

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)						
	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
UER0202	12mm	60	9600~10000	800~1200	0.03~0.05	1~2	溝銑(Slotting)
UER0202	12mm	60	9600~10000	300~500	4	0.03~0.05	側銑(Side milling)
UER0202	12mm	60	9600~10000	1000~1400	0.03~0.05	0.03~0.05	3D銑(3D milling)
UER0205	12mm	60	9600~10000	800~1200	0.03~0.05	0.5~2	溝銑(Slotting)
UER0205	12mm	60	9600~10000	300~500	4	0.03~0.05	側銑(Side milling)
UER0205	12mm	60	9600~10000	1000~1400	0.03~0.05	0.03~0.05	3D銑(3D milling)
UER0302S	12mm	85	9000~9500	800~1200	0.03~0.06	1~3	溝銑(Slotting)
UER0302S	12mm	60	6400~6800	400~600	6	0.03~0.06	側銑(Side milling)
UER0302S	12mm	85	9000~9500	1000~1400	0.03~0.06	0.03~0.06	3D銑(3D milling)
UER0305S	12mm	85	9000~9500	800~1200	0.03~0.06	1~3	溝銑(Slotting)
UER0305S	12mm	60	6400~6800	400~600	6	0.03~0.06	側銑(Side milling)
UER0305S	12mm	85	9000~9500	1000~1400	0.03~0.06	0.03~0.06	3D銑(3D milling)
UER0402	12mm	110	8600~9000	1000~1400	0.05~0.08	3~4	溝銑(Slotting)
UER0402	12mm	65	5000~5400	400~600	8	0.05~0.08	側銑(Side milling)
UER0402	12mm	110	8600~9000	1400~1800	0.05~0.08	0.05~0.08	3D銑(3D milling)
UER0405	12mm	110	8600~9000	1000~1400	0.05~0.08	2~4	溝銑(Slotting)
UER0405	12mm	65	5000~5400	400~600	8	0.05~0.08	側銑(Side milling)
UER0405	12mm	110	8600~9000	1400~1800	0.05~0.08	0.05~0.08	3D銑(3D milling)
UER0505	16mm	135	8600~9000	1000~1400	0.05~0.1	3~5	溝銑(Slotting)
UER0505	16mm	70	4300~4800	400~600	10	0.05~0.1	側銑(Side milling)
UER0505	16mm	135	8600~9000	1400~1800	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER0510	16mm	135	8600~9000	1000~1400	0.05~0.1	2~5	溝銑(Slotting)
UER0510	16mm	70	4300~4800	400~600	10	0.05~0.1	側銑(Side milling)
UER0510	16mm	135	8600~9000	1400~1800	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER0605	20mm	155	8000~8400	1600~2000	0.05~0.1	4~6	溝銑(Slotting)
UER0605	20mm	70	3600~4000	400~600	12	0.05~0.1	側銑(Side milling)
UER0605	20mm	160	8200~8600	1800~2200	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER0610	20mm	155	8000~8400	1600~2000	0.05~0.1	3~6	溝銑(Slotting)
UER0610	20mm	70	3600~4000	400~600	12	0.05~0.1	側銑(Side milling)
UER0610	20mm	160	8200~8600	1800~2200	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER0805	25mm	160	6200~6600	1600~2000	0.05~0.1	6~8	溝銑(Slotting)
UER0805	25mm	75	3000~3400	600~800	16	0.05~0.1	側銑(Side milling)
UER0805	25mm	170	6600~7000	1600~2000	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER0810	25mm	160	6200~6600	1600~2000	0.05~0.1	5~8	溝銑(Slotting)
UER0810	25mm	75	3000~3400	600~800	16	0.05~0.1	側銑(Side milling)
UER0810	25mm	170	6600~7000	1600~2000	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	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)						
	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
UER1005	35mm	175	5600~6000	1600~2000	0.05~0.1	8~10	溝銑(Slotting)
UER1005	35mm	90	2800~3200	600~800	20	0.05~0.1	側銑(Side milling)
UER1005	35mm	185	5800~6200	1600~2000	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER1010	35mm	175	5600~6000	1600~2000	0.05~0.1	7~10	溝銑(Slotting)
UER1010	35mm	90	2800~3200	600~800	20	0.05~0.1	側銑(Side milling)
UER1010	35mm	185	5800~6200	1600~2000	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER1020	35mm	175	5600~6000	1600~2000	0.05~0.1	5~10	溝銑(Slotting)
UER1020	35mm	90	2800~3200	600~800	20	0.05~0.1	側銑(Side milling)
UER1020	35mm	185	5800~6200	1600~2000	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER1030	35mm	175	5600~6000	1600~2000	0.05~0.1	3~10	溝銑(Slotting)
UER1030	35mm	90	2800~3200	600~800	20	0.05~0.1	側銑(Side milling)
UER1030	35mm	185	5800~6200	1600~2000	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER1210	35mm	170	4400~4800	1600~2000	0.1~0.15	9~12	溝銑(Slotting)
UER1210	35mm	75	2000~2400	400~600	24	0.1~0.15	側銑(Side milling)
UER1210	35mm	170	4400~4800	1600~2000	0.1~0.15	0.1~0.15	3D銑(3D milling)
UER1220	35mm	170	4400~4800	1600~2000	0.1~0.15	7~12	溝銑(Slotting)
UER1220	35mm	75	2000~2400	400~600	24	0.1~0.15	側銑(Side milling)
UER1220	35mm	170	4400~4800	1600~2000	0.1~0.15	0.1~0.15	3D銑(3D milling)
UER1230	35mm	170	4400~4800	1600~2000	0.1~0.15	5~12	溝銑(Slotting)
UER1230	35mm	75	2000~2400	400~600	24	0.1~0.15	側銑(Side milling)
UER1230	35mm	170	4400~4800	1600~2000	0.1~0.15	0.1~0.15	3D銑(3D milling)
UER1610	50mm	170	3200~3600	1600~2000	0.1~0.15	13~16	溝銑(Slotting)
UER1610	50mm	75	1500~2000	400~600	32	0.1~0.15	側銑(Side milling)
UER1610	50mm	170	3200~3600	1600~2000	0.1~0.15	0.1~0.15	3D銑(3D milling)
UER1620	50mm	170	3200~3600	1600~2000	0.1~0.15	11~16	溝銑(Slotting)
UER1620	50mm	75	1500~2000	400~600	32	0.1~0.15	側銑(Side milling)
UER1620	50mm	170	3200~3600	1600~2000	0.1~0.15	0.1~0.15	3D銑(3D milling)
UER1630	50mm	170	3200~3600	1600~2000	0.1~0.15	9~16	溝銑(Slotting)
UER1630	50mm	75	1500~2000	400~600	32	0.1~0.15	側銑(Side milling)
UER1630	50mm	170	3200~3600	1600~2000	0.1~0.15	0.1~0.15	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)						
	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
UER0202	12mm	115	18000~20000	1600~2000	0.03~0.05	1~2	溝銑(Slotting)
UER0202	12mm	65	10000~11000	300~500	4	0.03~0.05	側銑(Side milling)
UER0202	12mm	115	18000~20000	1600~2000	0.03~0.05	0.03~0.05	3D銑(3D milling)
UER0205	12mm	115	18000~20000	1600~2000	0.03~0.05	0.5~2	溝銑(Slotting)
UER0205	12mm	65	10000~11000	300~500	4	0.03~0.05	側銑(Side milling)
UER0205	12mm	115	18000~20000	1600~2000	0.03~0.05	0.03~0.05	3D銑(3D milling)
UER0302S	12mm	135	14000~15000	1600~2000	0.03~0.06	1~3	溝銑(Slotting)
UER0302S	12mm	60	6400~6800	400~600	6	0.03~0.06	側銑(Side milling)
UER0302S	12mm	135	14000~15000	1600~2000	0.03~0.06	0.03~0.06	3D銑(3D milling)
UER0305S	12mm	135	14000~15000	1600~2000	0.03~0.06	1~3	溝銑(Slotting)
UER0305S	12mm	60	6400~6800	400~600	6	0.03~0.06	側銑(Side milling)
UER0305S	12mm	135	14000~15000	1600~2000	0.03~0.06	0.03~0.06	3D銑(3D milling)
UER0402	12mm	140	11000~12000	1800~2200	0.05~0.08	3~4	溝銑(Slotting)
UER0402	12mm	65	5000~5400	400~600	8	0.05~0.08	側銑(Side milling)
UER0402	12mm	140	11000~12000	2000~2400	0.05~0.08	0.05~0.08	3D銑(3D milling)
UER0405	12mm	140	11000~12000	1800~2200	0.05~0.08	2~4	溝銑(Slotting)
UER0405	12mm	65	5000~5400	400~600	8	0.05~0.08	側銑(Side milling)
UER0405	12mm	140	11000~12000	2000~2400	0.05~0.08	0.05~0.08	3D銑(3D milling)
UER0505	16mm	135	8600~9000	1000~1400	0.05~0.1	3~5	溝銑(Slotting)
UER0505	16mm	70	4300~4800	400~600	10	0.05~0.1	側銑(Side milling)
UER0505	16mm	135	8600~9000	1400~1800	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER0510	16mm	135	8600~9000	1000~1400	0.05~0.1	2~5	溝銑(Slotting)
UER0510	16mm	70	4300~4800	400~600	10	0.05~0.1	側銑(Side milling)
UER0510	16mm	135	8600~9000	1400~1800	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER0605	20mm	155	8000~8400	1600~2000	0.05~0.1	4~6	溝銑(Slotting)
UER0605	20mm	70	3600~4000	400~600	12	0.05~0.1	側銑(Side milling)
UER0605	20mm	160	8200~8600	1800~2200	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER0610	20mm	155	8000~8400	1600~2000	0.05~0.1	3~6	溝銑(Slotting)
UER0610	20mm	70	3600~4000	400~600	12	0.05~0.1	側銑(Side milling)
UER0610	20mm	160	8200~8600	1800~2200	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER0805	25mm	160	6200~6600	1600~2000	0.05~0.1	6~8	溝銑(Slotting)
UER0805	25mm	75	3000~3400	600~800	16	0.05~0.1	側銑(Side milling)
UER0805	25mm	170	6600~7000	1600~2000	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER0810	25mm	160	6200~6600	1600~2000	0.05~0.1	5~8	溝銑(Slotting)
UER0810	25mm	75	3000~3400	600~800	16	0.05~0.1	側銑(Side milling)
UER0810	25mm	170	6600~7000	1600~2000	0.05~0.1	0.05~0.1	3D銑(3D milling)

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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)						
	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
UER1005	35mm	175	5600~6000	1600~2000	0.05~0.1	8~10	溝銑(Slotting)
UER1005	35mm	90	2800~3200	600~800	20	0.05~0.1	側銑(Side milling)
UER1005	35mm	185	5800~6200	1600~2000	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER1010	35mm	175	5600~6000	1600~2000	0.05~0.1	7~10	溝銑(Slotting)
UER1010	35mm	90	2800~3200	600~800	20	0.05~0.1	側銑(Side milling)
UER1010	35mm	185	5800~6200	1600~2000	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER1020	35mm	175	5600~6000	1600~2000	0.05~0.1	5~10	溝銑(Slotting)
UER1020	35mm	90	2800~3200	600~800	20	0.05~0.1	側銑(Side milling)
UER1020	35mm	185	5800~6200	1600~2000	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER1030	35mm	175	5600~6000	1600~2000	0.05~0.1	3~10	溝銑(Slotting)
UER1030	35mm	90	2800~3200	600~800	20	0.05~0.1	側銑(Side milling)
UER1030	35mm	185	5800~6200	1600~2000	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER1210	35mm	170	4400~4800	1600~2000	0.1~0.15	9~12	溝銑(Slotting)
UER1210	35mm	75	2000~2400	400~600	24	0.1~0.15	側銑(Side milling)
UER1210	35mm	170	4400~4800	1600~2000	0.1~0.15	0.1~0.15	3D銑(3D milling)
UER1220	35mm	170	4400~4800	1600~2000	0.1~0.15	7~12	溝銑(Slotting)
UER1220	35mm	75	2000~2400	400~600	24	0.1~0.15	側銑(Side milling)
UER1220	35mm	170	4400~4800	1600~2000	0.1~0.15	0.1~0.15	3D銑(3D milling)
UER1230	35mm	170	4400~4800	1600~2000	0.1~0.15	5~12	溝銑(Slotting)
UER1230	35mm	75	2000~2400	400~600	24	0.1~0.15	側銑(Side milling)
UER1230	35mm	170	4400~4800	1600~2000	0.1~0.15	0.1~0.15	3D銑(3D milling)
UER1610	50mm	170	3200~3600	1600~2000	0.1~0.15	13~16	溝銑(Slotting)
UER1610	50mm	75	1500~2000	400~600	32	0.1~0.15	側銑(Side milling)
UER1610	50mm	170	3200~3600	1600~2000	0.1~0.15	0.1~0.15	3D銑(3D milling)
UER1620	50mm	170	3200~3600	1600~2000	0.1~0.15	11~16	溝銑(Slotting)
UER1620	50mm	75	1500~2000	400~600	32	0.1~0.15	側銑(Side milling)
UER1620	50mm	170	3200~3600	1600~2000	0.1~0.15	0.1~0.15	3D銑(3D milling)
UER1630	50mm	170	3200~3600	1600~2000	0.1~0.15	9~16	溝銑(Slotting)
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UER1630	50mm	170	3200~3600	1600~2000	0.1~0.15	0.1~0.15	3D銑(3D milling)

附註 / Note :

建議冷卻方式為濕式。

Suggest to use Wet coolant.

被切削材 Work Material	調質鋼 / 預硬鋼 : Prehardened Steels NAK80 : 1.2083 : AISI420 : M310 (HRC36~45)						
	型號 Type NO.	刀具伸長量 Extension Length	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
UER0202	12mm	60	9600~10000	800~1200	0.03~0.05	1~2	溝銑(Slotting)
UER0202	12mm	60	9600~10000	300~500	4	0.03~0.05	側銑(Side milling)
UER0202	12mm	60	9600~10000	1000~1400	0.03~0.05	0.03~0.05	3D銑(3D milling)
UER0205	12mm	60	9600~10000	800~1200	0.03~0.05	0.5~2	溝銑(Slotting)
UER0205	12mm	60	9600~10000	300~500	4	0.03~0.05	側銑(Side milling)
UER0205	12mm	60	9600~10000	1000~1400	0.03~0.05	0.03~0.05	3D銑(3D milling)
UER0302S	12mm	85	9000~9500	800~1200	0.03~0.06	1~3	溝銑(Slotting)
UER0302S	12mm	60	6400~6800	400~600	6	0.03~0.06	側銑(Side milling)
UER0302S	12mm	85	9000~9500	1000~1400	0.03~0.06	0.03~0.06	3D銑(3D milling)
UER0305S	12mm	85	9000~9500	800~1200	0.03~0.06	1~3	溝銑(Slotting)
UER0305S	12mm	60	6400~6800	400~600	6	0.03~0.06	側銑(Side milling)
UER0305S	12mm	85	9000~9500	1000~1400	0.03~0.06	0.03~0.06	3D銑(3D milling)
UER0402	12mm	110	8600~9000	1000~1400	0.05~0.08	3~4	溝銑(Slotting)
UER0402	12mm	65	5000~5400	400~600	8	0.05~0.08	側銑(Side milling)
UER0402	12mm	110	8600~9000	1400~1800	0.05~0.08	0.05~0.08	3D銑(3D milling)
UER0405	12mm	110	8600~9000	1000~1400	0.05~0.08	2~4	溝銑(Slotting)
UER0405	12mm	65	5000~5400	400~600	8	0.05~0.08	側銑(Side milling)
UER0405	12mm	110	8600~9000	1400~1800	0.05~0.08	0.05~0.08	3D銑(3D milling)
UER0505	16mm	135	8600~9000	1000~1400	0.05~0.1	3~5	溝銑(Slotting)
UER0505	16mm	70	4300~4800	400~600	10	0.05~0.1	側銑(Side milling)
UER0505	16mm	135	8600~9000	1400~1800	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER0510	16mm	135	8600~9000	1000~1400	0.05~0.1	2~5	溝銑(Slotting)
UER0510	16mm	70	4300~4800	400~600	10	0.05~0.1	側銑(Side milling)
UER0510	16mm	135	8600~9000	1400~1800	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER0605	20mm	145	7600~8000	1200~1600	0.05~0.1	4~6	溝銑(Slotting)
UER0605	20mm	70	3600~4000	400~600	12	0.05~0.1	側銑(Side milling)
UER0605	20mm	150	8000~8400	1400~1800	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER0610	20mm	145	7600~8000	1200~1600	0.05~0.1	3~6	溝銑(Slotting)
UER0610	20mm	70	3600~4000	400~600	12	0.05~0.1	側銑(Side milling)
UER0610	20mm	150	8000~8400	1400~1800	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER0805	25mm	150	6000~6400	1200~1600	0.05~0.1	6~8	溝銑(Slotting)
UER0805	25mm	75	3000~3400	600~800	16	0.05~0.1	側銑(Side milling)
UER0805	25mm	155	6200~6600	1400~1800	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER0810	25mm	150	6000~6400	1200~1600	0.05~0.1	5~8	溝銑(Slotting)
UER0810	25mm	75	3000~3400	600~800	16	0.05~0.1	側銑(Side milling)
UER0810	25mm	155	6200~6600	1400~1800	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	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
UER1005	35mm	170	5400~5800	1400~1800	0.05~0.1	8~10	溝銑(Slotting)
UER1005	35mm	75	2400~2800	600~800	20	0.05~0.1	側銑(Side milling)
UER1005	35mm	185	5800~6200	1600~2000	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER1010	35mm	170	5400~5800	1400~1800	0.05~0.1	7~10	溝銑(Slotting)
UER1010	35mm	75	2400~2800	600~800	20	0.05~0.1	側銑(Side milling)
UER1010	35mm	185	5800~6200	1600~2000	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER1020	35mm	170	5400~5800	1400~1800	0.05~0.1	5~10	溝銑(Slotting)
UER1020	35mm	75	2400~2800	600~800	20	0.05~0.1	側銑(Side milling)
UER1020	35mm	185	5800~6200	1600~2000	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER1030	35mm	170	5400~5800	1400~1800	0.05~0.1	3~10	溝銑(Slotting)
UER1030	35mm	75	2400~2800	600~800	20	0.05~0.1	側銑(Side milling)
UER1030	35mm	185	5800~6200	1600~2000	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER1210	35mm	150	4000~4400	1400~1800	0.1~0.15	9~12	溝銑(Slotting)
UER1210	35mm	70	1800~2200	400~600	24	0.1~0.15	側銑(Side milling)
UER1210	35mm	150	4000~4400	1600~2000	0.1~0.15	0.1~0.15	3D銑(3D milling)
UER1220	35mm	150	4000~4400	1400~1800	0.1~0.15	7~12	溝銑(Slotting)
UER1220	35mm	70	1800~2200	400~600	24	0.1~0.15	側銑(Side milling)
UER1220	35mm	150	4000~4400	1600~2000	0.1~0.15	0.1~0.15	3D銑(3D milling)
UER1230	35mm	150	4000~4400	1400~1800	0.1~0.15	5~12	溝銑(Slotting)
UER1230	35mm	70	1800~2200	400~600	24	0.1~0.15	側銑(Side milling)
UER1230	35mm	150	4000~4400	1600~2000	0.1~0.15	0.1~0.15	3D銑(3D milling)
UER1610	50mm	150	3000~3400	1400~1800	0.1~0.15	13~16	溝銑(Slotting)
UER1610	50mm	75	1500~2000	400~600	32	0.1~0.15	側銑(Side milling)
UER1610	50mm	150	3000~3400	1600~2000	0.1~0.15	0.1~0.15	3D銑(3D milling)
UER1620	50mm	150	3000~3400	1400~1800	0.1~0.15	11~16	溝銑(Slotting)
UER1620	50mm	75	1500~2000	400~600	32	0.1~0.15	側銑(Side milling)
UER1620	50mm	150	3000~3400	1600~2000	0.1~0.15	0.1~0.15	3D銑(3D milling)
UER1630	50mm	150	3000~3400	1400~1800	0.1~0.15	9~16	溝銑(Slotting)
UER1630	50mm	75	1500~2000	400~600	32	0.1~0.15	側銑(Side milling)
UER1630	50mm	150	3000~3400	1600~2000	0.1~0.15	0.1~0.15	3D銑(3D milling)

附註 / Note :

建議冷卻方式為濕式。

Suggest to use Wet coolant.

被切削材 Work Material	調質鋼 / 預硬鋼 : Prehardened Steels NAK80 : 1.2083 : AISI420 : M310 (HRC36~45)						
	型號 Type NO.	刀具伸長量 Extension Length	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
UER0202	12mm	115	18000~20000	1600~2000	0.03~0.05	1~2	溝銑(Slotting)
UER0202	12mm	65	10000~11000	300~500	4	0.03~0.05	側銑(Side milling)
UER0202	12mm	115	18000~20000	1600~2000	0.03~0.05	0.03~0.05	3D銑(3D milling)
UER0205	12mm	115	18000~20000	1600~2000	0.03~0.05	0.5~2	溝銑(Slotting)
UER0205	12mm	65	10000~11000	300~500	4	0.03~0.05	側銑(Side milling)
UER0205	12mm	115	18000~20000	1600~2000	0.03~0.05	0.03~0.05	3D銑(3D milling)
UER0302S	12mm	135	14000~15000	1600~2000	0.03~0.06	1~3	溝銑(Slotting)
UER0302S	12mm	60	6400~6800	400~600	6	0.03~0.06	側銑(Side milling)
UER0302S	12mm	135	14000~15000	1600~2000	0.03~0.06	0.03~0.06	3D銑(3D milling)
UER0305S	12mm	135	14000~15000	1600~2000	0.03~0.06	1~3	溝銑(Slotting)
UER0305S	12mm	60	6400~6800	400~600	6	0.03~0.06	側銑(Side milling)
UER0305S	12mm	135	14000~15000	1600~2000	0.03~0.06	0.03~0.06	3D銑(3D milling)
UER0402	12mm	140	11000~12000	1800~2200	0.05~0.08	3~4	溝銑(Slotting)
UER0402	12mm	65	5000~5400	400~600	8	0.05~0.08	側銑(Side milling)
UER0402	12mm	140	11000~12000	2000~2400	0.05~0.08	0.05~0.08	3D銑(3D milling)
UER0405	12mm	140	11000~12000	1800~2200	0.05~0.08	2~4	溝銑(Slotting)
UER0405	12mm	65	5000~5400	400~600	8	0.05~0.08	側銑(Side milling)
UER0405	12mm	140	11000~12000	2000~2400	0.05~0.08	0.05~0.08	3D銑(3D milling)
UER0505	16mm	135	8600~9000	1000~1400	0.05~0.1	3~5	溝銑(Slotting)
UER0505	16mm	70	4300~4800	400~600	10	0.05~0.1	側銑(Side milling)
UER0505	16mm	135	8600~9000	1400~1800	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER0510	16mm	135	8600~9000	1000~1400	0.05~0.1	2~5	溝銑(Slotting)
UER0510	16mm	70	4300~4800	400~600	10	0.05~0.1	側銑(Side milling)
UER0510	16mm	135	8600~9000	1400~1800	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER0605	20mm	145	7600~8000	1200~1600	0.05~0.1	4~6	溝銑(Slotting)
UER0605	20mm	70	3600~4000	400~600	12	0.05~0.1	側銑(Side milling)
UER0605	20mm	150	8000~8400	1400~1800	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER0610	20mm	145	7600~8000	1200~1600	0.05~0.1	3~6	溝銑(Slotting)
UER0610	20mm	70	3600~4000	400~600	12	0.05~0.1	側銑(Side milling)
UER0610	20mm	150	8000~8400	1400~1800	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER0805	25mm	150	6000~6400	1200~1600	0.05~0.1	6~8	溝銑(Slotting)
UER0805	25mm	75	3000~3400	600~800	16	0.05~0.1	側銑(Side milling)
UER0805	25mm	155	6200~6600	1400~1800	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER0810	25mm	150	6000~6400	1200~1600	0.05~0.1	5~8	溝銑(Slotting)
UER0810	25mm	75	3000~3400	600~800	16	0.05~0.1	側銑(Side milling)
UER0810	25mm	155	6200~6600	1400~1800	0.05~0.1	0.05~0.1	3D銑(3D milling)

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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
UER1005	35mm	170	5400~5800	1400~1800	0.05~0.1	8~10	溝銑(Slotting)
UER1005	35mm	75	2400~2800	600~800	20	0.05~0.1	側銑(Side milling)
UER1005	35mm	185	5800~6200	1600~2000	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER1010	35mm	170	5400~5800	1400~1800	0.05~0.1	7~10	溝銑(Slotting)
UER1010	35mm	75	2400~2800	600~800	20	0.05~0.1	側銑(Side milling)
UER1010	35mm	185	5800~6200	1600~2000	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER1020	35mm	170	5400~5800	1400~1800	0.05~0.1	5~10	溝銑(Slotting)
UER1020	35mm	75	2400~2800	600~800	20	0.05~0.1	側銑(Side milling)
UER1020	35mm	185	5800~6200	1600~2000	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER1030	35mm	170	5400~5800	1400~1800	0.05~0.1	3~10	溝銑(Slotting)
UER1030	35mm	75	2400~2800	600~800	20	0.05~0.1	側銑(Side milling)
UER1030	35mm	185	5800~6200	1600~2000	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER1210	35mm	150	4000~4400	1400~1800	0.1~0.15	9~12	溝銑(Slotting)
UER1210	35mm	70	1800~2200	400~600	24	0.1~0.15	側銑(Side milling)
UER1210	35mm	150	4000~4400	1600~2000	0.1~0.15	0.1~0.15	3D銑(3D milling)
UER1220	35mm	150	4000~4400	1400~1800	0.1~0.15	7~12	溝銑(Slotting)
UER1220	35mm	70	1800~2200	400~600	24	0.1~0.15	側銑(Side milling)
UER1220	35mm	150	4000~4400	1600~2000	0.1~0.15	0.1~0.15	3D銑(3D milling)
UER1230	35mm	150	4000~4400	1400~1800	0.1~0.15	5~12	溝銑(Slotting)
UER1230	35mm	70	1800~2200	400~600	24	0.1~0.15	側銑(Side milling)
UER1230	35mm	150	4000~4400	1600~2000	0.1~0.15	0.1~0.15	3D銑(3D milling)
UER1610	50mm	150	3000~3400	1400~1800	0.1~0.15	13~16	溝銑(Slotting)
UER1610	50mm	75	1500~2000	400~600	32	0.1~0.15	側銑(Side milling)
UER1610	50mm	150	3000~3400	1600~2000	0.1~0.15	0.1~0.15	3D銑(3D milling)
UER1620	50mm	150	3000~3400	1400~1800	0.1~0.15	11~16	溝銑(Slotting)
UER1620	50mm	75	1500~2000	400~600	32	0.1~0.15	側銑(Side milling)
UER1620	50mm	150	3000~3400	1600~2000	0.1~0.15	0.1~0.15	3D銑(3D milling)
UER1630	50mm	150	3000~3400	1400~1800	0.1~0.15	9~16	溝銑(Slotting)
UER1630	50mm	75	1500~2000	400~600	32	0.1~0.15	側銑(Side milling)
UER1630	50mm	150	3000~3400	1600~2000	0.1~0.15	0.1~0.15	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
UER0202	12mm	90	14000~15000	800~1200	0.03~0.05	1~2	溝銑(Slotting)
UER0202	12mm	60	9600~10000	300~500	4	0.03~0.05	側銑(Side milling)
UER0202	12mm	70	14000~15000	1000~1400	0.03~0.05	0.03~0.05	3D銑(3D milling)
UER0205	12mm	90	14000~15000	800~1200	0.03~0.05	0.5~2	溝銑(Slotting)
UER0205	12mm	60	9600~10000	300~500	4	0.03~0.05	側銑(Side milling)
UER0205	12mm	70	14000~15000	1000~1400	0.03~0.05	0.03~0.05	3D銑(3D milling)
UER0302S	12mm	100	10000~11000	800~1200	0.03~0.06	1~3	溝銑(Slotting)
UER0302S	12mm	60	6400~6800	400~600	6	0.03~0.06	側銑(Side milling)
UER0302S	12mm	100	10000~11000	1000~1400	0.03~0.06	0.03~0.06	3D銑(3D milling)
UER0305S	12mm	100	10000~11000	800~1200	0.03~0.06	1~3	溝銑(Slotting)
UER0305S	12mm	60	6400~6800	400~600	6	0.03~0.06	側銑(Side milling)
UER0305S	12mm	100	10000~11000	1000~1400	0.03~0.06	0.03~0.06	3D銑(3D milling)
UER0402	12mm	100	7700~8200	1000~1400	0.05~0.08	3~4	溝銑(Slotting)
UER0402	12mm	65	5000~5400	400~600	8	0.05~0.08	側銑(Side milling)
UER0402	12mm	100	7700~8200	1400~1800	0.05~0.08	0.05~0.08	3D銑(3D milling)
UER0405	12mm	100	7700~8200	1000~1400	0.05~0.08	2~4	溝銑(Slotting)
UER0405	12mm	65	5000~5400	400~600	8	0.05~0.08	側銑(Side milling)
UER0405	12mm	100	7700~8200	1400~1800	0.05~0.08	0.05~0.08	3D銑(3D milling)
UER0505	16mm	110	7000~7400	800~1000	0.05~0.1	3~5	溝銑(Slotting)
UER0505	16mm	70	4300~4800	400~600	10	0.05~0.1	側銑(Side milling)
UER0505	16mm	110	7000~7400	800~1000	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER0510	16mm	110	7000~7400	800~1000	0.05~0.1	2~5	溝銑(Slotting)
UER0510	16mm	70	4300~4800	400~600	10	0.05~0.1	側銑(Side milling)
UER0510	16mm	110	7000~7400	800~1000	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER0605	20mm	125	6600~7000	800~1000	0.05~0.1	4~6	溝銑(Slotting)
UER0605	20mm	70	3600~4000	400~600	12	0.05~0.1	側銑(Side milling)
UER0605	20mm	125	6600~7000	800~1000	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER0610	20mm	125	6600~7000	800~1000	0.05~0.1	3~6	溝銑(Slotting)
UER0610	20mm	70	3600~4000	400~600	12	0.05~0.1	側銑(Side milling)
UER0610	20mm	125	6600~7000	800~1000	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER0805	25mm	145	5800~6200	800~1000	0.05~0.1	6~8	溝銑(Slotting)
UER0805	25mm	75	3000~3400	600~800	16	0.05~0.1	側銑(Side milling)
UER0805	25mm	150	6000~6400	1000~1400	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER0810	25mm	145	5800~6200	800~1000	0.05~0.1	5~8	溝銑(Slotting)
UER0810	25mm	75	3000~3400	600~800	16	0.05~0.1	側銑(Side milling)
UER0810	25mm	150	6000~6400	1000~1400	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)						
	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
UER1005	35mm	160	5000~5400	800~1000	0.05~0.1	8~10	溝銑(Slotting)
UER1005	35mm	90	2800~3200	600~800	20	0.05~0.1	側銑(Side milling)
UER1005	35mm	185	5800~6200	1200~1600	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER1010	35mm	160	5000~5400	800~1000	0.05~0.1	7~10	溝銑(Slotting)
UER1010	35mm	90	2800~3200	600~800	20	0.05~0.1	側銑(Side milling)
UER1010	35mm	185	5800~6200	1200~1600	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER1020	35mm	160	5000~5400	800~1000	0.05~0.1	5~10	溝銑(Slotting)
UER1020	35mm	90	2800~3200	600~800	20	0.05~0.1	側銑(Side milling)
UER1020	35mm	185	5800~6200	1200~1600	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER1030	35mm	160	5000~5400	800~1000	0.05~0.1	3~10	溝銑(Slotting)
UER1030	35mm	90	2800~3200	600~800	20	0.05~0.1	側銑(Side milling)
UER1030	35mm	185	5800~6200	1200~1600	0.05~0.1	0.05~0.1	3D銑(3D milling)
UER1210	35mm	145	3800~4200	800~1200	0.1~0.15	9~12	溝銑(Slotting)
UER1210	35mm	70	1800~2200	400~600	24	0.1~0.15	側銑(Side milling)
UER1210	35mm	150	4000~4400	800~1200	0.1~0.15	0.1~0.15	3D銑(3D milling)
UER1220	35mm	145	3800~4200	800~1200	0.1~0.15	7~12	溝銑(Slotting)
UER1220	35mm	70	1800~2200	400~600	24	0.1~0.15	側銑(Side milling)
UER1220	35mm	150	4000~4400	800~1200	0.1~0.15	0.1~0.15	3D銑(3D milling)
UER1230	35mm	145	3800~4200	800~1200	0.1~0.15	5~12	溝銑(Slotting)
UER1230	35mm	70	1800~2200	400~600	24	0.1~0.15	側銑(Side milling)
UER1230	35mm	150	4000~4400	800~1200	0.1~0.15	0.1~0.15	3D銑(3D milling)
UER1610	50mm	140	2800~3200	800~1200	0.1~0.15	13~16	溝銑(Slotting)
UER1610	50mm	70	1400~1800	400~600	32	0.1~0.15	側銑(Side milling)
UER1610	50mm	150	3000~3400	800~1200	0.1~0.15	0.1~0.15	3D銑(3D milling)
UER1620	50mm	140	2800~3200	800~1200	0.1~0.15	11~16	溝銑(Slotting)
UER1620	50mm	70	1400~1800	400~600	32	0.1~0.15	側銑(Side milling)
UER1620	50mm	150	3000~3400	800~1200	0.1~0.15	0.1~0.15	3D銑(3D milling)
UER1630	50mm	140	2800~3200	800~1200	0.1~0.15	9~16	溝銑(Slotting)
UER1630	50mm	70	1400~1800	400~600	32	0.1~0.15	側銑(Side milling)
UER1630	50mm	150	3000~3400	800~1200	0.1~0.15	0.1~0.15	3D銑(3D milling)

附註 / Note :

建議冷卻方式為乾式。

Suggest to use Dry coolant.