

## 切削條件表

# X-UEYR

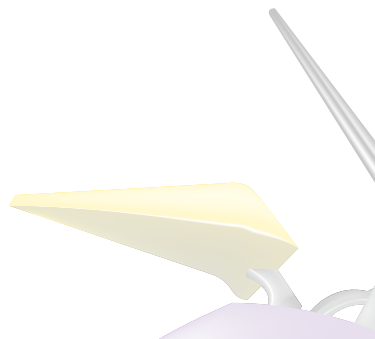
## MILLING CONDITIONS

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/油霧切削 Dry/MQL 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 <sup>-1</sup> )	進給速度 Feed (mm/min)	加工深度 (A <sub>s</sub> ) Depth of Cut	加工寬度 (A <sub>p</sub> ) Width of Cut		
X-UEYR0810	25	170	6800~7200	3000~3400	0.2~0.25	5~8	溝銑 SLOTTING	
X-UEYR0810	25	170	6800~7200	4500~5000	0.2~0.25	0.2~0.25	3D銑 3D MILLING	
X-UEYR0810	40	120	4800~5200	2400~2800	0.15~0.2	5~8	溝銑 SLOTTING	
X-UEYR0810	40	120	4800~5200	3400~3800	0.15~0.2	0.15~0.2	3D銑 3D MILLING	
X-UEYR0810	60	55	2200~2600	1000~1200	0.1~0.15	5~8	溝銑 SLOTTING	
X-UEYR0810	60	70	2800~3300	2800~3200	0.1~0.15	0.1~0.15	3D銑 3D MILLING	
X-UEYR0820	25	170	6800~7200	3000~3400	0.2~0.25	3~8	溝銑 SLOTTING	
X-UEYR0820	25	170	6800~7200	4500~5000	0.2~0.25	0.2~0.25	3D銑 3D MILLING	
X-UEYR0820	40	120	4800~5200	2400~2800	0.15~0.2	3~8	溝銑 SLOTTING	
X-UEYR0820	40	120	4800~5200	3400~3800	0.15~0.2	0.15~0.2	3D銑 3D MILLING	
X-UEYR0820	60	55	2200~2600	1000~1200	0.1~0.15	3~8	溝銑 SLOTTING	
X-UEYR0820	60	70	2800~3300	2800~3200	0.1~0.15	0.1~0.15	3D銑 3D MILLING	
X-UEYR1010	30	255	8000~8600	5500~6000	0.2~0.3	7~10	溝銑 SLOTTING	
X-UEYR1010	30	205	6600~7000	3600~4000	0.2~0.3	7~10	溝銑 SLOTTING	
X-UEYR1010	30	255	8000~8600	5500~6000	0.2~0.3	0.2~0.3	3D銑 3D MILLING	
X-UEYR1010	30	205	6600~7000	4700~5200	0.2~0.3	0.2~0.3	3D銑 3D MILLING	
X-UEYR1010	50	160	5000~5500	2200~2600	0.15~0.2	7~10	溝銑 SLOTTING	
X-UEYR1010	50	160	5000~5500	3800~4200	0.15~0.2	0.15~0.2	3D銑 3D MILLING	
X-UEYR1010	70	115	3600~4000	1600~2000	0.1~0.15	7~10	溝銑 SLOTTING	
X-UEYR1010	70	115	3600~4000	2600~3000	0.1~0.15	0.1~0.15	3D銑 3D MILLING	
X-UEYR1020	30	255	8000~8600	5500~6000	0.2~0.3	5~10	溝銑 SLOTTING	
X-UEYR1020	30	205	6600~7000	3600~4000	0.2~0.3	5~10	溝銑 SLOTTING	
X-UEYR1020	30	255	8000~8600	5500~6000	0.2~0.3	0.2~0.3	3D銑 3D MILLING	
X-UEYR1020	30	205	6600~7000	4700~5200	0.2~0.3	0.2~0.3	3D銑 3D MILLING	
X-UEYR1020	50	160	5000~5500	2200~2600	0.15~0.2	5~10	溝銑 SLOTTING	
X-UEYR1020	50	160	5000~5500	3800~4200	0.15~0.2	0.15~0.2	3D銑 3D MILLING	
X-UEYR1020	70	115	3600~4000	1600~2000	0.1~0.15	5~10	溝銑 SLOTTING	
X-UEYR1020	70	115	3600~4000	2600~3000	0.1~0.15	0.1~0.15	3D銑 3D MILLING	
X-UEYR1220	40	170	4500~5000	2800~3200	0.3~0.35	7~12	溝銑 SLOTTING	
X-UEYR1220	40	190	5000~5500	3600~4000	0.3~0.35	0.3~0.35	3D銑 3D MILLING	
X-UEYR1220	70	165	4400~4800	2200~2600	0.2~0.25	7~12	溝銑 SLOTTING	
X-UEYR1220	70	120	3200~3600	2200~2600	0.2~0.25	0.2~0.25	3D銑 3D MILLING	
X-UEYR1220	90	105	2700~3200	600~1000	0.05~0.1	7~12	溝銑 SLOTTING	
X-UEYR1220	90	120	3200~3600	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING	
X-UEYR1230	40	170	4500~5000	2800~3200	0.3~0.35	5~12	溝銑 SLOTTING	
X-UEYR1230	40	190	5000~5500	3600~4000	0.3~0.35	0.3~0.35	3D銑 3D MILLING	
X-UEYR1230	70	165	4400~4800	2200~2600	0.2~0.25	5~12	溝銑 SLOTTING	
X-UEYR1230	70	120	3200~3600	2200~2600	0.2~0.25	0.2~0.25	3D銑 3D MILLING	
X-UEYR1230	90	105	2700~3200	600~1000	0.05~0.1	5~12	溝銑 SLOTTING	
X-UEYR1230	90	120	3200~3600	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING	

# EXCHANGEABLE HEAD ENDMILL II



被切削材 Work Material		熱處理鋼 Hardened Steels					
冷卻方式 Coolant Type		乾式/油霧切削 Dry/MQL 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 <sup>-1</sup> )	進給速度 Feed (mm/min)	加工深度 (A <sub>a</sub> ) Depth of Cut	加工寬度 (A <sub>p</sub> ) Width of Cut	加工方式 Milling Type
X-UEYR1620	60	170	3400~3800	1600~2000	0.3~0.35	11~16	溝銑 SLOTTING
X-UEYR1620	60	115	2300~2700	1400~1800	0.3~0.35	0.3~0.35	3D銑 3D MILLING
X-UEYR1620	90	120	2400~2800	1000~1200	0.2~0.25	11~16	溝銑 SLOTTING
X-UEYR1620	90	90	1800~2200	1000~1200	0.2~0.25	0.2~0.25	3D銑 3D MILLING
X-UEYR1620	120	90	1800~2200	800~1000	0.05~0.1	11~16	溝銑 SLOTTING
X-UEYR1620	120	90	1800~2200	1000~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UEYR1630	60	170	3400~3800	1600~2000	0.3~0.35	9~16	溝銑 SLOTTING
X-UEYR1630	60	115	2300~2700	1400~1800	0.3~0.35	0.3~0.35	3D銑 3D MILLING
X-UEYR1630	90	120	2400~2800	1000~1200	0.2~0.25	9~16	溝銑 SLOTTING
X-UEYR1630	90	90	1800~2200	1000~1200	0.2~0.25	0.2~0.25	3D銑 3D MILLING
X-UEYR1630	120	90	1800~2200	800~1000	0.05~0.1	9~16	溝銑 SLOTTING
X-UEYR1630	120	90	1800~2200	1000~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UEYR1640	60	170	3400~3800	1600~2000	0.3~0.35	7~16	溝銑 SLOTTING
X-UEYR1640	60	115	2300~2700	1400~1800	0.3~0.35	0.3~0.35	3D銑 3D MILLING
X-UEYR1640	90	120	2400~2800	1000~1200	0.2~0.25	7~16	溝銑 SLOTTING
X-UEYR1640	90	90	1800~2200	1000~1200	0.2~0.25	0.2~0.25	3D銑 3D MILLING
X-UEYR1640	120	90	1800~2200	800~1000	0.05~0.1	7~16	溝銑 SLOTTING
X-UEYR1640	120	90	1800~2200	1000~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UEYR2030	60	170	2500~2900	1300~1700	0.3~0.35	13~20	溝銑 SLOTTING
X-UEYR2030	60	120	1700~2100	1200~1600	0.3~0.35	0.3~0.35	3D銑 3D MILLING
X-UEYR2030	110	120	1700~2100	900~1100	0.2~0.25	13~20	溝銑 SLOTTING
X-UEYR2030	110	100	1400~1800	900~1100	0.2~0.25	0.2~0.25	3D銑 3D MILLING
X-UEYR2030	150	95	1300~1700	700~900	0.05~0.1	13~20	溝銑 SLOTTING
X-UEYR2030	150	95	1300~1700	900~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UEYR2050	60	170	2500~2900	1300~1700	0.3~0.35	9~20	溝銑 SLOTTING
X-UEYR2050	60	120	1700~2100	1200~1600	0.3~0.35	0.3~0.35	3D銑 3D MILLING
X-UEYR2050	110	120	1700~2100	900~1100	0.2~0.25	9~20	溝銑 SLOTTING
X-UEYR2050	110	100	1400~1800	900~1100	0.2~0.25	0.2~0.25	3D銑 3D MILLING
X-UEYR2050	150	95	1300~1700	700~900	0.05~0.1	9~20	溝銑 SLOTTING
X-UEYR2050	150	95	1300~1700	900~1100	0.05~0.1	0.05~0.1	3D銑 3D MILLING



## 切削條件表

# X-UEYR

## 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/油霧切削 Dry/MQL 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 <sup>-1</sup> )	進給速度 Feed (mm/min)	加工深度 (A <sub>s</sub> ) Depth of Cut	加工寬度 (A <sub>p</sub> ) Width of Cut	加工方式 Milling Type
X-UEYR0810	25	105	4200~4600	1800~2200	0.05~0.1	5~8	溝銑 SLOTTING
X-UEYR0810	25	105	4200~4600	1600~2000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UEYR0810	40	95	3800~4200	1000~1200	0.05~0.08	5~8	溝銑 SLOTTING
X-UEYR0810	40	90	3600~4000	1600~2000	0.05~0.08	0.05~0.08	3D銑 3D MILLING
X-UEYR0810	60	45	1800~2200	600~800	0.05~0.08	5~8	溝銑 SLOTTING
X-UEYR0810	60	65	2600~3000	1200~1600	0.05~0.08	0.05~0.08	3D銑 3D MILLING
X-UEYR0820	25	105	4200~4600	1800~2200	0.05~0.1	3~8	溝銑 SLOTTING
X-UEYR0820	25	105	4200~4600	1600~2000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UEYR0820	40	95	3800~4200	1000~1200	0.05~0.08	3~8	溝銑 SLOTTING
X-UEYR0820	40	90	3600~4000	1600~2000	0.05~0.08	0.05~0.08	3D銑 3D MILLING
X-UEYR0820	60	45	1800~2200	600~800	0.05~0.08	3~8	溝銑 SLOTTING
X-UEYR0820	60	65	2600~3000	1200~1600	0.05~0.08	0.05~0.08	3D銑 3D MILLING
X-UEYR1010	30	95	3000~3400	2000~2400	0.05~0.1	7~10	溝銑 SLOTTING
X-UEYR1010	30	100	3200~3600	2000~2400	0.05~0.1	0.07~0.1	3D銑 3D MILLING
X-UEYR1010	50	90	2800~3200	1400~1600	0.05~0.1	7~10	溝銑 SLOTTING
X-UEYR1010	50	75	2400~2800	1400~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UEYR1010	70	60	1800~2200	800~1000	0.05~0.08	7~10	溝銑 SLOTTING
X-UEYR1010	70	60	1800~2200	1000~1400	0.05~0.08	0.05~0.08	3D銑 3D MILLING
X-UEYR1020	30	95	3000~3400	2000~2400	0.05~0.1	5~10	溝銑 SLOTTING
X-UEYR1020	30	100	3200~3600	2000~2400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UEYR1020	50	90	2800~3200	1400~1600	0.05~0.1	5~10	溝銑 SLOTTING
X-UEYR1020	50	75	2400~2800	1400~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UEYR1020	70	60	1800~2200	800~1000	0.05~0.08	5~10	溝銑 SLOTTING
X-UEYR1020	70	60	1800~2200	1000~1400	0.05~0.08	0.05~0.08	3D銑 3D MILLING
X-UEYR1220	40	105	2800~3200	1200~1600	0.1~0.15	7~12	溝銑 SLOTTING
X-UEYR1220	40	100	2600~3000	1600~2000	0.1~0.15	0.1~0.15	3D銑 3D MILLING
X-UEYR1220	70	75	2000~2400	800~1000	0.05~0.1	7~12	溝銑 SLOTTING
X-UEYR1220	70	85	2200~2600	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UEYR1220	90	70	1800~2200	600~800	0.05~0.1	7~12	溝銑 SLOTTING
X-UEYR1220	90	70	1800~2200	800~1000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UEYR1230	40	105	2800~3200	1200~1600	0.1~0.15	5~12	溝銑 SLOTTING
X-UEYR1230	40	100	2600~3000	1600~2000	0.1~0.15	0.1~0.15	3D銑 3D MILLING
X-UEYR1230	70	75	2000~2400	800~1000	0.05~0.1	5~12	溝銑 SLOTTING
X-UEYR1230	70	85	2200~2600	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UEYR1230	90	70	1800~2200	600~800	0.05~0.1	5~12	溝銑 SLOTTING
X-UEYR1230	90	70	1800~2200	800~1000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UEYR1620	60	120	2400~2800	800~1000	0.1~0.15	11~16	溝銑 SLOTTING
X-UEYR1620	60	130	2600~3000	1000~1200	0.1~0.15	0.1~0.15	3D銑 3D MILLING
X-UEYR1620	90	90	1800~2200	600~800	0.05~0.1	11~16	溝銑 SLOTTING
X-UEYR1620	90	90	1800~2200	800~1000	0.05~0.1	0.05~0.1	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/油霧切削 Dry/MQL 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 <sup>-1</sup> )	進給速度 Feed (mm/min)	加工深度 (A <sub>p</sub> ) Depth of Cut	加工寬度 (A <sub>p</sub> ) Width of Cut	加工方式 Milling Type
X-UEYR1620	120	70	1400~1800	400~600	0.05~0.1	11~16	溝銑 SLOTTING
X-UEYR1620	120	80	1600~2000	600~800	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UEYR1630	60	120	2400~2800	800~1000	0.1~0.15	9~16	溝銑 SLOTTING
X-UEYR1630	60	130	2600~3000	1000~1200	0.1~0.15	0.1~0.15	3D銑 3D MILLING
X-UEYR1630	90	90	1800~2200	600~800	0.05~0.1	9~16	溝銑 SLOTTING
X-UEYR1630	90	90	1800~2200	800~1000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UEYR1630	120	70	1400~1800	400~600	0.05~0.1	9~16	溝銑 SLOTTING
X-UEYR1630	120	80	1600~2000	600~800	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UEYR1640	60	120	2400~2800	800~1000	0.1~0.15	7~16	溝銑 SLOTTING
X-UEYR1640	60	130	2600~3000	1000~1200	0.1~0.15	0.1~0.15	3D銑 3D MILLING
X-UEYR1640	90	90	1800~2200	600~800	0.05~0.1	7~16	溝銑 SLOTTING
X-UEYR1640	90	90	1800~2200	800~1000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UEYR1640	120	70	1400~1800	400~600	0.05~0.1	7~16	溝銑 SLOTTING
X-UEYR1640	120	80	1600~2000	600~800	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UEYR2030	60	120	1700~2100	800~1000	0.1~0.15	12~20	溝銑 SLOTTING
X-UEYR2030	60	130	1900~2300	1000~1200	0.1~0.15	0.1~0.15	3D銑 3D MILLING
X-UEYR2030	110	90	1200~1600	600~800	0.05~0.1	12~20	溝銑 SLOTTING
X-UEYR2030	110	90	1200~1600	800~1000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UEYR2030	150	70	900~1300	400~600	0.05~0.1	12~20	溝銑 SLOTTING
X-UEYR2030	150	80	1000~1400	600~800	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UEYR2050	60	120	1700~2100	800~1000	0.1~0.15	9~20	溝銑 SLOTTING
X-UEYR2050	60	130	1900~2300	1000~1200	0.1~0.15	0.1~0.15	3D銑 3D MILLING
X-UEYR2050	110	90	1200~1600	600~800	0.05~0.1	9~20	溝銑 SLOTTING
X-UEYR2050	110	90	1200~1600	800~1000	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UEYR2050	150	70	900~1300	400~600	0.05~0.1	9~20	溝銑 SLOTTING
X-UEYR2050	150	80	1000~1400	600~800	0.05~0.1	0.05~0.1	3D銑 3D MILLING

