

切削條件表

X-UVTR

MILLING CONDITIONS

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-UVTR0805	25	115	4500~5000	1400~1600	0.2~0.3	6~8	溝銼 SLOTTING
X-UVTR0805	25	150	5500~6500	1000~1400	0.05~0.1	6~8	溝銼 SLOTTING
X-UVTR0805	25	65	2600~3000	1000~1400	8	0.2~0.3	側銼 SIDE MILLING
X-UVTR0805	25	85	3300~3600	600~800	8	0.05~0.15	側銼 SIDE MILLING
X-UVTR0805	25	150	5500~6000	2000~2400	0.2~0.3	0.2~0.3	3D銼 3D MILLING
X-UVTR0805	25	175	7000~8000	3000~3400	0.05~0.15	0.05~0.1	3D銼 3D MILLING
X-UVTR0805	40	130	5000~5500	800~1000	0.05~0.1	6~8	溝銼 SLOTTING
X-UVTR0805	40	55	2200~2600	400~600	8	0.05~0.15	側銼 SIDE MILLING
X-UVTR0805	40	140	5500~6300	2000~2400	0.05~0.1	0.05~0.1	3D銼 3D MILLING
X-UVTR0805	60	75	3000~3500	600~800	0.05~0.1	6~8	溝銼 SLOTTING
X-UVTR0805	60	75	3000~3500	1200~1600	0.05~0.1	0.05~0.1	3D銼 3D MILLING
X-UVTR0810	25	115	4500~5000	1400~1600	0.2~0.3	5~8	溝銼 SLOTTING
X-UVTR0810	25	150	5500~6500	1000~1400	0.05~0.1	5~8	溝銼 SLOTTING
X-UVTR0810	25	65	2600~3000	1000~1400	8	0.05~0.15	側銼 SIDE MILLING
X-UVTR0810	25	85	3300~3600	600~800	8	0.05~0.15	側銼 SIDE MILLING
X-UVTR0810	25	150	5500~6000	2000~2400	0.2~0.3	0.2~0.3	3D銼 3D MILLING
X-UVTR0810	25	175	7000~8000	3000~3400	0.05~0.15	0.05~0.1	3D銼 3D MILLING
X-UVTR0810	40	130	5000~5500	800~1000	0.05~0.1	5~8	溝銼 SLOTTING
X-UVTR0810	40	55	2200~2600	400~600	8	0.05~0.15	側銼 SIDE MILLING
X-UVTR0810	40	140	5500~6300	2000~2400	0.05~0.1	0.05~0.1	3D銼 3D MILLING
X-UVTR0810	60	75	3000~3500	600~800	0.05~0.1	5.5	溝銼 SLOTTING
X-UVTR0810	60	75	3000~3500	1200~1600	0.05~0.1	0.05~0.1	3D銼 3D MILLING
X-UVTR1005	35	135	4300~4800	1400~1800	0.2~0.3	8~10	溝銼 SLOTTING
X-UVTR1005	35	140	4200~4700	800~1200	0.05~0.15	8~10	溝銼 SLOTTING
X-UVTR1005	35	100	3200~3600	1000~1400	10	0.3~0.5	側銼 SIDE MILLING
X-UVTR1005	35	120	3800~4200	600~800	10	0.05~0.15	側銼 SIDE MILLING
X-UVTR1005	35	145	4500~5000	1800~2200	0.2~0.3	0.2~0.3	3D銼 3D MILLING
X-UVTR1005	35	190	6000~7000	2800~3200	0.05~0.15	0.05~0.15	3D銼 3D MILLING
X-UVTR1005	50	125	4000~4500	800~1000	0.05~0.15	8~10	溝銼 SLOTTING
X-UVTR1005	50	65	2000~2400	400~600	10	0.05~0.15	側銼 SIDE MILLING
X-UVTR1005	50	125	4000~4500	1400~1800	0.05~0.15	0.05~0.15	3D銼 3D MILLING
X-UVTR1005	70	60	1800~2200	400~600	0.05~0.15	8~10	溝銼 SLOTTING
X-UVTR1005	70	50	1600~2000	1000~1400	0.05~0.15	0.05~0.15	3D銼 3D MILLING
X-UVTR1010	35	135	4300~4800	1400~1800	0.2~0.3	7~10	溝銼 SLOTTING
X-UVTR1010	35	140	4200~4700	800~1200	0.05~0.15	7~10	溝銼 SLOTTING
X-UVTR1010	35	100	3200~3600	1000~1400	10	0.3~0.5	側銼 SIDE MILLING
X-UVTR1010	35	120	3800~4200	600~800	10	0.05~0.15	側銼 SIDE MILLING
X-UVTR1010	35	145	4500~5000	1800~2200	0.2~0.3	0.2~0.3	3D銼 3D MILLING
X-UVTR1010	35	190	6000~7000	2800~3200	0.05~0.15	0.05~0.15	3D銼 3D MILLING
X-UVTR1010	50	115	3600~4000	800~1000	0.05~0.15	7~10	溝銼 SLOTTING

EXCHANGEABLE HEAD ENDMILL II



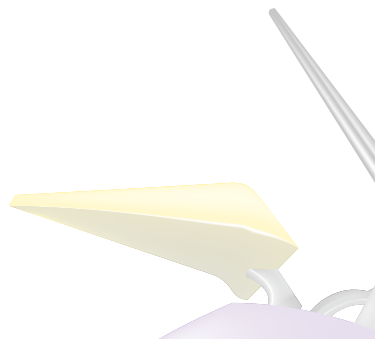
被切削材 Work Material		熱處理鋼 Hardened Steels					
		SKD61/ STAVAX / 17-4PH : 1.2083 / 1.2344 / 1.4542 : H13 / 420 (HRC48~54)					
冷卻方式 Coolant Type		乾式/油霧切削 Dry/MQL coolant					
型號 Type No.	刀具伸長量 Extension Length (mm)	切削速度 Cutting Speed (m/min)	迴轉速度 Speed (min ⁻¹)	進給速度 Feed (mm/min)	加工深度 (A _p) Depth of Cut	加工寬度 (A _p) Width of Cut	加工方式 Milling Type
X-UVTR1010	50	65	2000~2400	400~600	10	0.05~0.15	側銑 SIDE MILLING
X-UVTR1010	50	125	4000~4500	1400~1800	0.05~0.15	0.05~0.15	3D銑 3D MILLING
X-UVTR1010	70	60	1800~2200	400~600	0.05~0.15	7~10	溝銑 SLOTTING
X-UVTR1010	70	50	1600~2000	1000~1400	0.05~0.15	0.05~0.15	3D銑 3D MILLING
X-UVTR1205	40	105	2700~3200	1000~1400	0.2~0.3	9~12	溝銑 SLOTTING
X-UVTR1205	40	170	4500~5000	800~1000	0.05~0.15	10~12	溝銑 SLOTTING
X-UVTR1205	40	115	3000~3400	1000~1400	12	0.3~0.5	側銑 SIDE MILLING
X-UVTR1205	40	115	3000~3400	600~800	12	0.05~0.15	側銑 SIDE MILLING
X-UVTR1205	40	105	2700~3200	1000~1400	0.2~0.3	0.2~0.3	3D銑 3D MILLING
X-UVTR1205	40	180	4700~5200	2200~2600	0.05~0.15	0.05~0.15	3D銑 3D MILLING
X-UVTR1205	60	115	3000~3400	600~800	0.05~0.15	10~12	溝銑 SLOTTING
X-UVTR1205	60	75	2000~2400	400~600	12	0.05~0.15	側銑 SIDE MILLING
X-UVTR1205	60	150	4000~4500	1400~1800	0.05~0.15	0.05~0.15	3D銑 3D MILLING
X-UVTR1205	100	75	2000~2400	400~600	0.05~0.15	10~12	溝銑 SLOTTING
X-UVTR1205	100	65	1700~2200	800~1200	0.05~0.15	0.05~0.15	3D銑 3D MILLING
X-UVTR1210	40	105	2700~3200	1000~1400	0.2~0.3	9~12	溝銑 SLOTTING
X-UVTR1210	40	170	4500~5000	800~1000	0.05~0.15	9~12	溝銑 SLOTTING
X-UVTR1210	40	115	3000~3400	1000~1400	12	0.3~0.5	側銑 SIDE MILLING
X-UVTR1210	40	115	3000~3400	600~800	12	0.05~0.15	側銑 SIDE MILLING
X-UVTR1210	40	105	2700~3200	1000~1400	0.2~0.3	0.2~0.3	3D銑 3D MILLING
X-UVTR1210	40	180	4700~5200	2200~2600	0.05~0.15	0.05~0.15	3D銑 3D MILLING
X-UVTR1210	60	115	3000~3400	600~800	0.05~0.15	9~12	溝銑 SLOTTING
X-UVTR1210	60	75	2000~2400	400~600	12	0.05~0.15	側銑 SIDE MILLING
X-UVTR1210	60	150	4000~4500	1400~1800	0.05~0.15	0.05~0.15	3D銑 3D MILLING
X-UVTR1210	100	75	2000~2400	400~600	0.05~0.15	9~12	溝銑 SLOTTING
X-UVTR1210	100	65	1700~2200	800~1200	0.05~0.15	0.05~0.15	3D銑 3D MILLING
X-UVTR1605	60	100	2000~2500	500~700	0.25~0.35	14~16	溝銑 SLOTTING
X-UVTR1605	60	185	3700~4200	1000~1200	0.05~0.15	14~16	溝銑 SLOTTING
X-UVTR1605	60	90	1800~2200	1000~1400	16	0.3~0.5	側銑 SIDE MILLING
X-UVTR1605	60	90	1800~2200	500~700	16	0.05~0.2	側銑 SIDE MILLING
X-UVTR1605	60	135	2700~3200	1600~2000	0.25~0.35	0.25~0.35	3D銑 3D MILLING
X-UVTR1605	60	185	3700~4200	1800~2200	0.05~0.2	0.05~0.2	3D銑 3D MILLING
X-UVTR1605	100	120	2400~2800	600~800	0.05~0.15	14~16	溝銑 SLOTTING
X-UVTR1605	100	50	1000~1400	300~500	16	0.05~0.2	側銑 SIDE MILLING
X-UVTR1605	100	100	2000~2400	800~1200	0.05~0.2	0.05~0.2	3D銑 3D MILLING
X-UVTR1605	130	170	3400~3600	400~600	0.05~0.15	14~16	溝銑 SLOTTING
X-UVTR1605	130	80	1600~2000	600~800	0.05~0.2	0.05~0.2	3D銑 3D MILLING
X-UVTR1610	60	100	2000~2500	500~700	0.25~0.35	13~16	溝銑 SLOTTING
X-UVTR1610	60	185	3700~4200	1000~1200	0.05~0.15	13~16	溝銑 SLOTTING
X-UVTR1610	60	90	1800~2200	1000~1400	16	0.3~0.5	側銑 SIDE 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/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 (A _s) Depth of Cut	加工寬度 (A _p) Width of Cut		
X-UVTR1610	60	90	1800~2200	500~700	16	0.05~0.2	側銑 SIDE MILLING	
X-UVTR1610	60	135	2700~3200	1600~2000	0.25~0.35	0.25~0.35	3D銑 3D MILLING	
X-UVTR1610	60	185	3700~4200	1800~2200	0.05~0.2	0.05~0.2	3D銑 3D MILLING	
X-UVTR1610	100	120	2400~2800	600~800	0.05~0.15	13~16	溝銑 SLOTTING	
X-UVTR1610	100	50	1000~1400	300~500	16	0.05~0.2	側銑 SIDE MILLING	
X-UVTR1610	100	100	2000~2400	800~1200	0.05~0.2	0.05~0.2	3D銑 3D MILLING	
X-UVTR1610	130	170	3400~3600	400~600	0.05~0.15	13~16	溝銑 SLOTTING	
X-UVTR1610	130	80	1600~2000	600~800	0.05~0.2	0.05~0.2	3D銑 3D MILLING	
X-UVTR1620	60	100	2000~2500	500~700	0.25~0.35	11~16	溝銑 SLOTTING	
X-UVTR1620	60	185	3700~4200	1000~1200	0.05~0.15	11~16	溝銑 SLOTTING	
X-UVTR1620	60	90	1800~2200	1000~1400	16	0.3~0.5	側銑 SIDE MILLING	
X-UVTR1620	60	90	1800~2200	500~700	16	0.05~0.2	側銑 SIDE MILLING	
X-UVTR1620	60	135	2700~3200	1600~2000	0.25~0.35	0.25~0.35	3D銑 3D MILLING	
X-UVTR1620	60	185	3700~4200	1800~2200	0.05~0.2	0.05~0.2	3D銑 3D MILLING	
X-UVTR1620	100	120	2400~2800	600~800	0.05~0.15	11~16	溝銑 SLOTTING	
X-UVTR1620	100	50	1000~1400	300~500	16	0.05~0.2	側銑 SIDE MILLING	
X-UVTR1620	100	100	2000~2400	800~1200	0.05~0.2	0.05~0.2	3D銑 3D MILLING	
X-UVTR1620	130	170	3400~3600	400~600	0.05~0.15	11~16	溝銑 SLOTTING	
X-UVTR1620	130	80	1600~2000	600~800	0.05~0.2	0.05~0.2	3D銑 3D MILLING	
X-UVTR2010	80	100	1600~2000	400~600	0.3~0.4	17~20	溝銑 SLOTTING	
X-UVTR2010	80	200	3000~3500	800~1200	0.05~0.2	17~20	溝銑 SLOTTING	
X-UVTR2010	80	50	800~1000	400~600	20	0.5~0.6	側銑 SIDE MILLING	
X-UVTR2010	80	50	800~1100	300~500	20	0.05~0.2	側銑 SIDE MILLING	
X-UVTR2010	80	115	1800~2200	800~1200	0.3~0.4	0.3~0.4	3D銑 3D MILLING	
X-UVTR2010	80	285	4500~5000	1600~2000	0.05~0.2	0.05~0.2	3D銑 3D MILLING	
X-UVTR2010	130	190	3000~3500	600~800	0.05~0.2	17~20	溝銑 SLOTTING	
X-UVTR2010	130	170	2700~3200	1000~1400	0.05~0.2	0.05~0.2	3D銑 3D MILLING	
X-UVTR2010	180	135	2100~2300	400~600	0.05~0.2	17~20	溝銑 SLOTTING	
X-UVTR2010	180	125	2000~2400	600~800	0.05~0.2	0.05~0.2	3D銑 3D MILLING	
X-UVTR2020	80	100	1600~2000	400~600	0.3~0.4	15~20	溝銑 SLOTTING	
X-UVTR2020	80	200	3000~3500	800~1200	0.05~0.2	15~20	溝銑 SLOTTING	
X-UVTR2020	80	50	800~1000	400~600	20	0.5~0.6	側銑 SIDE MILLING	
X-UVTR2020	80	50	800~1100	400~600	20	0.05~0.2	側銑 SIDE MILLING	
X-UVTR2020	80	115	1800~2200	800~1200	0.3~0.4	0.3~0.4	3D銑 3D MILLING	
X-UVTR2020	80	285	4500~5000	1600~2000	0.05~0.2	0.05~0.2	3D銑 3D MILLING	
X-UVTR2020	130	190	3000~3500	600~800	0.05~0.2	15~20	溝銑 SLOTTING	
X-UVTR2020	130	170	2700~3200	1000~1400	0.05~0.2	0.05~0.2	3D銑 3D MILLING	
X-UVTR2020	180	135	2100~2300	400~600	0.05~0.2	15~20	溝銑 SLOTTING	
X-UVTR2020	180	125	2000~2400	600~800	0.05~0.2	0.05~0.2	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 ⁻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-UVTR2030	80	100	1600~2000	400~600	0.3~0.4	13~20	溝銑 SLOTTING
X-UVTR2030	80	200	3000~3500	800~1200	0.05~0.2	13~20	溝銑 SLOTTING
X-UVTR2030	80	50	800~1000	400~600	20	0.5~0.6	側銑 SIDE MILLING
X-UVTR2030	80	50	800~1100	300~500	20	0.05~0.2	側銑 SIDE MILLING
X-UVTR2030	80	115	1800~2200	800~1200	0.3~0.4	0.3~0.4	3D銑 3D MILLING
X-UVTR2030	80	285	4500~5000	1600~2000	0.05~0.2	0.05~0.2	3D銑 3D MILLING
X-UVTR2030	130	190	3000~3500	600~800	0.05~0.2	13~20	溝銑 SLOTTING
X-UVTR2030	130	170	2700~3200	1000~1400	0.05~0.2	0.05~0.2	3D銑 3D MILLING
X-UVTR2030	180	135	2100~2300	400~600	0.05~0.2	13.5	溝銑 SLOTTING
X-UVTR2030	180	125	2000~2400	600~800	0.05~0.2	0.05~0.2	3D銑 3D MILLING
X-UVTR2530	90	100	1100~1500	300~500	0.3~0.4	13~25	溝銑 SLOTTING
X-UVTR2530	90	200	2500~3000	700~1100	0.05~0.25	18~25	溝銑 SLOTTING
X-UVTR2530	90	50	600~800	180~280	25	0.5~0.6	側銑 SIDE MILLING
X-UVTR2530	90	50	600~800	180~280	25	0.05~0.2	側銑 SIDE MILLING
X-UVTR2530	90	115	1300~1700	600~1000	0.3~0.4	0.3~0.4	3D銑 3D MILLING
X-UVTR2530	90	215	2700~3200	1000~1400	0.05~0.25	0.05~0.25	3D銑 3D MILLING
X-UVTR2530	140	160	2000~2400	600~1000	0.05~0.25	18~25	溝銑 SLOTTING
X-UVTR2530	140	165	2100~2500	800~1200	0.05~0.25	0.05~0.25	3D銑 3D MILLING
X-UVTR2530	200	90	1100~1500	500~800	0.05~0.25	18~25	溝銑 SLOTTING
X-UVTR2530	200	95	1200~1600	600~900	0.05~0.25	0.05~0.25	3D銑 3D MILLING
X-UVTR2550	90	100	1100~1500	300~500	0.3~0.4	13~25	溝銑 SLOTTING
X-UVTR2550	90	200	2500~3000	700~1100	0.05~0.25	13~25	溝銑 SLOTTING
X-UVTR2550	90	50	600~800	180~280	25	0.5~0.6	側銑 SIDE MILLING
X-UVTR2550	90	50	600~800	180~280	25	0.05~0.2	側銑 SIDE MILLING
X-UVTR2550	90	115	1300~1700	600~1000	0.3~0.4	0.3~0.4	3D銑 3D MILLING
X-UVTR2550	90	215	2700~3200	1000~1400	0.05~0.25	0.05~0.25	3D銑 3D MILLING
X-UVTR2550	140	160	2000~2400	600~1000	0.05~0.25	13~25	溝銑 SLOTTING
X-UVTR2550	140	165	2100~2500	800~1200	0.05~0.25	0.05~0.25	3D銑 3D MILLING
X-UVTR2550	200	90	1100~1500	500~800	0.05~0.25	13~25	溝銑 SLOTTING
X-UVTR2550	200	95	1200~1600	600~900	0.05~0.25	0.05~0.25	3D銑 3D MILLING



切削條件表

X-UVTR

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 ⁻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	加工方式 Milling Type
X-UVTR0805	25	115	4500~5500	800~1000	0.05~0.1	4~6	溝銑 SLOTTING
X-UVTR0805	25	70	2800~3300	400~600	8	0.05~0.1	側銑 SIDE MILLING
X-UVTR0805	25	115	4500~5500	1800~2200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UVTR0805	40	95	3700~4200	500~700	0.05~0.1	4~6	溝銑 SLOTTING
X-UVTR0805	40	40	1600~2000	300~500	8	0.05~0.1	側銑 SIDE MILLING
X-UVTR0805	40	85	3300~3800	1200~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UVTR0805	60	70	2700~3200	300~500	0.05~0.1	4~6	溝銑 SLOTTING
X-UVTR0805	60	70	2700~3200	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UVTR0810	25	115	4500~5500	800~1000	0.05~0.1	4~6	溝銑 SLOTTING
X-UVTR0810	25	70	2800~3300	400~600	8	0.05~0.1	側銑 SIDE MILLING
X-UVTR0810	25	115	4500~5500	1800~2200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UVTR0810	40	95	3700~4200	500~700	0.05~0.1	4~6	溝銑 SLOTTING
X-UVTR0810	40	40	1600~2000	300~500	8	0.05~0.1	側銑 SIDE MILLING
X-UVTR0810	40	85	3300~3800	1200~1600	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UVTR0810	60	70	2700~3200	300~500	0.05~0.1	4~6	溝銑 SLOTTING
X-UVTR0810	60	70	2700~3200	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UVTR1005	35	95	3000~4000	500~700	0.05~0.1	6~8	溝銑 SLOTTING
X-UVTR1005	35	85	2600~3000	400~600	10	0.05~0.1	側銑 SIDE MILLING
X-UVTR1005	35	95	3000~4000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UVTR1005	50	85	2700~3200	400~600	0.05~0.1	6~8	溝銑 SLOTTING
X-UVTR1005	50	50	1600~2000	300~500	10	0.05~0.1	側銑 SIDE MILLING
X-UVTR1005	50	80	2500~3000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UVTR1005	70	55	1700~2200	300~500	0.05~0.1	6~8	溝銑 SLOTTING
X-UVTR1005	70	55	1700~2200	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UVTR1010	35	95	3000~4000	500~700	0.05~0.11	5~7	溝銑 SLOTTING
X-UVTR1010	35	85	2600~3000	400~600	10	0.05~0.11	側銑 SIDE MILLING
X-UVTR1010	35	95	3000~4000	1000~1400	0.05~0.11	0.05~0.11	3D銑 3D MILLING
X-UVTR1010	50	85	2700~3200	400~600	0.05~0.1	5~7	溝銑 SLOTTING
X-UVTR1010	50	50	1600~2000	300~500	10	0.05~0.1	側銑 SIDE MILLING
X-UVTR1010	50	80	2500~3000	1000~1400	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UVTR1010	70	55	1700~2200	300~500	0.05~0.1	5~7	溝銑 SLOTTING
X-UVTR1010	70	55	1700~2200	800~1200	0.05~0.1	0.05~0.1	3D銑 3D MILLING
X-UVTR1205	40	105	2700~3200	500~700	0.05~0.15	8~10	溝銑 SLOTTING
X-UVTR1205	40	75	2000~2400	400~600	12	0.05~0.15	側銑 SIDE MILLING
X-UVTR1205	40	105	2700~3200	1000~1400	0.05~0.15	0.05~0.15	3D銑 3D MILLING
X-UVTR1205	60	90	2300~2800	400~600	0.05~0.15	8~10	溝銑 SLOTTING
X-UVTR1205	60	55	1400~1800	300~500	12	0.05~0.15	側銑 SIDE MILLING
X-UVTR1205	60	90	2300~2800	800~1200	0.05~0.15	0.05~0.15	3D銑 3D MILLING
X-UVTR1205	100	65	1700~2200	300~500	0.05~0.15	8~10	溝銑 SLOTTING
X-UVTR1205	100	65	1700~2200	600~800	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 ⁻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-UVTR1210	40	105	2700~3200	500~700	0.05~0.15	7~9	溝銑 SLOTTING
X-UVTR1210	40	75	2000~2400	400~600	12	0.05~0.15	側銑 SIDE MILLING
X-UVTR1210	40	105	2700~3200	1000~1400	0.05~0.15	0.05~0.15	3D銑 3D MILLING
X-UVTR1210	60	90	2300~2800	400~600	0.05~0.15	7~9	溝銑 SLOTTING
X-UVTR1210	60	55	1400~1800	300~500	12	0.05~0.15	側銑 SIDE MILLING
X-UVTR1210	60	90	2300~2800	800~1200	0.05~0.15	0.05~0.15	3D銑 3D MILLING
X-UVTR1210	100	65	1700~2200	300~500	0.05~0.15	7~9	溝銑 SLOTTING
X-UVTR1210	100	65	1700~2200	600~800	0.05~0.15	0.05~0.15	3D銑 3D MILLING
X-UVTR1605	60	120	2400~2800	600~800	0.05~0.15	12~14	溝銑 SLOTTING
X-UVTR1605	60	70	1400~1800	400~600	16	0.05~0.15	側銑 SIDE MILLING
X-UVTR1605	60	100	2000~2400	800~1200	0.05~0.15	0.05~0.15	3D銑 3D MILLING
X-UVTR1605	100	100	2000~2400	500~700	0.05~0.15	12~14	溝銑 SLOTTING
X-UVTR1605	100	40	800~1100	200~400	16	0.05~0.15	側銑 SIDE MILLING
X-UVTR1605	100	90	1800~2200	600~800	0.05~0.15	0.05~0.15	3D銑 3D MILLING
X-UVTR1605	130	80	1600~2000	300~500	0.05~0.15	12~14	溝銑 SLOTTING
X-UVTR1605	130	70	1400~1800	300~500	0.05~0.15	0.05~0.15	3D銑 3D MILLING
X-UVTR1610	60	120	2400~2800	600~800	0.05~0.15	11~13	溝銑 SLOTTING
X-UVTR1610	60	70	1400~1800	400~600	16	0.05~0.15	側銑 SIDE MILLING
X-UVTR1610	60	100	2000~2400	800~1200	0.05~0.15	0.05~0.15	3D銑 3D MILLING
X-UVTR1610	100	100	2000~2400	500~700	0.05~0.15	11~13	溝銑 SLOTTING
X-UVTR1610	100	40	800~1100	200~400	16	0.05~0.15	側銑 SIDE MILLING
X-UVTR1610	100	90	1800~2200	600~800	0.05~0.15	0.05~0.15	3D銑 3D MILLING
X-UVTR1610	130	80	1600~2000	300~500	0.05~0.15	11~13	溝銑 SLOTTING
X-UVTR1610	130	70	1400~1800	300~500	0.05~0.15	0.05~0.15	3D銑 3D MILLING
X-UVTR1620	60	120	2400~2800	600~800	0.05~0.15	9~11	溝銑 SLOTTING
X-UVTR1620	60	70	1400~1800	400~600	16	0.05~0.15	側銑 SIDE MILLING
X-UVTR1620	60	100	2000~2400	800~1200	0.05~0.15	0.05~0.15	3D銑 3D MILLING
X-UVTR1620	100	100	2000~2400	500~700	0.05~0.15	9~11	溝銑 SLOTTING
X-UVTR1620	100	40	800~1100	200~400	16	0.05~0.15	側銑 SIDE MILLING
X-UVTR1620	100	90	1800~2200	600~800	0.05~0.15	0.05~0.15	3D銑 3D MILLING
X-UVTR1620	130	80	1600~2000	300~500	0.05~0.15	9~11	溝銑 SLOTTING
X-UVTR1620	130	70	1400~1800	300~500	0.05~0.15	0.05~0.15	3D銑 3D MILLING
X-UVTR2010	80	150	2400~2800	600~800	0.05~0.15	15~17	溝銑 SLOTTING
X-UVTR2010	80	50	800~1000	150~300	20	0.05~0.15	側銑 SIDE MILLING
X-UVTR2010	80	150	2400~2800	600~1000	0.05~0.15	0.05~0.15	3D銑 3D MILLING
X-UVTR2010	130	125	2000~2400	400~600	0.05~0.15	15~17	溝銑 SLOTTING
X-UVTR2010	130	125	2000~2400	600~800	0.05~0.15	0.05~0.15	3D銑 3D MILLING
X-UVTR2010	180	90	1400~1800	300~500	0.05~0.15	15~17	溝銑 SLOTTING
X-UVTR2010	180	90	1400~1800	400~600	0.05~0.15	0.05~0.15	3D銑 3D MILLING
X-UVTR2020	80	150	2400~2800	600~800	0.05~0.15	13~15	溝銑 SLOTTING

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 ⁻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-UVTR2020	80	50	800~1000	150~300	20	0.05~0.15	側銑 SIDE MILLING
X-UVTR2020	80	150	2400~2800	600~1000	0.05~0.15	0.05~0.15	3D銑 3D MILLING
X-UVTR2020	130	125	2000~2400	400~600	0.05~0.15	13~15	溝銑 SLOTTING
X-UVTR2020	130	125	2000~2400	600~800	0.05~0.15	0.05~0.15	3D銑 3D MILLING
X-UVTR2020	180	90	1400~1800	300~500	0.05~0.15	13~15	溝銑 SLOTTING
X-UVTR2020	180	90	1400~1800	400~600	0.05~0.15	0.05~0.15	3D銑 3D MILLING
X-UVTR2030	80	150	2400~2800	600~800	0.05~0.15	11~13	溝銑 SLOTTING
X-UVTR2030	80	50	800~1000	150~300	20	0.05~0.15	側銑 SIDE MILLING
X-UVTR2030	80	150	2400~2800	600~1000	0.05~0.15	0.05~0.15	3D銑 3D MILLING
X-UVTR2030	130	125	2000~2400	400~600	0.05~0.15	11~13	溝銑 SLOTTING
X-UVTR2030	130	125	2000~2400	600~800	0.05~0.15	0.05~0.15	3D銑 3D MILLING
X-UVTR2030	180	90	1400~1800	300~500	0.05~0.15	11~13	溝銑 SLOTTING
X-UVTR2030	180	90	1400~1800	400~600	0.05~0.15	0.05~0.15	3D銑 3D MILLING
X-UVTR2530	90	160	2000~2400	600~800	0.05~0.2	16~18	溝銑 SLOTTING
X-UVTR2530	90	45	500~700	160~260	25	0.05~0.15	側銑 SIDE MILLING
X-UVTR2530	90	160	2000~2400	700~1000	0.05~0.2	0.05~0.2	3D銑 3D MILLING
X-UVTR2530	140	135	1700~2100	400~600	0.05~0.2	16~18	溝銑 SLOTTING
X-UVTR2530	140	135	1700~2100	600~900	0.05~0.2	0.05~0.2	3D銑 3D MILLING
X-UVTR2530	200	70	900~1300	300~500	0.05~0.2	16~18	溝銑 SLOTTING
X-UVTR2530	200	70	900~1300	400~700	0.05~0.2	0.05~0.2	3D銑 3D MILLING
X-UVTR2550	90	160	2000~2400	600~800	0.05~0.2	12~14	溝銑 SLOTTING
X-UVTR2550	90	45	500~700	160~260	25	0.05~0.15	側銑 SIDE MILLING
X-UVTR2550	90	160	2000~2400	700~1000	0.05~0.2	0.05~0.2	3D銑 3D MILLING
X-UVTR2550	140	135	1700~2100	400~600	0.05~0.2	12~14	溝銑 SLOTTING
X-UVTR2550	140	135	1700~2100	600~900	0.05~0.2	0.05~0.2	3D銑 3D MILLING
X-UVTR2550	200	70	900~1300	300~500	0.05~0.2	12~14	溝銑 SLOTTING
X-UVTR2550	200	70	900~1300	400~700	0.05~0.2	0.05~0.2	3D銑 3D MILLING

