



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
UOB0102	15mm	65	18000~20000	600~800	0.06~0.08	0.12~0.16	3D銑(3D milling)
UOB0102	15mm	65	18000~20000	1000~1200	0.03~0.05	0.06~0.1	3D銑(3D milling)
UOB0152	15mm	85	17000~18000	700~900	0.06~0.08	0.12~0.16	3D銑(3D milling)
UOB0152	15mm	85	17000~18000	1000~1200	0.03~0.05	0.06~0.1	3D銑(3D milling)
UOB0202	15mm	115	17000~18000	700~900	0.08~0.1	0.16~0.2	3D銑(3D milling)
UOB0202	15mm	115	17000~18000	1600~1800	0.04~0.05	0.08~0.1	3D銑(3D milling)
UOB0302S	15mm	160	16000~17000	600~800	0.1~0.13	0.2~0.26	3D銑(3D milling)
UOB0302S	15mm	160	16000~17000	1600~1800	0.03~0.05	0.06~0.1	3D銑(3D milling)
UOB0302	15mm	160	16000~17000	800~1000	0.1~0.13	0.2~0.26	3D銑(3D milling)
UOB0302	15mm	160	16000~17000	1800~2000	0.04~0.06	0.08~0.12	3D銑(3D milling)
UOB0302L	40mm	140	14000~15000	400~600	0.08~0.11	0.16~0.22	3D銑(3D milling)
UOB0302L	40mm	160	16000~17000	1300~1500	0.03~0.05	0.06~0.1	3D銑(3D milling)
UOB0402S	15mm	200	15000~16000	600~800	0.12~0.15	0.24~0.3	3D銑(3D milling)
UOB0402S	15mm	200	15000~16000	2400~2600	0.04~0.05	0.08~0.1	3D銑(3D milling)
UOB0402	15mm	200	15000~16000	800~1000	0.12~0.15	0.24~0.3	3D銑(3D milling)
UOB0402	15mm	200	15000~16000	2400~2800	0.05~0.08	0.1~0.16	3D銑(3D milling)
UOB0402L	40mm	175	13000~14000	400~600	0.1~0.12	0.2~0.24	3D銑(3D milling)
UOB0402L	40mm	190	14000~15000	1900~2300	0.03~0.05	0.06~0.1	3D銑(3D milling)
UOB0602	15mm	230	11000~12000	800~1200	0.2~0.3	0.4~0.6	3D銑(3D milling)
UOB0602	15mm	245	12000~13000	3000~3400	0.05~0.09	0.1~0.18	3D銑(3D milling)
UOB0602M	35mm	210	10000~11000	600~1000	0.15~0.2	0.3~0.4	3D銑(3D milling)
UOB0602M	35mm	245	12000~13000	2400~2900	0.04~0.06	0.08~0.12	3D銑(3D milling)
UOB0602L	50mm	75	3400~3800	600~800	0.15~0.2	0.3~0.4	3D銑(3D milling)
UOB0602L	50mm	75	3400~3800	1600~2000	0.04~0.06	0.08~0.12	3D銑(3D milling)
UOB0802	20mm	235	8700~9200	1200~1600	0.3~0.5	0.6~1	3D銑(3D milling)
UOB0802	20mm	305	10000~12000	3000~3400	0.07~0.1	0.14~0.2	3D銑(3D milling)
UOB0802L	50mm	145	5400~5800	800~1200	0.2~0.4	0.4~0.8	3D銑(3D milling)
UOB0802L	50mm	145	5400~5800	2000~2400	0.07~0.1	0.14~0.2	3D銑(3D milling)
UOB1002	30mm	270	7500~8500	1400~1800	0.4~0.6	0.8~1.2	3D銑(3D milling)
UOB1002	30mm	300	8700~9500	3000~3400	0.08~0.12	0.16~0.24	3D銑(3D milling)
UOB1002L	60mm	230	6700~7200	1000~1400	0.2~0.25	0.4~0.5	3D銑(3D milling)
UOB1002L	60mm	230	6700~7200	2000~2500	0.08~0.12	0.16~0.24	3D銑(3D milling)

附註 / Note :

建議冷卻方式為油霧。

Suggest to use MQL coolant.

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 SKD11 / SKH9 : 1.2379 / 1.3342 : D2 / M2 (HRC55~62)						
	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
UOB0102	15mm	65	18000~20000	600~800	0.03~0.05	0.06~0.1	3D銑(3D milling)
UOB0152	15mm	85	17000~18000	700~900	0.03~0.05	0.06~0.1	3D銑(3D milling)
UOB0202	15mm	115	17000~18000	700~900	0.04~0.05	0.08~0.1	3D銑(3D milling)
UOB0302S	15mm	150	14000~16000	500~700	0.07~0.09	0.14~0.18	3D銑(3D milling)
UOB0302S	15mm	160	16000~17000	1000~1200	0.03~0.05	0.06~0.1	3D銑(3D milling)
UOB0302	15mm	150	14000~16000	600~800	0.07~0.09	0.14~0.18	3D銑(3D milling)
UOB0302	15mm	160	16000~17000	1300~1500	0.04~0.06	0.08~0.12	3D銑(3D milling)
UOB0302L	40mm	125	12000~13000	400~600	0.06~0.08	0.12~0.16	3D銑(3D milling)
UOB0302L	40mm	125	12000~13000	700~900	0.03~0.05	0.06~0.1	3D銑(3D milling)
UOB0402S	15mm	175	13000~14000	400~600	0.08~0.12	0.16~0.24	3D銑(3D milling)
UOB0402S	15mm	200	15000~16000	1100~1500	0.03~0.05	0.06~0.1	3D銑(3D milling)
UOB0402	15mm	175	13000~14000	600~800	0.11~0.13	0.22~0.26	3D銑(3D milling)
UOB0402	15mm	200	15000~16000	1300~1700	0.04~0.06	0.08~0.12	3D銑(3D milling)
UOB0402L	40mm	150	11000~12000	400~600	0.08~0.12	0.16~0.24	3D銑(3D milling)
UOB0402L	40mm	150	11000~12000	900~1300	0.03~0.05	0.06~0.1	3D銑(3D milling)
UOB0602	15mm	175	8700~9200	600~1000	0.14~0.15	0.28~0.3	3D銑(3D milling)
UOB0602	15mm	210	10000~11000	1700~2100	0.05~0.08	0.1~0.16	3D銑(3D milling)
UOB0602M	35mm	160	7500~8500	500~800	0.1~0.12	0.2~0.24	3D銑(3D milling)
UOB0602M	35mm	190	9000~10000	1300~1700	0.04~0.06	0.08~0.12	3D銑(3D milling)
UOB0602L	50mm	75	3400~3800	500~700	0.07~0.09	0.14~0.18	3D銑(3D milling)
UOB0602L	50mm	75	3400~3800	700~900	0.04~0.06	0.08~0.12	3D銑(3D milling)
UOB0802	20mm	180	6800~7200	600~1000	0.2~0.25	0.4~0.5	3D銑(3D milling)
UOB0802	20mm	235	8700~9200	2100~2500	0.07~0.1	0.14~0.2	3D銑(3D milling)
UOB0802L	50mm	165	5500~6500	500~700	0.1~0.15	0.2~0.3	3D銑(3D milling)
UOB0802L	50mm	175	6500~7000	1100~1600	0.06~0.08	0.14~0.2	3D銑(3D milling)
UOB1002	30mm	190	5500~6000	1000~1400	0.3~0.4	0.6~0.8	3D銑(3D milling)
UOB1002	30mm	210	6200~6700	2100~2500	0.08~0.12	0.16~0.24	3D銑(3D milling)
UOB1002L	60mm	160	4500~5000	600~1000	0.15~0.2	0.3~0.4	3D銑(3D milling)
UOB1002L	60mm	190	5000~6000	1600~2100	0.08~0.11	0.16~0.24	3D銑(3D milling)

附註 / Note :

建議冷卻方式為油霧。

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