

| 被切削材 Work Material | 熱處理鋼 : Hardened Steels SKD11 : 1.2379 : D2 / (HRC55) | | | | | | | |
|-----------------------|---|---------------------------|----------------------------------|------------------------------------|-----------------------|---------------------------|--------------------------|-------------------------|
| | 型號 Type NO. | 刀具伸長量 Extension Length | 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) Cut of depth | 加工寬度(Ap) Cut of width | 冷卻方式 Coolant Type |
| UHR0805 | 45mm | 65 | 2400~2800 | 500~700 | 0.03~0.07 | 5~8 | Dry/MQL | Finishing(Slotting) |
| UHR0805 | 45mm | 55 | 2000~2400 | 300~450 | 8 | 0.03~0.07 | Dry/MQL | Finishing(Side Milling) |
| UHR1005 | 55mm | 60 | 1800~2200 | 400~600 | 0.03~0.07 | 7~10 | Dry/MQL | Finishing(Slotting) |
| UHR1005 | 55mm | 45 | 1300~1600 | 250~400 | 10 | 0.03~0.07 | Dry/MQL | Finishing(Side Milling) |
| UHR1010 | 55mm | 60 | 1800~2200 | 400~600 | 0.03~0.07 | 7~10 | Dry/MQL | Finishing(Slotting) |
| UHR1010 | 55mm | 45 | 1300~1600 | 250~400 | 10 | 0.03~0.07 | Dry/MQL | Finishing(Side Milling) |
| UHR1205 | 55mm | 60 | 1400~1800 | 400~600 | 0.04~0.08 | 8~12 | Dry/MQL | Finishing(Slotting) |
| UHR1205 | 55mm | 50 | 1200~1600 | 200~400 | 12 | 0.04~0.08 | Dry/MQL | Finishing(Side Milling) |
| UHR1610 | 55mm | 70 | 1400~1800 | 400~600 | 0.05~0.12 | 9~16 | Dry/MQL | Finishing(Slotting) |
| UHR1610 | 55mm | 60 | 1100~1500 | 200~350 | 16 | 0.05~0.12 | Dry/MQL | Finishing(Side Milling) |
| UHR1610 | 90mm | 60 | 1100~1500 | 300~450 | 0.04~0.08 | 9~16 | Dry/MQL | Finishing(Slotting) |
| UHR1610 | 90mm | 50 | 900~1200 | 150~250 | 16 | 0.04~0.08 | Dry/MQL | Finishing(Side Milling) |

The cutting parameter needs to be adjusted according to the processing condition.