



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
UHB0202	40mm	105	15500~16500	1800~2200	0.03~0.05	0.06~0.1	3D銑(3D milling)
UHB0302	40mm	135	13000~14000	2000~2400	0.04~0.05	0.08~0.1	3D銑(3D milling)
UHB0402	40mm	160	11500~12500	2400~2800	0.06~0.08	0.12~0.16	3D銑(3D milling)
UHB0502	40mm	175	10000~11000	2600~3000	0.06~0.08	0.12~0.16	3D銑(3D milling)
UHB0602	40mm	160	7800~8300	2200~2600	0.12~0.15	0.24~0.3	3D銑(3D milling)
UHB0602	40mm	175	8800~9300	3000~3400	0.07~0.09	0.14~0.18	3D銑(3D milling)
UHB0802	40mm	235	8700~9200	1800~2200	0.16~0.2	0.32~0.4	3D銑(3D milling)
UHB0802	40mm	265	9500~10500	2800~3200	0.08~0.1	0.16~0.2	3D銑(3D milling)
UIB0402	50mm	150	11500~12000	2000~2400	0.04~0.06	0.08~0.12	3D銑(3D milling)
UIB0602	50mm	230	11000~12000	2000~2400	0.06~0.08	0.12~0.16	3D銑(3D milling)
UIB0802	50mm	185	6700~7300	1200~1600	0.15~0.2	0.3~0.4	3D銑(3D milling)
UIB0802	50mm	225	8300~8800	1800~2200	0.06~0.1	0.16~0.2	3D銑(3D milling)
UIB1002	60mm	290	8700~9200	1800~2200	0.09~0.14	0.18~0.28	3D銑(3D milling)
UIB1202	60mm	325	8200~8600	1600~2000	0.2~0.25	0.4~0.5	3D銑(3D milling)
UIB1202	60mm	325	8200~8600	2200~2600	0.1~0.15	0.2~0.3	3D銑(3D milling)
UJB1002	100mm	195	5700~6200	1100~1300	0.1~0.14	0.2~0.28	3D銑(3D milling)
UJB1002	100mm	260	7700~8200	1400~1700	0.06~0.1	0.16~0.2	3D銑(3D milling)
UJB1202	100mm	220	5300~5800	800~1200	0.1~0.15	0.2~0.3	3D銑(3D milling)
UJB1602	100mm	230	4000~4500	1800~2200	0.12~0.17	0.24~0.34	3D銑(3D milling)
UJB2002	100mm	240	3800~4300	1400~1800	0.1~0.15	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	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
UHB0202	40mm	95	14000~15000	1000~1400	0.03~0.05	0.06~0.1	3D銑(3D milling)
UHB0302	40mm	125	12000~13000	1200~1600	0.03~0.05	0.06~0.1	3D銑(3D milling)
UHB0402	40mm	135	9500~10500	1200~1600	0.04~0.06	0.08~0.12	3D銑(3D milling)
UHB0502	40mm	140	8300~8800	1400~1800	0.05~0.06	0.1~0.12	3D銑(3D milling)
UHB0602	40mm	150	7500~8000	1400~1800	0.05~0.07	0.1~0.14	3D銑(3D milling)
UHB0802	40mm	235	8700~9200	2000~2400	0.06~0.08	0.12~0.16	3D銑(3D milling)
UIB0402	50mm	135	9500~10500	1800~2200	0.03~0.05	0.06~0.1	3D銑(3D milling)
UIB0602	50mm	160	7700~8300	1800~2200	0.05~0.07	0.1~0.14	3D銑(3D milling)
UIB0802	50mm	145	5400~5800	1600~2000	0.06~0.08	0.12~0.16	3D銑(3D milling)
UIB1002	60mm	230	6700~7200	1400~1800	0.08~0.13	0.16~0.26	3D銑(3D milling)
UIB1202	60mm	290	7200~7700	1000~1400	0.08~0.13	0.16~0.26	3D銑(3D milling)
UJB1002	80mm	185	5300~5800	1000~1200	0.08~0.1	0.16~0.2	3D銑(3D milling)
UJB1202	100mm	220	5300~5800	800~1200	0.08~0.13	0.16~0.26	3D銑(3D milling)
UJB1602	100mm	160	2800~3200	1200~1600	0.1~0.15	0.2~0.3	3D銑(3D milling)
UJB2002	100mm	220	3300~3800	900~1300	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.