

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 ⁻¹)	進給速度 Feed (mm/min)	加工深度(Aa) Depth of Cut	加工寬度(Ap) Width of Cut
UPW0305	18mm	90	9000~10000	700~1000	0.02~0.07	3	溝銑(Slotting)
UPW0305	18mm	90	9000~10000	1200~1600	0~0.2	3	溝銑(Slotting)
UPW0305	18mm	90	9000~10000	500~800	0.7~1	3	溝銑(Slotting)
UPW0305	18mm	90	9000~10000	500~800	3	3	溝銑(Slotting)
UPW0305	18mm	90	9000~10000	800~1200	3	0.02~0.07	側銑(Side milling)
UPW0305	18mm	90	9000~10000	1200~1600	3	0~0.2	側銑(Side milling)
UPW0305	18mm	90	9000~10000	800~1200	6	0.02~0.07	側銑(Side milling)
UPW0305	18mm	90	9000~10000	1000~1400	6	0~0.2	側銑(Side milling)
UPW0405	18mm	100	7500~8000	700~1000	0.03~0.08	4	溝銑(Slotting)
UPW0405	18mm	100	7500~8000	1200~1600	0~0.3	4	溝銑(Slotting)
UPW0405	18mm	100	7500~8000	500~800	1~1.5	4	溝銑(Slotting)
UPW0405	18mm	100	7500~8000	400~700	4	4	溝銑(Slotting)
UPW0405	18mm	100	7500~8000	800~1200	4	0.03~0.08	側銑(Side milling)
UPW0405	18mm	100	7500~8000	1200~1600	4	0~0.3	側銑(Side milling)
UPW0405	18mm	100	7500~8000	800~1200	8	0.03~0.08	側銑(Side milling)
UPW0405	18mm	100	7500~8000	1000~1400	8	0~0.3	側銑(Side milling)
UPW0505	20mm	100	6300~6800	500~800	0.05~0.1	5	溝銑(Slotting)
UPW0505	20mm	100	6300~6800	1800~2200	0~0.4	5	溝銑(Slotting)
UPW0505	20mm	100	6300~6800	700~1000	2~2.5	5	溝銑(Slotting)
UPW0505	20mm	100	6300~6800	500~800	5	5	溝銑(Slotting)
UPW0505	20mm	100	6300~6800	700~1100	5	0.05~0.1	側銑(Side milling)
UPW0505	20mm	100	6300~6800	1800~2200	5	0~0.4	側銑(Side milling)
UPW0505	20mm	100	6300~6800	700~1100	10	0.05~0.1	側銑(Side milling)
UPW0505	20mm	100	6300~6800	1200~1600	10	0~0.4	側銑(Side milling)
UPW0605	20mm	100	5200~5700	500~800	0.05~0.1	6	溝銑(Slotting)
UPW0605	20mm	100	5200~5700	2000~2400	0~0.4	6	溝銑(Slotting)
UPW0605	20mm	100	5200~5700	700~1000	2~3	6	溝銑(Slotting)
UPW0605	20mm	100	5200~5700	500~800	6	6	溝銑(Slotting)
UPW0605	20mm	100	5200~5700	700~1100	6	0.05~0.1	側銑(Side milling)
UPW0605	20mm	100	5200~5700	2000~2400	6	0~0.4	側銑(Side milling)
UPW0605	20mm	100	5200~5700	700~1100	12	0.05~0.1	側銑(Side milling)
UPW0605	20mm	100	5200~5700	1400~1800	12	0~0.4	側銑(Side milling)

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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 ⁻¹)	進給速度 Feed (mm/min)	加工深度(Aa) Depth of Cut	加工寬度(Ap) Width of Cut
UPW0805	25mm	120	4500~5000	500~800	0.05~0.1	8	溝銑(Slotting)
UPW0805	25mm	120	4500~5000	1800~2200	0~0.5	8	溝銑(Slotting)
UPW0805	25mm	120	4500~5000	500~800	3~4	8	溝銑(Slotting)
UPW0805	25mm	120	4500~5000	500~800	8	8	溝銑(Slotting)
UPW0805	25mm	120	4500~5000	700~1100	8	0.05~0.1	側銑(Side milling)
UPW0805	25mm	120	4500~5000	1800~2200	8	0~0.5	側銑(Side milling)
UPW0805	25mm	120	4500~5000	700~1100	16	0.05~0.1	側銑(Side milling)
UPW0805	25mm	120	4500~5000	1400~1800	16	0~0.5	側銑(Side milling)
UPW1005	30mm	130	3800~4300	500~800	0.05~0.1	10	溝銑(Slotting)
UPW1005	30mm	130	3800~4300	2000~2400	0~0.5	10	溝銑(Slotting)
UPW1005	30mm	130	3800~4300	700~1000	4~5	10	溝銑(Slotting)
UPW1005	30mm	130	3800~4300	500~800	10	10	溝銑(Slotting)
UPW1005	30mm	130	3800~4300	700~1100	10	0.05~0.1	側銑(Side milling)
UPW1005	30mm	130	3800~4300	2000~2400	10	0~0.5	側銑(Side milling)
UPW1005	30mm	130	3800~4300	1200~1600	10	1	側銑(Side milling)
UPW1005	30mm	130	3800~4300	700~1100	20	0.05~0.1	側銑(Side milling)
UPW1005	30mm	130	3800~4300	1400~1800	20	0~0.5	側銑(Side milling)
UPW1005	30mm	130	3800~4300	800~1200	20	1	側銑(Side milling)
UPW1205	35mm	105	2500~3000	500~800	0.1~0.15	12	溝銑(Slotting)
UPW1205	35mm	105	2500~3000	1400~1800	0~0.5	12	溝銑(Slotting)
UPW1205	35mm	105	2500~3000	500~800	2~3	12	溝銑(Slotting)
UPW1205	35mm	105	2500~3000	500~800	5~6	12	溝銑(Slotting)
UPW1205	35mm	105	2500~3000	700~1000	12	0.1~0.15	側銑(Side milling)
UPW1205	35mm	105	2500~3000	1400~1800	12	0~0.5	側銑(Side milling)
UPW1205	35mm	105	2500~3000	800~1200	12	1	側銑(Side milling)
UPW1205	35mm	105	2500~3000	700~1000	24	0.1~0.15	側銑(Side milling)
UPW1205	35mm	105	2500~3000	1200~1600	24	0~0.5	側銑(Side milling)
UPW1205	35mm	105	2500~3000	700~1000	24	1	側銑(Side milling)

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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 ⁻¹)	進給速度 Feed (mm/min)	加工深度(Aa) Depth of Cut	加工寬度(Ap) Width of Cut
UPW1405	40mm	100	2000~2500	500~800	0.1~0.15	14	溝銑(Slotting)
UPW1405	40mm	100	2000~2500	1000~1400	0~0.6	14	溝銑(Slotting)
UPW1405	40mm	100	2000~2500	500~800	2~3	14	溝銑(Slotting)
UPW1405	40mm	100	2000~2500	400~700	5~6	14	溝銑(Slotting)
UPW1405	40mm	100	2000~2500	700~1000	14	0.1~0.15	側銑(Side milling)
UPW1405	40mm	100	2000~2500	1000~1400	14	0~0.6	側銑(Side milling)
UPW1405	40mm	100	2000~2500	700~1000	14	1	側銑(Side milling)
UPW1405	40mm	100	2000~2500	700~1000	28	0.1~0.15	側銑(Side milling)
UPW1405	40mm	100	2000~2500	800~1200	28	0~0.6	側銑(Side milling)
UPW1405	40mm	100	2000~2500	500~800	28	1	側銑(Side milling)
UPW1605	50mm	100	1800~2300	500~800	0.1~0.15	16	溝銑(Slotting)
UPW1605	50mm	100	1800~2300	1000~1400	0~0.6	16	溝銑(Slotting)
UPW1605	50mm	100	1800~2300	500~800	2~3	16	溝銑(Slotting)
UPW1605	50mm	100	1800~2300	400~700	5~6	16	溝銑(Slotting)
UPW1605	50mm	100	1800~2300	700~1000	16	0.1~0.15	側銑(Side milling)
UPW1605	50mm	100	1800~2300	1000~1400	16	0~0.6	側銑(Side milling)
UPW1605	50mm	100	1800~2300	700~1000	16	1	側銑(Side milling)
UPW1605	50mm	100	1800~2300	700~1000	32	0.1~0.15	側銑(Side milling)
UPW1605	50mm	100	1800~2300	800~1200	32	0~0.6	側銑(Side milling)
UPW1605	50mm	100	1800~2300	500~800	32	1	側銑(Side milling)
UPW1805	55mm	100	1500~1900	400~700	0.1~0.15	18	溝銑(Slotting)
UPW1805	55mm	100	1500~1900	700~1000	0~0.6	18	溝銑(Slotting)
UPW1805	55mm	100	1500~1900	300~450	3~4	18	溝銑(Slotting)
UPW1805	55mm	100	1500~1900	400~600	18	0.1~0.15	側銑(Side milling)
UPW1805	55mm	100	1500~1900	600~900	18	0~0.6	側銑(Side milling)
UPW1805	55mm	100	1500~1900	400~600	36	0.1~0.15	側銑(Side milling)
UPW1805	55mm	100	1500~1900	500~700	36	0~0.6	側銑(Side milling)

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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 ⁻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
	UPW2005	60mm	100	1400~1800	300~600	0.1~0.15	20	溝銑(Slotting)
	UPW2005	60mm	100	1400~1800	600~900	0~0.6	20	溝銑(Slotting)
	UPW2005	60mm	100	1400~1800	250~400	3~4	20	溝銑(Slotting)
	UPW2005	60mm	100	1400~1800	300~500	20	0.1~0.15	側銑(Side milling)
	UPW2005	60mm	100	1400~1800	500~800	20	0~0.6	側銑(Side milling)
	UPW2005	60mm	100	1400~1800	300~500	40	0.1~0.15	側銑(Side milling)
	UPW2005	60mm	100	1400~1800	400~700	40	0~0.6	側銑(Side milling)
	UPW2505	60mm	100	1000~1400	300~500	0.1~0.15	25	溝銑(Slotting)
	UPW2505	60mm	100	1000~1400	500~700	0~0.6	25	溝銑(Slotting)
	UPW2505	60mm	100	1000~1400	200~300	3~4	25	溝銑(Slotting)
	UPW2505	60mm	100	1000~1400	200~350	25	0.1~0.15	側銑(Side milling)
	UPW2505	60mm	100	1000~1400	400~600	25	0~0.6	側銑(Side milling)
	UPW2505	60mm	100	1000~1400	200~350	40	0.1~0.15	側銑(Side milling)
	UPW2505	60mm	100	1000~1400	300~500	40	0~0.6	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 ⁻¹)	進給速度 Feed (mm/min)	加工深度(Aa) Depth of Cut	加工寬度(Ap) Width of Cut
UPW0305	18mm	90	9000~10000	700~1000	0.02~0.07	3	溝銑(Slotting)
UPW0305	18mm	90	9000~10000	1000~1400	0~0.2	3	溝銑(Slotting)
UPW0305	18mm	90	9000~10000	400~700	0.7~1	3	溝銑(Slotting)
UPW0305	18mm	90	9000~10000	400~700	3	3	溝銑(Slotting)
UPW0305	18mm	90	9000~10000	800~1200	3	0.02~0.07	側銑(Side milling)
UPW0305	18mm	90	9000~10000	1000~1400	3	0~0.2	側銑(Side milling)
UPW0305	18mm	90	9000~10000	800~1200	6	0.02~0.07	側銑(Side milling)
UPW0305	18mm	90	9000~10000	800~1200	6	0~0.2	側銑(Side milling)
UPW0405	18mm	100	7500~8000	700~1000	0.03~0.08	4	溝銑(Slotting)
UPW0405	18mm	100	7500~8000	1000~1400	0~0.3	4	溝銑(Slotting)
UPW0405	18mm	100	7500~8000	400~700	1~1.5	4	溝銑(Slotting)
UPW0405	18mm	100	7500~8000	300~600	4	4	溝銑(Slotting)
UPW0405	18mm	100	7500~8000	800~1200	4	0.03~0.08	側銑(Side milling)
UPW0405	18mm	100	7500~8000	1000~1400	4	0~0.3	側銑(Side milling)
UPW0405	18mm	100	7500~8000	800~1200	8	0.03~0.08	側銑(Side milling)
UPW0405	18mm	100	7500~8000	800~1200	8	0~0.3	側銑(Side milling)
UPW0505	20mm	100	6300~6800	500~800	0.05~0.1	5	溝銑(Slotting)
UPW0505	20mm	100	6300~6800	1600~2000	0~0.4	5	溝銑(Slotting)
UPW0505	20mm	100	6300~6800	500~800	2~2.5	5	溝銑(Slotting)
UPW0505	20mm	100	6300~6800	400~700	5	5	溝銑(Slotting)
UPW0505	20mm	100	6300~6800	700~1100	5	0.05~0.1	側銑(Side milling)
UPW0505	20mm	100	6300~6800	1600~2000	5	0~0.4	側銑(Side milling)
UPW0505	20mm	100	6300~6800	700~1100	10	0.05~0.1	側銑(Side milling)
UPW0505	20mm	100	6300~6800	1000~1400	10	0~0.4	側銑(Side milling)
UPW0605	20mm	100	5200~5700	500~800	0.05~0.1	6	溝銑(Slotting)
UPW0605	20mm	100	5200~5700	1800~2200	0~0.4	6	溝銑(Slotting)
UPW0605	20mm	100	5200~5700	500~800	2~3	6	溝銑(Slotting)
UPW0605	20mm	100	5200~5700	400~700	6	6	溝銑(Slotting)
UPW0605	20mm	100	5200~5700	700~1100	6	0.05~0.1	側銑(Side milling)
UPW0605	20mm	100	5200~5700	1800~2200	6	0~0.4	側銑(Side milling)
UPW0605	20mm	100	5200~5700	700~1100	12	0.05~0.1	側銑(Side milling)
UPW0605	20mm	100	5200~5700	1200~1600	12	0~0.4	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 ⁻¹)	進給速度 Feed (mm/min)	加工深度(Aa) Depth of Cut	加工寬度(Ap) Width of Cut
UPW0805	25mm	120	4500~5000	500~800	0.05~0.1	8	溝銑(Slotting)
UPW0805	25mm	120	4500~5000	1600~2000	0~0.5	8	溝銑(Slotting)
UPW0805	25mm	120	4500~5000	400~700	3~4	8	溝銑(Slotting)
UPW0805	25mm	120	4500~5000	400~700	8	8	溝銑(Slotting)
UPW0805	25mm	120	4500~5000	700~1100	8	0.05~0.1	側銑(Side milling)
UPW0805	25mm	120	4500~5000	1600~2000	8	0~0.5	側銑(Side milling)
UPW0805	25mm	120	4500~5000	700~1100	16	0.05~0.1	側銑(Side milling)
UPW0805	25mm	120	4500~5000	1200~1600	16	0~0.5	側銑(Side milling)
UPW1005	30mm	130	3800~4300	500~800	0.05~0.1	10	溝銑(Slotting)
UPW1005	30mm	130	3800~4300	1800~2200	0~0.5	10	溝銑(Slotting)
UPW1005	30mm	130	3800~4300	500~800	4~5	10	溝銑(Slotting)
UPW1005	30mm	130	3800~4300	500~800	10	10	溝銑(Slotting)
UPW1005	30mm	130	3800~4300	700~1100	10	0.05~0.1	側銑(Side milling)
UPW1005	30mm	130	3800~4300	1800~2200	10	0~0.5	側銑(Side milling)
UPW1005	30mm	130	3800~4300	1000~1400	10	1	側銑(Side milling)
UPW1005	30mm	130	3800~4300	700~1100	20	0.05~0.1	側銑(Side milling)
UPW1005	30mm	130	3800~4300	1200~1600	20	0~0.5	側銑(Side milling)
UPW1005	30mm	130	3800~4300	700~1100	20	1	側銑(Side milling)
UPW1205	35mm	105	2500~3000	500~800	0.1~0.15	12	溝銑(Slotting)
UPW1205	35mm	105	2500~3000	1200~1600	0~0.5	12	溝銑(Slotting)
UPW1205	35mm	105	2500~3000	400~700	2~3	12	溝銑(Slotting)
UPW1205	35mm	105	2500~3000	400~700	5~6	12	溝銑(Slotting)
UPW1205	35mm	105	2500~3000	700~1000	12	0.1~0.15	側銑(Side milling)
UPW1205	35mm	105	2500~3000	1200~1600	12	0~0.5	側銑(Side milling)
UPW1205	35mm	105	2500~3000	700~1000	12	1	側銑(Side milling)
UPW1205	35mm	105	2500~3000	700~1000	24	0.1~0.15	側銑(Side milling)
UPW1205	35mm	105	2500~3000	1000~1400	24	0~0.5	側銑(Side milling)
UPW1205	35mm	105	2500~3000	500~800	24	1	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 ⁻¹)	進給速度 Feed (mm/min)	加工深度(Aa) Depth of Cut	加工寬度(Ap) Width of Cut
UPW1405	40mm	100	2000~2500	500~800	0.1~0.15	14	溝銑(Slotting)
UPW1405	40mm	100	2000~2500	800~1200	0~0.6	14	溝銑(Slotting)
UPW1405	40mm	100	2000~2500	400~700	2~3	14	溝銑(Slotting)
UPW1405	40mm	100	2000~2500	300~600	5~6	14	溝銑(Slotting)
UPW1405	40mm	100	2000~2500	700~1000	14	0.1~0.15	側銑(Side milling)
UPW1405	40mm	100	2000~2500	800~1200	14	0~0.6	側銑(Side milling)
UPW1405	40mm	100	2000~2500	500~800	14	1	側銑(Side milling)
UPW1405	40mm	100	2000~2500	700~1000	28	0.1~0.15	側銑(Side milling)
UPW1405	40mm	100	2000~2500	700~1000	28	0~0.6	側銑(Side milling)
UPW1405	40mm	100	2000~2500	400~700	28	1	側銑(Side milling)
UPW1605	50mm	100	1800~2300	500~800	0.1~0.15	16	溝銑(Slotting)
UPW1605	50mm	100	1800~2300	800~1200	0~0.6	16	溝銑(Slotting)
UPW1605	50mm	100	1800~2300	400~700	2~3	16	溝銑(Slotting)
UPW1605	50mm	100	1800~2300	300~600	5~6	16	溝銑(Slotting)
UPW1605	50mm	100	1800~2300	700~1000	16	0.1~0.15	側銑(Side milling)
UPW1605	50mm	100	1800~2300	800~1200	16	0~0.6	側銑(Side milling)
UPW1605	50mm	100	1800~2300	500~800	16	1	側銑(Side milling)
UPW1605	50mm	100	1800~2300	700~1000	32	0.1~0.15	側銑(Side milling)
UPW1605	50mm	100	1800~2300	700~1000	32	0~0.6	側銑(Side milling)
UPW1605	50mm	100	1800~2300	400~700	32	1	側銑(Side milling)
UPW1805	55mm	80	1200~1700	400~600	0.1~0.15	18	溝銑(Slotting)
UPW1805	55mm	80	1200~1700	700~900	0~0.6	18	溝銑(Slotting)
UPW1805	55mm	80	1200~1700	250~400	3~4	18	側銑(Side milling)
UPW1805	55mm	80	1200~1700	300~500	18	0.1~0.15	側銑(Side milling)
UPW1805	55mm	80	1200~1700	500~800	18	0~0.6	側銑(Side milling)
UPW1805	55mm	80	1200~1700	300~500	36	0.1~0.15	側銑(Side milling)
UPW1805	55mm	80	1200~1700	400~600	36	0~0.6	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 ⁻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
	UPW2005	60mm	80	1000~1500	300~600	0.1~0.15	20	溝銑(Slotting)
	UPW2005	60mm	80	1000~1500	600~800	0~0.6	20	溝銑(Slotting)
	UPW2005	60mm	80	1000~1500	200~350	3~4	20	側銑(Side milling)
	UPW2005	60mm	80	1000~1500	300~500	20	0.1~0.15	側銑(Side milling)
	UPW2005	60mm	80	1000~1500	500~700	20	0~0.6	側銑(Side milling)
	UPW2005	60mm	80	1000~1500	300~500	40	0.1~0.15	側銑(Side milling)
	UPW2005	60mm	80	1000~1500	400~600	40	0~0.6	側銑(Side milling)
	UPW2505	60mm	80	800~1300	250~450	0.1~0.15	25	溝銑(Slotting)
	UPW2505	60mm	80	800~1300	400~600	0~0.6	25	溝銑(Slotting)
	UPW2505	60mm	80	800~1300	170~270	3~4	25	側銑(Side milling)
	UPW2505	60mm	80	800~1300	200~300	25	0.1~0.15	側銑(Side milling)
	UPW2505	60mm	80	800~1300	300~500	25	0~0.6	側銑(Side milling)
	UPW2505	60mm	80	800~1300	200~300	40	0.1~0.15	側銑(Side milling)
	UPW2505	60mm	80	800~1300	300~500	40	0~0.6	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 ⁻¹)	進給速度 Feed (mm/min)	加工深度(Aa) Depth of Cut	加工寬度(Ap) Width of Cut
UPW0305	18mm	90	9000~10000	700~1000	0.02~0.07	3	溝銑(Slotting)
UPW0305	18mm	90	9000~10000	1000~1400	0~0.2	3	溝銑(Slotting)
UPW0305	18mm	90	9000~10000	400~700	0.7~1	3	溝銑(Slotting)
UPW0305	18mm	90	9000~10000	400~700	3	3	溝銑(Slotting)
UPW0305	18mm	90	9000~10000	800~1200	3	0.02~0.07	側銑(Side milling)
UPW0305	18mm	90	9000~10000	1000~1400	3	0~0.2	側銑(Side milling)
UPW0305	18mm	90	9000~10000	800~1200	6	0.02~0.07	側銑(Side milling)
UPW0305	18mm	90	9000~10000	800~1200	6	0~0.2	側銑(Side milling)
UPW0405	18mm	100	7500~8000	700~1000	0~0.3	4	溝銑(Slotting)
UPW0405	18mm	100	7500~8000	1000~1400	0~0.3	4	溝銑(Slotting)
UPW0405	18mm	100	7500~8000	400~700	1~1.5	4	溝銑(Slotting)
UPW0405	18mm	100	7500~8000	300~600	4	4	溝銑(Slotting)
UPW0405	18mm	100	7500~8000	800~1200	4	0.03~0.08	側銑(Side milling)
UPW0405	18mm	100	7500~8000	1000~1400	4	0~0.3	側銑(Side milling)
UPW0405	18mm	100	7500~8000	800~1200	8	0.03~0.08	側銑(Side milling)
UPW0405	18mm	100	7500~8000	800~1200	8	0~0.3	側銑(Side milling)
UPW0505	20mm	100	6300~6800	500~800	0~0.4	5	溝銑(Slotting)
UPW0505	20mm	100	6300~6800	1600~2000	0~0.4	5	溝銑(Slotting)
UPW0505	20mm	100	6300~6800	500~800	2~2.5	5	溝銑(Slotting)
UPW0505	20mm	100	6300~6800	400~700	5	5	溝銑(Slotting)
UPW0505	20mm	100	6300~6800	700~1100	5	0.05~0.1	側銑(Side milling)
UPW0505	20mm	100	6300~6800	1600~2000	5	0~0.4	側銑(Side milling)
UPW0505	20mm	100	6300~6800	700~1100	10	0.05~0.1	側銑(Side milling)
UPW0505	20mm	100	6300~6800	1000~1400	10	0~0.4	側銑(Side milling)
UPW0605	20mm	100	5200~5700	500~800	0.05~0.1	6	溝銑(Slotting)
UPW0605	20mm	100	5200~5700	1800~2200	0~0.4	6	溝銑(Slotting)
UPW0605	20mm	100	5200~5700	500~800	2~3	6	溝銑(Slotting)
UPW0605	20mm	100	5200~5700	400~700	6	6	溝銑(Slotting)
UPW0605	20mm	100	5200~5700	700~1100	6	0.05~0.1	側銑(Side milling)
UPW0605	20mm	100	5200~5700	1800~2200	6	0~0.4	側銑(Side milling)
UPW0605	20mm	100	5200~5700	700~1100	12	0.05~0.1	側銑(Side milling)
UPW0605	20mm	100	5200~5700	1200~1600	12	0~0.4	側銑(Side milling)

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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 ⁻¹)	進給速度 Feed (mm/min)	加工深度(Aa) Depth of Cut	加工寬度(Ap) Width of Cut
UPW0805	25mm	120	4500~5000	500~800	0.05~0.1	8	溝銑(Slotting)
UPW0805	25mm	120	4500~5000	1600~2000	0~0.5	8	溝銑(Slotting)
UPW0805	25mm	120	4500~5000	400~700	3~4	8	溝銑(Slotting)
UPW0805	25mm	120	4500~5000	400~700	8	8	溝銑(Slotting)
UPW0805	25mm	120	4500~5000	700~1100	8	0.05~0.1	側銑(Side milling)
UPW0805	25mm	120	4500~5000	1600~2000	8	0~0.5	側銑(Side milling)
UPW0805	25mm	120	4500~5000	700~1100	16	0.05~0.1	側銑(Side milling)
UPW0805	25mm	120	4500~5000	1200~1600	16	0~0.5	側銑(Side milling)
UPW1005	30mm	130	3800~4300	500~800	0.05~0.1	10	溝銑(Slotting)
UPW1005	30mm	130	3800~4300	1800~2200	0~0.5	10	溝銑(Slotting)
UPW1005	30mm	130	3800~4300	500~800	4~5	10	溝銑(Slotting)
UPW1005	30mm	130	3800~4300	500~800	10	10	溝銑(Slotting)
UPW1005	30mm	130	3800~4300	700~1100	10	0.05~0.1	側銑(Side milling)
UPW1005	30mm	130	3800~4300	1800~2200	10	0~0.5	側銑(Side milling)
UPW1005	30mm	130	3800~4300	1000~1400	10	1	側銑(Side milling)
UPW1005	30mm	130	3800~4300	700~1100	20	0.05~0.1	側銑(Side milling)
UPW1005	30mm	130	3800~4300	1200~1600	20	0~0.5	側銑(Side milling)
UPW1005	30mm	130	3800~4300	700~1100	20	1	側銑(Side milling)
UPW1205	35mm	105	2500~3000	500~800	0.1~0.15	12	溝銑(Slotting)
UPW1205	35mm	105	2500~3000	1200~1600	0~0.5	12	溝銑(Slotting)
UPW1205	35mm	105	2500~3000	400~700	2~3	12	溝銑(Slotting)
UPW1205	35mm	105	2500~3000	400~700	5~6	12	溝銑(Slotting)
UPW1205	35mm	105	2500~3000	700~1000	12	0.1~0.15	側銑(Side milling)
UPW1205	35mm	105	2500~3000	1200~1600	12	0~0.5	側銑(Side milling)
UPW1205	35mm	105	2500~3000	700~1000	12	1	側銑(Side milling)
UPW1205	35mm	105	2500~3000	700~1000	24	0.1~0.15	側銑(Side milling)
UPW1205	35mm	105	2500~3000	1000~1400	24	0~0.5	側銑(Side milling)
UPW1205	35mm	105	2500~3000	500~800	24	1	側銑(Side milling)

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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 ⁻¹)	進給速度 Feed (mm/min)	加工深度(Aa) Depth of Cut	加工寬度(Ap) Width of Cut
UPW1405	40mm	100	2000~2500	500~800	0.1~0.15	14	溝銑(Slotting)
UPW1405	40mm	100	2000~2500	800~1200	0~0.6	14	溝銑(Slotting)
UPW1405	40mm	100	2000~2500	400~700	2~3	14	溝銑(Slotting)
UPW1405	40mm	100	2000~2500	300~600	5~6	14	溝銑(Slotting)
UPW1405	40mm	100	2000~2500	700~1000	14	0.1~0.15	側銑(Side milling)
UPW1405	40mm	100	2000~2500	800~1200	14	0~0.6	側銑(Side milling)
UPW1405	40mm	100	2000~2500	500~800	14	1	側銑(Side milling)
UPW1405	40mm	100	2000~2500	700~1000	28	0.1~0.15	側銑(Side milling)
UPW1405	40mm	100	2000~2500	700~1000	28	0~0.6	側銑(Side milling)
UPW1405	40mm	100	2000~2500	400~700	28	1	側銑(Side milling)
UPW1605	50mm	100	1800~2300	500~800	0.1~0.15	16	溝銑(Slotting)
UPW1605	50mm	100	1800~2300	800~1200	0~0.6	16	溝銑(Slotting)
UPW1605	50mm	100	1800~2300	400~700	2~3	16	溝銑(Slotting)
UPW1605	50mm	100	1800~2300	300~600	5~6	16	溝銑(Slotting)
UPW1605	50mm	100	1800~2300	700~1000	16	0.1~0.15	側銑(Side milling)
UPW1605	50mm	100	1800~2300	800~1200	16	0~0.6	側銑(Side milling)
UPW1605	50mm	100	1800~2300	500~800	16	1	側銑(Side milling)
UPW1605	50mm	100	1800~2300	700~1000	32	0.1~0.15	側銑(Side milling)
UPW1605	50mm	100	1800~2300	700~1000	32	0~0.6	側銑(Side milling)
UPW1605	50mm	100	1800~2300	400~700	32	1	側銑(Side milling)
UPW1805	55mm	90	1400~1800	400~600	0.1~0.15	18	溝銑(Slotting)
UPW1805	55mm	90	1400~1800	700~900	0~0.6	18	溝銑(Slotting)
UPW1805	55mm	90	1400~1800	250~400	3~4	18	溝銑(Slotting)
UPW1805	55mm	90	1400~1800	300~500	18	0.1~0.15	側銑(Side milling)
UPW1805	55mm	90	1400~1800	500~800	18	0~0.6	側銑(Side milling)
UPW1805	55mm	90	1400~1800	300~500	36	0.1~0.15	側銑(Side milling)
UPW1805	55mm	90	1400~1800	400~600	36	0~0.6	側銑(Side milling)

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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 ⁻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
UPW2005	60mm	90	1200~1600	300~600	0.1~0.15	20	溝銑(Slotting)
UPW2005	60mm	90	1200~1600	600~800	0~0.6	20	溝銑(Slotting)
UPW2005	60mm	90	1200~1600	200~350	3~4	20	溝銑(Slotting)
UPW2005	60mm	90	1200~1600	300~500	20	0.1~0.15	側銑(Side milling)
UPW2005	60mm	90	1200~1600	500~700	20	0~0.6	側銑(Side milling)
UPW2005	60mm	90	1200~1600	300~500	40	0.1~0.15	側銑(Side milling)
UPW2005	60mm	90	1200~1600	400~600	40	0~0.6	側銑(Side milling)
UPW2505	60mm	90	900~1300	250~450	0.1~0.15	25	溝銑(Slotting)
UPW2505	60mm	90	900~1300	400~600	0~0.6	25	溝銑(Slotting)
UPW2505	60mm	90	900~1300	170~270	3~4	25	溝銑(Slotting)
UPW2505	60mm	90	900~1300	200~300	25	0.1~0.15	側銑(Side milling)
UPW2505	60mm	90	900~1300	300~500	25	0~0.6	側銑(Side milling)
UPW2505	60mm	90	900~1300	200~300	40	0.1~0.15	側銑(Side milling)
UPW2505	60mm	90	900~1300	300~500	40	0~0.6	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 ⁻¹)	進給速度 Feed (mm/min)	加工深度(Aa) Depth of Cut	加工寬度(Ap) Width of Cut
UPW0305	18mm	85	8700~9200	700~1000	0.02~0.07	3	溝銑(Slotting)
UPW0305	18mm	85	8700~9200	800~1200	0~0.2	3	溝銑(Slotting)
UPW0305	18mm	85	8700~9200	300~600	0.7~1	3	溝銑(Slotting)
UPW0305	18mm	85	8700~9200	300~600	3	3	溝銑(Slotting)
UPW0305	18mm	85	8700~9200	700~1000	3	0.02~0.07	側銑(Side milling)
UPW0305	18mm	85	8700~9200	800~1200	3	0~0.2	側銑(Side milling)
UPW0305	18mm	85	8700~9200	700~1000	6	0.02~0.07	側銑(Side milling)
UPW0305	18mm	85	8700~9200	700~1000	6	0~0.2	側銑(Side milling)
UPW0405	18mm	95	7200~7700	700~1000	0~0.3	4	溝銑(Slotting)
UPW0405	18mm	95	7200~7700	800~1200	0~0.3	4	溝銑(Slotting)
UPW0405	18mm	95	7200~7700	300~600	1~1.5	4	溝銑(Slotting)
UPW0405	18mm	95	7200~7700	300~500	4	4	溝銑(Slotting)
UPW0405	18mm	95	7200~7700	800~1200	4	0.03~0.08	側銑(Side milling)
UPW0405	18mm	95	7200~7700	800~1200	4	0~0.3	側銑(Side milling)
UPW0405	18mm	95	7200~7700	800~1200	8	0.03~0.08	側銑(Side milling)
UPW0405	18mm	95	7200~7700	700~1000	8	0~0.3	側銑(Side milling)
UPW0505	20mm	95	5800~6300	500~800	0~0.4	5	溝銑(Slotting)
UPW0505	20mm	95	5800~6300	1400~1800	0~0.4	5	溝銑(Slotting)
UPW0505	20mm	95	5800~6300	400~7000	2~2.5	5	溝銑(Slotting)
UPW0505	20mm	95	5800~6300	300~600	5	5	溝銑(Slotting)
UPW0505	20mm	95	5800~6300	700~1100	5	0.05~0.1	側銑(Side milling)
UPW0505	20mm	95	5800~6300	1400~1800	5	0~0.4	側銑(Side milling)
UPW0505	20mm	95	5800~6300	700~1100	10	0.05~0.1	側銑(Side milling)
UPW0505	20mm	95	5800~6300	800~1200	10	0~0.4	側銑(Side milling)
UPW0605	20mm	95	4800~5300	500~800	0.05~0.1	6	溝銑(Slotting)
UPW0605	20mm	95	4800~5300	1600~2000	0~0.4	6	溝銑(Slotting)
UPW0605	20mm	95	4800~5300	400~700	2~3	6	溝銑(Slotting)
UPW0605	20mm	95	4800~5300	300~600	6	6	溝銑(Slotting)
UPW0605	20mm	95	4800~5300	700~1100	6	0.05~0.1	側銑(Side milling)
UPW0605	20mm	95	4800~5300	1600~2000	6	0~0.4	側銑(Side milling)
UPW0605	20mm	95	4800~5300	700~1100	12	0.05~0.1	側銑(Side milling)
UPW0605	20mm	95	4800~5300	1000~1400	12	0~0.4	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 ⁻¹)	進給速度 Feed (mm/min)	加工深度(Aa) Depth of Cut	加工寬度(Ap) Width of Cut
UPW0805	25mm	115	4300~4800	500~800	0.05~0.1	8	溝銑(Slotting)
UPW0805	25mm	115	4300~4800	1400~1800	0~0.5	8	溝銑(Slotting)
UPW0805	25mm	115	4300~4800	300~600	3~4	8	溝銑(Slotting)
UPW0805	25mm	115	4300~4800	300~600	8	8	溝銑(Slotting)
UPW0805	25mm	115	4300~4800	700~1100	8	0.05~0.1	側銑(Side milling)
UPW0805	25mm	115	4300~4800	1400~1800	8	0~0.5	側銑(Side milling)
UPW0805	25mm	115	4300~4800	700~1100	16	0.05~0.1	側銑(Side milling)
UPW0805	25mm	115	4300~4800	1000~1400	16	0~0.5	側銑(Side milling)
UPW1005	30mm	125	3700~4200	500~800	0.05~0.1	10	溝銑(Slotting)
UPW1005	30mm	125	3700~4200	1600~2000	0~0.5	10	溝銑(Slotting)
UPW1005	30mm	125	3700~4200	400~700	4~5	10	溝銑(Slotting)
UPW1005	30mm	125	3700~4200	400~700	10	10	溝銑(Slotting)
UPW1005	30mm	125	3700~4200	700~1100	10	0.05~0.1	側銑(Side milling)
UPW1005	30mm	125	3700~4200	1600~2000	10	0~0.5	側銑(Side milling)
UPW1005	30mm	125	3700~4200	800~1200	10	1	側銑(Side milling)
UPW1005	30mm	125	3700~4200	700~1100	20	0.05~0.1	側銑(Side milling)
UPW1005	30mm	125	3700~4200	1000~1400	20	0~0.5	側銑(Side milling)
UPW1005	30mm	125	3700~4200	500~800	20	1	側銑(Side milling)
UPW1205	35mm	95	2300~2800	500~800	0.1~0.15	12	溝銑(Slotting)
UPW1205	35mm	95	2300~2800	1000~1400	0~0.5	12	溝銑(Slotting)
UPW1205	35mm	95	2300~2800	300~600	2~3	12	溝銑(Slotting)
UPW1205	35mm	95	2300~2800	300~600	5~6	12	溝銑(Slotting)
UPW1205	35mm	95	2300~2800	700~1000	12	0.1~0.15	側銑(Side milling)
UPW1205	35mm	95	2300~2800	1000~1400	12	0~0.5	側銑(Side milling)
UPW1205	35mm	95	2300~2800	500~800	12	1	側銑(Side milling)
UPW1205	35mm	95	2300~2800	700~1000	24	0.1~0.15	側銑(Side milling)
UPW1205	35mm	95	2300~2800	800~1200	24	0~0.5	側銑(Side milling)
UPW1205	35mm	95	2300~2800	400~700	24	1	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 ⁻¹)	進給速度 Feed (mm/min)	加工深度(Aa) Depth of Cut	加工寬度(Ap) Width of Cut
UPW1405	40mm	90	1800~2300	500~800	0.1~0.15	14	溝銑(Slotting)
UPW1405	40mm	90	1800~2300	700~1000	0~0.6	14	溝銑(Slotting)
UPW1405	40mm	90	1800~2300	300~600	2~3	14	溝銑(Slotting)
UPW1405	40mm	90	1800~2300	300~500	5~6	14	溝銑(Slotting)
UPW1405	40mm	90	1800~2300	700~1000	14	0.1~0.15	側銑(Side milling)
UPW1405	40mm	90	1800~2300	700~1000	14	0~0.6	側銑(Side milling)
UPW1405	40mm	90	1800~2300	400~700	14	1	側銑(Side milling)
UPW1405	40mm	90	1800~2300	700~1000	28	0.1~0.15	側銑(Side milling)
UPW1405	40mm	90	1800~2300	500~800	28	0~0.6	側銑(Side milling)
UPW1405	40mm	90	1800~2300	300~600	28	1	側銑(Side milling)
UPW1605	50mm	90	1500~2000	500~800	0.1~0.15	16	溝銑(Slotting)
UPW1605	50mm	90	1500~2000	700~1000	0~0.6	16	溝銑(Slotting)
UPW1605	50mm	90	1500~2000	300~600	2~3	16	溝銑(Slotting)
UPW1605	50mm	90	1500~2000	300~500	5~6	16	溝銑(Slotting)
UPW1605	50mm	90	1500~2000	700~1000	16	0.1~0.15	側銑(Side milling)
UPW1605	50mm	90	1500~2000	700~1000	16	0~0.6	側銑(Side milling)
UPW1605	50mm	90	1500~2000	400~700	16	1	側銑(Side milling)
UPW1605	50mm	90	1500~2000	700~1000	32	0.1~0.15	側銑(Side milling)
UPW1605	50mm	90	1500~2000	500~800	32	0~0.6	側銑(Side milling)
UPW1605	50mm	90	1500~2000	300~600	32	1	側銑(Side milling)
UPW1805	55mm	70	1000~1500	300~550	0.1~0.15	18	溝銑(Slotting)
UPW1805	55mm	70	1000~1500	600~800	0~0.5	18	溝銑(Slotting)
UPW1805	55mm	70	1000~1500	250~350	2~3	18	溝銑(Slotting)
UPW1805	55mm	70	1000~1500	300~500	18	0.1~0.15	側銑(Side milling)
UPW1805	55mm	70	1000~1500	500~700	18	0~0.5	側銑(Side milling)
UPW1805	55mm	70	1000~1500	300~500	36	0.1~0.15	側銑(Side milling)
UPW1805	55mm	70	1000~1500	400~600	36	0~0.5	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 ⁻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
	UPW2005	60mm	70	900~1300	250~500	0.1~0.15	20	溝銑(Slotting)
	UPW2005	60mm	70	900~1300	400~600	0~0.5	20	溝銑(Slotting)
	UPW2005	60mm	70	900~1300	200~350	2~3	20	溝銑(Slotting)
	UPW2005	60mm	70	900~1300	250~400	20	0.1~0.15	側銑(Side milling)
	UPW2005	60mm	70	900~1300	400~600	20	0~0.5	側銑(Side milling)
	UPW2005	60mm	70	900~1300	250~400	40	0.1~0.15	側銑(Side milling)
	UPW2005	60mm	70	900~1300	300~500	40	0~0.5	側銑(Side milling)
	UPW2505	60mm	70	700~1100	250~400	0.1~0.15	25	溝銑(Slotting)
	UPW2505	60mm	70	700~1100	300~500	0~0.5	25	溝銑(Slotting)
	UPW2505	60mm	70	700~1100	150~250	2~3	25	溝銑(Slotting)
	UPW2505	60mm	70	700~1100	200~300	25	0.1~0.15	側銑(Side milling)
	UPW2505	60mm	70	700~1100	300~400	25	0~0.5	側銑(Side milling)
	UPW2505	60mm	70	700~1100	200~300	40	0.1~0.15	側銑(Side milling)
	UPW2505	60mm	70	700~1100	250~350	40	0~0.5	側銑(Side milling)

附註 / Note :

建議冷卻方式為濕式。

Suggest to use Wet coolant.