



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
UBT0102	13mm	65	18000~20000	600~800	0.06~0.08	0.12~0.16	3D銑(3D milling)
UBT0102	13mm	65	18000~20000	1000~1200	0.03~0.05	0.06~0.1	3D銑(3D milling)
UBT0152	14mm	95	18000~20000	700~900	0.06~0.08	0.12~0.16	3D銑(3D milling)
UBT0152	14mm	95	18000~20000	1000~1200	0.03~0.05	0.06~0.1	3D銑(3D milling)
UBT0202	15mm	115	17000~18000	700~900	0.08~0.1	0.16~0.2	3D銑(3D milling)
UBT0202	15mm	115	17000~18000	1600~1800	0.04~0.05	0.08~0.1	3D銑(3D milling)
UBT0302	17mm	160	16000~17000	1000~1200	0.1~0.12	0.2~0.24	3D銑(3D milling)
UBT0302	17mm	160	16000~17000	1800~2000	0.04~0.06	0.08~0.12	3D銑(3D milling)
UBT0402	20mm	200	15000~16000	1400~1600	0.12~0.15	0.24~0.3	3D銑(3D milling)
UBT0402	20mm	200	15000~16000	2400~2800	0.05~0.08	0.1~0.16	3D銑(3D milling)
UBT0502	20mm	235	13000~15000	1800~2000	0.13~0.17	0.26~0.34	3D銑(3D milling)
UBT0502	20mm	235	13000~15000	2800~3200	0.05~0.08	0.1~0.16	3D銑(3D milling)
UBT0602	20mm	245	11000~13000	1800~2000	0.14~0.18	0.28~0.36	3D銑(3D milling)
UBT0602	20mm	245	11000~13000	3000~3400	0.05~0.09	0.1~0.18	3D銑(3D milling)
UBT0802	24mm	280	10000~11000	1800~2000	0.15~0.2	0.3~0.4	3D銑(3D milling)
UBT0802	24mm	280	10000~11000	3000~3400	0.07~0.1	0.14~0.2	3D銑(3D milling)
UBT1002	35mm	290	8700~9200	1800~2200	0.2~0.3	0.4~0.6	3D銑(3D milling)
UBT1002	35mm	290	8700~9200	3000~3400	0.08~0.12	0.16~0.24	3D銑(3D milling)
UBT1202	37mm	275	6800~7300	2000~2400	0.2~0.3	0.4~0.6	3D銑(3D milling)
UBT1202	37mm	275	6800~7300	2600~3000	0.08~0.13	0.16~0.26	3D銑(3D milling)
UBT1602	50mm	250	4500~5000	1200~1400	0.3~0.35	0.6~0.7	3D銑(3D milling)
UBT1602	50mm	250	4500~5000	1800~2200	0.1~0.15	0.2~0.3	3D銑(3D milling)

附註 / Note :

建議冷卻方式為油霧。

Suggest to use MQL coolant.



被切削材 Work Material	熱處理鋼 : Hardened Steels SKD11 / SKH9 : 1.2379 / 1.3342 : D2 / M2 (HRC55~62)						
	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
UBT0102	13mm	65	18000~20000	400~600	0.03~0.05	0.06~0.1	3D銑(3D milling)
UBT0152	14mm	85	16000~18000	500~700	0.03~0.05	0.06~0.1	3D銑(3D milling)
UBT0202	15mm	100	14000~16000	600~800	0.04~0.05	0.08~0.1	3D銑(3D milling)
UBT0302	17mm	135	13000~14000	1200~1400	0.04~0.06	0.08~0.12	3D銑(3D milling)
UBT0402	20mm	150	11000~12000	1200~1600	0.04~0.06	0.08~0.12	3D銑(3D milling)
UBT0502	20mm	175	10000~11000	1800~2200	0.05~0.08	0.1~0.16	3D銑(3D milling)
UBT0602	20mm	210	10000~11000	1600~2000	0.05~0.08	0.1~0.16	3D銑(3D milling)
UBT0802	24mm	210	7800~8300	2000~2400	0.07~0.1	0.14~0.2	3D銑(3D milling)
UBT1002	35mm	230	6800~7300	2000~2400	0.08~0.12	0.16~0.24	3D銑(3D milling)
UBT1202	37mm	240	5800~6300	1800~2200	0.08~0.13	0.16~0.26	3D銑(3D milling)
UBT1602	50mm	185	3200~3700	1200~1600	0.1~0.15	0.2~0.3	3D銑(3D milling)

附註 / Note :

建議冷卻方式為油霧。

Suggest to use MQL coolant.