



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
UKR0102	12mm	65	18000~20000	2000~2400	0.06~0.08	0.4~1	溝銑(Slotting)
UKR0102	12mm	65	18000~20000	600~1000	0.03~0.05	0.4~1	溝銑(Slotting)
UKR0102	12mm	65	18000~20000	2200~2600	0.06~0.08	0.06~0.08	3D銑(3D milling)
UKR0102	12mm	65	18000~20000	1800~2200	0.03~0.05	0.03~0.05	3D銑(3D milling)
UKR0152	12mm	95	18000~20000	2200~2600	0.06~0.08	0.7~1.5	溝銑(Slotting)
UKR0152	12mm	95	18000~20000	800~1200	0.03~0.05	0.7~1.5	溝銑(Slotting)
UKR0152	12mm	95	18000~20000	2400~2800	0.06~0.08	0.06~0.08	3D銑(3D milling)
UKR0152	12mm	95	18000~20000	2000~2400	0.03~0.05	0.03~0.05	3D銑(3D milling)
UKR0202	14mm	115	16000~18000	2400~2800	0.07~0.09	1~2	溝銑(Slotting)
UKR0202	14mm	115	16000~18000	1000~1400	0.03~0.05	1~2	溝銑(Slotting)
UKR0202	14mm	115	16000~18000	2600~3000	0.07~0.09	0.07~0.09	3D銑(3D milling)
UKR0202	14mm	115	16000~18000	2200~2600	0.03~0.05	0.03~0.05	3D銑(3D milling)
UKR0205	14mm	115	16000~18000	2400~2800	0.07~0.09	0.5~2	溝銑(Slotting)
UKR0205	14mm	115	16000~18000	1000~1400	0.03~0.05	0.5~2	溝銑(Slotting)
UKR0205	14mm	115	16000~18000	2600~3000	0.07~0.09	0.07~0.09	3D銑(3D milling)
UKR0205	14mm	115	16000~18000	2200~2600	0.03~0.05	0.03~0.05	3D銑(3D milling)
UKR0252	14mm	125	15000~16000	2600~3000	0.09~0.12	1.5~2.5	溝銑(Slotting)
UKR0252	14mm	125	15000~16000	1200~1600	0.04~0.06	1.5~2.5	溝銑(Slotting)
UKR0252	14mm	125	15000~16000	2600~3000	0.09~0.12	0.09~0.12	3D銑(3D milling)
UKR0252	14mm	125	15000~16000	2400~2800	0.04~0.06	0.04~0.06	3D銑(3D milling)
UKR0255	14mm	125	15000~16000	2600~3000	0.09~0.12	1~2.5	溝銑(Slotting)
UKR0255	14mm	125	15000~16000	1200~1600	0.04~0.06	1~2.5	溝銑(Slotting)
UKR0255	14mm	125	15000~16000	2600~3000	0.09~0.12	0.09~0.12	3D銑(3D milling)
UKR0255	14mm	125	15000~16000	2400~2800	0.04~0.06	0.04~0.06	3D銑(3D milling)
UKR0302	14mm	150	15000~16000	2800~3200	0.09~0.12	2~3	溝銑(Slotting)
UKR0302	14mm	150	15000~16000	1400~1800	0.04~0.06	2~3	溝銑(Slotting)
UKR0302	14mm	150	15000~16000	2800~3200	0.09~0.12	0.09~0.12	3D銑(3D milling)
UKR0302	14mm	150	15000~16000	2600~3000	0.04~0.06	0.04~0.06	3D銑(3D milling)
UKR0303	14mm	150	15000~16000	2800~3200	0.09~0.12	2~3	溝銑(Slotting)
UKR0303	14mm	150	15000~16000	1400~1800	0.04~0.06	2~3	溝銑(Slotting)
UKR0303	14mm	150	15000~16000	2800~3200	0.09~0.12	0.09~0.12	3D銑(3D milling)
UKR0303	14mm	150	15000~16000	2600~3000	0.04~0.06	0.04~0.06	3D銑(3D milling)
UKR0305	14mm	150	15000~16000	2800~3200	0.09~0.12	1.5~3	溝銑(Slotting)
UKR0305	14mm	150	15000~16000	1400~1800	0.04~0.06	1.5~3	溝銑(Slotting)
UKR0305	14mm	150	15000~16000	2800~3200	0.09~0.12	0.09~0.12	3D銑(3D milling)
UKR0305	14mm	150	15000~16000	2600~3000	0.04~0.06	0.04~0.06	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
UKR0402	16mm	175	13000~14000	2800~3200	0.11~0.13	3~4	溝銑(Slotting)
UKR0402	16mm	175	13000~14000	1400~1800	0.05~0.07	3~4	溝銑(Slotting)
UKR0402	16mm	175	13000~14000	3000~3400	0.11~0.13	0.11~0.13	3D銑(3D milling)
UKR0402	16mm	175	13000~14000	3200~3600	0.05~0.07	0.05~0.07	3D銑(3D milling)
UKR0403	16mm	175	13000~14000	2800~3200	0.11~0.13	3~4	溝銑(Slotting)
UKR0403	16mm	175	13000~14000	1400~1800	0.05~0.07	3~4	溝銑(Slotting)
UKR0403	16mm	175	13000~14000	3000~3400	0.11~0.13	0.11~0.13	3D銑(3D milling)
UKR0403	16mm	175	13000~14000	3200~3600	0.05~0.07	0.05~0.07	3D銑(3D milling)
UKR0405	16mm	175	13000~14000	2800~3200	0.11~0.13	2~4	溝銑(Slotting)
UKR0405	16mm	175	13000~14000	1400~1800	0.05~0.07	2~4	溝銑(Slotting)
UKR0405	16mm	175	13000~14000	3000~3400	0.11~0.13	0.11~0.13	3D銑(3D milling)
UKR0405	16mm	175	13000~14000	3200~3600	0.05~0.07	0.05~0.07	3D銑(3D milling)
UKR0503	18mm	205	12000~13000	2800~3200	0.13~0.16	4~5	溝銑(Slotting)
UKR0503	18mm	205	12000~13000	1400~1800	0.06~0.08	4~5	溝銑(Slotting)
UKR0503	18mm	205	12000~13000	3200~3600	0.13~0.16	0.13~0.16	3D銑(3D milling)
UKR0503	18mm	205	12000~13000	3200~3600	0.06~0.08	0.06~0.08	3D銑(3D milling)
UKR0505	18mm	205	12000~13000	2800~3200	0.13~0.16	3~5	溝銑(Slotting)
UKR0505	18mm	205	12000~13000	1400~1800	0.06~0.08	3~5	溝銑(Slotting)
UKR0505	18mm	205	12000~13000	3200~3600	0.13~0.16	0.13~0.16	3D銑(3D milling)
UKR0505	18mm	205	12000~13000	3200~3600	0.06~0.08	0.06~0.08	3D銑(3D milling)
UKR0602	24mm	230	11000~12000	3000~3500	0.15~0.18	5~6	溝銑(Slotting)
UKR0602	24mm	230	11000~12000	1600~2000	0.07~0.1	5~6	溝銑(Slotting)
UKR0602	24mm	230	11000~12000	3400~3800	0.15~0.18	0.15~0.18	3D銑(3D milling)
UKR0602	24mm	230	11000~12000	3400~3800	0.07~0.1	0.07~0.1	3D銑(3D milling)
UKR0603	24mm	230	11000~12000	3000~3500	0.15~0.18	5~6	溝銑(Slotting)
UKR0603	24mm	230	11000~12000	1600~2000	0.07~0.1	5~6	溝銑(Slotting)
UKR0603	24mm	230	11000~12000	3400~3800	0.15~0.18	0.15~0.18	3D銑(3D milling)
UKR0603	24mm	230	11000~12000	3400~3800	0.07~0.1	0.07~0.1	3D銑(3D milling)
UKR0605	24mm	230	11000~12000	3000~3500	0.15~0.18	4~6	溝銑(Slotting)
UKR0605	24mm	230	11000~12000	1600~2000	0.07~0.1	4~6	溝銑(Slotting)
UKR0605	24mm	230	11000~12000	3400~3800	0.15~0.18	0.15~0.18	3D銑(3D milling)
UKR0605	24mm	230	11000~12000	3400~3800	0.07~0.1	0.07~0.1	3D銑(3D milling)
UKR0610	24mm	230	11000~12000	3000~3500	0.15~0.18	3~6	溝銑(Slotting)
UKR0610	24mm	230	11000~12000	1600~2000	0.07~0.1	3~6	溝銑(Slotting)
UKR0610	24mm	230	11000~12000	3400~3800	0.15~0.18	0.15~0.18	3D銑(3D milling)
UKR0610	24mm	230	11000~12000	3400~3800	0.07~0.1	0.07~0.1	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
UKR0803	28mm	280	10000~11000	2200~2600	0.15~0.2	7~8	溝銑(Slotting)
UKR0803	28mm	280	10000~11000	1400~1800	0.08~0.11	7~8	溝銑(Slotting)
UKR0803	28mm	280	10000~11000	3000~3400	0.15~0.2	0.15~0.2	3D銑(3D milling)
UKR0803	28mm	280	10000~11000	2800~3200	0.08~0.11	0.08~0.11	3D銑(3D milling)
UKR0805	28mm	280	10000~11000	2200~2600	0.15~0.2	6~8	溝銑(Slotting)
UKR0805	28mm	280	10000~11000	1400~1800	0.08~0.11	6~8	溝銑(Slotting)
UKR0805	28mm	280	10000~11000	3000~3400	0.15~0.2	0.15~0.2	3D銑(3D milling)
UKR0805	28mm	280	10000~11000	2800~3200	0.08~0.11	0.08~0.11	3D銑(3D milling)
UKR0810	28mm	280	10000~11000	2200~2600	0.15~0.2	5~8	溝銑(Slotting)
UKR0810	28mm	280	10000~11000	1400~1800	0.08~0.11	5~8	溝銑(Slotting)
UKR0810	28mm	280	10000~11000	3000~3400	0.15~0.2	0.15~0.2	3D銑(3D milling)
UKR0810	28mm	280	10000~11000	2800~3200	0.08~0.11	0.08~0.11	3D銑(3D milling)
UKR1002	36mm	315	9000~10000	2000~2400	0.15~0.2	9~10	溝銑(Slotting)
UKR1002	36mm	315	9000~10000	1200~1600	0.08~0.12	9~10	溝銑(Slotting)
UKR1002	36mm	315	9000~10000	2800~3200	0.18~0.22	0.18~0.22	3D銑(3D milling)
UKR1002	36mm	315	9000~10000	2800~3200	0.08~0.12	0.08~0.12	3D銑(3D milling)
UKR1003	36mm	315	9000~10000	2000~2400	0.15~0.2	9~10	溝銑(Slotting)
UKR1003	36mm	315	9000~10000	1200~1600	0.08~0.12	9~10	溝銑(Slotting)
UKR1003	36mm	315	9000~10000	2800~3200	0.18~0.22	0.18~0.22	3D銑(3D milling)
UKR1003	36mm	315	9000~10000	2800~3200	0.08~0.12	0.08~0.12	3D銑(3D milling)
UKR1005	36mm	315	9000~10000	2000~2400	0.15~0.2	8~10	溝銑(Slotting)
UKR1005	36mm	315	9000~10000	1200~1600	0.08~0.12	8~10	溝銑(Slotting)
UKR1005	36mm	315	9000~10000	2800~3200	0.18~0.22	0.18~0.22	3D銑(3D milling)
UKR1005	36mm	315	9000~10000	2800~3200	0.08~0.12	0.08~0.12	3D銑(3D milling)
UKR1010	36mm	315	9000~10000	2000~2400	0.15~0.2	7~10	溝銑(Slotting)
UKR1010	36mm	315	9000~10000	1200~1600	0.08~0.12	7~10	溝銑(Slotting)
UKR1010	36mm	315	9000~10000	2800~3200	0.18~0.22	0.18~0.22	3D銑(3D milling)
UKR1010	36mm	315	9000~10000	2800~3200	0.08~0.12	0.08~0.12	3D銑(3D milling)
UKR1203	40mm	245	5500~6500	2000~2400	0.18~0.23	11~12	溝銑(Slotting)
UKR1203	40mm	245	5500~6500	1200~1600	0.13~0.16	11~12	溝銑(Slotting)
UKR1203	40mm	245	5500~6500	2600~3000	0.18~0.23	0.18~0.23	3D銑(3D milling)
UKR1203	40mm	245	5500~6500	2000~2400	0.13~0.16	0.13~0.16	3D銑(3D milling)
UKR1205	40mm	245	5500~6500	2000~2400	0.18~0.23	10~12	溝銑(Slotting)
UKR1205	40mm	245	5500~6500	1200~1600	0.13~0.16	10~12	溝銑(Slotting)
UKR1205	40mm	245	5500~6500	2600~3000	0.18~0.23	0.18~0.23	3D銑(3D milling)
UKR1205	40mm	245	5500~6500	2000~2400	0.13~0.16	0.13~0.16	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	加工方式 Milling Type
UKR1210	40mm	245	5500~6500	2000~2400	0.18~0.23	9~12	溝銑(Slotting)
UKR1210	40mm	245	5500~6500	1200~1600	0.13~0.16	9~12	溝銑(Slotting)
UKR1210	40mm	245	5500~6500	2600~3000	0.18~0.23	0.18~0.23	3D銑(3D milling)
UKR1210	40mm	245	5500~6500	2000~2400	0.13~0.16	0.13~0.16	3D銑(3D milling)
UKR1215	40mm	245	5500~6500	2000~2400	0.18~0.23	7~12	溝銑(Slotting)
UKR1215	40mm	245	5500~6500	1200~1600	0.13~0.16	7~12	溝銑(Slotting)
UKR1215	40mm	245	5500~6500	2600~3000	0.18~0.23	0.18~0.23	3D銑(3D milling)
UKR1215	40mm	245	5500~6500	2000~2400	0.13~0.16	0.13~0.16	3D銑(3D milling)
UKR1220	40mm	245	5500~6500	2000~2400	0.18~0.23	7~12	溝銑(Slotting)
UKR1220	40mm	245	5500~6500	1200~1600	0.13~0.16	7~12	溝銑(Slotting)
UKR1220	40mm	245	5500~6500	2600~3000	0.18~0.23	0.18~0.23	3D銑(3D milling)
UKR1220	40mm	245	5500~6500	2000~2400	0.13~0.16	0.13~0.16	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
UKR0102	12mm	60	17000~18000	600~1000	0.03~0.05	0.4~1	溝銑(Slotting)
UKR0102	12mm	60	17000~18000	1800~2200	0.03~0.05	0.03~0.05	3D銑(3D milling)
UKR0152	12mm	85	17000~18000	600~1000	0.03~0.05	0.7~1.5	溝銑(Slotting)
UKR0152	12mm	85	17000~18000	1800~2200	0.03~0.05	0.03~0.05	3D銑(3D milling)
UKR0202	14mm	110	16000~17000	800~1200	0.03~0.05	1~2	溝銑(Slotting)
UKR0202	14mm	110	16000~17000	2000~2400	0.03~0.05	0.03~0.05	3D銑(3D milling)
UKR0205	14mm	110	16000~17000	800~1200	0.03~0.05	0.5~2	溝銑(Slotting)
UKR0205	14mm	110	16000~17000	2000~2400	0.03~0.05	0.03~0.05	3D銑(3D milling)
UKR0252	14mm	120	14000~15000	1000~1400	0.04~0.06	1.5~2.5	溝銑(Slotting)
UKR0252	14mm	120	14000~15000	2200~2600	0.04~0.06	0.04~0.06	3D銑(3D milling)
UKR0255	14mm	120	14000~15000	1000~1400	0.04~0.06	1~2.5	溝銑(Slotting)
UKR0255	14mm	120	14000~15000	2200~2600	0.04~0.06	0.04~0.06	3D銑(3D milling)
UKR0302	14mm	135	14000~15000	1200~1600	0.04~0.06	2~3	溝銑(Slotting)
UKR0302	14mm	135	14000~15000	2400~2800	0.04~0.06	0.04~0.06	3D銑(3D milling)
UKR0303	14mm	135	14000~15000	1200~1600	0.04~0.06	2~3	溝銑(Slotting)
UKR0303	14mm	135	14000~15000	2400~2800	0.04~0.06	0.04~0.06	3D銑(3D milling)
UKR0305	14mm	135	14000~15000	1200~1600	0.04~0.06	1.5~3	溝銑(Slotting)
UKR0305	14mm	135	14000~15000	2400~2800	0.04~0.06	0.04~0.06	3D銑(3D milling)
UKR0402	16mm	175	13000~14000	1200~1600	0.05~0.07	3~4	溝銑(Slotting)
UKR0402	16mm	175	13000~14000	2600~3000	0.05~0.07	0.05~0.07	3D銑(3D milling)
UKR0403	16mm	175	13000~14000	1200~1600	0.05~0.07	3~4	溝銑(Slotting)
UKR0403	16mm	175	13000~14000	2600~3000	0.05~0.07	0.05~0.07	3D銑(3D milling)
UKR0405	16mm	175	13000~14000	1200~1600	0.05~0.07	2~4	溝銑(Slotting)
UKR0405	16mm	175	13000~14000	2600~3000	0.05~0.07	0.05~0.07	3D銑(3D milling)
UKR0503	18mm	200	12000~13000	1400~1800	0.06~0.08	4~5	溝銑(Slotting)
UKR0503	18mm	200	12000~13000	2800~3200	0.06~0.08	0.06~0.08	3D銑(3D milling)
UKR0505	18mm	200	12000~13000	1400~1800	0.06~0.08	3~5	溝銑(Slotting)
UKR0505	18mm	200	12000~13000	2800~3200	0.06~0.08	0.06~0.08	3D銑(3D milling)
UKR0602	24mm	205	10000~11000	1400~1800	0.06~0.08	5~6	溝銑(Slotting)
UKR0602	24mm	205	10000~11000	3000~3400	0.06~0.08	0.06~0.08	3D銑(3D milling)
UKR0603	24mm	205	10000~11000	1400~1800	0.06~0.08	5~6	溝銑(Slotting)
UKR0603	24mm	205	10000~11000	3000~3400	0.06~0.08	0.06~0.08	3D銑(3D milling)
UKR0605	24mm	205	10000~11000	1400~1800	0.06~0.08	4~6	溝銑(Slotting)
UKR0605	24mm	205	10000~11000	3000~3400	0.06~0.08	0.06~0.08	3D銑(3D milling)
UKR0610	24mm	205	10000~11000	1400~1800	0.06~0.08	3~6	溝銑(Slotting)
UKR0610	24mm	205	10000~11000	3000~3400	0.06~0.08	0.06~0.08	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
UKR0803	28mm	205	7500~8500	1200~1600	0.08~0.1	7~8	溝銑(Slotting)
UKR0803	28mm	205	7500~8500	2600~3000	0.08~0.1	0.08~0.1	3D銑(3D milling)
UKR0805	28mm	205	7500~8500	1200~1600	0.08~0.1	6~8	溝銑(Slotting)
UKR0805	28mm	205	7500~8500	2600~3000	0.08~0.1	0.08~0.1	3D銑(3D milling)
UKR0810	28mm	205	7500~8500	1200~1600	0.08~0.1	5~8	溝銑(Slotting)
UKR0810	28mm	205	7500~8500	2600~3000	0.08~0.1	0.08~0.1	3D銑(3D milling)
UKR1002	36mm	205	6000~7000	1100~1500	0.08~0.12	9~10	溝銑(Slotting)
UKR1002	36mm	205	6000~7000	2600~3000	0.08~0.12	0.08~0.12	3D銑(3D milling)
UKR1003	36mm	205	6000~7000	1100~1500	0.08~0.12	9~10	溝銑(Slotting)
UKR1003	36mm	205	6000~7000	2600~3000	0.08~0.12	0.08~0.12	3D銑(3D milling)
UKR1005	36mm	205	6000~7000	1100~1500	0.08~0.12	8~10	溝銑(Slotting)
UKR1005	36mm	205	6000~7000	2600~3000	0.08~0.12	0.08~0.12	3D銑(3D milling)
UKR1010	36mm	205	6000~7000	1100~1500	0.08~0.12	7~10	溝銑(Slotting)
UKR1010	36mm	205	6000~7000	2600~3000	0.08~0.12	0.08~0.12	3D銑(3D milling)
UKR1203	40mm	200	4500~5500	1100~1500	0.1~0.13	11~12	溝銑(Slotting)
UKR1203	40mm	200	4500~5500	2000~2400	0.1~0.13	0.1~0.13	3D銑(3D milling)
UKR1205	40mm	200	4500~5500	1100~1500	0.1~0.13	10~12	溝銑(Slotting)
UKR1205	40mm	200	4500~5500	2000~2400	0.1~0.13	0.1~0.13	3D銑(3D milling)
UKR1210	40mm	200	4500~5500	1100~1500	0.1~0.13	9~12	溝銑(Slotting)
UKR1210	40mm	200	4500~5500	2000~2400	0.1~0.13	0.1~0.13	3D銑(3D milling)
UKR1215	40mm	200	4500~5500	1100~1500	0.1~0.13	7~12	溝銑(Slotting)
UKR1215	40mm	200	4500~5500	2000~2400	0.1~0.13	0.1~0.13	3D銑(3D milling)
UKR1220	40mm	200	4500~5500	1100~1500	0.1~0.13	7~12	溝銑(Slotting)
UKR1220	40mm	200	4500~5500	2000~2400	0.1~0.13	0.1~0.13	3D銑(3D milling)

附註/ Note :

建議冷卻方式為乾式。

Suggest to use Dry coolant .