被切削材 Work Material	鈦合金 / 純鈦 : 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 (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	加工方式 Milling Type
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)
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 / Note:

◆ 建議冷卻方式為濕式。

◆ Suggest to use Wet coolant.

◆ UTJ本身刀法應用於粗、中、精銑加工，且其無論在溝銑與側銑皆有0.4~0.8D之能力，
但在UTJ1004以上需視主軸扭力與機器剛性做調整。

◆ UTJ is good at roughing, semi-finishing and finishing. It can do 0.4D~0.8D slot milling and side milling.
For diameter 10mm and above, make necessary adjustment as per spindle torque and machine rigidity.

◆ 因UTJ為粗中精銑刀具，故粗切削時請用濕式高壓水溶性切削液沖排削，以免造成積屑。

◆ Since UTJ is suitable for roughing, semi-finishing and finishing, use high pressure water soluble cutting fluid during
roughing to evacuate chips.

◆ 純鈦與鈦合金材料屬性較沾黏，加工時請務必使用高壓水溶性切削液沖排削，以免造成積屑。

◆ Owing to the sticky features of pure titanium and titanium alloy materials, be sure to use high pressure water soluble
cutting fluid to evacuate chips.