

切削條件表

X-UEXR

MILLING CONDITIONS

被切削材 Work Material		熱處理鋼 Hardened Steels					
冷卻方式 Coolant Type		乾式切削 Dry coolant					
型號 Type No.	刀具伸長量 Extension Length (mm)	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
X-UEXR0803	30	200	7700~8200	2400~2800	0.15~0.18	7~8	溝銑 SLOTTING
X-UEXR0803	30	200	7700~8200	1200~1600	0.08~0.11	7~8	溝銑 SLOTTING
X-UEXR0803	30	200	7700~8200	2600~3000	0.15~0.18	0.15~0.18	3D銑 3D MILLING
X-UEXR0803	30	200	7700~8200	2600~3000	0.08~0.11	0.08~0.11	3D銑 3D MILLING
X-UEXR0803	50	150	5500~6000	600~1000	0.07~0.1	7~8	溝銑 SLOTTING
X-UEXR0803	50	150	5500~6000	1200~1600	0.08~0.11	0.08~0.11	3D銑 3D MILLING
X-UEXR0803	70	70	2400~2700	400~800	0.07~0.1	7~8	溝銑 SLOTTING
X-UEXR0803	70	90	3000~3500	800~1200	0.07~0.1	0.07~0.1	3D銑 3D MILLING
X-UEXR0805	30	200	7700~8200	2400~2800	0.15~0.18	6~8	溝銑 SLOTTING
X-UEXR0805	30	200	7700~8200	1200~1600	0.08~0.11	6~8	溝銑 SLOTTING
X-UEXR0805	30	200	7700~8200	2600~3000	0.15~0.18	0.15~0.18	3D銑 3D MILLING
X-UEXR0805	30	200	7700~8200	2600~3000	0.08~0.11	0.08~0.11	3D銑 3D MILLING
X-UEXR0805	50	150	5500~6000	600~1000	0.07~0.1	6~8	溝銑 SLOTTING
X-UEXR0805	50	150	5500~6000	1200~1600	0.08~0.11	0.08~0.11	3D銑 3D MILLING
X-UEXR0805	70	70	2400~2700	400~800	0.07~0.1	6~8	溝銑 SLOTTING
X-UEXR0805	70	90	3000~3500	800~1200	0.07~0.1	0.07~0.1	3D銑 3D MILLING
X-UEXR0810	30	200	7700~8200	2400~2800	0.15~0.18	5~8	溝銑 SLOTTING
X-UEXR0810	30	200	7700~8200	1200~1600	0.08~0.11	5~8	溝銑 SLOTTING
X-UEXR0810	30	200	7700~8200	2600~3000	0.15~0.18	0.15~0.18	3D銑 3D MILLING
X-UEXR0810	30	200	7700~8200	2600~3000	0.08~0.11	0.08~0.11	3D銑 3D MILLING
X-UEXR0810	50	150	5500~6000	600~1000	0.07~0.1	5~8	溝銑 SLOTTING
X-UEXR0810	50	150	5500~6000	1200~1600	0.08~0.11	0.08~0.11	3D銑 3D MILLING
X-UEXR0810	70	70	2400~2700	400~800	0.07~0.1	5~8	溝銑 SLOTTING
X-UEXR0810	70	90	3000~3500	800~1200	0.07~0.1	0.07~0.1	3D銑 3D MILLING
X-UEXR1005	35	200	6000~6500	1800~2200	0.15~0.18	8~10	溝銑 SLOTTING
X-UEXR1005	35	200	6000~6500	1000~1400	0.08~0.11	8~10	溝銑 SLOTTING
X-UEXR1005	35	200	6000~6500	2400~2800	0.15~0.18	0.15~0.18	3D銑 3D MILLING
X-UEXR1005	35	200	6000~6500	2400~2800	0.08~0.11	0.08~0.11	3D銑 3D MILLING
X-UEXR1005	50	145	4000~4500	800~1200	0.08~0.11	8~10	溝銑 SLOTTING
X-UEXR1005	50	145	4000~4500	1400~1800	0.08~0.11	0.08~0.11	3D銑 3D MILLING
X-UEXR1005	70	100	2700~3200	600~1000	0.07~0.11	8~10	溝銑 SLOTTING
X-UEXR1005	70	100	2700~3200	800~1200	0.07~0.11	0.07~0.11	3D銑 3D MILLING
X-UEXR1010	35	200	6000~6500	1800~2200	0.15~0.18	7~10	溝銑 SLOTTING
X-UEXR1010	35	200	6000~6500	1000~1400	0.08~0.11	7~10	溝銑 SLOTTING
X-UEXR1010	35	200	6000~6500	2400~2800	0.15~0.18	0.15~0.18	3D銑 3D MILLING
X-UEXR1010	35	200	6000~6500	2400~2800	0.08~0.11	0.08~0.11	3D銑 3D MILLING
X-UEXR1010	50	145	4000~4500	800~1200	0.08~0.11	7~10	溝銑 SLOTTING
X-UEXR1010	50	145	4000~4500	1400~1800	0.08~0.11	0.08~0.11	3D銑 3D MILLING
X-UEXR1010	70	100	2700~3200	600~1000	0.07~0.11	7~10	溝銑 SLOTTING
X-UEXR1010	70	100	2700~3200	800~1200	0.07~0.11	0.07~0.11	3D銑 3D MILLING

EXCHANGEABLE HEAD ENDMILL II



被切削材 Work Material		熱處理鋼 Hardened Steels						加工方式 Milling Type
冷卻方式 Coolant Type		乾式切削 Dry coolant						
型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A _p) Depth of Cut	加工寬度 (A _p) Width of Cut		
X-UEXR1205	40	130	3000~3400	1400~1800	0.15~0.2	10~12	溝銑 SLOTTING	
X-UEXR1205	40	170	4000~4500	1000~1400	0.1~0.13	10~12	溝銑 SLOTTING	
X-UEXR1205	40	130	3000~3400	2000~2400	0.15~0.2	0.15~0.2	3D銑 3D MILLING	
X-UEXR1205	40	170	4000~4500	1400~1800	0.1~0.13	0.1~0.13	3D銑 3D MILLING	
X-UEXR1205	60	120	2700~3200	800~1200	0.1~0.13	10~12	溝銑 SLOTTING	
X-UEXR1205	60	120	2700~3200	1000~1400	0.1~0.13	0.1~0.13	3D銑 3D MILLING	
X-UEXR1205	100	85	1700~2200	600~1000	0.07~0.1	10~12	溝銑 SLOTTING	
X-UEXR1205	100	85	1700~2200	800~1200	0.07~0.1	0.07~0.1	3D銑 3D MILLING	
X-UEXR1210	40	130	3000~3400	1400~1800	0.15~0.2	9~12	溝銑 SLOTTING	
X-UEXR1210	40	170	4000~4500	1000~1400	0.1~0.13	9~12	溝銑 SLOTTING	
X-UEXR1210	40	130	3000~3400	2000~2400	0.15~0.2	0.15~0.2	3D銑 3D MILLING	
X-UEXR1210	40	170	4000~4500	1400~1800	0.1~0.13	0.1~0.13	3D銑 3D MILLING	
X-UEXR1210	60	120	2700~3200	800~1200	0.1~0.13	9~12	溝銑 SLOTTING	
X-UEXR1210	60	120	2700~3200	1000~1400	0.1~0.13	0.1~0.13	3D銑 3D MILLING	
X-UEXR1210	100	85	1700~2200	600~1000	0.07~0.1	9~12	溝銑 SLOTTING	
X-UEXR1210	100	85	1700~2200	800~1200	0.07~0.1	0.07~0.1	3D銑 3D MILLING	
X-UEXR1220	40	130	3000~3400	1400~1800	0.15~0.2	7~12	溝銑 SLOTTING	
X-UEXR1220	40	170	4000~4500	1000~1400	0.1~0.13	7~12	溝銑 SLOTTING	
X-UEXR1220	40	130	3000~3400	2000~2400	0.15~0.2	0.15~0.2	3D銑 3D MILLING	
X-UEXR1220	40	170	4000~4500	1400~1800	0.1~0.13	0.1~0.13	3D銑 3D MILLING	
X-UEXR1220	60	120	2700~3200	800~1200	0.1~0.13	7~12	溝銑 SLOTTING	
X-UEXR1220	60	120	2700~3200	1000~1400	0.1~0.13	0.1~0.13	3D銑 3D MILLING	
X-UEXR1220	100	85	1700~2200	600~1000	0.07~0.1	7~12	溝銑 SLOTTING	
X-UEXR1220	100	85	1700~2200	800~1200	0.07~0.1	0.07~0.1	3D銑 3D MILLING	
X-UEXR1610	60	160	2700~3200	1600~2000	0.18~0.23	13~16	溝銑 SLOTTING	
X-UEXR1610	60	160	2700~3200	800~1200	0.12~0.15	13~16	溝銑 SLOTTING	
X-UEXR1610	60	160	2700~3200	1600~2000	0.18~0.23	0.18~0.23	3D銑 3D MILLING	
X-UEXR1610	60	160	2700~3200	1400~1800	0.12~0.15	0.12~0.15	3D銑 3D MILLING	
X-UEXR1610	100	110	1800~2200	600~1000	0.1~0.15	13~16	溝銑 SLOTTING	
X-UEXR1610	100	110	1800~2200	800~1200	0.1~0.15	0.1~0.15	3D銑 3D MILLING	
X-UEXR1610	130	90	1400~1800	400~700	0.08~0.12	13~16	溝銑 SLOTTING	
X-UEXR1610	130	90	1400~1800	600~800	0.08~0.12	0.08~0.12	3D銑 3D MILLING	
X-UEXR1620	60	160	2700~3200	1600~2000	0.18~0.23	11~16	溝銑 SLOTTING	
X-UEXR1620	60	160	2700~3200	800~1200	0.12~0.15	11~16	溝銑 SLOTTING	
X-UEXR1620	60	160	2700~3200	1600~2000	0.18~0.23	0.18~0.23	3D銑 3D MILLING	
X-UEXR1620	60	160	2700~3200	1400~1800	0.12~0.15	0.12~0.15	3D銑 3D MILLING	
X-UEXR1620	100	110	1800~2200	600~1000	0.1~0.15	11~16	溝銑 SLOTTING	
X-UEXR1620	100	110	1800~2200	800~1200	0.1~0.15	0.1~0.15	3D銑 3D MILLING	
X-UEXR1620	130	90	1400~1800	400~800	0.08~0.12	11~16	溝銑 SLOTTING	
X-UEXR1620	130	90	1400~1800	600~800	0.08~0.12	0.08~0.12	3D銑 3D MILLING	

被切削材 Work Material		熱處理鋼 Hardened Steels						加工方式 Milling Type
冷卻方式 Coolant Type		乾式切削 Dry coolant						
型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A _p) Depth of Cut	加工寬度 (A _w) Width of Cut		
X-UEXR1630	60	160	2700~3200	1600~2000	0.18~0.23	9~16	溝銼 SLOTTING	
X-UEXR1630	60	160	2700~3200	800~1200	0.1~0.15	9~16	溝銼 SLOTTING	
X-UEXR1630	60	160	2700~3200	1600~2000	0.18~0.23	0.18~0.23	3D銼 3D MILLING	
X-UEXR1630	60	160	2700~3200	1400~1800	0.12~0.15	0.12~0.15	3D銼 3D MILLING	
X-UEXR1630	100	110	1800~2200	600~1000	0.1~0.15	9~16	溝銼 SLOTTING	
X-UEXR1630	100	110	1800~2200	800~1200	0.1~0.15	0.1~0.15	3D銼 3D MILLING	
X-UEXR1630	130	90	1400~1800	400~700	0.08~0.12	9~16	溝銼 SLOTTING	
X-UEXR1630	130	90	1400~1800	600~800	0.08~0.12	0.08~0.12	3D銼 3D MILLING	
X-UEXR2010	70	175	2500~3000	1200~1600	0.18~0.23	17~20	溝銼 SLOTTING	
X-UEXR2010	70	175	2500~3000	800~1200	0.1~0.15	17~20	溝銼 SLOTTING	
X-UEXR2010	70	175	2500~3000	1400~1800	0.15~0.23	0.15~0.23	3D銼 3D MILLING	
X-UEXR2010	70	175	2500~3000	1200~1600	0.1~0.15	0.17~0.2	3D銼 3D MILLING	
X-UEXR2010	120	110	1600~2000	600~1000	0.1~0.2	17~20	溝銼 SLOTTING	
X-UEXR2010	120	120	1800~2200	800~1000	0.1~0.2	0.1~0.15	3D銼 3D MILLING	
X-UEXR2010	170	80	1100~1400	400~700	0.1~0.15	17~20	溝銼 SLOTTING	
X-UEXR2010	170	90	1300~1600	600~800	0.1~0.15	0.1~0.15	3D銼 3D MILLING	
X-UEXR2020	70	175	2500~3000	1200~1600	0.18~0.23	15~20	溝銼 SLOTTING	
X-UEXR2020	70	175	2500~3000	800~1200	0.1~0.15	15~20	溝銼 SLOTTING	
X-UEXR2020	70	175	2500~3000	1400~1800	0.15~0.23	0.15~0.23	3D銼 3D MILLING	
X-UEXR2020	70	175	2500~3000	1200~1600	0.1~0.15	0.17~0.2	3D銼 3D MILLING	
X-UEXR2020	120	110	1600~2000	600~1000	0.1~0.2	15~20	溝銼 SLOTTING	
X-UEXR2020	120	120	1800~2200	800~1000	0.1~0.2	0.1~0.15	3D銼 3D MILLING	
X-UEXR2020	170	80	1100~1400	400~700	0.1~0.15	15~20	溝銼 SLOTTING	
X-UEXR2020	170	90	1300~1600	600~800	0.1~0.15	0.1~0.15	3D銼 3D MILLING	
X-UEXR2030	70	175	2500~3000	1200~1600	0.18~0.23	13~20	溝銼 SLOTTING	
X-UEXR2030	70	175	2500~3000	800~1200	0.1~0.15	13~20	溝銼 SLOTTING	
X-UEXR2030	70	175	2500~3000	1400~1800	0.15~0.23	0.15~0.23	3D銼 3D MILLING	
X-UEXR2030	70	175	2500~3000	1200~1600	0.1~0.15	0.17~0.2	3D銼 3D MILLING	
X-UEXR2030	120	110	1600~2000	600~1000	0.1~0.2	13~20	溝銼 SLOTTING	
X-UEXR2030	120	120	1800~2200	800~1000	0.1~0.2	0.1~0.15	3D銼 3D MILLING	
X-UEXR2030	170	80	1100~1400	400~700	0.1~0.15	13~20	溝銼 SLOTTING	
X-UEXR2030	170	90	1300~1600	600~800	0.1~0.15	0.1~0.15	3D銼 3D MILLING	
X-UEXR2510	80	175	2000~2400	800~1200	0.15~0.25	22~25	溝銼 SLOTTING	
X-UEXR2510	80	175	2000~2400	600~1000	0.1~0.15	22~25	溝銼 SLOTTING	
X-UEXR2510	80	175	2000~2400	1000~1400	0.15~0.25	0.15~0.25	3D銼 3D MILLING	
X-UEXR2510	80	175	2000~2400	1000~1400	0.1~0.2	0.17~0.2	3D銼 3D MILLING	
X-UEXR2510	130	110	1200~1600	400~600	0.1~0.15	22~25	溝銼 SLOTTING	
X-UEXR2510	130	120	1300~1700	700~900	0.1~0.2	0.12~0.15	3D銼 3D MILLING	
X-UEXR2510	180	80	800~1200	300~400	0.1~0.15	22~25	溝銼 SLOTTING	
X-UEXR2510	180	90	1000~1400	500~700	0.1~0.15	0.12~0.15	3D銼 3D MILLING	

EXCHANGEABLE HEAD ENDMILL II



被切削材 Work Material		熱處理鋼 Hardened Steels						加工方式 Milling Type
冷卻方式 Coolant Type		乾式切削 Dry coolant						
型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A _a) Depth of Cut	加工寬度 (A _p) Width of Cut		
X-UEXR2530	80	175	2000~2400	800~1200	0.15~0.25	18~25	溝銼 SLOTTING	
X-UEXR2530	80	175	2000~2400	600~1000	0.1~0.15	18~25	溝銼 SLOTTING	
X-UEXR2530	80	175	2000~2400	1000~1400	0.15~0.25	0.15~0.25	3D銼 3D MILLING	
X-UEXR2530	80	175	2000~2400	1000~1400	0.1~0.2	0.17~0.2	3D銼 3D MILLING	
X-UEXR2530	130	110	1200~1600	400~600	0.1~0.15	18~25	溝銼 SLOTTING	
X-UEXR2530	130	120	1300~1700	700~900	0.1~0.2	0.12~0.15	3D銼 3D MILLING	
X-UEXR2530	180	80	800~1200	300~400	0.1~0.15	18~25	溝銼 SLOTTING	
X-UEXR2530	180	90	1000~1400	500~700	0.1~0.15	0.12~0.15	3D銼 3D MILLING	
X-UEXR2550	80	175	2000~2400	800~1200	0.15~0.25	14~25	溝銼 SLOTTING	
X-UEXR2550	80	175	2000~2400	600~1000	0.1~0.15	14~25	溝銼 SLOTTING	
X-UEXR2550	80	175	2000~2400	1000~1400	0.15~0.25	0.15~0.25	3D銼 3D MILLING	
X-UEXR2550	80	175	2000~2400	1000~1400	0.1~0.2	0.17~0.2	3D銼 3D MILLING	
X-UEXR2550	130	110	1200~1600	400~600	0.1~0.15	14~25	溝銼 SLOTTING	
X-UEXR2550	130	120	1300~1700	700~900	0.1~0.2	0.12~0.15	3D銼 3D MILLING	
X-UEXR2550	180	80	800~1200	300~400	0.1~0.15	14~25	溝銼 SLOTTING	
X-UEXR2550	180	90	1000~1400	500~700	0.1~0.15	0.12~0.15	3D銼 3D MILLING	
X-UEXR3230	80	175	1600~2000	600~1000	0.15~0.25	25~32	溝銼 SLOTTING	
X-UEXR3230	80	175	1600~2000	500~800	0.1~0.15	25~32	溝銼 SLOTTING	
X-UEXR3230	80	175	1600~2000	800~1100	0.15~0.25	0.15~0.25	3D銼 3D MILLING	
X-UEXR3230	80	175	1600~2000	800~1100	0.1~0.2	0.17~0.2	3D銼 3D MILLING	
X-UEXR3230	140	110	900~1300	300~500	0.1~0.15	25~32	溝銼 SLOTTING	
X-UEXR3230	140	120	1000~1400	600~800	0.1~0.2	0.12~0.15	3D銼 3D MILLING	
X-UEXR3230	200	80	700~1000	250~400	0.1~0.15	25~32	溝銼 SLOTTING	
X-UEXR3230	200	90	800~1100	400~600	0.1~0.15	0.12~0.15	3D銼 3D MILLING	
X-UEXR3250	80	175	1600~2000	600~1000	0.15~0.25	21~32	溝銼 SLOTTING	
X-UEXR3250	80	175	1600~2000	500~800	0.1~0.15	21~32	溝銼 SLOTTING	
X-UEXR3250	80	175	1600~2000	800~1100	0.15~0.25	0.15~0.25	3D銼 3D MILLING	
X-UEXR3250	80	175	1600~2000	800~1100	0.1~0.2	0.17~0.2	3D銼 3D MILLING	
X-UEXR3250	140	110	900~1300	300~500	0.1~0.15	21~32	溝銼 SLOTTING	
X-UEXR3250	140	120	1000~1400	600~800	0.1~0.2	0.12~0.15	3D銼 3D MILLING	
X-UEXR3250	200	80	700~1000	250~400	0.1~0.15	21~32	溝銼 SLOTTING	
X-UEXR3250	200	90	800~1100	400~600	0.1~0.15	0.12~0.15	3D銼 3D MILLING	



切削條件表

X-UEXR

MILLING CONDITIONS

被切削材 Work Material		熱處理鋼 Hardened Steels :SKD11 / SKH9 : 1.2379 / 1.3342 : D2 / M2 (HRC55~62)					
冷卻方式 Coolant Type		乾式切削 Dry coolant					
型號 Type No.	刀具伸長量 Extension Length (mm)	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
X-UEXR0803	30	125	4500~5000	1000~1400	0.07~0.09	7~8	溝銑 SLOTTING
X-UEXR0803	30	125	4500~5000	1600~2000	0.07~0.09	0.07~0.09	3D銑 3D MILLING
X-UEXR0803	50	80	2700~3200	600~1000	0.06~0.08	7~8	溝銑 SLOTTING
X-UEXR0803	50	80	2700~3200	1000~1400	0.06~0.08	0.06~0.08	3D銑 3D MILLING
X-UEXR0803	70	55	1800~2200	400~800	0.06~0.08	7~8	溝銑 SLOTTING
X-UEXR0803	70	55	1800~2200	600~1000	0.06~0.08	0.06~0.08	3D銑 3D MILLING
X-UEXR0805	30	125	4500~5000	1000~1400	0.07~0.09	6~8	溝銑 SLOTTING
X-UEXR0805	30	125	4500~5000	1600~2000	0.07~0.09	0.07~0.09	3D銑 3D MILLING
X-UEXR0805	50	80	2700~3200	600~1000	0.06~0.08	6~8	溝銑 SLOTTING
X-UEXR0805	50	80	2700~3200	1000~1400	0.06~0.08	0.06~0.08	3D銑 3D MILLING
X-UEXR0805	70	55	1800~2200	400~800	0.06~0.08	6~8	溝銑 SLOTTING
X-UEXR0805	70	55	1800~2200	600~1000	0.06~0.08	0.06~0.08	3D銑 3D MILLING
X-UEXR0810	30	125	4500~5000	1000~1400	0.07~0.09	5~8	溝銑 SLOTTING
X-UEXR0810	30	125	4500~5000	1600~2000	0.07~0.09	0.07~0.09	3D銑 3D MILLING
X-UEXR0810	50	80	2700~3200	600~1000	0.06~0.08	5~8	溝銑 SLOTTING
X-UEXR0810	50	80	2700~3200	1000~1400	0.06~0.08	0.06~0.08	3D銑 3D MILLING
X-UEXR0810	70	55	1800~2200	400~800	0.06~0.08	5~8	溝銑 SLOTTING
X-UEXR0810	70	55	1800~2200	600~1000	0.06~0.08	0.06~0.08	3D銑 3D MILLING
X-UEXR1005	35	110	3000~3400	1000~1400	0.07~0.09	8~10	溝銑 SLOTTING
X-UEXR1005	35	110	3000~3400	1000~1400	0.07~0.09	0.07~0.09	3D銑 3D MILLING
X-UEXR1005	50	100	2700~3200	800~1200	0.07~0.09	8~10	溝銑 SLOTTING
X-UEXR1005	50	100	2700~3200	800~1200	0.07~0.09	0.07~0.09	3D銑 3D MILLING
X-UEXR1005	70	70	1700~2200	400~800	0.07~0.09	8~10	溝銑 SLOTTING
X-UEXR1005	70	70	1700~2200	600~1000	0.07~0.09	0.07~0.09	3D銑 3D MILLING
X-UEXR1010	35	110	3000~3400	1000~1400	0.07~0.09	7~10	溝銑 SLOTTING
X-UEXR1010	35	110	3000~3400	1000~1400	0.07~0.09	0.07~0.09	3D銑 3D MILLING
X-UEXR1010	50	100	2700~3200	800~1200	0.07~0.09	7~10	溝銑 SLOTTING
X-UEXR1010	50	100	2700~3200	800~1200	0.07~0.09	0.07~0.09	3D銑 3D MILLING
X-UEXR1010	70	70	1700~2200	400~800	0.07~0.09	7~10	溝銑 SLOTTING
X-UEXR1010	70	70	1700~2200	600~1000	0.07~0.09	0.07~0.09	3D銑 3D MILLING
X-UEXR1205	40	120	2700~3200	1000~1400	0.09~0.11	10~12	溝銑 SLOTTING
X-UEXR1205	40	120	2700~3200	1000~1400	0.09~0.11	0.09~0.11	3D銑 3D MILLING
X-UEXR1205	60	105	2300~2800	600~1000	0.09~0.11	10~12	溝銑 SLOTTING
X-UEXR1205	60	105	2300~2800	800~1200	0.09~0.11	0.09~0.11	3D銑 3D MILLING
X-UEXR1205	100	85	1700~2200	400~700	0.07~0.1	10~12	溝銑 SLOTTING
X-UEXR1205	100	85	1700~2200	600~1000	0.07~0.1	0.07~0.1	3D銑 3D MILLING
X-UEXR1210	40	120	2700~3200	1000~1400	0.09~0.11	9~12	溝銑 SLOTTING
X-UEXR1210	40	120	2700~3200	1000~1400	0.09~0.11	0.09~0.11	3D銑 3D MILLING
X-UEXR1210	60	105	2300~2800	600~1000	0.09~0.11	9~12	溝銑 SLOTTING
X-UEXR1210	60	105	2300~2800	800~1200	0.09~0.11	0.09~0.11	3D銑 3D MILLING

EXCHANGEABLE HEAD ENDMILL II



被切削材 Work Material		熱處理鋼 Hardened Steels : SKD11 / SKH9 : 1.2379 / 1.3342 : D2 / M2 (HRC55~62)					
冷卻方式 Coolant Type		乾式切削 Dry coolant					
型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A _p) Depth of Cut	加工寬度 (A _p) Width of Cut	加工方式 Milling Type
X-UEXR1210	100	85	1700~2200	400~700	0.07~0.1	9~12	溝銼 SLOTTING
X-UEXR1210	100	85	1700~2200	600~1000	0.07~0.1	0.07~0.1	3D銼 3D MILLING
X-UEXR1220	40	120	2700~3200	1000~1400	0.09~0.11	7~12	溝銼 SLOTTING
X-UEXR1220	40	120	2700~3200	1000~1400	0.09~0.11	0.09~0.11	3D銼 3D MILLING
X-UEXR1220	60	105	2300~2800	600~1000	0.09~0.11	7~12	溝銼 SLOTTING
X-UEXR1220	60	105	2300~2800	800~1200	0.09~0.11	0.09~0.11	3D銼 3D MILLING
X-UEXR1220	100	85	1700~2200	400~700	0.07~0.1	7~12	溝銼 SLOTTING
X-UEXR1220	100	85	1700~2200	600~1000	0.07~0.1	0.07~0.1	3D銼 3D MILLING
X-UEXR1610	60	120	2000~2400	600~1000	0.1~0.13	13~16	溝銼 SLOTTING
X-UEXR1610	60	140	2400~2800	800~1200	0.1~0.13	0.1~0.13	3D銼 3D MILLING
X-UEXR1610	100	100	1700~2100	600~800	0.1~0.13	13~16	溝銼 SLOTTING
X-UEXR1610	100	100	1700~2100	600~1000	0.1~0.13	0.1~0.13	3D銼 3D MILLING
X-UEXR1610	130	90	1400~1800	400~700	0.1~0.13	13~16	溝銼 SLOTTING
X-UEXR1610	130	90	1400~1800	400~700	0.1~0.13	0.1~0.13	3D銼 3D MILLING
X-UEXR1620	60	120	2000~2400	600~1000	0.1~0.13	11~16	溝銼 SLOTTING
X-UEXR1620	60	140	2400~2800	800~1200	0.1~0.13	0.1~0.13	3D銼 3D MILLING
X-UEXR1620	100	100	1700~2100	600~800	0.1~0.13	11~16	溝銼 SLOTTING
X-UEXR1620	100	100	1700~2100	600~1000	0.1~0.13	0.1~0.13	3D銼 3D MILLING
X-UEXR1620	130	90	1400~1800	400~700	0.1~0.13	11~16	溝銼 SLOTTING
X-UEXR1620	130	90	1400~1800	400~700	0.1~0.13	0.1~0.13	3D銼 3D MILLING
X-UEXR1630	60	120	2000~2400	600~1000	0.1~0.13	9~16	溝銼 SLOTTING
X-UEXR1630	60	140	2400~2800	800~1200	0.1~0.13	0.1~0.13	3D銼 3D MILLING
X-UEXR1630	100	100	1700~2100	600~800	0.1~0.13	9~16	溝銼 SLOTTING
X-UEXR1630	100	100	1700~2100	600~1000	0.1~0.13	0.1~0.13	3D銼 3D MILLING
X-UEXR1630	130	90	1400~1800	400~700	0.1~0.13	9~16	溝銼 SLOTTING
X-UEXR1630	130	90	1400~1800	400~700	0.1~0.13	0.1~0.13	3D銼 3D MILLING
X-UEXR2010	70	120	1800~2100	600~800	0.1~0.13	17~20	溝銼 SLOTTING
X-UEXR2010	70	140	2000~2400	800~1200	0.1~0.13	0.1~0.13	3D銼 3D MILLING
X-UEXR2010	120	100	1500~1800	400~600	0.1~0.13	17~20	溝銼 SLOTTING
X-UEXR2010	120	100	1500~1800	600~800	0.1~0.13	0.1~0.13	3D銼 3D MILLING
X-UEXR2010	170	70	1000~1300	300~500	0.1~0.13	17~20	溝銼 SLOTTING
X-UEXR2010	170	70	1000~1300	500~700	0.1~0.13	0.1~0.13	3D銼 3D MILLING
X-UEXR2020	70	120	1800~2100	600~800	0.1~0.13	15~20	溝銼 SLOTTING
X-UEXR2020	70	140	2000~2400	800~1200	0.1~0.13	0.1~0.13	3D銼 3D MILLING
X-UEXR2020	120	100	1500~1800	400~600	0.1~0.13	15~20	溝銼 SLOTTING
X-UEXR2020	120	100	1500~1800	600~800	0.1~0.13	0.1~0.13	3D銼 3D MILLING
X-UEXR2020	170	70	1000~1300	300~500	0.1~0.13	15~20	溝銼 SLOTTING
X-UEXR2020	170	70	1000~1300	500~700	0.1~0.13	0.1~0.13	3D銼 3D MILLING
X-UEXR2030	70	120	1800~2100	600~800	0.1~0.13	13~20	溝銼 SLOTTING
X-UEXR2030	70	140	2000~2400	800~1200	0.1~0.13	0.1~0.13	3D銼 3D MILLING

被切削材 Work Material		熱處理鋼 Hardened Steels :SKD11 / SKH9 : 1.2379 / 1.3342 : D2 / M2 (HRC55~62)					
冷卻方式 Coolant Type		乾式切削 Dry coolant					
型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A _p) Depth of Cut	加工寬度 (A _p) Width of Cut	加工方式 Milling Type
X-UEXR2030	120	100	1500~1800	400~600	0.1~0.13	13~20	溝銑 SLOTTING
X-UEXR2030	120	100	1500~1800	600~800	0.1~0.13	0.1~0.13	3D銑 3D MILLING
X-UEXR2030	170	70	1000~1300	300~500	0.1~0.13	13~20	溝銑 SLOTTING
X-UEXR2030	170	70	1000~1300	500~700	0.1~0.13	0.1~0.13	3D銑 3D MILLING
X-UEXR2510	80	120	1400~1700	500~700	0.1~0.13	22~25	溝銑 SLOTTING
X-UEXR2510	80	140	1600~2000	600~1000	0.1~0.13	0.1~0.13	3D銑 3D MILLING
X-UEXR2510	130	100	1100~1500	300~500	0.1~0.13	22~25	溝銑 SLOTTING
X-UEXR2510	130	100	1100~1500	500~800	0.1~0.13	0.1~0.13	3D銑 3D MILLING
X-UEXR2510	180	70	700~1100	250~350	0.1~0.13	22~25	溝銑 SLOTTING
X-UEXR2510	180	70	700~1100	400~600	0.1~0.13	0.1~0.13	3D銑 3D MILLING
X-UEXR2530	80	120	1400~1700	500~700	0.1~0.13	18~25	溝銑 SLOTTING
X-UEXR2530	80	140	1600~2000	600~1000	0.1~0.13	0.1~0.13	3D銑 3D MILLING
X-UEXR2530	130	100	1100~1500	300~500	0.1~0.13	18~25	溝銑 SLOTTING
X-UEXR2530	130	100	1100~1500	500~800	0.1~0.13	0.1~0.13	3D銑 3D MILLING
X-UEXR2530	180	70	700~1100	250~350	0.1~0.13	18~25	溝銑 SLOTTING
X-UEXR2530	180	70	700~1100	400~600	0.1~0.13	0.1~0.13	3D銑 3D MILLING
X-UEXR2550	80	120	1400~1700	500~700	0.1~0.13	14~25	溝銑 SLOTTING
X-UEXR2550	80	140	1600~2000	600~1000	0.1~0.13	0.1~0.13	3D銑 3D MILLING
X-UEXR2550	130	100	1100~1500	300~500	0.1~0.13	14~25	溝銑 SLOTTING
X-UEXR2550	130	100	1100~1500	500~800	0.1~0.13	0.1~0.13	3D銑 3D MILLING
X-UEXR2550	180	70	700~1100	250~350	0.1~0.13	14~25	溝銑 SLOTTING
X-UEXR2550	180	70	700~1100	400~600	0.1~0.13	0.1~0.13	3D銑 3D MILLING
X-UEXR3230	80	120	1000~1300	400~600	0.1~0.13	25~32	溝銑 SLOTTING
X-UEXR3230	80	140	1200~1500	600~800	0.1~0.13	0.1~0.13	3D銑 3D MILLING
X-UEXR3230	140	100	800~1200	300~400	0.1~0.13	25~32	溝銑 SLOTTING
X-UEXR3230	140	100	800~1200	500~700	0.1~0.13	0.1~0.13	3D銑 3D MILLING
X-UEXR3230	200	70	600~900	200~350	0.1~0.13	25~32	溝銑 SLOTTING
X-UEXR3230	200	70	600~900	300~500	0.1~0.13	0.1~0.13	3D銑 3D MILLING
X-UEXR3250	80	120	1000~1300	400~600	0.1~0.13	21~32	溝銑 SLOTTING
X-UEXR3250	80	140	1200~1500	600~800	0.1~0.13	0.1~0.13	3D銑 3D MILLING
X-UEXR3250	140	100	800~1200	300~400	0.1~0.13	21~32	溝銑 SLOTTING
X-UEXR3250	140	100	800~1200	500~700	0.1~0.13	0.1~0.13	3D銑 3D MILLING
X-UEXR3250	200	70	600~900	200~350	0.1~0.13	21~32	溝銑 SLOTTING
X-UEXR3250	200	70	600~900	300~500	0.1~0.13	0.1~0.13	3D銑 3D MILLING

