

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 <sup>-1</sup> )	進給速度 Feed (mm/min)	加工深度(Aa) Depth of Cut	加工寬度(Ap) Width of Cut
ULR0605	40mm	65	3400~3800	600~800	0.05~0.1	4~6	溝銑(Slotting)
ULR0605	40mm	50	2600~3000	400~600	12	0.05~0.1	側銑(Side milling)
ULR0605	40mm	75	3800~4200	800~1200	0.05~0.1	0.05~0.1	3D銑(3D milling)
ULR0610	40mm	65	3400~3800	600~800	0.05~0.1	3~6	溝銑(Slotting)
ULR0610	40mm	50	2600~3000	400~600	12	0.05~0.1	側銑(Side milling)
ULR0610	40mm	75	3800~4200	800~1200	0.05~0.1	0.05~0.1	3D銑(3D milling)
ULR0805	50mm	60	2400~2800	800~1200	0.05~0.1	6~8	溝銑(Slotting)
ULR0805	50mm	45	1800~2200	400~600	16	0.05~0.1	側銑(Side milling)
ULR0805	50mm	75	3000~3400	1000~1200	0.05~0.1	0.05~0.1	3D銑(3D milling)
ULR0810	50mm	60	2400~2800	800~1200	0.05~0.1	5~8	溝銑(Slotting)
ULR0810	50mm	45	1800~2200	400~600	16	0.05~0.1	側銑(Side milling)
ULR0810	50mm	75	3000~3400	1000~1200	0.05~0.1	0.05~0.1	3D銑(3D milling)
ULR1005	50mm	120	3800~4200	1000~1400	0.05~0.1	8~10	溝銑(Slotting)
ULR1005	50mm	50	1600~2000	400~600	20	0.05~0.1	側銑(Side milling)
ULR1005	50mm	125	4000~4400	1200~1600	0.05~0.1	0.05~0.1	3D銑(3D milling)
ULR1010	50mm	120	3800~4200	1000~1400	0.05~0.1	7~10	溝銑(Slotting)
ULR1010	50mm	50	1600~2000	400~600	20	0.05~0.1	側銑(Side milling)
ULR1010	50mm	125	4000~4400	1200~1600	0.05~0.1	0.05~0.1	3D銑(3D milling)
ULR1020	50mm	120	3800~4200	1000~1400	0.05~0.1	5~10	溝銑(Slotting)
ULR1020	50mm	50	1600~2000	400~600	20	0.05~0.1	側銑(Side milling)
ULR1020	50mm	125	4000~4400	1200~1600	0.05~0.1	0.05~0.1	3D銑(3D milling)
ULR1205	60mm	105	2800~3200	1000~1400	0.05~0.1	10~12	溝銑(Slotting)
ULR1205	60mm	30	800~1100	300~500	24	0.05~0.1	側銑(Side milling)
ULR1205	60mm	115	3000~3400	1400~1800	0.05~0.1	0.05~0.1	3D銑(3D milling)
ULR1210	60mm	105	2800~3200	1000~1400	0.05~0.1	9~12	溝銑(Slotting)
ULR1210	60mm	30	800~1100	300~500	24	0.05~0.1	側銑(Side milling)
ULR1210	60mm	115	3000~3400	1400~1800	0.05~0.1	0.05~0.1	3D銑(3D milling)
ULR1220	60mm	105	2800~3200	1000~1400	0.05~0.1	7~12	溝銑(Slotting)
ULR1220	60mm	30	800~1100	300~500	24	0.05~0.1	側銑(Side milling)
ULR1220	60mm	115	3000~3400	1400~1800	0.05~0.1	0.05~0.1	3D銑(3D milling)
ULR1610	100mm	105	2100~2500	1000~1400	0.07~0.12	13~16	溝銑(Slotting)
ULR1610	100mm	30	800~1100	300~500	32	0.07~0.12	側銑(Side milling)
ULR1610	100mm	115	2300~2700	1400~1800	0.07~0.12	0.07~0.12	3D銑(3D milling)
ULR1620	100mm	105	2100~2500	1000~1400	0.07~0.12	11~16	溝銑(Slotting)
ULR1620	100mm	30	800~1100	300~500	32	0.07~0.12	側銑(Side milling)
ULR1620	100mm	115	2300~2700	1400~1800	0.07~0.12	0.07~0.12	3D銑(3D milling)

附註 / Note :

建議冷卻方式為濕式

Suggest to use Wet coolant.

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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 <sup>-1</sup> )	進給速度 Feed (mm/min)	加工深度(Aa) Depth of Cut	加工寬度(Ap) Width of Cut
ULR0605	40mm	65	3400~3800	600~800	0.05~0.1	4~6	溝銑(Slotting)
ULR0605	40mm	45	2400~2800	300~500	12	0.05~0.1	側銑(Side milling)
ULR0605	40mm	75	3800~4200	800~1200	0.05~0.1	0.05~0.1	3D銑(3D milling)
ULR0610	40mm	65	3400~3800	600~800	0.05~0.1	3~6	溝銑(Slotting)
ULR0610	40mm	45	2400~2800	300~500	12	0.05~0.1	側銑(Side milling)
ULR0610	40mm	75	3800~4200	800~1200	0.05~0.1	0.05~0.1	3D銑(3D milling)
ULR0805	50mm	60	2400~2800	800~1200	0.05~0.1	6~8	溝銑(Slotting)
ULR0805	50mm	40	1600~2000	400~600	16	0.05~0.1	側銑(Side milling)
ULR0805	50mm	75	3000~3400	1000~1200	0.05~0.1	0.05~0.1	3D銑(3D milling)
ULR0810	50mm	60	2400~2800	800~1200	0.05~0.1	5~8	溝銑(Slotting)
ULR0810	50mm	40	1600~2000	400~600	16	0.05~0.1	側銑(Side milling)
ULR0810	50mm	75	3000~3400	1000~1200	0.05~0.1	0.05~0.1	3D銑(3D milling)
ULR1005	50mm	120	3800~4200	1000~1200	0.05~0.1	8~10	溝銑(Slotting)
ULR1005	50mm	50	1600~2000	400~600	20	0.05~0.1	側銑(Side milling)
ULR1005	50mm	125	4000~4400	1000~1400	0.05~0.1	0.05~0.1	3D銑(3D milling)
ULR1010	50mm	120	3800~4200	1000~1200	0.05~0.1	7~10	溝銑(Slotting)
ULR1010	50mm	50	1600~2000	400~600	20	0.05~0.1	側銑(Side milling)
ULR1010	50mm	125	4000~4400	1000~1400	0.05~0.1	0.05~0.1	3D銑(3D milling)
ULR1020	50mm	120	3800~4200	1000~1200	0.05~0.1	5~10	溝銑(Slotting)
ULR1020	50mm	50	1600~2000	400~600	20	0.05~0.1	側銑(Side milling)
ULR1020	50mm	125	4000~4400	1000~1400	0.05~0.1	0.05~0.1	3D銑(3D milling)
ULR1205	60mm	105	2800~3200	1000~1400	0.05~0.1	10~12	溝銑(Slotting)
ULR1205	60mm	30	800~1100	300~500	24	0.05~0.1	側銑(Side milling)
ULR1205	60mm	115	3000~3400	1200~1600	0.05~0.1	0.05~0.1	3D銑(3D milling)
ULR1210	60mm	105	2800~3200	1000~1400	0.05~0.1	9~12	溝銑(Slotting)
ULR1210	60mm	30	800~1100	300~500	24	0.05~0.1	側銑(Side milling)
ULR1210	60mm	115	3000~3400	1200~1600	0.05~0.1	0.05~0.1	3D銑(3D milling)
ULR1220	60mm	105	2800~3200	1000~1400	0.05~0.1	7~12	溝銑(Slotting)
ULR1220	60mm	30	800~1100	300~500	24	0.05~0.1	側銑(Side milling)
ULR1220	60mm	115	3000~3400	1200~1600	0.05~0.1	0.05~0.1	3D銑(3D milling)
ULR1610	100mm	105	2100~2500	1000~1400	0.07~0.12	13~16	溝銑(Slotting)
ULR1610	100mm	30	800~1100	300~500	32	0.07~0.12	側銑(Side milling)
ULR1610	100mm	115	2300~2700	1200~1600	0.07~0.12	0.07~0.12	3D銑(3D milling)
ULR1620	100mm	105	2100~2500	1000~1400	0.07~0.12	11~16	溝銑(Slotting)
ULR1620	100mm	30	800~1100	300~500	32	0.07~0.12	側銑(Side milling)
ULR1620	100mm	115	2300~2700	1200~1600	0.07~0.12	0.07~0.12	3D銑(3D milling)

附註 / Note :

建議冷卻方式為濕式

Suggest to use Wet coolant.

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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 <sup>-1</sup> )	進給速度 Feed (mm/min)	加工深度(Aa) Depth of Cut	加工寬度(Ap) Width of Cut
ULR0605	40mm	45	2400~2800	300~500	0.05~0.1	4~6	溝銑(Slotting)
ULR0605	40mm	45	2400~2800	300~500	12	0.05~0.1	側銑(Side milling)
ULR0605	40mm	65	3400~3800	800~1000	0.05~0.1	0.05~0.1	3D銑(3D milling)
ULR0610	40mm	45	2400~2800	300~500	0.05~0.1	3~6	溝銑(Slotting)
ULR0610	40mm	45	2400~2800	300~500	12	0.05~0.1	側銑(Side milling)
ULR0610	40mm	65	3400~3800	800~1000	0.05~0.1	0.05~0.1	3D銑(3D milling)
ULR0805	50mm	55	2200~2600	800~1000	0.05~0.1	6~8	溝銑(Slotting)
ULR0805	50mm	60	2400~2800	600~800	16	0.05~0.1	側銑(Side milling)
ULR0805	50mm	75	3000~3400	800~1000	0.05~0.1	0.05~0.1	3D銑(3D milling)
ULR0810	50mm	55	2200~2600	800~1000	0.05~0.1	5~8	溝銑(Slotting)
ULR0810	50mm	60	2400~2800	600~800	16	0.05~0.1	側銑(Side milling)
ULR0810	50mm	75	3000~3400	800~1000	0.05~0.1	0.05~0.1	3D銑(3D milling)
ULR1005	50mm	115	3600~4000	800~1000	0.05~0.1	8~10	溝銑(Slotting)
ULR1005	50mm	65	2000~2400	400~600	20	0.05~0.1	側銑(Side milling)
ULR1005	50mm	125	4000~4400	800~1200	0.05~0.1	0.05~0.1	3D銑(3D milling)
ULR1010	50mm	115	3600~4000	800~1000	0.05~0.1	7~10	溝銑(Slotting)
ULR1010	50mm	65	2000~2400	400~600	20	0.05~0.1	側銑(Side milling)
ULR1010	50mm	125	4000~4400	800~1200	0.05~0.1	0.05~0.1	3D銑(3D milling)
ULR1020	50mm	115	3600~4000	800~1000	0.05~0.1	5~10	溝銑(Slotting)
ULR1020	50mm	65	2000~2400	400~600	20	0.05~0.1	側銑(Side milling)
ULR1020	50mm	125	4000~4400	800~1200	0.05~0.1	0.05~0.1	3D銑(3D milling)
ULR1205	60mm	105	2800~3200	800~1200	0.05~0.1	10~12	溝銑(Slotting)
ULR1205	60mm	70	1800~2200	400~600	24	0.05~0.1	側銑(Side milling)
ULR1205	60mm	115	3000~3400	800~1200	0.05~0.1	0.05~0.1	3D銑(3D milling)
ULR1210	60mm	105	2800~3200	800~1200	0.05~0.1	9~12	溝銑(Slotting)
ULR1210	60mm	70	1800~2200	400~600	24	0.05~0.1	側銑(Side milling)
ULR1210	60mm	115	3000~3400	800~1200	0.05~0.1	0.05~0.1	3D銑(3D milling)
ULR1220	60mm	105	2800~3200	800~1200	0.05~0.1	7~12	溝銑(Slotting)
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