

								
被切削材 Work Material	鈦合金 / 鈦鈦 : Titanium Alloy / Pure Titanium Ti-6Al-4V / Ti-2 : 3.7165 / 3.7035 : Gr5 / Gr2 : TC4 / TA1							
	型號 Type NO.	刀具伸長量 Extension Length	切削速度 (m/min) Cutting Speed	迴轉速度 Speed (min/1) (mm/1)	進給速度 Feed (mm/min)	加工深度 (Aa) Cut of depth	加工寬度(Ap) Cut of width	加工方式 Milling Type
UTHR0305	13mm	135	14000-14500	1200-1400	0-0.13	3	溝銑(Slotting)	
UTHR0305	13mm	130	13500-14000	800-1000	0.7	3	溝銑(Slotting)	
UTHR0305	13mm	130	13500-14000	500-700	0.8-1.3	3	溝銑(Slotting)	
UTHR0305	13mm	130	13500-14000	400-500	1.3-1.7	3	溝銑(Slotting)	
UTHR0305	13mm	130	13500-14000	900-1100	3	0.7	側銑(Side milling)	
UTHR0305	13mm	130	13500-14000	500-700	3	0.8-1.3	側銑(Side milling)	
UTHR0305	13mm	130	13500-14000	400-500	3	1.3-1.7	側銑(Side milling)	
UTHR0305	13mm	130	13500-14000	700-900	3-6	0-0.13	側銑(Side milling)	
UTHR0405	16mm	135	10000-10500	1200-1400	0-0.15	4	溝銑(Slotting)	
UTHR0405	16mm	130	9500-10000	800-1000	0.8	4	溝銑(Slotting)	
UTHR0405	16mm	130	9500-10000	500-700	1-2	4	溝銑(Slotting)	
UTHR0405	16mm	130	9500-10000	400-500	2-2.5	4	溝銑(Slotting)	
UTHR0405	16mm	130	9500-10000	900-1100	4	0.8	側銑(Side milling)	
UTHR0405	16mm	130	9500-10000	500-700	4	1-2	側銑(Side milling)	
UTHR0405	16mm	130	9500-10000	400-500	4	2-2.5	側銑(Side milling)	
UTHR0405	16mm	130	9500-10000	700-900	4-8	0-0.15	側銑(Side milling)	
UTHR0505	18mm	135	8500-9000	1100-1300	0-0.15	5	溝銑(Slotting)	
UTHR0505	18mm	130	8000-8500	900-1100	0.9	5	溝銑(Slotting)	
UTHR0505	18mm	130	8000-8500	500-700	1.5-2.5	5	溝銑(Slotting)	
UTHR0505	18mm	130	8000-8500	400-500	3-4	5	溝銑(Slotting)	
UTHR0505	18mm	130	8000-8500	900-1100	5	0.9	側銑(Side milling)	
UTHR0505	18mm	130	8000-8500	500-700	5	1.5-2.5	側銑(Side milling)	
UTHR0505	18mm	130	8000-8500	400-500	5	3-4	側銑(Side milling)	
UTHR0505	18mm	130	8000-8500	700-900	5-10	0-0.15	側銑(Side milling)	
UTHR0605	20mm	135	7000-7400	1000-1300	0-0.15	6	溝銑(Slotting)	
UTHR0605	20mm	130	6600-7000	900-1100	1	6	溝銑(Slotting)	
UTHR0605	20mm	130	6600-7000	500-700	2-3	6	溝銑(Slotting)	
UTHR0605	20mm	130	6600-7000	400-500	4-5	6	溝銑(Slotting)	
UTHR0605	20mm	130	6600-7000	1000-1200	6	1	側銑(Side milling)	
UTHR0605	20mm	130	6600-7000	500-700	6	2-3	側銑(Side milling)	
UTHR0605	20mm	130	6600-7000	400-500	6	4-5	側銑(Side milling)	
UTHR0605	20mm	130	6600-7000	500-700	6-12	0-0.2	側銑(Side milling)	
UTHR0610	20mm	135	7000-7400	1000-1300	0-0.15	6	溝銑(Slotting)	
UTHR0610	20mm	130	6600-7000	900-1100	1	6	溝銑(Slotting)	
UTHR0610	20mm	130	6600-7000	500-700	2-3	6	溝銑(Slotting)	
UTHR0610	20mm	130	6600-7000	400-500	4-5	6	溝銑(Slotting)	
UTHR0610	20mm	130	6600-7000	1000-1200	6	1	側銑(Side milling)	
UTHR0610	20mm	130	6600-7000	500-700	6	2-3	側銑(Side milling)	
UTHR0610	20mm	130	6600-7000	400-500	6	4-5	側銑(Side milling)	
UTHR0610	20mm	130	6600-7000	500-700	6-12	0-0.2	側銑(Side milling)	
UTHR0805	24mm	135	5000-5500	1000-1300	0-0.2	8	溝銑(Slotting)	
UTHR0805	24mm	130	4800-5300	900-1100	0.5-1	8	溝銑(Slotting)	
UTHR0805	24mm	130	4800-5300	500-700	3-4	8	溝銑(Slotting)	
UTHR0805	24mm	130	4800-5300	400-500	4-6.5	8	溝銑(Slotting)	
UTHR0805	24mm	130	4800-5300	1000-1200	8	0.5-1	側銑(Side milling)	
UTHR0805	24mm	130	4800-5300	500-700	8	3-4	側銑(Side milling)	
UTHR0805	24mm	130	4800-5300	400-500	8	4-6.5	側銑(Side milling)	
UTHR0805	24mm	130	4800-5300	500-700	8-16	0-0.2	側銑(Side milling)	
UTHR0810	24mm	135	5000-5500	1000-1300	0-0.2	8	溝銑(Slotting)	
UTHR0810	24mm	130	4800-5300	900-1100	0.5-1	8	溝銑(Slotting)	
UTHR0810	24mm	130	4800-5300	500-700	3-4	8	溝銑(Slotting)	
UTHR0810	24mm	130	4800-5300	400-500	4-6.5	8	溝銑(Slotting)	
UTHR0810	24mm	130	4800-5300	1000-1200	8	0.5-1	側銑(Side milling)	
UTHR0810	24mm	130	4800-5300	500-700	8	3-4	側銑(Side milling)	
UTHR0810	24mm	130	4800-5300	400-500	8	4-6.5	側銑(Side milling)	
UTHR0810	24mm	130	4800-5300	500-700	8-16	0-0.2	側銑(Side milling)	
UTHR1005	30mm	150	4800-5200	1000-1200	0-0.2	10	溝銑(Slotting)	
UTHR1005	30mm	135	4200-4500	900-1100	0.5-1	10	溝銑(Slotting)	
UTHR1005	30mm	135	4200-4500	500-600	4-5	10	溝銑(Slotting)	
UTHR1005	30mm	135	4200-4500	400-500	7-8	10	溝銑(Slotting)	
UTHR1005	30mm	135	4200-4500	900-1100	10	0.5-1	側銑(Side milling)	
UTHR1005	30mm	135	4200-4500	500-700	10	4-5	側銑(Side milling)	
UTHR1005	30mm	135	4200-4500	400-500	10	7-8	側銑(Side milling)	
UTHR1005	30mm	135	4200-4500	500-700	10-20	0-0.25	側銑(Side milling)	
UTHR1010	30mm	150	4800-5200	1000-1200	0-0.2	10	溝銑(Slotting)	
UTHR1010	30mm	135	4200-4500	900-1100	0.5-1	10	溝銑(Slotting)	
UTHR1010	30mm	135	4200-4500	500-600	4-5	10	溝銑(Slotting)	
UTHR1010	30mm	135	4200-4500	350-450	7-8	10	溝銑(Slotting)	
UTHR1010	30mm	135	4200-4500	900-1100	10	0.5-1	側銑(Side milling)	
UTHR1010	30mm	135	4200-4500	500-600	10	4-5	側銑(Side milling)	
UTHR1010	30mm	135	4200-4500	350-450	10	7-8	側銑(Side milling)	
UTHR1010	30mm	135	4200-4500	500-700	10-20	0-0.25	側銑(Side milling)	
UTHR1020	30mm	150	4800-5200	1000-1200	0-0.2	10	溝銑(Slotting)	
UTHR1020	30mm	135	4200-4500	900-1100	0.5-1	10	溝銑(Slotting)	
UTHR1020	30mm	135	4200-4500	500-600	4-5	10	溝銑(Slotting)	
UTHR1020	30mm	135	4200-4500	350-450	7-8	10	溝銑(Slotting)	
UTHR1020	30mm	135	4200-4500	900-1100	10	0.5-1	側銑(Side milling)	
UTHR1020	30mm	135	4200-4500	500-600	10	4-5	側銑(Side milling)	
UTHR1020	30mm	135	4200-4500	350-450	10	7-8	側銑(Side milling)	
UTHR1020	30mm	135	4200-4500	500-700	10-20	0-0.25	側銑(Side milling)	
UTHR1210	33mm	150	3800-4200	1000-1200	0-0.25	12	溝銑(Slotting)	
UTHR1210	33mm	135	3400-3800	750-950	0.6-1.2	12	溝銑(Slotting)	
UTHR1210	33mm	135	3400-3800	400-500	4-5	12	溝銑(Slotting)	
UTHR1210	33mm	135	3400-3800	250-400	6-7	12	溝銑(Slotting)	
UTHR1210	33mm	135	3400-3800	800-1000	12	0.6-1.2	側銑(Side milling)	
UTHR1210	33mm	135	3400-3800	400-500	12	4-5	側銑(Side milling)	
UTHR1210	33mm	135	3400-3800	300-400	12	6-7	側銑(Side milling)	
UTHR1210	33mm	135	3400-3800	500-700	12-24	0-0.25	側銑(Side milling)	
UTHR1220	33mm	150	3800-4200	1000-1200	0-0.25	12	溝銑(Slotting)	
UTHR1220	33mm	135	3400-3800	750-950	0.6-1.2	12	溝銑(Slotting)	
UTHR1220	33mm	135	3400-3800	400-500	4-5	12	溝銑(Slotting)	
UTHR1220	33mm	135	3400-3800	250-400	5-6	12	溝銑(Slotting)	
UTHR1220	33mm	135	3400-3800	800-1000	12	0.6-1.2	側銑(Side milling)	
UTHR1220	33mm	135	3400-3800	400-500	12	4-5	側銑(Side milling)	
UTHR1220	33mm	135	3400-3800	300-400	12	5-6	側銑(Side milling)	
UTHR1220	33mm	135	3400-3800	500-700	12-24	0-0.25	側銑(Side milling)	
UTHR1230	33mm	150	3800-4200	1000-1200	0-0.25	12	溝銑(Slotting)	
UTHR1230	33mm	135	3400-3800	750-950	0.6-1.2	12	溝銑(Slotting)	
UTHR1230	33mm	135	3400-3800	400-500	4-5	12	溝銑(Slotting)	
UTHR1230	33mm	135	3400-3800	250-400	5-6	12	溝銑(Slotting)	
UTHR1230	33mm	135	3400-3800	800-1000	12	0.6-1.2	側銑(Side milling)	
UTHR1230	33mm	135	3400-3800	400-500	12	4-5	側銑(Side milling)	
UTHR1230	33mm	135	3400-3800	300-400	12	5-6	側銑(Side milling)	
UTHR1230	33mm	135	3400-3800	500-700	12-24	0-0.25	側銑(Side milling)	
UTHR1610	43mm	150	2800-3200	800-1000	0-0.25	16	溝銑(Slotting)	
UTHR1610	43mm	135	2500-2900	700-850	0.6-1.2	16	溝銑(Slotting)	
UTHR1610	43mm	135	2500-2900	350-500	3-4	16	溝銑(Slotting)	
UTHR1610	43mm	135	2500-2900	200-350	4-5	16	溝銑(Slotting)	
UTHR1610	43mm	135	2500-2900	700-900	16	0.6-1.2	側銑(Side milling)	
UTHR1610	43mm	135	2500-2900	350-500	16	3-4	側銑(Side milling)	
UTHR1610	43mm	135	2500-2900	200-350	16	4-5	側銑(Side milling)	
UTHR1610	43mm	135	2500-2900	350-550	16-32	0-0.3	側銑(Side milling)	
UTHR1620	43mm	150	2800-3200	800-1000	0-0.25	16	溝銑(Slotting)	
UTHR1620	43mm	135	2500-2900	700-850	0.6-1.2	16	溝銑(Slotting)	
UTHR1620	43mm	135	2500-2900	350-500	3-4	16	溝銑(Slotting)	
UTHR1620	43mm	135	2500-2900	200-350	4-5	16	溝銑(Slotting)	
UTHR1620	43mm	135	2500-2900	700-900	16	0.6-1.2	側銑(Side milling)	
UTHR1620	43mm	135	2500-2900	350-500	16	3-4	側銑(Side milling)	
UTHR1620	43mm	135	2500-2900	200-350	16	4-5	側銑(Side milling)	
UTHR1620	43mm	135	2500-2900	350-550	16-32	0-0.3	側銑(Side milling)	
UTHR1630	43mm	150	2800-3200	800-1000	0-0.25	16	溝銑(Slotting)	
UTHR1630	43mm	135	2500-2900	700-850	0.6-1.2	16	溝銑(Slotting)	
UTHR1630	43mm	135	2500-2900	350-500	3-4	16	溝銑(Slotting)	
UTHR1630	43mm	135	2500-2900	200-350	4-5	16	溝銑(Slotting)	
UTHR1630	43mm	135	2500-2900	700-900	16	0.6-1.2	側銑(Side milling)	
UTHR1630	43mm	135	2500-2900	350-500	16	3-4	側銑(Side milling)	
UTHR1630	43mm	135	2500-2900	200-350	16	4-5	側銑(Side milling)	
UTHR1630	43mm	135	2500-2900	350-550	16-32	0-0.3	側銑(Side milling)	
UTHR2010	47mm	150	2200-2600	600-800	0-0.3	20	溝銑(Slotting)	
UTHR2010	47mm	135	2000-2300	500-700	0.6-1.2	20	溝銑(Slotting)	
UTHR2010	47mm	135	2000-2300	200-350	3-4	20	溝銑(Slotting)	
UTHR2010	47mm	135	2000-2300	150-250	4-5	20	溝銑(Slotting)	
UTHR2010	47mm	135	2000-2300	600-800	20	0.6-1.2	側銑(Side milling)	
UTHR2010	47mm	135	2000-2300	250-350	20	3-4	側銑(Side milling)	
UTHR2010	47mm	135	2000-2300	200-300	20	4-5	側銑(Side milling)	