTTING
RTG1005	30	95	2800~3300	1000~1400	0.25~0.35	10	溝銑 SLOTTING
RTG1005	30	95	2800~3300	700~1000	10~20	0.05~0.1	側銑 SIDE MILLING
RTG1005	30	95	2800~3300	1200~1600	10~20	0.25~0.35	側銑 SIDE MILLING
RTG1005	30	190	5800~6300	1200~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1005	30	190	5800~6300	1800~2200	0.25~0.3	0.25~0.3	3D銑 3D MILLING

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
RTG1010	30	95	2800~3300	700~1000	0.05~0.1	10	溝銑 SLOTTING
RTG1010	30	95	2800~3300	1000~1400	0.25~0.35	10	溝銑 SLOTTING
RTG1010	30	95	2800~3300	700~1000	10~20	0.05~0.1	側銑 SIDE MILLING
RTG1010	30	95	2800~3300	1200~1600	10~20	0.25~0.35	側銑 SIDE MILLING
RTG1010	30	190	5800~6300	1200~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1010	30	190	5800~6300	1800~2200	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1203	35	90	2200~2700	700~1000	0.05~0.1	12	溝銑 SLOTTING
RTG1203	35	90	2200~2700	800~1200	0.25~0.35	12	溝銑 SLOTTING
RTG1203	35	90	2200~2700	700~1000	12~24	0.05~0.1	側銑 SIDE MILLING
RTG1203	35	90	2200~2700	1000~1400	12~24	0.25~0.35	側銑 SIDE MILLING
RTG1203	35	190	4800~5300	1200~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1203	35	190	4800~5300	1800~2200	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1205	35	90	2200~2700	700~1000	0.05~0.1	12	溝銑 SLOTTING
RTG1205	35	90	2200~2700	800~1200	0.25~0.35	12	溝銑 SLOTTING
RTG1205	35	90	2200~2700	700~1000	12~24	0.05~0.1	側銑 SIDE MILLING
RTG1205	35	90	2200~2700	1000~1400	12~24	0.25~0.35	側銑 SIDE MILLING
RTG1205	35	190	4800~5300	1200~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1205	35	190	4800~5300	1800~2200	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1210	35	90	2200~2700	700~1000	0.05~0.1	12	溝銑 SLOTTING
RTG1210	35	90	2200~2700	800~1200	0.25~0.35	12	溝銑 SLOTTING
RTG1210	35	90	2200~2700	700~1000	12~24	0.05~0.1	側銑 SIDE MILLING
RTG1210	35	90	2200~2700	1000~1400	12~24	0.25~0.35	側銑 SIDE MILLING
RTG1210	35	190	4800~5300	1200~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1210	35	190	4800~5300	1800~2200	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1215	35	90	2200~2700	700~1000	0.05~0.1	12	溝銑 SLOTTING
RTG1215	35	90	2200~2700	800~1200	0.25~0.35	12	溝銑 SLOTTING
RTG1215	35	90	2200~2700	700~1000	12~24	0.05~0.1	側銑 SIDE MILLING
RTG1215	35	90	2200~2700	1000~1400	12~24	0.25~0.35	側銑 SIDE MILLING
RTG1215	35	190	4800~5300	1200~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1215	35	190	4800~5300	1800~2200	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1220	35	90	2200~2700	700~1000	0.05~0.1	12	溝銑 SLOTTING
RTG1220	35	90	2200~2700	800~1200	0.25~0.35	12	溝銑 SLOTTING
RTG1220	35	90	2200~2700	700~1000	12~24	0.05~0.1	側銑 SIDE MILLING
RTG1220	35	90	2200~2700	1000~1400	12~24	0.25~0.35	側銑 SIDE MILLING
RTG1220	35	190	4800~5300	1200~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1220	35	190	4800~5300	1800~2200	0.25~0.3	0.25~0.3	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		鉻鉬合金鋼 Chromium Molybdenum Alloy Steels SCM440 : 1.7225 : 4140 : 42CrMoA (HRC25~28)					
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
RTG0102	12	30	9000~10000	700~1100	0.05~0.1	1	溝銑 SLOTTING
RTG0102	12	30	9000~10000	500~800	0.2	1	溝銑 SLOTTING
RTG0102	12	30	9000~10000	700~1100	1~2	0.05~0.1	側銑 SIDE MILLING
RTG0102	12	30	9000~10000	500~800	1~2	0.2	側銑 SIDE MILLING
RTG0102	12	30	9000~10000	700~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0102	12	30	9000~10000	800~1200	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0102	12	60	18000~20000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0102	12	60	18000~20000	1200~1600	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0152	12	45	9000~10000	700~1100	0.05~0.1	1.5	溝銑 SLOTTING
RTG0152	12	45	9000~10000	500~800	0.2	1.5	溝銑 SLOTTING
RTG0152	12	45	9000~10000	700~1100	1.5~3	0.05~0.1	側銑 SIDE MILLING
RTG0152	12	45	9000~10000	500~800	1.5~3	0.2	側銑 SIDE MILLING
RTG0152	12	45	9000~10000	700~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0152	12	45	9000~10000	800~1200	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0152	12	90	18000~20000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0152	12	90	18000~20000	1200~1600	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0202	12	60	9000~9500	700~1100	0.05~0.1	2	溝銑 SLOTTING
RTG0202	12	60	9000~9500	700~1100	0.2	2	溝銑 SLOTTING
RTG0202	12	60	9000~9500	700~1100	2~4	0.05~0.1	側銑 SIDE MILLING
RTG0202	12	60	9000~9500	700~1100	2~4	0.2	側銑 SIDE MILLING
RTG0202	12	60	9000~10000	700~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0202	12	60	9000~10000	1000~1400	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0202	12	105	16000~18000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0202	12	105	16000~18000	1400~1800	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0205	12	60	9000~9500	700~1100	0.05~0.1	2	溝銑 SLOTTING
RTG0205	12	60	9000~9500	700~1100	0.2	2	溝銑 SLOTTING
RTG0205	12	60	9000~9500	700~1100	2~4	0.05~0.1	側銑 SIDE MILLING
RTG0205	12	60	9000~9500	700~1100	2~4	0.2	側銑 SIDE MILLING
RTG0205	12	60	9000~10000	700~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0205	12	60	9000~10000	1000~1400	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0205	12	105	16000~18000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0205	12	105	16000~18000	1400~1800	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0252	12	70	9000~9500	700~1100	0.05~0.1	2.5	溝銑 SLOTTING
RTG0252	12	70	9000~9500	700~1100	0.2	2.5	溝銑 SLOTTING
RTG0252	12	70	9000~9500	700~1100	2.5~5	0.05~0.1	側銑 SIDE MILLING
RTG0252	12	70	9000~9500	700~1100	2.5~5	0.2	側銑 SIDE MILLING
RTG0252	12	75	9000~10000	700~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0252	12	75	9000~10000	1000~1400	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0252	12	135	16000~18000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0252	12	135	16000~18000	1400~1800	0.15~0.2	0.15~0.2	3D銑 3D MILLING

被切削材 Work Material		鉻鉬合金鋼 Chromium Molybdenum Alloy Steels SCM440 : 1.7225 : 4140 : 42CrMoA (HRc25~28)					
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
RTG0255	12	70	9000~9500	700~1100	0.05~0.1	2.5	溝銑 SLOTTING
RTG0255	12	70	9000~9500	700~1100	0.2	2.5	溝銑 SLOTTING
RTG0255	12	70	9000~9500	700~1100	2.5~5	0.05~0.1	側銑 SIDE MILLING
RTG0255	12	70	9000~9500	700~1100	2.5~5	0.2	側銑 SIDE MILLING
RTG0255	12	75	9000~10000	700~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0255	12	75	9000~10000	1000~1400	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0255	12	135	16000~18000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0255	12	135	16000~18000	1400~1800	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0302	12	80	8500~9000	700~1000	0.05~0.1	3	溝銑 SLOTTING
RTG0302	12	80	8500~9000	800~1200	0.2	3	溝銑 SLOTTING
RTG0302	12	80	8500~9000	700~1100	3~6	0.05~0.1	側銑 SIDE MILLING
RTG0302	12	80	8500~9000	1000~1400	3~6	0.2	側銑 SIDE MILLING
RTG0302	12	90	9000~10000	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0302	12	90	9000~10000	1000~1400	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0302	12	160	16000~18000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0302	12	160	16000~18000	1400~1800	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0303	12	80	8500~9000	700~1000	0.05~0.1	3	溝銑 SLOTTING
RTG0303	12	80	8500~9000	800~1200	0.2	3	溝銑 SLOTTING
RTG0303	12	80	8500~9000	700~1100	3~6	0.05~0.1	側銑 SIDE MILLING
RTG0303	12	80	8500~9000	1000~1400	3~6	0.2	側銑 SIDE MILLING
RTG0303	12	90	9000~10000	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0303	12	90	9000~10000	1000~1400	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0303	12	160	16000~18000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0303	12	160	16000~18000	1400~1800	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0305	12	80	8500~9000	700~1000	0.05~0.1	3	溝銑 SLOTTING
RTG0305	12	80	8500~9000	800~1200	0.2	3	溝銑 SLOTTING
RTG0305	12	80	8500~9000	700~1100	3~6	0.05~0.1	側銑 SIDE MILLING
RTG0305	12	80	8500~9000	1000~1400	3~6	0.2	側銑 SIDE MILLING
RTG0305	12	90	9000~10000	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0305	12	90	9000~10000	1000~1400	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0305	12	160	16000~18000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0305	12	160	16000~18000	1400~1800	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0402	15	90	7000~7500	700~1000	0.05~0.1	4	溝銑 SLOTTING
RTG0402	15	90	7000~7500	800~1200	0.2~0.3	4	溝銑 SLOTTING
RTG0402	15	90	7000~7500	700~1000	4~8	0.05~0.1	側銑 SIDE MILLING
RTG0402	15	90	7000~7500	1000~1400	4~8	0.2~0.3	側銑 SIDE MILLING
RTG0402	15	120	9000~10000	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0402	15	120	9000~10000	1000~1400	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0402	15	180	14000~15000	1200~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0402	15	180	14000~15000	1400~1800	0.15~0.2	0.15~0.2	3D銑 3D MILLING

被切削材 Work Material		鉻鉬合金鋼 Chromium Molybdenum Alloy Steels SCM440 : 1.7225 : 4140 : 42CrMoA (HRC25~28)					
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
RTG0403	15	90	7000~7500	700~1000	0.05~0.1	4	溝銑 SLOTTING
RTG0403	15	90	7000~7500	800~1200	0.2~0.3	4	溝銑 SLOTTING
RTG0403	15	90	7000~7500	700~1000	4~8	0.05~0.1	側銑 SIDE MILLING
RTG0403	15	90	7000~7500	1000~1400	4~8	0.2~0.3	側銑 SIDE MILLING
RTG0403	15	120	9000~10000	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0403	15	120	9000~10000	1000~1400	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0403	15	180	14000~15000	1200~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0403	15	180	14000~15000	1400~1800	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0405	15	90	7000~7500	700~1000	0.05~0.1	4	溝銑 SLOTTING
RTG0405	15	90	7000~7500	800~1200	0.2~0.3	4	溝銑 SLOTTING
RTG0405	15	90	7000~7500	700~1000	4~8	0.05~0.1	側銑 SIDE MILLING
RTG0405	15	90	7000~7500	1000~1400	4~8	0.2~0.3	側銑 SIDE MILLING
RTG0405	15	120	9000~10000	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0405	15	120	9000~10000	1000~1400	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0405	15	180	14000~15000	1200~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0405	15	180	14000~15000	1400~1800	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0503	17	95	5700~6200	700~1100	0.05~0.1	5	溝銑 SLOTTING
RTG0503	17	95	5700~6200	800~1200	0.2~0.3	5	溝銑 SLOTTING
RTG0503	17	95	5700~6200	700~1000	5~10	0.05~0.1	側銑 SIDE MILLING
RTG0503	17	95	5700~6200	1000~1400	5~10	0.2~0.3	側銑 SIDE MILLING
RTG0503	17	150	9000~10000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0503	17	150	9000~10000	1200~1600	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0503	17	180	11000~12000	1200~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0503	17	180	11000~12000	1600~2000	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0505	17	95	5700~6200	700~1100	0.05~0.1	5	溝銑 SLOTTING
RTG0505	17	95	5700~6200	800~1200	0.2~0.3	5	溝銑 SLOTTING
RTG0505	17	95	5700~6200	700~1000	5~10	0.05~0.1	側銑 SIDE MILLING
RTG0505	17	95	5700~6200	1000~1400	5~10	0.2~0.3	側銑 SIDE MILLING
RTG0505	17	150	9000~10000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0505	17	150	9000~10000	1200~1600	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0505	17	180	11000~12000	1200~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0505	17	180	11000~12000	1600~2000	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0602	20	95	4700~5200	700~1100	0.05~0.1	6	溝銑 SLOTTING
RTG0602	20	95	4700~5200	800~1200	0.2~0.3	6	溝銑 SLOTTING
RTG0602	20	95	4700~5200	700~1000	6~12	0.05~0.1	側銑 SIDE MILLING
RTG0602	20	95	4700~5200	1000~1400	6~12	0.2~0.3	側銑 SIDE MILLING
RTG0602	20	180	9000~10000	1400~1800	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0602	20	180	9000~10000	1600~2000	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTG0603	20	95	4700~5200	700~1100	0.05~0.1	6	溝銑 SLOTTING
RTG0603	20	95	4700~5200	800~1200	0.2~0.3	6	溝銑 SLOTTING
RTG0603	20	95	4700~5200	700~1000	6~12	0.05~0.1	側銑 SIDE MILLING
RTG0603	20	95	4700~5200	1000~1400	6~12	0.2~0.3	側銑 SIDE MILLING
RTG0603	20	180	9000~10000	1400~1800	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0603	20	180	9000~10000	1600~2000	0.2~0.25	0.2~0.25	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		鉻鉬合金鋼 Chromium Molybdenum Alloy Steels SCM440 : 1.7225 : 4140 : 42CrMoA (HRC25~28)					
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
RTG0605	20	95	4700~5200	700~1100	0.05~0.1	6	溝銑 SLOTTING
RTG0605	20	95	4700~5200	800~1200	0.2~0.3	6	溝銑 SLOTTING
RTG0605	20	95	4700~5200	700~1000	6~12	0.05~0.1	側銑 SIDE MILLING
RTG0605	20	95	4700~5200	1000~1400	6~12	0.2~0.3	側銑 SIDE MILLING
RTG0605	20	180	9000~10000	1400~1800	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0605	20	180	9000~10000	1600~2000	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTG0610	20	95	4700~5200	700~1100	0.05~0.1	6	溝銑 SLOTTING
RTG0610	20	95	4700~5200	800~1200	0.2~0.3	6	溝銑 SLOTTING
RTG0610	20	95	4700~5200	700~1000	6~12	0.05~0.1	側銑 SIDE MILLING
RTG0610	20	95	4700~5200	1000~1400	6~12	0.2~0.3	側銑 SIDE MILLING
RTG0610	20	180	9000~10000	1400~1800	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0610	20	180	9000~10000	1600~2000	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTG0803	30	100	3800~4300	700~1000	0.05~0.1	8	溝銑 SLOTTING
RTG0803	30	100	3800~4300	800~1200	0.25~0.35	8	溝銑 SLOTTING
RTG0803	30	100	3800~4300	700~1000	8~16	0.05~0.1	側銑 SIDE MILLING
RTG0803	30	100	3800~4300	1000~1400	8~16	0.25~0.35	側銑 SIDE MILLING
RTG0803	30	190	7200~7700	1400~1800	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0803	30	190	7200~7700	1800~2200	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG0805	30	100	3800~4300	700~1000	0.05~0.1	8	溝銑 SLOTTING
RTG0805	30	100	3800~4300	800~1200	0.25~0.35	8	溝銑 SLOTTING
RTG0805	30	100	3800~4300	700~1000	8~16	0.05~0.1	側銑 SIDE MILLING
RTG0805	30	100	3800~4300	1000~1400	8~16	0.25~0.35	側銑 SIDE MILLING
RTG0805	30	190	7200~7700	1400~1800	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0805	30	190	7200~7700	1800~2200	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1002	30	95	2800~3300	700~1000	0.05~0.1	10	溝銑 SLOTTING
RTG1002	30	95	2800~3300	1000~1400	0.25~0.35	10	溝銑 SLOTTING
RTG1002	30	95	2800~3300	700~1000	10~20	0.05~0.1	側銑 SIDE MILLING
RTG1002	30	95	2800~3300	1000~1400	10~20	0.25~0.35	側銑 SIDE MILLING
RTG1002	30	190	5800~6300	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1002	30	190	5800~6300	1400~1800	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1003	30	95	2800~3300	700~1000	0.05~0.1	10	溝銑 SLOTTING
RTG1003	30	95	2800~3300	1000~1400	0.25~0.35	10	溝銑 SLOTTING
RTG1003	30	95	2800~3300	700~1000	10~20	0.05~0.1	側銑 SIDE MILLING
RTG1003	30	95	2800~3300	1000~1400	10~20	0.25~0.35	側銑 SIDE MILLING
RTG1003	30	190	5800~6300	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1003	30	190	5800~6300	1400~1800	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1005	30	95	2800~3300	700~1000	0.05~0.1	10	溝銑 SLOTTING
RTG1005	30	95	2800~3300	1000~1400	0.25~0.35	10	溝銑 SLOTTING
RTG1005	30	95	2800~3300	700~1000	10~20	0.05~0.1	側銑 SIDE MILLING
RTG1005	30	95	2800~3300	1000~1400	10~20	0.25~0.35	側銑 SIDE MILLING
RTG1005	30	190	5800~6300	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1005	30	190	5800~6300	1400~1800	0.25~0.3	0.25~0.3	3D銑 3D MILLING

被切劑材 Work Material		鉻鉬合金鋼 Chromium Molybdenum Alloy Steels SCM440 : 1.7225 : 4140 : 42CrMoA (HRc25~28)					
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
RTG1010	30	95	2800~3300	700~1000	0.05~0.1	10	溝銑 SLOTTING
RTG1010	30	95	2800~3300	1000~1400	0.25~0.35	10	溝銑 SLOTTING
RTG1010	30	95	2800~3300	700~1000	10~20	0.05~0.1	側銑 SIDE MILLING
RTG1010	30	95	2800~3300	1000~1400	10~20	0.25~0.35	側銑 SIDE MILLING
RTG1010	30	190	5800~6300	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1010	30	190	5800~6300	1400~1800	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1203	35	90	2200~2700	700~1000	0.05~0.1	12	溝銑 SLOTTING
RTG1203	35	90	2200~2700	800~1200	0.25~0.35	12	溝銑 SLOTTING
RTG1203	35	90	2200~2700	700~1000	12~24	0.05~0.1	側銑 SIDE MILLING
RTG1203	35	90	2200~2700	800~1200	12~24	0.25~0.35	側銑 SIDE MILLING
RTG1203	35	190	4800~5300	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1203	35	190	4800~5300	1400~1800	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1205	35	90	2200~2700	700~1000	0.05~0.1	12	溝銑 SLOTTING
RTG1205	35	90	2200~2700	800~1200	0.25~0.35	12	溝銑 SLOTTING
RTG1205	35	90	2200~2700	700~1000	12~24	0.05~0.1	側銑 SIDE MILLING
RTG1205	35	90	2200~2700	800~1200	12~24	0.25~0.35	側銑 SIDE MILLING
RTG1205	35	190	4800~5300	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1205	35	190	4800~5300	1400~1800	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1210	35	90	2200~2700	700~1000	0.05~0.1	12	溝銑 SLOTTING
RTG1210	35	90	2200~2700	800~1200	0.25~0.35	12	溝銑 SLOTTING
RTG1210	35	90	2200~2700	700~1000	12~24	0.05~0.1	側銑 SIDE MILLING
RTG1210	35	90	2200~2700	800~1200	12~24	0.25~0.35	側銑 SIDE MILLING
RTG1210	35	190	4800~5300	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1210	35	190	4800~5300	1400~1800	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1215	35	90	2200~2700	700~1000	0.05~0.1	12	溝銑 SLOTTING
RTG1215	35	90	2200~2700	800~1200	0.25~0.35	12	溝銑 SLOTTING
RTG1215	35	90	2200~2700	700~1000	12~24	0.05~0.1	側銑 SIDE MILLING
RTG1215	35	90	2200~2700	800~1200	12~24	0.25~0.35	側銑 SIDE MILLING
RTG1215	35	190	4800~5300	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1215	35	190	4800~5300	1400~1800	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1220	35	90	2200~2700	700~1000	0.05~0.1	12	溝銑 SLOTTING
RTG1220	35	90	2200~2700	800~1200	0.25~0.35	12	溝銑 SLOTTING
RTG1220	35	90	2200~2700	700~1000	12~24	0.05~0.1	側銑 SIDE MILLING
RTG1220	35	90	2200~2700	800~1200	12~24	0.25~0.35	側銑 SIDE MILLING
RTG1220	35	190	4800~5300	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1220	35	190	4800~5300	1400~1800	0.25~0.3	0.25~0.3	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
RTG0102	12	30	9000~10000	400~700	0.05~0.1	1	溝銑 SLOTTING
RTG0102	12	30	9000~10000	400~700	0.2	1	溝銑 SLOTTING
RTG0102	12	30	9000~10000	400~700	1~2	0.05~0.1	側銑 SIDE MILLING
RTG0102	12	30	9000~10000	400~700	1~2	0.2	側銑 SIDE MILLING
RTG0102	12	30	9000~10000	700~1000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0102	12	30	9000~10000	700~1100	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0102	12	60	18000~20000	700~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0102	12	60	18000~20000	800~1200	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0152	12	45	9000~10000	400~700	0.05~0.1	1.5	溝銑 SLOTTING
RTG0152	12	45	9000~10000	400~700	0.2	1.5	溝銑 SLOTTING
RTG0152	12	45	9000~10000	400~700	1.5~3	0.05~0.1	側銑 SIDE MILLING
RTG0152	12	45	9000~10000	400~700	1.5~3	0.2	側銑 SIDE MILLING
RTG0152	12	45	9000~10000	700~1000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0152	12	45	9000~10000	700~1100	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0152	12	90	18000~20000	700~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0152	12	90	18000~20000	800~1200	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0202	12	60	9000~9500	500~800	0.05~0.1	2	溝銑 SLOTTING
RTG0202	12	60	9000~9500	700~1000	0.2	2	溝銑 SLOTTING
RTG0202	12	60	9000~9500	500~800	2~4	0.05~0.1	側銑 SIDE MILLING
RTG0202	12	60	9000~9500	700~1000	2~4	0.2	側銑 SIDE MILLING
RTG0202	12	60	9000~10000	700~1000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0202	12	60	9000~10000	800~1200	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0202	12	105	16000~18000	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0202	12	105	16000~18000	1000~1400	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0205	12	60	9000~9500	500~800	0.05~0.1	2	溝銑 SLOTTING
RTG0205	12	60	9000~9500	700~1000	0.2	2	溝銑 SLOTTING
RTG0205	12	60	9000~9500	500~800	2~4	0.05~0.1	側銑 SIDE MILLING
RTG0205	12	60	9000~9500	700~1000	2~4	0.2	側銑 SIDE MILLING
RTG0205	12	60	9000~10000	700~1000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0205	12	60	9000~10000	800~1200	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0205	12	105	16000~18000	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0205	12	105	16000~18000	1000~1400	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0252	12	70	9000~9500	500~800	0.05~0.1	2.5	溝銑 SLOTTING
RTG0252	12	70	9000~9500	700~1100	0.2	2.5	溝銑 SLOTTING
RTG0252	12	70	9000~9500	700~1000	2.5~5	0.05~0.1	側銑 SIDE MILLING
RTG0252	12	70	9000~9500	800~1200	2.5~5	0.2	側銑 SIDE MILLING
RTG0252	12	75	9000~10000	700~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0252	12	75	9000~10000	800~1200	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0252	12	135	16000~18000	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0252	12	135	16000~18000	1200~1600	0.15~0.2	0.15~0.2	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
RTG0255	12	70	9000~9500	500~800	0.05~0.1	2.5	溝銑 SLOTTING
RTG0255	12	70	9000~9500	700~1100	0.2	2.5	溝銑 SLOTTING
RTG0255	12	70	9000~9500	700~1000	2.5~5	0.05~0.1	側銑 SIDE MILLING
RTG0255	12	70	9000~9500	800~1200	2.5~5	0.2	側銑 SIDE MILLING
RTG0255	12	75	9000~10000	700~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0255	12	75	9000~10000	800~1200	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0255	12	135	16000~18000	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0255	12	135	16000~18000	1200~1600	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0302	12	80	8500~9000	500~800	0.05~0.1	3	溝銑 SLOTTING
RTG0302	12	80	8500~9000	700~1100	0.2	3	溝銑 SLOTTING
RTG0302	12	80	8500~9000	700~1000	3~6	0.05~0.1	側銑 SIDE MILLING
RTG0302	12	80	8500~9000	800~1200	3~6	0.2	側銑 SIDE MILLING
RTG0302	12	90	9000~10000	700~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0302	12	90	9000~10000	800~1200	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0302	12	160	16000~18000	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0302	12	160	16000~18000	1200~1600	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0303	12	80	8500~9000	500~800	0.05~0.1	3	溝銑 SLOTTING
RTG0303	12	80	8500~9000	700~1100	0.2	3	溝銑 SLOTTING
RTG0303	12	80	8500~9000	700~1000	3~6	0.05~0.1	側銑 SIDE MILLING
RTG0303	12	80	8500~9000	800~1200	3~6	0.2	側銑 SIDE MILLING
RTG0303	12	90	9000~10000	700~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0303	12	90	9000~10000	800~1200	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0303	12	160	16000~18000	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0303	12	160	16000~18000	1200~1600	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0305	12	80	8500~9000	500~800	0.05~0.1	3	溝銑 SLOTTING
RTG0305	12	80	8500~9000	700~1100	0.2	3	溝銑 SLOTTING
RTG0305	12	80	8500~9000	700~1000	3~6	0.05~0.1	側銑 SIDE MILLING
RTG0305	12	80	8500~9000	800~1200	3~6	0.2	側銑 SIDE MILLING
RTG0305	12	90	9000~10000	700~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0305	12	90	9000~10000	800~1200	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0305	12	160	16000~18000	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0305	12	160	16000~18000	1200~1600	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0402	15	90	7000~7500	500~800	0.05~0.1	4	溝銑 SLOTTING
RTG0402	15	90	7000~7500	700~1000	0.2~0.3	4	溝銑 SLOTTING
RTG0402	15	90	7000~7500	500~800	4~8	0.05~0.1	側銑 SIDE MILLING
RTG0402	15	90	7000~7500	800~1200	4~8	0.2~0.3	側銑 SIDE MILLING
RTG0402	15	120	9000~10000	700~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0402	15	120	9000~10000	800~1200	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0402	15	180	14000~15000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0402	15	180	14000~15000	1200~1600	0.15~0.2	0.15~0.2	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
RTG0403	15	90	7000~7500	500~800	0.05~0.1	4	溝銑 SLOTTING
RTG0403	15	90	7000~7500	700~1000	0.2~0.3	4	溝銑 SLOTTING
RTG0403	15	90	7000~7500	500~800	4~8	0.05~0.1	側銑 SIDE MILLING
RTG0403	15	90	7000~7500	800~1200	4~8	0.2~0.3	側銑 SIDE MILLING
RTG0403	15	120	9000~10000	700~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0403	15	120	9000~10000	800~1200	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0403	15	180	14000~15000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0403	15	180	14000~15000	1200~1600	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0405	15	90	7000~7500	500~800	0.05~0.1	4	溝銑 SLOTTING
RTG0405	15	90	7000~7500	700~1000	0.2~0.3	4	溝銑 SLOTTING
RTG0405	15	90	7000~7500	500~800	4~8	0.05~0.1	側銑 SIDE MILLING
RTG0405	15	90	7000~7500	800~1200	4~8	0.2~0.3	側銑 SIDE MILLING
RTG0405	15	120	9000~10000	700~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0405	15	120	9000~10000	800~1200	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0405	15	180	14000~15000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0405	15	180	14000~15000	1200~1600	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0503	17	95	5700~6200	500~800	0.05~0.1	5	溝銑 SLOTTING
RTG0503	17	95	5700~6200	700~1000	0.2~0.3	5	溝銑 SLOTTING
RTG0503	17	95	5700~6200	500~800	5~10	0.05~0.1	側銑 SIDE MILLING
RTG0503	17	95	5700~6200	800~1200	5~10	0.2~0.3	側銑 SIDE MILLING
RTG0503	17	150	9000~10000	700~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0503	17	150	9000~10000	800~1200	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0503	17	180	11000~12000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0503	17	180	11000~12000	1200~1600	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0505	17	95	5700~6200	500~800	0.05~0.1	5	溝銑 SLOTTING
RTG0505	17	95	5700~6200	700~1000	0.2~0.3	5	溝銑 SLOTTING
RTG0505	17	95	5700~6200	500~800	5~10	0.05~0.1	側銑 SIDE MILLING
RTG0505	17	95	5700~6200	800~1200	5~10	0.2~0.3	側銑 SIDE MILLING
RTG0505	17	150	9000~10000	700~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0505	17	150	9000~10000	800~1200	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0505	17	180	11000~12000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0505	17	180	11000~12000	1200~1600	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0602	20	95	4700~5200	500~800	0.05~0.1	6	溝銑 SLOTTING
RTG0602	20	95	4700~5200	700~1000	0.2~0.3	6	溝銑 SLOTTING
RTG0602	20	95	4700~5200	500~800	6~12	0.05~0.1	側銑 SIDE MILLING
RTG0602	20	95	4700~5200	800~1200	6~12	0.2~0.3	側銑 SIDE MILLING
RTG0602	20	180	9000~10000	1200~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0602	20	180	9000~10000	1400~1800	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTG0603	20	95	4700~5200	500~800	0.05~0.1	6	溝銑 SLOTTING
RTG0603	20	95	4700~5200	700~1000	0.2~0.3	6	溝銑 SLOTTING
RTG0603	20	95	4700~5200	500~800	6~12	0.05~0.1	側銑 SIDE MILLING
RTG0603	20	95	4700~5200	800~1200	6~12	0.2~0.3	側銑 SIDE MILLING
RTG0603	20	180	9000~10000	1200~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0603	20	180	9000~10000	1400~1800	0.2~0.25	0.2~0.25	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
RTG0605	20	95	4700~5200	500~800	0.05~0.1	6	溝銑 SLOTTING
RTG0605	20	95	4700~5200	700~1000	0.2~0.3	6	溝銑 SLOTTING
RTG0605	20	95	4700~5200	500~800	6~12	0.05~0.1	側銑 SIDE MILLING
RTG0605	20	95	4700~5200	800~1200	6~12	0.2~0.3	側銑 SIDE MILLING
RTG0605	20	180	9000~10000	1200~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0605	20	180	9000~10000	1400~1800	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTG0610	20	95	4700~5200	500~800	0.05~0.1	6	溝銑 SLOTTING
RTG0610	20	95	4700~5200	700~1000	0.2~0.3	6	溝銑 SLOTTING
RTG0610	20	95	4700~5200	500~800	6~12	0.05~0.1	側銑 SIDE MILLING
RTG0610	20	95	4700~5200	800~1200	6~12	0.2~0.3	側銑 SIDE MILLING
RTG0610	20	180	9000~10000	1200~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0610	20	180	9000~10000	1400~1800	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTG0803	30	100	3800~4300	500~800	0.05~0.1	8	溝銑 SLOTTING
RTG0803	30	100	3800~4300	700~1000	0.25~0.35	8	溝銑 SLOTTING
RTG0803	30	100	3800~4300	500~800	8~16	0.05~0.1	側銑 SIDE MILLING
RTG0803	30	100	3800~4300	800~1200	8~16	0.25~0.35	側銑 SIDE MILLING
RTG0803	30	190	7200~7700	1200~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0803	30	190	7200~7700	1600~2000	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG0805	30	100	3800~4300	500~800	0.05~0.1	8	溝銑 SLOTTING
RTG0805	30	100	3800~4300	700~1000	0.25~0.35	8	溝銑 SLOTTING
RTG0805	30	100	3800~4300	500~800	8~16	0.05~0.1	側銑 SIDE MILLING
RTG0805	30	100	3800~4300	800~1200	8~16	0.25~0.35	側銑 SIDE MILLING
RTG0805	30	190	7200~7700	1200~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0805	30	190	7200~7700	1600~2000	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1002	30	95	2800~3300	500~800	0.05~0.1	10	溝銑 SLOTTING
RTG1002	30	95	2800~3300	800~1200	0.25~0.35	10	溝銑 SLOTTING
RTG1002	30	75	2200~2700	500~800	10~20	0.05~0.1	側銑 SIDE MILLING
RTG1002	30	75	2200~2700	800~1200	10~20	0.25~0.35	側銑 SIDE MILLING
RTG1002	30	190	5800~6300	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1002	30	190	5800~6300	1200~1600	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1003	30	95	2800~3300	500~800	0.05~0.1	10	溝銑 SLOTTING
RTG1003	30	95	2800~3300	800~1200	0.25~0.35	10	溝銑 SLOTTING
RTG1003	30	75	2200~2700	500~800	10~20	0.05~0.1	側銑 SIDE MILLING
RTG1003	30	75	2200~2700	800~1200	10~20	0.25~0.35	側銑 SIDE MILLING
RTG1003	30	190	5800~6300	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1003	30	190	5800~6300	1200~1600	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1005	30	95	2800~3300	500~800	0.05~0.1	10	溝銑 SLOTTING
RTG1005	30	95	2800~3300	800~1200	0.25~0.35	10	溝銑 SLOTTING
RTG1005	30	75	2200~2700	500~800	10~20	0.05~0.1	側銑 SIDE MILLING
RTG1005	30	75	2200~2700	800~1200	10~20	0.25~0.35	側銑 SIDE MILLING
RTG1005	30	190	5800~6300	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1005	30	190	5800~6300	1200~1600	0.25~0.3	0.25~0.3	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
RTG1010	30	95	2800~3300	500~800	0.05~0.1	10	溝銑 SLOTTING
RTG1010	30	95	2800~3300	800~1200	0.25~0.35	10	溝銑 SLOTTING
RTG1010	30	75	2200~2700	500~800	10~20	0.05~0.1	側銑 SIDE MILLING
RTG1010	30	75	2200~2700	800~1200	10~20	0.25~0.35	側銑 SIDE MILLING
RTG1010	30	190	5800~6300	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1010	30	190	5800~6300	1200~1600	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1203	35	90	2200~2700	500~800	0.05~0.1	12	溝銑 SLOTTING
RTG1203	35	90	2200~2700	700~1000	0.25~0.35	12	溝銑 SLOTTING
RTG1203	35	75	1800~2300	500~800	12~24	0.05~0.1	側銑 SIDE MILLING
RTG1203	35	75	1800~2300	700~1000	12~24	0.25~0.35	側銑 SIDE MILLING
RTG1203	35	190	4800~5300	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1203	35	190	4800~5300	1000~1400	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1205	35	90	2200~2700	500~800	0.05~0.1	12	溝銑 SLOTTING
RTG1205	35	90	2200~2700	700~1000	0.25~0.35	12	溝銑 SLOTTING
RTG1205	35	75	1800~2300	500~800	12~24	0.05~0.1	側銑 SIDE MILLING
RTG1205	35	75	1800~2300	700~1000	12~24	0.25~0.35	側銑 SIDE MILLING
RTG1205	35	190	4800~5300	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1205	35	190	4800~5300	1000~1400	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1210	35	90	2200~2700	500~800	0.05~0.1	12	溝銑 SLOTTING
RTG1210	35	90	2200~2700	700~1000	0.25~0.35	12	溝銑 SLOTTING
RTG1210	35	75	1800~2300	500~800	12~24	0.05~0.1	側銑 SIDE MILLING
RTG1210	35	75	1800~2300	700~1000	12~24	0.25~0.35	側銑 SIDE MILLING
RTG1210	35	190	4800~5300	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1210	35	190	4800~5300	1000~1400	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1215	35	90	2200~2700	500~800	0.05~0.1	12	溝銑 SLOTTING
RTG1215	35	90	2200~2700	700~1000	0.25~0.35	12	溝銑 SLOTTING
RTG1215	35	75	1800~2300	500~800	12~24	0.05~0.1	側銑 SIDE MILLING
RTG1215	35	75	1800~2300	700~1000	12~24	0.25~0.35	側銑 SIDE MILLING
RTG1215	35	190	4800~5300	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1215	35	190	4800~5300	1000~1400	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1220	35	90	2200~2700	500~800	0.05~0.1	12	溝銑 SLOTTING
RTG1220	35	90	2200~2700	700~1000	0.25~0.35	12	溝銑 SLOTTING
RTG1220	35	75	1800~2300	500~800	12~24	0.05~0.1	側銑 SIDE MILLING
RTG1220	35	75	1800~2300	700~1000	12~24	0.25~0.35	側銑 SIDE MILLING
RTG1220	35	190	4800~5300	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1220	35	190	4800~5300	1000~1400	0.25~0.3	0.25~0.3	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		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
RTG0102	12	30	9000~10000	400~700	0.05~0.1	1	溝銑 SLOTTING
RTG0102	12	30	9000~10000	400~600	0.2	1	溝銑 SLOTTING
RTG0102	12	30	9000~10000	400~600	1~2	0.05~0.1	側銑 SIDE MILLING
RTG0102	12	30	9000~10000	400~600	1~2	0.2	側銑 SIDE MILLING
RTG0102	12	30	9000~10000	700~1000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0102	12	30	9000~10000	700~1000	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0102	12	60	18000~20000	700~1000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0102	12	60	18000~20000	800~1100	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0152	12	45	9000~10000	400~700	0.05~0.1	1.5	溝銑 SLOTTING
RTG0152	12	45	9000~10000	400~600	0.2	1.5	溝銑 SLOTTING
RTG0152	12	45	9000~10000	400~600	1.5~3	0.05~0.1	側銑 SIDE MILLING
RTG0152	12	45	9000~10000	400~600	1.5~3	0.2	側銑 SIDE MILLING
RTG0152	12	45	9000~10000	700~1000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0152	12	45	9000~10000	700~1000	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0152	12	90	18000~20000	700~1000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0152	12	90	18000~20000	800~1100	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0202	12	60	9000~9500	500~800	0.05~0.1	2	溝銑 SLOTTING
RTG0202	12	60	9000~9500	700~900	0.2	2	溝銑 SLOTTING
RTG0202	12	60	9000~9500	500~700	2~4	0.05~0.1	側銑 SIDE MILLING
RTG0202	12	60	9000~9500	700~900	2~4	0.2	側銑 SIDE MILLING
RTG0202	12	60	9000~10000	700~900	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0202	12	60	9000~10000	800~1200	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0202	12	105	16000~18000	800~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0202	12	105	16000~18000	1000~1300	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0205	12	60	9000~9500	500~800	0.05~0.1	2	溝銑 SLOTTING
RTG0205	12	60	9000~9500	700~900	0.2	2	溝銑 SLOTTING
RTG0205	12	60	9000~9500	500~700	2~4	0.05~0.1	側銑 SIDE MILLING
RTG0205	12	60	9000~9500	700~900	2~4	0.2	側銑 SIDE MILLING
RTG0205	12	60	9000~10000	700~900	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0205	12	60	9000~10000	800~1100	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0205	12	105	16000~18000	800~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0205	12	105	16000~18000	1000~1300	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0252	12	70	9000~9500	500~800	0.05~0.1	2.5	溝銑 SLOTTING
RTG0252	12	70	9000~9500	700~1000	0.2	2.5	溝銑 SLOTTING
RTG0252	12	70	9000~9500	700~900	2.5~5	0.05~0.1	側銑 SIDE MILLING
RTG0252	12	70	9000~9500	800~1100	2.5~5	0.2	側銑 SIDE MILLING
RTG0252	12	75	9000~10000	700~1000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0252	12	75	9000~10000	800~1100	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0252	12	135	16000~18000	800~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0252	12	135	16000~18000	1200~1500	0.15~0.2	0.15~0.2	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
RTG0255	12	70	9000~9500	500~800	0.05~0.1	2.5	溝銑 SLOTTING
RTG0255	12	70	9000~9500	700~1000	0.2	2.5	溝銑 SLOTTING
RTG0255	12	70	9000~9500	700~900	2.5~5	0.05~0.1	側銑 SIDE MILLING
RTG0255	12	70	9000~9500	800~1100	2.5~5	0.2	側銑 SIDE MILLING
RTG0255	12	75	9000~10000	700~1000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0255	12	75	9000~10000	800~1100	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0255	12	135	16000~18000	800~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0255	12	135	16000~18000	1200~1500	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0302	12	80	8500~9000	500~800	0.05~0.1	3	溝銑 SLOTTING
RTG0302	12	80	8500~9000	700~1000	0.2	3	溝銑 SLOTTING
RTG0302	12	80	8500~9000	700~900	3~6	0.05~0.1	側銑 SIDE MILLING
RTG0302	12	80	8500~9000	800~1100	3~6	0.2	側銑 SIDE MILLING
RTG0302	12	90	9000~10000	700~1000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0302	12	90	9000~10000	800~1100	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0302	12	160	16000~18000	800~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0302	12	160	16000~18000	1200~1500	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0303	12	80	8500~9000	500~800	0.05~0.1	3	溝銑 SLOTTING
RTG0303	12	80	8500~9000	700~1000	0.2	3	溝銑 SLOTTING
RTG0303	12	80	8500~9000	700~900	3~6	0.05~0.1	側銑 SIDE MILLING
RTG0303	12	80	8500~9000	800~1100	3~6	0.2	側銑 SIDE MILLING
RTG0303	12	90	9000~10000	700~1000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0303	12	90	9000~10000	800~1100	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0303	12	160	16000~18000	800~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0303	12	160	16000~18000	1200~1500	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0305	12	80	8500~9000	500~800	0.05~0.1	3	溝銑 SLOTTING
RTG0305	12	80	8500~9000	700~1000	0.2	3	溝銑 SLOTTING
RTG0305	12	80	8500~9000	700~900	3~6	0.05~0.1	側銑 SIDE MILLING
RTG0305	12	80	8500~9000	800~1100	3~6	0.2	側銑 SIDE MILLING
RTG0305	12	90	9000~10000	700~1000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0305	12	90	9000~10000	800~1100	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0305	12	160	16000~18000	800~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0305	12	160	16000~18000	1200~1500	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0402	15	90	7000~7500	500~800	0.05~0.1	4	溝銑 SLOTTING
RTG0402	15	90	7000~7500	700~1000	0.2~0.3	4	溝銑 SLOTTING
RTG0402	15	90	7000~7500	700~900	4~8	0.05~0.1	側銑 SIDE MILLING
RTG0402	15	90	7000~7500	800~1100	4~8	0.2~0.3	側銑 SIDE MILLING
RTG0402	15	120	9000~10000	700~1000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0402	15	120	9000~10000	800~1100	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0402	15	180	14000~15000	800~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0402	15	180	14000~15000	1200~1500	0.15~0.2	0.15~0.2	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
RTG0403	15	90	7000~7500	500~800	0.05~0.1	4	溝銑 SLOTTING
RTG0403	15	90	7000~7500	700~1000	0.2~0.3	4	溝銑 SLOTTING
RTG0403	15	90	7000~7500	700~900	4~8	0.05~0.1	側銑 SIDE MILLING
RTG0403	15	90	7000~7500	800~1100	4~8	0.2~0.3	側銑 SIDE MILLING
RTG0403	15	120	9000~10000	700~1000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0403	15	120	9000~10000	800~1100	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0403	15	180	14000~15000	800~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0403	15	180	14000~15000	1200~1500	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0405	15	90	7000~7500	500~800	0.05~0.1	4	溝銑 SLOTTING
RTG0405	15	90	7000~7500	700~1000	0.2~0.3	4	溝銑 SLOTTING
RTG0405	15	90	7000~7500	700~900	4~8	0.05~0.1	側銑 SIDE MILLING
RTG0405	15	90	7000~7500	800~1100	4~8	0.2~0.3	側銑 SIDE MILLING
RTG0405	15	120	9000~10000	700~1000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0405	15	120	9000~10000	800~1100	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0405	15	180	14000~15000	800~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0405	15	180	14000~15000	1200~1500	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0503	17	95	5700~6200	500~800	0.05~0.1	5	溝銑 SLOTTING
RTG0503	17	95	5700~6200	700~1000	0.2~0.3	5	溝銑 SLOTTING
RTG0503	17	95	5700~6200	700~900	5~10	0.05~0.1	側銑 SIDE MILLING
RTG0503	17	95	5700~6200	800~1100	5~10	0.2~0.3	側銑 SIDE MILLING
RTG0503	17	150	9000~10000	700~1000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0503	17	150	9000~10000	800~1100	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0503	17	180	11000~12000	800~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0503	17	180	11000~12000	1200~1500	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0505	17	95	5700~6200	500~800	0.05~0.1	5	溝銑 SLOTTING
RTG0505	17	95	5700~6200	700~1000	0.2~0.3	5	溝銑 SLOTTING
RTG0505	17	95	5700~6200	700~900	5~10	0.05~0.1	側銑 SIDE MILLING
RTG0505	17	95	5700~6200	800~1100	5~10	0.2~0.3	側銑 SIDE MILLING
RTG0505	17	150	9000~10000	700~1000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0505	17	150	9000~10000	800~1100	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0505	17	180	11000~12000	800~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0505	17	180	11000~12000	1200~1500	0.15~0.2	0.15~0.2	3D銑 3D MILLING
RTG0602	20	95	4700~5200	500~800	0.05~0.1	6	溝銑 SLOTTING
RTG0602	20	95	4700~5200	700~1000	0.2~0.3	6	溝銑 SLOTTING
RTG0602	20	95	4700~5200	500~800	6~12	0.05~0.1	側銑 SIDE MILLING
RTG0602	20	95	4700~5200	800~1200	6~12	0.2~0.3	側銑 SIDE MILLING
RTG0602	20	180	9000~10000	1200~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0602	20	180	9000~10000	1400~1800	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTG0603	20	95	4700~5200	500~800	0.05~0.1	6	溝銑 SLOTTING
RTG0603	20	95	4700~5200	700~1000	0.2~0.3	6	溝銑 SLOTTING
RTG0603	20	95	4700~5200	500~800	6~12	0.05~0.1	側銑 SIDE MILLING
RTG0603	20	95	4700~5200	800~1200	6~12	0.2~0.3	側銑 SIDE MILLING
RTG0603	20	180	9000~10000	1200~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0603	20	180	9000~10000	1400~1800	0.2~0.25	0.2~0.25	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		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
RTG0605	20	95	4700~5200	500~800	0.05~0.1	6	溝銑 SLOTTING
RTG0605	20	95	4700~5200	700~900	0.2~0.3	6	溝銑 SLOTTING
RTG0605	20	95	4700~5200	500~700	6~12	0.05~0.1	側銑 SIDE MILLING
RTG0605	20	95	4700~5200	800~1100	6~12	0.2~0.3	側銑 SIDE MILLING
RTG0605	20	180	9000~10000	1200~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0605	20	180	9000~10000	1400~1600	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTG0610	20	95	4700~5200	500~800	0.05~0.1	6	溝銑 SLOTTING
RTG0610	20	95	4700~5200	700~900	0.2~0.3	6	溝銑 SLOTTING
RTG0610	20	95	4700~5200	500~700	6~12	0.05~0.1	側銑 SIDE MILLING
RTG0610	20	95	4700~5200	800~1100	6~12	0.2~0.3	側銑 SIDE MILLING
RTG0610	20	180	9000~10000	1200~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0610	20	180	9000~10000	1400~1600	0.2~0.25	0.2~0.25	3D銑 3D MILLING
RTG0803	30	100	3800~4300	500~800	0.05~0.1	8	溝銑 SLOTTING
RTG0803	30	100	3800~4300	700~900	0.25~0.35	8	溝銑 SLOTTING
RTG0803	30	100	3800~4300	500~800	8~16	0.05~0.1	側銑 SIDE MILLING
RTG0803	30	100	3800~4300	800~1100	8~16	0.25~0.35	側銑 SIDE MILLING
RTG0803	30	190	7200~7700	1200~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0803	30	190	7200~7700	1600~1800	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG0805	30	100	3800~4300	500~800	0.05~0.1	8	溝銑 SLOTTING
RTG0805	30	100	3800~4300	700~900	0.25~0.35	8	溝銑 SLOTTING
RTG0805	30	100	3800~4300	500~800	8~16	0.05~0.1	側銑 SIDE MILLING
RTG0805	30	100	3800~4300	800~1100	8~16	0.25~0.35	側銑 SIDE MILLING
RTG0805	30	190	7200~7700	1200~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG0805	30	190	7200~7700	1600~1800	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1002	30	95	2800~3300	500~800	0.05~0.1	10	溝銑 SLOTTING
RTG1002	30	95	2800~3300	800~1200	0.25~0.35	10	溝銑 SLOTTING
RTG1002	30	75	2200~2700	500~800	10~20	0.05~0.1	側銑 SIDE MILLING
RTG1002	30	75	2200~2700	800~1200	10~20	0.25~0.35	側銑 SIDE MILLING
RTG1002	30	190	5800~6300	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1002	30	190	5800~6300	1200~1600	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1003	30	95	2800~3300	500~800	0.05~0.1	10	溝銑 SLOTTING
RTG1003	30	95	2800~3300	800~1200	0.25~0.35	10	溝銑 SLOTTING
RTG1003	30	75	2200~2700	500~800	10~20	0.05~0.1	側銑 SIDE MILLING
RTG1003	30	75	2200~2700	800~1200	10~20	0.25~0.35	側銑 SIDE MILLING
RTG1003	30	190	5800~6300	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1003	30	190	5800~6300	1200~1600	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1005	30	95	2800~3300	500~800	0.05~0.1	10	溝銑 SLOTTING
RTG1005	30	95	2800~3300	800~1200	0.25~0.35	10	溝銑 SLOTTING
RTG1005	30	75	2200~2700	500~800	10~20	0.05~0.1	側銑 SIDE MILLING
RTG1005	30	75	2200~2700	800~1200	10~20	0.25~0.35	側銑 SIDE MILLING
RTG1005	30	190	5800~6300	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1005	30	190	5800~6300	1200~1600	0.25~0.3	0.25~0.3	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
RTG1010	30	95	2800~3300	500~800	0.05~0.1	10	溝銑 SLOTTING
RTG1010	30	95	2800~3300	800~1200	0.25~0.35	10	溝銑 SLOTTING
RTG1010	30	75	2200~2700	500~800	10~20	0.05~0.1	側銑 SIDE MILLING
RTG1010	30	75	2200~2700	800~1200	10~20	0.25~0.35	側銑 SIDE MILLING
RTG1010	30	190	5800~6300	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1010	30	190	5800~6300	1200~1600	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1203	35	90	2200~2700	500~800	0.05~0.1	12	溝銑 SLOTTING
RTG1203	35	90	2200~2700	700~1000	0.25~0.35	12	溝銑 SLOTTING
RTG1203	35	75	1800~2300	500~800	12~24	0.05~0.1	側銑 SIDE MILLING
RTG1203	35	75	1800~2300	700~1000	12~24	0.25~0.35	側銑 SIDE MILLING
RTG1203	35	190	4800~5300	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1203	35	190	4800~5300	1000~1400	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1205	35	90	2200~2700	500~800	0.05~0.1	12	溝銑 SLOTTING
RTG1205	35	90	2200~2700	700~1000	0.25~0.35	12	溝銑 SLOTTING
RTG1205	35	75	1800~2300	500~800	12~24	0.05~0.1	側銑 SIDE MILLING
RTG1205	35	75	1800~2300	700~1000	12~24	0.25~0.35	側銑 SIDE MILLING
RTG1205	35	190	4800~5300	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1205	35	190	4800~5300	1000~1400	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1210	35	90	2200~2700	500~800	0.05~0.1	12	溝銑 SLOTTING
RTG1210	35	90	2200~2700	700~1000	0.25~0.35	12	溝銑 SLOTTING
RTG1210	35	75	1800~2300	500~800	12~24	0.05~0.1	側銑 SIDE MILLING
RTG1210	35	75	1800~2300	700~1000	12~24	0.25~0.35	側銑 SIDE MILLING
RTG1210	35	190	4800~5300	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1210	35	190	4800~5300	1000~1400	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1215	35	90	2200~2700	500~800	0.05~0.1	12	溝銑 SLOTTING
RTG1215	35	90	2200~2700	700~1000	0.25~0.35	12	溝銑 SLOTTING
RTG1215	35	75	1800~2300	500~800	12~24	0.05~0.1	側銑 SIDE MILLING
RTG1215	35	75	1800~2300	700~1000	12~24	0.25~0.35	側銑 SIDE MILLING
RTG1215	35	190	4800~5300	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1215	35	190	4800~5300	1000~1400	0.25~0.3	0.25~0.3	3D銑 3D MILLING
RTG1220	35	90	2200~2700	500~800	0.05~0.1	12	溝銑 SLOTTING
RTG1220	35	90	2200~2700	700~1000	0.25~0.35	12	溝銑 SLOTTING
RTG1220	35	75	1800~2300	500~800	12~24	0.05~0.1	側銑 SIDE MILLING
RTG1220	35	75	1800~2300	700~1000	12~24	0.25~0.35	側銑 SIDE MILLING
RTG1220	35	190	4800~5300	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
RTG1220	35	190	4800~5300	1000~1400	0.25~0.3	0.25~0.3	3D銑 3D MILLING

附註 / Note :

建議冷卻方式為濕式。

Suggest to use Wet coolant.