



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	切削速度 Cutting Speed (m/min)	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
UB0102	12mm	65	18000~20000	800~1000	0.06~0.08	0.12~0.16	3D銑(3D milling)
UB0102	12mm	65	18000~20000	1200~1600	0.03~0.04	0.06~0.08	3D銑(3D milling)
UB0152	13mm	85	17000~18000	800~1200	0.07~0.09	0.14~0.18	3D銑(3D milling)
UB0152	13mm	85	17000~18000	1400~1800	0.03~0.05	0.06~0.1	3D銑(3D milling)
UB0202	14mm	115	17000~18000	1000~1400	0.08~0.1	0.16~0.2	3D銑(3D milling)
UB0202	14mm	115	17000~18000	1800~2200	0.04~0.06	0.08~0.12	3D銑(3D milling)
UB0302	15mm	160	16000~17000	1400~1800	0.1~0.12	0.2~0.24	3D銑(3D milling)
UB0302	15mm	170	17000~18000	2400~2800	0.05~0.07	0.1~0.14	3D銑(3D milling)
UB0402	15mm	200	15000~16000	1800~2200	0.12~0.15	0.24~0.3	3D銑(3D milling)
UB0402	15mm	215	16000~17000	3600~4000	0.05~0.08	0.1~0.16	3D銑(3D milling)
UB0502	17mm	220	13000~14000	1800~2200	0.14~0.18	0.28~0.36	3D銑(3D milling)
UB0502	17mm	235	14000~15000	3600~4000	0.06~0.11	0.12~0.22	3D銑(3D milling)
UB0602	19mm	230	11000~12000	2000~2400	0.16~0.21	0.32~0.42	3D銑(3D milling)
UB0602	19mm	245	12000~13000	3800~4200	0.07~0.12	0.14~0.24	3D銑(3D milling)
UB0802	30mm	280	10000~11000	2000~2400	0.18~0.23	0.36~0.46	3D銑(3D milling)
UB0802	30mm	330	12000~13000	3800~4200	0.08~0.13	0.16~0.26	3D銑(3D milling)
UB1002	40mm	290	8700~9200	2600~3000	0.23~0.28	0.46~0.56	3D銑(3D milling)
UB1002	40mm	290	8700~9200	3800~4200	0.1~0.15	0.2~0.3	3D銑(3D milling)
UB1202	40mm	315	7800~8300	2400~2800	0.28~0.3	0.56~0.6	3D銑(3D milling)
UB1202	40mm	315	7800~8300	3600~4000	0.1~0.15	0.2~0.3	3D銑(3D milling)
UB1602	50mm	315	5700~6200	1400~1800	0.3~0.35	0.6~0.7	3D銑(3D milling)
UB1602	50mm	315	5700~6200	2400~2800	0.13~0.18	0.26~0.36	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	切削速度 Cutting Speed (m/min)	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
UB0102	12mm	65	18000~20000	800~1000	0.03~0.04	0.06~0.08	3D銑(3D milling)
UB0152	13mm	85	17000~18000	800~1200	0.03~0.05	0.06~0.1	3D銑(3D milling)
UB0202	14mm	115	17000~18000	1200~1600	0.03~0.05	0.06~0.1	3D銑(3D milling)
UB0302	15mm	170	17000~18000	1400~1800	0.04~0.06	0.08~0.12	3D銑(3D milling)
UB0402	15mm	200	15000~16000	2000~2400	0.04~0.07	0.08~0.14	3D銑(3D milling)
UB0502	17mm	220	13000~14000	2200~2600	0.05~0.07	0.1~0.14	3D銑(3D milling)
UB0602	19mm	230	11000~12000	2400~2800	0.06~0.08	0.12~0.16	3D銑(3D milling)
UB0802	30mm	280	10000~11000	2600~3000	0.06~0.09	0.12~0.18	3D銑(3D milling)
UB1002	40mm	260	7700~8200	2600~3000	0.08~0.12	0.16~0.24	3D銑(3D milling)
UB1202	40mm	305	7500~8000	1800~2200	0.08~0.13	0.16~0.26	3D銑(3D milling)
UB1602	50mm	255	4500~5000	1400~1800	0.1~0.15	0.2~0.3	3D銑(3D milling)

附註 / Note :

建議冷卻方式為乾式。

Suggest to use Dry coolant.