

切削條件表

X-UVT

MILLING CONDITIONS

被切削材 Work Material		調質鋼/預硬鋼 Prehardened Steels : NAK80 : 1.2083 : AISI420 : M310 (HRC36~45)					
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 ⁻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-UVT0806	25	95	3600~4000	1000~1400	0.1~0.2	6~8	溝銑 SLOTTING
X-UVT0806	25	95	3600~4000	800~1000	0.05~0.1	6~8	溝銑 SLOTTING
X-UVT0806	25	70	2600~3000	1000~1400	8	0.2~0.4	側銑 SIDE MILLING
X-UVT0806	25	85	3300~3600	600~800	8	0.05~0.15	側銑 SIDE MILLING
X-UVT0806	40	80	3000~3400	500~700	0.05~0.1	6~8	溝銑 SLOTTING
X-UVT0806	40	55	2200~2600	450~650	8	0.05~0.15	側銑 SIDE MILLING
X-UVT0806	60	60	2200~2600	300~500	0.05~0.1	6~8	溝銑 SLOTTING
X-UVT0806	60	60	2200~2600	350~500	8	0.05~0.1	側銑 SIDE MILLING
X-UVT1006	30	95	2800~3200	1000~1200	0.1~0.2	8~10	溝銑 SLOTTING
X-UVT1006	30	95	2800~3200	800~1000	0.05~0.1	8~10	溝銑 SLOTTING
X-UVT1006	30	95	2800~3200	900~1300	10	0.3~0.5	側銑 SIDE MILLING
X-UVT1006	30	95	2800~3200	500~700	10	0.05~0.15	側銑 SIDE MILLING
X-UVT1006	50	75	2200~2600	600~800	0.05~0.1	8~10	溝銑 SLOTTING
X-UVT1006	50	75	2200~2600	450~650	10	0.05~0.15	側銑 SIDE MILLING
X-UVT1006	70	60	1800~2200	300~500	0.05~0.1	8~10	溝銑 SLOTTING
X-UVT1006	70	60	1800~2200	350~550	10	0.05~0.1	側銑 SIDE MILLING
X-UVT1206	35	100	2400~2800	800~1000	0.1~0.2	10~12	溝銑 SLOTTING
X-UVT1206	35	135	3400~3800	600~800	0.05~0.1	10~12	溝銑 SLOTTING
X-UVT1206	35	115	2800~3200	800~1200	12	0.3~0.5	側銑 SIDE MILLING
X-UVT1206	35	115	2800~3200	600~800	12	0.05~0.15	側銑 SIDE MILLING
X-UVT1206	55	115	2800~3200	400~600	0.05~0.1	10~12	溝銑 SLOTTING
X-UVT1206	55	80	2000~2400	400~600	12	0.05~0.15	側銑 SIDE MILLING
X-UVT1206	80	80	2000~2400	300~500	0.05~0.1	10~12	溝銑 SLOTTING
X-UVT1206	80	75	1800~2200	350~450	12	0.05~0.1	側銑 SIDE MILLING
X-UVT1606	50	110	2000~2400	700~1000	0.1~0.2	14~16	溝銑 SLOTTING
X-UVT1606	50	120	2200~2600	600~800	0.05~0.15	14~16	溝銑 SLOTTING
X-UVT1606	50	100	1800~2200	900~1300	16	0.3~0.5	側銑 SIDE MILLING
X-UVT1606	50	100	1800~2200	450~650	16	0.05~0.2	側銑 SIDE MILLING
X-UVT1606	70	100	1800~2200	400~600	0.05~0.1	14~16	溝銑 SLOTTING
X-UVT1606	70	70	1200~1600	300~450	16	0.05~0.15	側銑 SIDE MILLING
X-UVT1606	100	80	1400~1800	300~500	0.05~0.1	14~16	溝銑 SLOTTING
X-UVT1606	100	50	800~1100	250~400	16	0.05~0.1	側銑 SIDE MILLING
X-UVT2006	50	110	1600~1900	700~1000	0.15~0.25	18~20	溝銑 SLOTTING
X-UVT2006	50	120	1800~2100	600~800	0.05~0.15	18~20	溝銑 SLOTTING
X-UVT2006	50	100	1400~1800	600~900	20	0.4~0.6	側銑 SIDE MILLING
X-UVT2006	50	100	1400~1800	400~600	20	0.05~0.2	側銑 SIDE MILLING
X-UVT2006	80	110	1600~1900	400~600	0.05~0.15	18~20	溝銑 SLOTTING
X-UVT2006	80	70	1000~1400	300~450	20	0.05~0.2	側銑 SIDE MILLING
X-UVT2006	110	80	1100~1500	300~500	0.05~0.1	18~20	溝銑 SLOTTING
X-UVT2006	110	50	600~1000	250~350	20	0.1~0.15	側銑 SIDE MILLING

被切削材 Work Material		調質鋼/預硬鋼 Prehardened Steels : NAK80 : 1.2083 : AISI420 : M310 (HRC36~45)					
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 ⁻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-UVT2506	70	110	1200~1600	600~900	0.15~0.25	23~25	溝銼 SLOTTING
X-UVT2506	70	120	1300~1700	500~700	0.05~0.15	23~25	溝銼 SLOTTING
X-UVT2506	70	100	1100~1500	600~900	25	0.4~0.6	側銼 SIDE MILLING
X-UVT2506	70	100	1100~1500	400~600	25	0.05~0.2	側銼 SIDE MILLING
X-UVT2506	100	110	1200~1600	400~600	0.05~0.15	23~25	溝銼 SLOTTING
X-UVT2506	100	70	800~1200	300~400	25	0.05~0.2	側銼 SIDE MILLING
X-UVT2506	130	80	800~1200	300~500	0.05~0.1	23~25	溝銼 SLOTTING
X-UVT2506	130	60	600~900	250~400	25	0.1~0.15	側銼 SIDE MILLING
X-UVT3206	80	110	900~1300	500~700	0.15~0.25	25~32	溝銼 SLOTTING
X-UVT3206	80	120	1000~1400	300~500	0.05~0.15	25~32	溝銼 SLOTTING
X-UVT3206	80	100	800~1200	500~700	32	0.4~0.6	側銼 SIDE MILLING
X-UVT3206	80	100	800~1200	300~480	32	0.05~0.2	側銼 SIDE MILLING
X-UVT3206	110	110	900~1300	300~500	0.05~0.15	25~32	溝銼 SLOTTING
X-UVT3206	110	70	600~800	240~380	32	0.05~0.2	側銼 SIDE MILLING
X-UVT3206	150	80	700~900	300~400	0.05~0.1	25~32	溝銼 SLOTTING
X-UVT3206	150	60	500~700	180~280	32	0.1~0.15	側銼 SIDE MILLING

被切削材 Work Material		熱處理鋼 Hardened Steels SKD61/ STAVAX / 17-4PH : 1.2083 / 1.2344 / 1.4542 : H13 / 420 (HRC48~54)					
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 ⁻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-UVT0806	25	95	3600~4000	1000~1400	0.1~0.2	6~8	溝銼 SLOTTING
X-UVT0806	25	95	3600~4000	800~1000	0.05~0.1	6~8	溝銼 SLOTTING
X-UVT0806	25	70	2600~3000	1000~1400	8	0.2~0.4	側銼 SIDE MILLING
X-UVT0806	25	85	3300~3600	600~800	8	0.05~0.15	側銼 SIDE MILLING
X-UVT0806	40	80	3000~3400	500~700	0.05~0.1	6~8	溝銼 SLOTTING
X-UVT0806	40	55	2200~2600	450~650	8	0.05~0.15	側銼 SIDE MILLING
X-UVT0806	60	60	2200~2600	300~500	0.05~0.1	6~8	溝銼 SLOTTING
X-UVT0806	60	60	2200~2600	350~500	8	0.05~0.1	側銼 SIDE MILLING
X-UVT1006	30	95	2800~3200	1000~1200	0.1~0.2	8~10	溝銼 SLOTTING
X-UVT1006	30	95	2800~3200	800~1000	0.05~0.1	8~10	溝銼 SLOTTING
X-UVT1006	30	95	2800~3200	900~1300	10	0.3~0.5	側銼 SIDE MILLING
X-UVT1006	30	95	2800~3200	500~700	10	0.05~0.15	側銼 SIDE MILLING
X-UVT1006	50	75	2200~2600	600~800	0.05~0.1	8~10	溝銼 SLOTTING
X-UVT1006	50	75	2200~2600	450~650	10	0.05~0.15	側銼 SIDE MILLING
X-UVT1006	70	60	1800~2200	300~500	0.05~0.1	8~10	溝銼 SLOTTING
X-UVT1006	70	60	1800~2200	350~550	10	0.05~0.1	側銼 SIDE MILLING

EXCHANGEABLE HEAD ENDMILL II



被切削材 Work Material		熱處理鋼 Hardened Steels					
		SKD61/ STAVAX / 17-4PH : 1.2083 / 1.2344 / 1.4542 : H13 / 420 (HRc48~54)					
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 ⁻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-UVT1206	35	100	2400~2800	800~1000	0.1~0.2	10~12	溝銑 SLOTTING
X-UVT1206	35	135	3400~3800	600~800	0.05~0.1	10~12	溝銑 SLOTTING
X-UVT1206	35	115	2800~3200	800~1200	12	0.3~0.5	側銑 SIDE MILLING
X-UVT1206	35	115	2800~3200	600~800	12	0.05~0.15	側銑 SIDE MILLING
X-UVT1206	55	115	2800~3200	400~600	0.05~0.1	10~12	溝銑 SLOTTING
X-UVT1206	55	80	2000~2400	400~600	12	0.05~0.15	側銑 SIDE MILLING
X-UVT1206	80	80	2000~2400	300~500	0.05~0.1	10~12	溝銑 SLOTTING
X-UVT1206	80	75	1800~2200	350~450	12	0.05~0.1	側銑 SIDE MILLING
X-UVT1606	50	110	2000~2400	700~1000	0.1~0.2	14~16	溝銑 SLOTTING
X-UVT1606	50	120	2200~2600	600~800	0.05~0.15	14~16	溝銑 SLOTTING
X-UVT1606	50	100	1800~2200	900~1300	16	0.3~0.5	側銑 SIDE MILLING
X-UVT1606	50	100	1800~2200	450~650	16	0.05~0.2	側銑 SIDE MILLING
X-UVT1606	70	100	1800~2200	400~600	0.05~0.1	14~16	溝銑 SLOTTING
X-UVT1606	70	70	1200~1600	300~450	16	0.05~0.15	側銑 SIDE MILLING
X-UVT1606	100	80	1400~1800	300~500	0.05~0.1	14~16	溝銑 SLOTTING
X-UVT1606	100	50	800~1100	250~400	16	0.05~0.1	側銑 SIDE MILLING
X-UVT2006	50	110	1600~1900	700~1000	0.15~0.25	18~20	溝銑 SLOTTING
X-UVT2006	50	120	1800~2100	600~800	0.05~0.15	18~20	溝銑 SLOTTING
X-UVT2006	50	100	1400~1800	600~900	20	0.4~0.6	側銑 SIDE MILLING
X-UVT2006	50	100	1400~1800	400~600	20	0.05~0.2	側銑 SIDE MILLING
X-UVT2006	80	110	1600~1900	400~600	0.05~0.15	18~20	溝銑 SLOTTING
X-UVT2006	80	70	1000~1400	300~450	20	0.05~0.2	側銑 SIDE MILLING
X-UVT2006	110	80	1100~1500	300~500	0.05~0.1	18~20	溝銑 SLOTTING
X-UVT2006	110	50	600~1000	250~350	20	0.1~0.15	側銑 SIDE MILLING
X-UVT2506	70	110	1200~1600	600~900	0.15~0.25	23~25	溝銑 SLOTTING
X-UVT2506	70	120	1300~1700	500~700	0.05~0.15	23~25	溝銑 SLOTTING
X-UVT2506	70	100	1100~1500	600~900	25	0.4~0.6	側銑 SIDE MILLING
X-UVT2506	70	100	1100~1500	400~600	25	0.05~0.2	側銑 SIDE MILLING
X-UVT2506	100	110	1200~1600	400~600	0.05~0.15	23~25	溝銑 SLOTTING
X-UVT2506	100	70	800~1200	300~400	25	0.05~0.2	側銑 SIDE MILLING
X-UVT2506	130	80	800~1200	300~500	0.05~0.1	23~25	溝銑 SLOTTING
X-UVT2506	130	60	600~900	250~400	25	0.1~0.15	側銑 SIDE MILLING
X-UVT3206	80	110	900~1300	500~700	0.15~0.25	25~32	溝銑 SLOTTING
X-UVT3206	80	120	1000~1400	300~500	0.05~0.15	25~32	溝銑 SLOTTING
X-UVT3206	80	100	800~1200	500~700	32	0.4~0.6	側銑 SIDE MILLING
X-UVT3206	80	100	800~1200	300~480	32	0.05~0.2	側銑 SIDE MILLING
X-UVT3206	110	110	900~1300	300~500	0.05~0.15	25~32	溝銑 SLOTTING
X-UVT3206	110	70	600~800	240~380	32	0.05~0.2	側銑 SIDE MILLING
X-UVT3206	150	80	700~900	300~400	0.05~0.1	25~32	溝銑 SLOTTING
X-UVT3206	150	60	500~700	180~280	32	0.1~0.15	側銑 SIDE MILLING