

切削條件表

## Xs-UBT

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 <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
Xs-UBT0802	25	280	10000~11000	1800~2000	0.15~0.2	0.3~0.4	3D銑 3D MILLING
Xs-UBT0802	25	280	10000~11000	3000~3400	0.07~0.1	0.14~0.2	3D銑 3D MILLING
Xs-UBT0802	45	145	5400~5800	1600~2000	0.06~0.08	0.12~0.16	3D銑 3D MILLING
Xs-UBT0802	65	130	4700~5200	1200~1600	0.06~0.08	0.12~0.16	3D銑 3D MILLING
Xs-UBT1002	40	280	8700~9200	1600~2000	0.2~0.25	0.4~0.5	3D銑 3D MILLING
Xs-UBT1002	40	280	8700~9200	2600~3000	0.08~0.13	0.16~0.26	3D銑 3D MILLING
Xs-UBT1002	60	215	6700~7200	1600~2000	0.08~0.13	0.16~0.26	3D銑 3D MILLING
Xs-UBT1002	80	175	5500~6000	1000~1200	0.07~0.1	0.14~0.2	3D銑 3D MILLING
Xs-UBT1202	40	300	7800~8200	2200~2600	0.25~0.3	0.5~0.6	3D銑 3D MILLING
Xs-UBT1202	40	300	7800~8200	2600~3000	0.1~0.15	0.2~0.3	3D銑 3D MILLING
Xs-UBT1202	60	225	5800~6300	1200~1600	0.2~0.25	0.4~0.5	3D銑 3D MILLING
Xs-UBT1202	60	280	7200~7700	2000~2400	0.1~0.15	0.2~0.3	3D銑 3D MILLING
Xs-UBT1202	100	160	4000~4500	1100~1300	0.1~0.15	0.2~0.3	3D銑 3D MILLING
Xs-UBT1602	60	200	3800~4200	1600~2000	0.2~0.25	0.4~0.5	3D銑 3D MILLING
Xs-UBT1602	60	200	3800~4200	2000~2400	0.1~0.15	0.2~0.3	3D銑 3D MILLING
Xs-UBT1602	100	170	3200~3700	1400~1700	0.1~0.15	0.2~0.3	3D銑 3D MILLING
Xs-UBT1602	130	135	2500~3000	1000~1200	0.1~0.12	0.2~0.24	3D銑 3D MILLING
Xs-UBT2002	80	325	5000~5500	1400~1800	0.2~0.23	0.4~0.46	3D銑 3D MILLING
Xs-UBT2002	80	355	5500~6000	2000~2400	0.1~0.15	0.2~0.3	3D銑 3D MILLING
Xs-UBT2002	130	220	3200~3700	800~1000	0.2~0.23	0.4~0.46	3D銑 3D MILLING
Xs-UBT2002	130	315	4700~5200	1400~1800	0.1~0.15	0.2~0.3	3D銑 3D MILLING
Xs-UBT2002	180	140	1700~2200	800~1000	0.08~0.1	0.16~0.2	3D銑 3D MILLING
Xs-UBT2502	80	300	3200~3700	1000~1400	0.2~0.25	0.35~0.5	3D銑 3D MILLING
Xs-UBT2502	80	315	3500~4000	1300~1700	0.1~0.15	0.2~0.3	3D銑 3D MILLING
Xs-UBT2502	130	240	2500~3000	1000~1400	0.1~0.15	0.2~0.3	3D銑 3D MILLING
Xs-UBT2502	180	200	2000~2500	800~1200	0.1~0.15	0.2~0.3	3D銑 3D MILLING

附註  
Note

- 由於機器剛性及主軸扭力不同，加工時若有尖銳聲音，請調降轉速(S)及進給(F)。
- 使用BT50 (SK50/HSK100A) 刀把夾持之機器，可視情況調高轉速(S)及進給(F)。

- Due to spindle torque and the rigidity of machine differs, please lower the Speed(S) and Feed(F) if hearing sharp voices while milling.
- For the machine use with holder of BT50(SK50/HSK100A), please higher Speed(S) and Feed(F) according to the cutting condition.

## 切削條件表

# Xs-UBT

## 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 <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
Xs-UBT0802	25	210	7800~8300	2000~2400	0.07~0.1	0.14~0.2	3D銑 3D MILLING
Xs-UBT0802	45	125	4500~5000	1300~1700	0.05~0.08	0.1~0.16	3D銑 3D MILLING
Xs-UBT0802	65	90	3000~3500	700~900	0.05~0.08	0.1~0.16	3D銑 3D MILLING
Xs-UBT1002	40	155	4700~5200	1400~1800	0.1~0.13	0.2~0.26	3D銑 3D MILLING
Xs-UBT1002	60	125	3700~4200	1200~1600	0.08~0.1	0.16~0.2	3D銑 3D MILLING
Xs-UBT1002	80	45	1400~1700	600~800	0.08~0.1	0.16~0.2	3D銑 3D MILLING
Xs-UBT1202	40	240	6200~6700	1600~2000	0.1~0.13	0.2~0.26	3D銑 3D MILLING
Xs-UBT1202	60	185	4700~5200	800~1200	0.08~0.1	0.16~0.2	3D銑 3D MILLING
Xs-UBT1202	100	95	2200~2700	500~700	0.08~0.1	0.16~0.2	3D銑 3D MILLING
Xs-UBT1602	60	150	2700~3200	800~1200	0.1~0.15	0.15~0.25	3D銑 3D MILLING
Xs-UBT1602	100	90	1500~2000	800~1200	0.07~0.1	0.07~0.1	3D銑 3D MILLING
Xs-UBT1602	130	90	1500~2000	600~1000	0.07~0.1	0.07~0.1	3D銑 3D MILLING
Xs-UBT2002	80	110	1500~2000	800~1200	0.07~0.1	0.07~0.1	3D銑 3D MILLING
Xs-UBT2002	130	100	1500~1700	600~800	0.07~0.1	0.07~0.1	3D銑 3D MILLING
Xs-UBT2502	80	150	1800~2300	800~1200	0.1~0.15	0.2~0.3	3D銑 3D MILLING
Xs-UBT2502	130	120	1300~1700	700~1000	0.1~0.15	0.2~0.3	3D銑 3D MILLING
Xs-UBT2502	180	100	1100~1400	600~900	0.1~0.15	0.2~0.3	3D銑 3D MILLING

### 附註 Note

1. 由於機器剛性及主軸扭力不同，加工時若有尖銳聲音，請調降轉速(S)及進給(F)。
2. 使用BT50 (SK50/HSK100A) 刀把夾持之機器，可視情況調高轉速(S)及進給(F)。

1. Due to spindle torque and the rigidity of machine differs, please lower the Speed(S) and Feed(F) if hearing sharp voices while milling.
2. For the machine use with holder of BT50(SK50/HSK100A), please higher Speed(S) and Feed(F) according to the cutting condition.

