

被切削材 Work Material	碳素鋼 : Carbon Steels S50C / SS400 : 1.1210 / 1.0036 : 1050 / A570 Gr.45 (~HRc22)						
	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
UPG0304	16mm	90	9000~10000	1600~2000	0~0.2	3	溝銑(Slotting)
UPG0304	16mm	90	9000~10000	700~1100	0.7~1	3	溝銑(Slotting)
UPG0304	16mm	90	9000~10000	500~800	3	3	溝銑(Slotting)
UPG0304	16mm	90	9000~10000	1600~2000	3	0~0.2	側銑(Side milling)
UPG0304	16mm	90	9000~10000	800~1200	3	1	側銑(Side milling)
UPG0304	16mm	90	9000~10000	700~1100	3	2	側銑(Side milling)
UPG0304	16mm	90	9000~10000	1200~1600	6	0~0.2	側銑(Side milling)
UPG0304	16mm	90	9000~10000	500~800	6	0.7~1	側銑(Side milling)
UPG0404	18mm	105	8000~8500	1600~2000	0~0.3	4	溝銑(Slotting)
UPG0404	18mm	105	8000~8500	700~1100	1~1.5	4	溝銑(Slotting)
UPG0404	18mm	105	8000~8500	500~800	4	4	溝銑(Slotting)
UPG0404	18mm	105	8000~8500	1600~2000	4	0~0.3	側銑(Side milling)
UPG0404	18mm	105	8000~8500	800~1200	4	1	側銑(Side milling)
UPG0404	18mm	105	8000~8500	700~1100	4	3	側銑(Side milling)
UPG0404	18mm	105	8000~8500	1200~1600	8	0~0.3	側銑(Side milling)
UPG0404	18mm	105	8000~8500	500~800	8	0.7~1	側銑(Side milling)
UPG0504	20mm	110	6800~7300	1600~2000	0~0.4	5	溝銑(Slotting)
UPG0504	20mm	110	6800~7300	500~800	2~2.5	5	溝銑(Slotting)
UPG0504	20mm	110	6800~7300	500~800	5	5	溝銑(Slotting)
UPG0504	20mm	110	6800~7300	1400~1800	5	0~0.4	側銑(Side milling)
UPG0504	20mm	110	6800~7300	700~1100	5	1	側銑(Side milling)
UPG0504	20mm	110	6800~7300	500~800	5	3~4	側銑(Side milling)
UPG0504	20mm	110	6800~7300	1000~1400	10	0~0.4	側銑(Side milling)
UPG0504	20mm	110	6800~7300	500~800	10	1~1.5	側銑(Side milling)
UPG0604	20mm	110	5700~6200	1800~2200	0~0.4	6	溝銑(Slotting)
UPG0604	20mm	110	5700~6200	700~1000	2~3	6	溝銑(Slotting)
UPG0604	20mm	110	5700~6200	700~1000	6	6	溝銑(Slotting)
UPG0604	20mm	110	5700~6200	1600~2000	6	0~0.4	側銑(Side milling)
UPG0604	20mm	110	5700~6200	800~1200	6	1~2	側銑(Side milling)
UPG0604	20mm	110	5700~6200	700~1000	6	4~5	側銑(Side milling)
UPG0604	20mm	110	5700~6200	1200~1600	12	0~0.4	側銑(Side milling)
UPG0604	20mm	110	5700~6200	700~1000	12	1~1.5	側銑(Side milling)
UPG0604L	30mm	85	4200~4700	800~1200	16	0~0.4	側銑(Side milling)
UPG0604L	30mm	85	4200~4700	500~800	16	0.8~1.2	側銑(Side 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	碳素鋼 : Carbon Steels S50C / SS400 : 1.1210 / 1.0036 : 1050 / A570 Gr.45 (~HRc22)						
	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
UPG0804	25mm	120	4500~5000	2000~2400	0~0.5	8	溝銑(Slotting)
UPG0804	25mm	120	4500~5000	700~1000	3~4	8	溝銑(Slotting)
UPG0804	25mm	120	4500~5000	500~800	8	8	溝銑(Slotting)
UPG0804	25mm	120	4500~5000	1800~2200	8	0~0.5	側銑(Side milling)
UPG0804	25mm	120	4500~5000	700~1000	8	3~4	側銑(Side milling)
UPG0804	25mm	120	4500~5000	700~1000	8	6~7	側銑(Side milling)
UPG0804	25mm	120	4500~5000	1400~1800	16	0~0.5	側銑(Side milling)
UPG0804	25mm	120	4500~5000	800~1200	16	1~2	側銑(Side milling)
UPG0804L	35mm	120	4500~5000	1000~1400	20	0~0.5	側銑(Side milling)
UPG0804L	35mm	75	2700~3200	700~1000	20	1~1.5	側銑(Side milling)
UPG1004	30mm	125	3700~4200	1600~2000	0~0.5	10	溝銑(Slotting)
UPG1004	30mm	125	3700~4200	500~800	4~5	10	溝銑(Slotting)
UPG1004	30mm	125	3700~4200	500~800	10	10	溝銑(Slotting)
UPG1004	30mm	125	3700~4200	1400~1800	10	0~0.5	側銑(Side milling)
UPG1004	30mm	95	2800~3300	700~1000	10	4~5	側銑(Side milling)
UPG1004	30mm	125	3700~4200	700~1000	10	7~8	側銑(Side milling)
UPG1004	30mm	125	3700~4200	1200~1600	20	0~0.5	側銑(Side milling)
UPG1004	30mm	115	3400~3800	700~1100	20	1~2	側銑(Side milling)
UPG1004L	40mm	125	3700~4200	1000~1400	25	0~0.5	側銑(Side milling)
UPG1004L	40mm	75	2200~2600	600~900	25	1~1.5	側銑(Side milling)
UPG1204	35mm	110	2700~3200	1800~2200	0~0.5	12	溝銑(Slotting)
UPG1204	35mm	110	2700~3200	500~800	2~3	12	溝銑(Slotting)
UPG1204	35mm	110	2700~3200	500~800	5~6	12	溝銑(Slotting)
UPG1204	35mm	110	2700~3200	1400~1800	12	0~0.5	側銑(Side milling)
UPG1204	35mm	110	2700~3200	800~1200	12	2~3	側銑(Side milling)
UPG1204	35mm	110	2700~3200	700~1000	12	5~6	側銑(Side milling)
UPG1204	35mm	110	2700~3200	1000~1400	24	0~0.5	側銑(Side milling)
UPG1204	35mm	110	2200~2700	500~800	24	2~3	側銑(Side milling)
UPG1204L	50mm	90	2200~2600	700~1000	30	0~0.5	側銑(Side milling)
UPG1204L	50mm	75	1800~2200	500~800	30	1~2	側銑(Side milling)

被切削材 Work Material	碳素鋼 : Carbon Steels S50C / SS400 : 1.1210 / 1.0036 : 1050 / A570 Gr.45 (~HRC22)						
	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
UPG1604	45mm	110	2000~2500	1200~1600	0~0.6	16	溝銑(Slotting)
UPG1604	45mm	110	2000~2500	400~700	3~4	16	溝銑(Slotting)
UPG1604	45mm	110	2000~2500	800~1200	16	0~0.6	側銑(Side milling)
UPG1604	45mm	110	2000~2500	500~800	16	3~4	側銑(Side milling)
UPG1604	45mm	110	2000~2500	700~1000	32	0~0.6	側銑(Side milling)
UPG1604	45mm	110	2000~2500	400~700	32	3~4	側銑(Side milling)
UPG1604L	65mm	90	1600~2000	500~800	40	0~0.6	側銑(Side milling)
UPG1604L	65mm	75	1300~1800	400~700	40	1~2	側銑(Side milling)
UPG1804	55mm	100	1500~2000	800~1100	0~0.6	18	溝銑(Slotting)
UPG1804	55mm	100	1500~2000	400~600	2~3	18	溝銑(Slotting)
UPG1804	55mm	100	1500~2000	700~1000	18	0~0.7	側銑(Side milling)
UPG1804	55mm	100	1500~2000	500~800	18	2~3	側銑(Side milling)
UPG1804	55mm	100	1500~2000	500~800	36	0~0.6	側銑(Side milling)
UPG1804	55mm	100	1500~2000	400~700	36	2~3	側銑(Side milling)
UPG2004	55mm	100	1400~1800	700~900	0~0.6	20	溝銑(Slotting)
UPG2004	55mm	100	1400~1800	300~500	2~3	20	溝銑(Slotting)
UPG2004	55mm	100	1400~1800	600~900	20	0~0.6	側銑(Side milling)
UPG2004	55mm	100	1400~1800	300~500	20	2~3	側銑(Side milling)
UPG2004	55mm	100	1400~1800	500~800	40	0~0.6	側銑(Side milling)
UPG2004	55mm	100	1400~1800	200~400	40	2~3	側銑(Side milling)
UPG2004L	70mm	90	1200~1600	500~700	40	0~0.6	側銑(Side milling)
UPG2004L	70mm	75	1000~1400	300~500	40	1~2	側銑(Side milling)

附註 / Note :

建議冷卻方式為濕式。

Suggest to use Wet coolant.

被切削材 Work Material	鉻鉬合金鋼 SCM440 : 1.7225 : 4140 : 42CrMoA (HRC25~28)						
	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
UPG0304	16mm	90	9000~10000	1400~1800	0~0.2	3	溝銑(Slotting)
UPG0304	16mm	90	9000~10000	700~1000	0.7~1	3	溝銑(Slotting)
UPG0304	16mm	90	9000~10000	400~700	3	3	溝銑(Slotting)
UPG0304	16mm	90	9000~10000	1400~1800	3	0~0.2	側銑(Side milling)
UPG0304	16mm	90	9000~10000	700~1100	3	1	側銑(Side milling)
UPG0304	16mm	90	9000~10000	500~800	3	2	側銑(Side milling)
UPG0304	16mm	90	9000~10000	1000~1400	6	0~0.2	側銑(Side milling)
UPG0304	16mm	90	9000~10000	400~700	6	0.7~1	側銑(Side milling)
UPG0404	18mm	105	8000~8500	1400~1800	0~0.3	4	溝銑(Slotting)
UPG0404	18mm	105	8000~8500	700~1000	1~1.5	4	溝銑(Slotting)
UPG0404	18mm	105	8000~8500	400~700	4	4	溝銑(Slotting)
UPG0404	18mm	105	8000~8500	1400~1800	4	0~0.3	側銑(Side milling)
UPG0404	18mm	105	8000~8500	700~1100	4	1	側銑(Side milling)
UPG0404	18mm	105	8000~8500	500~800	4	3	側銑(Side milling)
UPG0404	18mm	105	8000~8500	1000~1400	8	0~0.3	側銑(Side milling)
UPG0404	18mm	105	8000~8500	400~700	8	0.7~1	側銑(Side milling)
UPG0504	20mm	110	6800~7300	1400~1800	0~0.4	5	溝銑(Slotting)
UPG0504	20mm	110	6800~7300	400~700	2~2.5	5	溝銑(Slotting)
UPG0504	20mm	110	6800~7300	400~700	5	5	溝銑(Slotting)
UPG0504	20mm	110	6800~7300	1200~1600	5	0~0.4	側銑(Side milling)
UPG0504	20mm	110	6800~7300	500~800	5	1	側銑(Side milling)
UPG0504	20mm	110	6800~7300	400~700	5	3~4	側銑(Side milling)
UPG0504	20mm	110	6800~7300	800~1200	10	0~0.4	側銑(Side milling)
UPG0504	20mm	110	6800~7300	400~700	10	1~1.5	側銑(Side milling)
UPG0604	20mm	110	5700~6200	1600~2000	0~0.4	6	溝銑(Slotting)
UPG0604	20mm	110	5700~6200	500~800	2~3	6	溝銑(Slotting)
UPG0604	20mm	110	5700~6200	500~800	6	6	溝銑(Slotting)
UPG0604	20mm	110	5700~6200	1400~1800	6	0~0.4	側銑(Side milling)
UPG0604	20mm	110	5700~6200	700~1100	6	1~2	側銑(Side milling)
UPG0604	20mm	110	5700~6200	500~800	6	4~5	側銑(Side milling)
UPG0604	20mm	110	5700~6200	1000~1400	12	0~0.4	側銑(Side milling)
UPG0604	20mm	110	5700~6200	500~800	12	1~1.5	側銑(Side milling)
UPG0604L	30mm	85	4200~4700	700~1000	16	0~0.4	側銑(Side milling)
UPG0604L	30mm	85	4200~4700	400~700	16	0.8~1.2	側銑(Side milling)

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被切削材 Work Material	鉻鉬合金鋼 SCM440 : 1.7225 : 4140 : 42CrMoA (HRC25~28)						
	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
UPG0804	25mm	120	4500~5000	1800~2200	0~0.5	8	溝銑(Slotting)
UPG0804	25mm	120	4500~5000	500~800	3~4	8	溝銑(Slotting)
UPG0804	25mm	120	4500~5000	400~700	8	8	溝銑(Slotting)
UPG0804	25mm	120	4500~5000	1600~2000	8	0~0.5	側銑(Side milling)
UPG0804	25mm	120	4500~5000	500~800	8	3~4	側銑(Side milling)
UPG0804	25mm	120	4500~5000	500~800	8	6~7	側銑(Side milling)
UPG0804	25mm	120	4500~5000	1200~1600	16	0~0.5	側銑(Side milling)
UPG0804	25mm	120	4500~5000	700~1000	16	1~2	側銑(Side milling)
UPG0804L	35mm	120	4500~5000	800~1200	20	0~0.5	側銑(Side milling)
UPG0804L	35mm	75	2700~3200	500~800	20	1~1.5	側銑(Side milling)
UPG1004	30mm	125	3700~4200	1400~1800	0~0.5	10	溝銑(Slotting)
UPG1004	30mm	125	3700~4200	400~700	4~5	10	溝銑(Slotting)
UPG1004	30mm	125	3700~4200	400~700	10	10	溝銑(Slotting)
UPG1004	30mm	125	3700~4200	1200~1600	10	0~0.5	側銑(Side milling)
UPG1004	30mm	95	2800~3300	500~800	10	4~5	側銑(Side milling)
UPG1004	30mm	125	3700~4200	500~800	10	7~8	側銑(Side milling)
UPG1004	30mm	125	3700~4200	1000~1400	20	0~0.5	側銑(Side milling)
UPG1004	30mm	115	3400~3800	500~800	20	1~2	側銑(Side milling)
UPG1004L	40mm	125	3700~4200	800~1200	25	0~0.5	側銑(Side milling)
UPG1004L	40mm	75	2200~2600	500~800	25	1~1.5	側銑(Side milling)
UPG1204	35mm	110	2700~3200	1600~2000	0~0.5	12	溝銑(Slotting)
UPG1204	35mm	110	2700~3200	400~700	2~3	12	溝銑(Slotting)
UPG1204	35mm	110	2700~3200	400~700	5~6	12	溝銑(Slotting)
UPG1204	35mm	110	2700~3200	1200~1600	12	0~0.5	側銑(Side milling)
UPG1204	35mm	110	2700~3200	700~1100	12	2~3	側銑(Side milling)
UPG1204	35mm	110	2700~3200	500~800	12	5~6	側銑(Side milling)
UPG1204	35mm	110	2700~3200	800~1200	24	0~0.5	側銑(Side milling)
UPG1204	35mm	110	2200~2700	400~700	24	2~3	側銑(Side milling)
UPG1204L	50mm	110	2700~3200	700~1000	30	0~0.5	側銑(Side milling)
UPG1204L	50mm	75	1800~2200	400~700	30	1~2	側銑(Side milling)

被切削材 Work Material	鉻鉬合金鋼 SCM440 : 1.7225 : 4140 : 42CrMoA (HRC25~28)						
	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
UPG1604	45mm	110	2000~2500	800~1200	0~0.6	16	溝銑(Slotting)
UPG1604	45mm	110	2000~2500	300~600	3~4	16	溝銑(Slotting)
UPG1604	45mm	110	2000~2500	700~1000	16	0~0.6	側銑(Side milling)
UPG1604	45mm	110	2000~2500	400~700	16	3~4	側銑(Side milling)
UPG1604	45mm	110	2000~2500	500~800	32	0~0.6	側銑(Side milling)
UPG1604	45mm	110	2000~2500	300~600	32	3~4	側銑(Side milling)
UPG1604L	65mm	110	2000~2500	400~700	40	0~0.6	側銑(Side milling)
UPG1604L	65mm	75	1300~1800	300~600	40	1~2	側銑(Side milling)
UPG1804	55mm	100	1500~2000	700~1000	0~0.6	18	溝銑(Slotting)
UPG1804	55mm	100	1500~2000	300~600	2~3	18	溝銑(Slotting)
UPG1804	55mm	100	1500~2000	500~800	18	0~0.7	側銑(Side milling)
UPG1804	55mm	100	1500~2000	400~700	18	2~3	側銑(Side milling)
UPG1804	55mm	100	1500~2000	400~700	36	0~0.6	側銑(Side milling)
UPG1804	55mm	100	1500~2000	300~600	36	2~3	側銑(Side milling)
UPG2004	55mm	100	1400~1800	600~800	0~0.6	20	溝銑(Slotting)
UPG2004	55mm	100	1400~1800	300~400	2~3	20	側銑(Side milling)
UPG2004	55mm	100	1400~1800	600~800	20	0~0.6	側銑(Side milling)
UPG2004	55mm	100	1400~1800	250~450	20	2~3	溝銑(Slotting)
UPG2004	55mm	100	1400~1800	500~700	40	0~0.6	側銑(Side milling)
UPG2004	55mm	100	1400~1800	200~350	40	2~3	側銑(Side milling)
UPG2004L	70mm	90	1200~1600	500~700	40	0~0.6	側銑(Side milling)
UPG2004L	70mm	75	1000~1400	300~500	40	1~2	側銑(Side milling)

附註 / Note :

建議冷卻方式為濕式。

Suggest to use Wet coolant.

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
UPG0304	16mm	90	9000~10000	1400~1800	0~0.2	3	溝銑(Slotting)
UPG0304	16mm	90	9000~10000	700~1000	0.7~1	3	溝銑(Slotting)
UPG0304	16mm	90	9000~10000	400~700	3	3	溝銑(Slotting)
UPG0304	16mm	90	9000~10000	1400~1800	3	0~0.2	側銑(Side milling)
UPG0304	16mm	90	9000~10000	700~1100	3	1	側銑(Side milling)
UPG0304	16mm	90	9000~10000	500~800	3	2	側銑(Side milling)
UPG0304	16mm	90	9000~10000	1000~1400	6	0~0.2	側銑(Side milling)
UPG0304	16mm	90	9000~10000	400~700	6	0.7~1	側銑(Side milling)
UPG0404	18mm	105	8000~8500	1400~1800	0~0.3	4	溝銑(Slotting)
UPG0404	18mm	105	8000~8500	700~1000	1~1.5	4	溝銑(Slotting)
UPG0404	18mm	105	8000~8500	400~700	4	4	溝銑(Slotting)
UPG0404	18mm	105	8000~8500	1400~1800	4	0~0.3	側銑(Side milling)
UPG0404	18mm	105	8000~8500	700~1100	4	1	側銑(Side milling)
UPG0404	18mm	105	8000~8500	500~800	4	3	側銑(Side milling)
UPG0404	18mm	105	8000~8500	1000~1400	8	0~0.3	側銑(Side milling)
UPG0404	18mm	105	8000~8500	400~700	8	0.7~1	側銑(Side milling)
UPG0504	20mm	110	6800~7300	1400~1800	0~0.4	5	溝銑(Slotting)
UPG0504	20mm	110	6800~7300	400~700	2~2.5	5	溝銑(Slotting)
UPG0504	20mm	110	6800~7300	400~700	5	5	溝銑(Slotting)
UPG0504	20mm	110	6800~7300	1200~1600	5	0~0.4	側銑(Side milling)
UPG0504	20mm	110	6800~7300	500~800	5	1	側銑(Side milling)
UPG0504	20mm	110	6800~7300	400~700	5	3~4	側銑(Side milling)
UPG0504	20mm	110	6800~7300	800~1200	10	0~0.4	側銑(Side milling)
UPG0504	20mm	110	6800~7300	400~700	10	1~1.5	側銑(Side milling)
UPG0604	20mm	110	5700~6200	1600~2000	0~0.4	6	溝銑(Slotting)
UPG0604	20mm	110	5700~6200	500~800	2~3	6	溝銑(Slotting)
UPG0604	20mm	110	5700~6200	500~800	6	6	溝銑(Slotting)
UPG0604	20mm	110	5700~6200	1400~1800	6	0~0.4	側銑(Side milling)
UPG0604	20mm	110	5700~6200	700~1100	6	1~2	側銑(Side milling)
UPG0604	20mm	110	5700~6200	500~800	6	4~5	側銑(Side milling)
UPG0604	20mm	110	5700~6200	1000~1400	12	0~0.4	側銑(Side milling)
UPG0604	20mm	110	5700~6200	500~800	12	1~1.5	側銑(Side milling)
UPG0604L	30mm	85	4200~4700	700~1000	16	0~0.4	側銑(Side milling)
UPG0604L	30mm	85	4200~4700	400~700	16	0.8~1.2	側銑(Side 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	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
UPG0804	25mm	120	4500~5000	1800~2200	0~0.5	8	溝銑(Slotting)
UPG0804	25mm	120	4500~5000	500~800	3~4	8	溝銑(Slotting)
UPG0804	25mm	120	4500~5000	400~700	8	8	溝銑(Slotting)
UPG0804	25mm	120	4500~5000	1600~2000	8	0~0.5	側銑(Side milling)
UPG0804	25mm	120	4500~5000	500~800	8	3~4	側銑(Side milling)
UPG0804	25mm	120	4500~5000	500~800	8	6~7	側銑(Side milling)
UPG0804	25mm	120	4500~5000	1200~1600	16	0~0.5	側銑(Side milling)
UPG0804	25mm	120	4500~5000	700~1000	16	1~2	側銑(Side milling)
UPG0804L	35mm	120	4500~5000	800~1200	20	0~0.5	側銑(Side milling)
UPG0804L	35mm	75	2700~3200	500~800	20	1~1.5	側銑(Side milling)
UPG1004	30mm	125	3700~4200	1400~1800	0~0.5	10	溝銑(Slotting)
UPG1004	30mm	125	3700~4200	400~700	4~5	10	溝銑(Slotting)
UPG1004	30mm	125	3700~4200	400~700	10	10	溝銑(Slotting)
UPG1004	30mm	125	3700~4200	1200~1600	10	0~0.5	側銑(Side milling)
UPG1004	30mm	95	2800~3300	500~800	10	4~5	側銑(Side milling)
UPG1004	30mm	125	3700~4200	500~800	10	7~8	側銑(Side milling)
UPG1004	30mm	125	3700~4200	1000~1400	20	0~0.5	側銑(Side milling)
UPG1004	30mm	115	3400~3800	500~800	20	1~2	側銑(Side milling)
UPG1004L	40mm	125	3700~4200	800~1200	25	0~0.5	側銑(Side milling)
UPG1004L	40mm	75	2200~2600	500~800	25	1~1.5	側銑(Side milling)
UPG1204	35mm	110	2700~3200	1600~2000	0~0.5	12	溝銑(Slotting)
UPG1204	35mm	110	2700~3200	400~700	2~3	12	溝銑(Slotting)
UPG1204	35mm	110	2700~3200	400~700	5~6	12	溝銑(Slotting)
UPG1204	35mm	110	2700~3200	1200~1600	12	0~0.5	側銑(Side milling)
UPG1204	35mm	110	2700~3200	700~1100	12	2~3	側銑(Side milling)
UPG1204	35mm	110	2700~3200	500~800	12	5~6	側銑(Side milling)
UPG1204	35mm	110	2700~3200	800~1200	24	0~0.5	側銑(Side milling)
UPG1204	35mm	110	2200~2700	400~700	24	2~3	側銑(Side milling)
UPG1204L	50mm	90	2200~2600	600~900	30	0~0.5	側銑(Side milling)
UPG1204L	50mm	75	1800~2200	400~700	30	1~2	側銑(Side milling)



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	加工方式 Milling Type
	UPG1604	45mm	110	2000~2500	800~1200	0~0.6	16	溝銑(Slotting)
	UPG1604	45mm	110	2000~2500	300~600	3~4	16	溝銑(Slotting)
	UPG1604	45mm	110	2000~2500	700~1000	16	0~0.6	側銑(Side milling)
	UPG1604	45mm	110	2000~2500	400~700	16	3~4	側銑(Side milling)
	UPG1604	45mm	110	2000~2500	500~800	32	0~0.6	側銑(Side milling)
	UPG1604	45mm	110	2000~2500	300~600	32	3~4	側銑(Side milling)
	UPG1604L	65mm	90	1600~2000	400~700	40	0~0.6	側銑(Side milling)
	UPG1604L	65mm	75	1300~1800	300~600	40	1~2	側銑(Side milling)
	UPG1804	55mm	100	1500~2000	700~1000	0~0.6	18	溝銑(Slotting)
	UPG1804	55mm	100	1500~2000	300~500	2~3	18	溝銑(Slotting)
	UPG1804	55mm	100	1500~2000	500~800	18	0~0.7	側銑(Side milling)
	UPG1804	55mm	100	1500~2000	400~700	18	2~3	側銑(Side milling)
	UPG1804	55mm	100	1500~2000	400~700	36	0~0.6	側銑(Side milling)
	UPG1804	55mm	100	1500~2000	300~600	36	2~3	側銑(Side milling)
	UPG2004	55mm	100	1400~1800	600~800	0~0.6	20	溝銑(Slotting)
	UPG2004	55mm	100	1400~1800	300~400	2~3	20	溝銑(Slotting)
	UPG2004	55mm	100	1400~1800	600~800	20	0~0.6	側銑(Side milling)
	UPG2004	55mm	100	1400~1800	250~450	20	2~3	側銑(Side milling)
	UPG2004	55mm	100	1400~1800	500~700	40	0~0.6	側銑(Side milling)
	UPG2004	55mm	100	1400~1800	200~350	40	2~3	側銑(Side milling)
	UPG2004L	70mm	90	1200~1600	500~700	40	0~0.6	側銑(Side milling)
	UPG2004L	70mm	75	1000~1400	300~500	40	1~2	側銑(Side milling)

附註 / Note :

建議冷卻方式為濕式。

Suggest to use Wet coolant.

被切削材 Work Material	沃斯田鐵系不銹鋼：Stainless Steels 【Easy】 SUS304：1.4301：AISI 304 (HRC28~32)						
	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
UPG0304	16mm	85	8700~9200	1200~1600	0~0.2	3	溝銑(Slotting)
UPG0304	16mm	85	8700~9200	500~800	0.7~1	3	溝銑(Slotting)
UPG0304	16mm	85	8700~9200	300~600	3	3	溝銑(Slotting)
UPG0304	16mm	85	8700~9200	1200~1600	3	0~0.2	側銑(Side milling)
UPG0304	16mm	85	8700~9200	500~800	3	1	側銑(Side milling)
UPG0304	16mm	85	8700~9200	400~700	3	2	側銑(Side milling)
UPG0304	16mm	85	8700~9200	800~1200	6	0~0.2	側銑(Side milling)
UPG0304	16mm	85	8700~9200	300~600	6	0.7~1	側銑(Side milling)
UPG0404	18mm	100	7500~8000	1200~1600	0~0.3	4	溝銑(Slotting)
UPG0404	18mm	100	7500~8000	500~800	1~1.5	4	溝銑(Slotting)
UPG0404	18mm	100	7500~8000	300~600	4	4	溝銑(Slotting)
UPG0404	18mm	100	7500~8000	1200~1600	4	0~0.3	側銑(Side milling)
UPG0404	18mm	100	7500~8000	500~800	4	1	側銑(Side milling)
UPG0404	18mm	100	7500~8000	400~700	4	3	側銑(Side milling)
UPG0404	18mm	100	7500~8000	800~1200	8	0~0.3	側銑(Side milling)
UPG0404	18mm	100	7500~8000	300~600	8	0.7~1	側銑(Side milling)
UPG0504	20mm	100	6300~6800	1200~1600	0~0.4	5	溝銑(Slotting)
UPG0504	20mm	100	6300~6800	300~600	2~2.5	5	溝銑(Slotting)
UPG0504	20mm	100	6300~6800	300~600	5	5	溝銑(Slotting)
UPG0504	20mm	100	6300~6800	1000~1400	5	0~0.4	側銑(Side milling)
UPG0504	20mm	100	6300~6800	400~700	5	1	側銑(Side milling)
UPG0504	20mm	100	6300~6800	300~600	5	3~4	側銑(Side milling)
UPG0504	20mm	100	6300~6800	700~1000	10	0~0.4	側銑(Side milling)
UPG0504	20mm	100	6300~6800	300~600	10	1~1.5	側銑(Side milling)
UPG0604	20mm	100	5200~5700	1400~1800	0~0.4	6	溝銑(Slotting)
UPG0604	20mm	100	5200~5700	400~700	2~3	6	溝銑(Slotting)
UPG0604	20mm	100	5200~5700	400~700	6	6	溝銑(Slotting)
UPG0604	20mm	100	5200~5700	1200~1600	6	0~0.4	側銑(Side milling)
UPG0604	20mm	100	5200~5700	500~800	6	1~2	側銑(Side milling)
UPG0604	20mm	100	5200~5700	400~700	6	4~5	側銑(Side milling)
UPG0604	20mm	100	5200~5700	800~1200	12	0~0.4	側銑(Side milling)
UPG0604	20mm	100	5200~5700	400~700	12	1~1.5	側銑(Side milling)
UPG0604L	30mm	85	4200~4700	500~800	16	0~0.4	側銑(Side milling)
UPG0604L	30mm	85	4200~4700	300~600	16	0.8~1.2	側銑(Side milling)

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被切削材 Work Material	沃斯田鐵系不銹鋼：Stainless Steels 【Easy】 SUS304：1.4301：AISI 304 (HRc28~32)						
	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
UPG0804	25mm	95	3600~4000	1400~1800	0~0.5	8	溝銑(Slotting)
UPG0804	25mm	95	3600~4000	400~700	3~4	8	溝銑(Slotting)
UPG0804	25mm	95	3600~4000	300~600	8	8	溝銑(Slotting)
UPG0804	25mm	95	3600~4000	1400~1800	8	0~0.5	側銑(Side milling)
UPG0804	25mm	95	3600~4000	400~700	8	3~4	側銑(Side milling)
UPG0804	25mm	95	3600~4000	400~700	8	6~7	側銑(Side milling)
UPG0804	25mm	95	3600~4000	1000~1400	16	0~0.5	側銑(Side milling)
UPG0804	25mm	95	3600~4000	500~800	16	1~2	側銑(Side milling)
UPG0804L	35mm	115	4300~4800	700~1000	20	0~0.5	側銑(Side milling)
UPG0804L	35mm	75	2700~3200	400~700	20	1~1.5	側銑(Side milling)
UPG1004	30mm	95	2800~3300	1200~1600	0~0.5	10	溝銑(Slotting)
UPG1004	30mm	95	2800~3300	300~600	4~5	10	溝銑(Slotting)
UPG1004	30mm	95	2800~3300	300~600	10	10	溝銑(Slotting)
UPG1004	30mm	95	2800~3300	1000~1400	10	0~0.5	側銑(Side milling)
UPG1004	30mm	95	2800~3300	400~700	10	4~5	側銑(Side milling)
UPG1004	30mm	95	2800~3300	400~700	10	7~8	側銑(Side milling)
UPG1004	30mm	95	2800~3300	800~1200	20	0~0.5	側銑(Side milling)
UPG1004	30mm	90	2700~3200	400~700	20	1~2	側銑(Side milling)
UPG1004L	40mm	125	3700~4200	700~1000	25	0~0.5	側銑(Side milling)
UPG1004L	40mm	75	2200~2600	400~700	25	1~1.5	側銑(Side milling)
UPG1204	35mm	95	2300~2700	1200~1600	0~0.5	12	溝銑(Slotting)
UPG1204	35mm	95	2300~2700	300~600	2~3	12	溝銑(Slotting)
UPG1204	35mm	95	2300~2700	300~600	5~6	12	溝銑(Slotting)
UPG1204	35mm	95	2300~2700	1000~1400	12	0~0.5	側銑(Side milling)
UPG1204	35mm	95	2300~2700	500~800	12	2~3	側銑(Side milling)
UPG1204	35mm	95	2300~2700	400~700	12	5~6	側銑(Side milling)
UPG1204	35mm	95	2300~2700	700~1000	24	0~0.5	側銑(Side milling)
UPG1204	35mm	95	2300~2700	300~600	24	2~3	側銑(Side milling)
UPG1204L	50mm	90	2200~2600	500~800	30	0~0.5	側銑(Side milling)
UPG1204L	50mm	75	1800~2200	300~600	30	1~2	側銑(Side milling)

被切削材 Work Material	沃斯田鐵系不銹鋼：Stainless Steels 【Easy】 SUS304：1.4301：AISI 304 (HRC28~32)							
	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	加工方式 Milling Type
	UPG1604	45mm	90	1600~2000	600~800	0~0.6	16	溝銑(Slotting)
	UPG1604	45mm	90	1600~2000	300~500	2~3	16	溝銑(Slotting)
	UPG1604	45mm	90	1600~2000	500~800	16	0~0.6	側銑(Side milling)
	UPG1604	45mm	90	1600~2000	300~600	16	2~3	側銑(Side milling)
	UPG1604	45mm	90	1600~2000	400~700	32	0~0.6	側銑(Side milling)
	UPG1604	45mm	90	1600~2000	300~500	32	2~3	側銑(Side milling)
	UPG1604L	65mm	90	1600~2000	300~600	40	0~0.6	側銑(Side milling)
	UPG1604L	65mm	75	1300~1800	300~500	40	1~2	側銑(Side milling)
	UPG1804	55mm	80	1200~1700	500~800	0~0.6	18	溝銑(Slotting)
	UPG1804	55mm	80	1200~1700	300~500	2~3	18	溝銑(Slotting)
	UPG1804	55mm	80	1200~1700	400~700	18	0~0.7	側銑(Side milling)
	UPG1804	55mm	80	1200~1700	300~600	18	2~3	側銑(Side milling)
	UPG1804	55mm	80	1200~1700	300~600	36	0~0.6	側銑(Side milling)
	UPG1804	55mm	80	1200~1700	300~500	36	2~3	側銑(Side milling)
	UPG2004	55mm	75	1000~1400	500~700	0~0.6	20	溝銑(Slotting)
	UPG2004	55mm	75	1000~1400	300~400	1~2	20	溝銑(Slotting)
	UPG2004	55mm	75	1000~1400	500~700	20	0~0.6	側銑(Side milling)
	UPG2004	55mm	75	1000~1400	250~450	20	1~2	側銑(Side milling)
	UPG2004	55mm	75	1000~1400	400~600	40	0~0.6	側銑(Side milling)
	UPG2004	55mm	75	1000~1400	200~350	40	1~2	側銑(Side milling)
	UPG2004L	70mm	75	1000~1400	400~600	40	0~0.6	側銑(Side milling)
	UPG2004L	70mm	75	1000~1400	200~400	40	1~1.5	側銑(Side milling)

附註 / Note :

建議冷卻方式為濕式。

Suggest to use Wet coolant.