被切削材 Work Material	純鈦,鈦合金 Pure titanium, Titanium Alloy 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 (mim⁻1)	進給速度 Feed(mm/min)	加工深度 (Aa) Cut of depth	加工寬度 (Ap) Cut of width	冷卻方式Coolant	加工方式 Milling Type
XVO0604	22mm	200	10000~11000	3500~4000	6~9	0.15~0.2	中心出水 Coolant Through spindle	擺線側铣 Trochoidal side milling
XVO0604	22mm	200	10000~11000	2000~2500	6~9	0.25~0.3	中心出水 Coolant Through spindle	擺線側铣 Trochoidal side milling
XVO0604	22mm	95	4800~5300	插铣(Plunge milling)50/ /溝铣(slot milling)250	3	6	中心出水 Coolant Through spindle	插铣溝铣 Plunge Slot milling
XVO0604	22mm	95	4800~5300	250~400	6~9	1.5~2	中心出水 Coolant Through spindle	側铣 Side milling
XVO0604	22mm	95	4800~5300	200~280	6~9	3~4	中心出水 Coolant Through spindle	側铣 Side milling
XVO0604	22mm	95	4800~5300	200~250	2~3	6	中心出水 Coolant Through spindle	溝铣 Slotting
XVO0804	28mm	250	10000~10500	4500~5000	8~12	0.2~0.3	中心出水 Coolant Through spindle	擺線側铣 Trochoidal side milling
XVO0804	28mm	230	8800~9300	2500~3000	8~12	0.4~0.5	中心出水 Coolant Through spindle	擺線側铣 Trochoidal side milling
XVO0804	28mm	100	3800~4300	插铣(Plunge milling)50/ /溝铣(slot milling)250	4	8	中心出水 Coolant Through spindle	插铣溝铣 Plunge Slot milling
XVO0804	28mm	100	3800~4300	250~400	8~12	3~4	中心出水 Coolant Through spindle	側铣 Side milling
XVO0804	28mm	100	3800~4300	200~280	8~12	5~6	中心出水 Coolant Through spindle	側铣 Side milling
XVO0804	28mm	105	4000~4500	200~250	3~4	8	中心出水 Coolant Through spindle	溝铣 Slotting
XVO1004	34mm	270	8000~9000	4000~4500	15	0.3~0.4	中心出水 Coolant Through spindle	擺線側铣 Trochoidal side milling
XVO1004	34mm	270	8000~9000	1400~1700	15	0.6~0.8	中心出水 Coolant Through spindle	擺線側铣 Trochoidal side milling
XVO1004	34mm	95	2800~3300	插铣(Plunge milling)50/ /溝铣(slot milling)350	5	10	中心出水 Coolant Through spindle	插铣溝铣 Plunge Slot milling
XVO1004	34mm	95	2800~3300	250~400	10~15	3~5	中心出水 Coolant Through spindle	側铣 Side milling
XVO1004	34mm	95	2800~3300	180~250	10~15	7~9	中心出水 Coolant Through spindle	側铣 Side milling
XVO1004	34mm	125	3800~4300	280~350	5	10	中心出水 Coolant Through spindle	溝铣 Slotting
XVO1204	37mm	255	6500~7000	2000~2400	18	0,5	中心出水 Coolant Through spindle	擺線側铣 Trochoidal side milling
XVO1204	37mm	235	6000~6500	800~1200	18	0.8~1	中心出水 Coolant Through spindle	擺線側铣 Trochoidal side milling
XVO1204	37mm	85	2000~2500	插铣(Plunge milling)40/ /溝铣(slot milling)200	6	12	中心出水 Coolant Through spindle	插铣溝铣 Plunge Slot milling
XVO1204	37mm	85	2000~2500	250~400	18	2~3	中心出水 Coolant Through spindle	側铣 Side milling
XVO1204	37mm	85	2000~2500	150~220	18	5~6	中心出水 Coolant Through spindle	側铣 Side milling
XVO1204	37mm	85	2000~2500	150~200	6	12	中心出水 Coolant Through spindle	溝铣 Slotting