

被切削材 Work Material	純鈦,鈦合金 Titanium , Ti-6Al-4V, Gr2 , Gr5(TC4)						
	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
UTJ0304	13mm	145	15000~15500	3500~4000	0.13	3	溝銑(Slotting)
UTJ0304	13mm	100	10500~11000	800~1000	0.5~0.6	3	溝銑(Slotting)
UTJ0304	13mm	100	10500~11000	500~700	0.8~1.5	3	溝銑(Slotting)
UTJ0304	13mm	100	10500~11000	400~500	1.5~2	3	溝銑(Slotting)
UTJ0304	13mm	100	10500~11000	900~1100	3	0.5~0.6	側銑(Side milling)
UTJ0304	13mm	100	10500~11000	500~700	3	0.8~1.5	側銑(Side milling)
UTJ0304	13mm	100	10500~11000	400~500	3	1.5~2	側銑(Side milling)
UTJ0404	16mm	145	11000~11500	3500~4000	0.15	4	溝銑(Slotting)
UTJ0404	16mm	100	7800~8200	1000~1200	0.6~0.7	4	溝銑(Slotting)
UTJ0404	16mm	100	7800~8200	500~700	1~2	4	溝銑(Slotting)
UTJ0404	16mm	100	7800~8200	400~500	2~3	4	溝銑(Slotting)
UTJ0404	16mm	100	7800~8200	1000~1200	4	0.6~0.7	側銑(Side milling)
UTJ0404	16mm	100	7800~8200	500~700	4	1~2	側銑(Side milling)
UTJ0404	16mm	100	7800~8200	400~500	4	2~3	側銑(Side milling)
UTJ0504	18mm	145	9000~9500	3500~4000	0.2	5	溝銑(Slotting)
UTJ0504	18mm	100	6200~6600	1200~1400	0.7~0.8	5	溝銑(Slotting)
UTJ0504	18mm	100	6200~6600	500~700	1.5~2.5	5	溝銑(Slotting)
UTJ0504	18mm	100	6200~6600	400~500	3~4	5	溝銑(Slotting)
UTJ0504	18mm	100	6200~6600	1000~1200	5	0.7~0.8	側銑(Side milling)
UTJ0504	18mm	100	6200~6600	500~700	5	1.5~2.5	側銑(Side milling)
UTJ0504	18mm	100	6200~6600	400~500	5	3~4	側銑(Side milling)
UTJ0604	20mm	160	8500~9000	3500~4000	0.2	6	溝銑(Slotting)
UTJ0604	20mm	100	5200~5600	900~1100	0.8~0.9	6	溝銑(Slotting)
UTJ0604	20mm	100	5200~5600	500~700	2~3	6	溝銑(Slotting)
UTJ0604	20mm	100	5200~5600	400~500	4~5	6	溝銑(Slotting)
UTJ0604	20mm	100	5200~5600	1000~1200	6	0.8~0.9	側銑(Side milling)
UTJ0604	20mm	100	5200~5600	500~700	6	2~3	側銑(Side milling)
UTJ0604	20mm	100	5200~5600	400~500	6	4~5	側銑(Side milling)
UTJ0804	24mm	180	7000~7300	3500~4000	0.2	8	溝銑(Slotting)
UTJ0804	24mm	100	3800~4200	800~1000	0.8~1	8	溝銑(Slotting)
UTJ0804	24mm	100	3800~4200	500~700	3~4	8	溝銑(Slotting)
UTJ0804	24mm	100	3800~4200	400~500	4~6.5	8	溝銑(Slotting)
UTJ0804	24mm	100	3800~4200	1000~1200	8	0.8~1	側銑(Side milling)
UTJ0804	24mm	100	3800~4200	500~700	8	3~4	側銑(Side milling)
UTJ0804	24mm	100	3800~4200	400~500	8	4~6.5	側銑(Side milling)

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	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
UTJ1004	30mm	180	5600~6000	3000~3500	0.2	10	溝銑(Slotting)
UTJ1004	30mm	100	3000~3400	900~1100	0.8~1	10	溝銑(Slotting)
UTJ1004	30mm	100	3000~3400	500~700	4~5	10	溝銑(Slotting)
UTJ1004	30mm	100	3000~3400	400~500	7~8	10	溝銑(Slotting)
UTJ1004	30mm	100	3000~3400	900~1100	10	0.8~1	側銑(Side milling)
UTJ1004	30mm	100	3000~3400	500~700	10	4~5	側銑(Side milling)
UTJ1004	30mm	100	3000~3400	400~500	10	7~8	側銑(Side milling)
UTJ1204	33mm	180	4600~5000	2800~3200	0.2	12	溝銑(Slotting)
UTJ1204	33mm	100	2400~2800	650~800	0.9~1.2	12	溝銑(Slotting)
UTJ1204	33mm	100	2400~2800	350~500	4~5	12	溝銑(Slotting)
UTJ1204	33mm	100	2400~2800	250~350	5~6	12	溝銑(Slotting)
UTJ1204	33mm	100	2400~2800	700~900	12	0.9~1.2	側銑(Side milling)
UTJ1204	33mm	100	2400~2800	350~450	12	4~5	側銑(Side milling)
UTJ1204	33mm	100	2400~2800	200~320	12	5~6	側銑(Side milling)
UTJ1604	50mm	180	3400~3800	2000~2500	0.2	16	溝銑(Slotting)
UTJ1604	50mm	100	1800~2200	600~700	0.9~1.2	16	溝銑(Slotting)
UTJ1604	50mm	100	1800~2200	300~400	3~4	16	溝銑(Slotting)
UTJ1604	50mm	100	1800~2200	200~350	4~5	16	溝銑(Slotting)
UTJ1604	50mm	100	1800~2200	700~900	16	0.9~1.2	側銑(Side milling)
UTJ1604	50mm	100	1800~2200	300~450	16	3~4	側銑(Side milling)
UTJ1604	50mm	100	1800~2200	200~350	16	4~5	側銑(Side milling)
UTJ2004	55mm	180	2700~3000	1300~1800	0.2	20	溝銑(Slotting)
UTJ2004	55mm	100	1400~1800	500~700	0.9~1.2	20	溝銑(Slotting)
UTJ2004	55mm	100	1400~1800	200~350	3~4	20	溝銑(Slotting)
UTJ2004	55mm	100	1400~1800	150~250	4~5	20	溝銑(Slotting)
UTJ2004	55mm	100	1400~1800	600~800	20	0.9~1.2	側銑(Side milling)
UTJ2004	55mm	100	1400~1800	220~320	20	3~4	側銑(Side milling)
UTJ2004	55mm	100	1400~1800	180~280	20	4~5	側銑(Side milling)

附註：

1. UTJ 適用於粗、中、精銑加工，溝銑 (Aa) 與側銑 (Ap) 都有 0.4~0.8D 切削能力。粗切削時建議使用濕式高壓水溶性切削液，以免造成排屑不良；特別是用於易沾黏鐵削的純鈦與鈦合金材料上。直徑 Ø10 以上，需視機器剛性與主軸扭力值的不同，做適當調整。
2. 以上冷卻方式皆為濕式。

Note：

1. UTJ is good at Roughing, Semi-finishing and Finishing. It can do a 0.4~0.8D machining for both Slotting (Aa) and Side milling (Ap). When Roughing, suggest to use the high pressure emulsion coolant in order to prevent chip removal. UTJ is especially good at Gr2 and Gr5 material with chip stickness. For diameter above 10.0mm, adjustment is required and depends on the rigidity of machine and the torque of spindle.
2. Wet coolant type is suggested for all above cutting conditions.