

DE 4T

切削條件表 MILLING CONDITIONS

| 被切削材 Work Material | | 碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron S50C / Fc250 / SS440 : 1.1210 / 0.6025 / 1.0036 : 1050 / N0.35 / A570 Gr.45 (~HRc22) | | | | | |
|--------------------|----------------------------|--|---------------------------------|--------------------|------------------------|------------------------|-------------------|
| 冷卻方式 Coolant Type | | 乾式切削 Dry coolant | | | | | |
| Type NO. | 刀具伸長量 Extension Length(mm) | 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 |
| DE0104 | 9 | 65 | 20000 | 1000~1300 | 0.03~0.05 | 1 | 溝銑 (Slotting) |
| DE0104 | 9 | 65 | 20000 | 500~700 | 0.05~0.1 | 1 | 溝銑 (Slotting) |
| DE0104 | 9 | 65 | 20000 | 500~800 | 1~2 | 0.03~0.05 | 側銑 (Side milling) |
| DE0104 | 9 | 65 | 20000 | 700~900 | 1~2 | 0.05~0.1 | 側銑 (Side milling) |
| DE0104 | 9 | 65 | 20000 | 500~700 | 1~2 | 0.15~0.2 | 側銑 (Side milling) |
| DE0154 | 9 | 80 | 17000 | 1000~1300 | 0.03~0.05 | 1.5 | 溝銑 (Slotting) |
| DE0154 | 9 | 80 | 17000 | 500~700 | 0.1~0.15 | 1.5 | 溝銑 (Slotting) |
| DE0154 | 9 | 80 | 17000 | 500~800 | 1.5~3 | 0.03~0.05 | 側銑 (Side milling) |
| DE0154 | 9 | 80 | 17000 | 700~900 | 1.5~3 | 0.1~0.15 | 側銑 (Side milling) |
| DE0154 | 9 | 80 | 17000 | 500~700 | 1.5~3 | 0.15~0.25 | 側銑 (Side milling) |
| DE0204 | 11 | 95 | 15000 | 1000~1300 | 0.03~0.05 | 2 | 溝銑 (Slotting) |
| DE0204 | 11 | 90 | 14300 | 500~700 | 0.1~0.15 | 2 | 溝銑 (Slotting) |
| DE0204 | 11 | 95 | 15000 | 500~800 | 2~4 | 0.03~0.05 | 側銑 (Side milling) |
| DE0204 | 11 | 90 | 14300 | 700~900 | 2~4 | 0.1~0.15 | 側銑 (Side milling) |
| DE0204 | 11 | 90 | 14300 | 500~700 | 2~4 | 0.2~0.3 | 側銑 (Side milling) |
| DE0254 | 12 | 110 | 14000 | 1000~1300 | 0.04~0.06 | 2.5 | 溝銑 (Slotting) |
| DE0254 | 12 | 90 | 11400 | 500~700 | 0.4~0.5 | 2.5 | 溝銑 (Slotting) |
| DE0254 | 12 | 110 | 14000 | 500~800 | 2.5~5 | 0.04~0.06 | 側銑 (Side milling) |
| DE0254 | 12 | 90 | 11400 | 700~900 | 2.5~5 | 0.2~0.3 | 側銑 (Side milling) |
| DE0254 | 12 | 90 | 11400 | 500~700 | 2.5~5 | 0.4~0.5 | 側銑 (Side milling) |
| DE0304 | 15 | 115 | 12200 | 1000~1300 | 0.04~0.06 | 3 | 溝銑 (Slotting) |
| DE0304 | 15 | 90 | 9500 | 500~700 | 0.8~0.9 | 3 | 溝銑 (Slotting) |
| DE0304 | 15 | 115 | 12200 | 500~800 | 3~6 | 0.04~0.06 | 側銑 (Side milling) |
| DE0304 | 15 | 90 | 9500 | 700~900 | 3~6 | 0.4~0.6 | 側銑 (Side milling) |
| DE0304 | 15 | 90 | 9500 | 500~700 | 3~6 | 0.8~0.9 | 側銑 (Side milling) |

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|--------------------|----------------------------|--|--------------------------------|--------------------|------------------------|------------------------|-------------------|
| 冷卻方式 Coolant Type | | 乾式切削 Dry coolant | | | | | |
| Type NO. | 刀具伸長量 Extension Length(mm) | 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 |
| DE0404 | 16 | 125 | 10000 | 1000~1300 | 0.04~0.07 | 4 | 溝銑 (Slotting) |
| DE0404 | 16 | 100 | 8000 | 500~700 | 1~1.2 | 4 | 溝銑 (Slotting) |
| DE0404 | 16 | 125 | 10000 | 500~800 | 4~8 | 0.04~0.07 | 側銑 (Side milling) |
| DE0404 | 16 | 100 | 8000 | 800~1100 | 4~8 | 0.6~0.7 | 側銑 (Side milling) |
| DE0404 | 16 | 100 | 8000 | 500~700 | 4~8 | 1~1.2 | 側銑 (Side milling) |
| DE0504 | 19 | 125 | 8000 | 1000~1300 | 0.05~0.08 | 5 | 溝銑 (Slotting) |
| DE0504 | 19 | 100 | 6400 | 500~700 | 1.3~1.5 | 5 | 溝銑 (Slotting) |
| DE0504 | 19 | 125 | 8000 | 500~800 | 5~10 | 0.05~0.08 | 側銑 (Side milling) |
| DE0504 | 19 | 100 | 6400 | 800~1100 | 5~10 | 0.8~1 | 側銑 (Side milling) |
| DE0504 | 19 | 100 | 6400 | 500~700 | 5~10 | 1.3~1.5 | 側銑 (Side milling) |
| DE0604 | 21 | 125 | 6600 | 1000~1300 | 0.05~0.1 | 6 | 溝銑 (Slotting) |
| DE0604 | 21 | 100 | 5300 | 600~800 | 1.5~1.8 | 6 | 溝銑 (Slotting) |
| DE0604 | 21 | 125 | 6600 | 500~800 | 6~12 | 0.05~0.1 | 側銑 (Side milling) |
| DE0604 | 21 | 100 | 5300 | 800~1100 | 6~12 | 0.8~1.2 | 側銑 (Side milling) |
| DE0604 | 21 | 100 | 5300 | 600~800 | 6~12 | 1.5~1.8 | 側銑 (Side milling) |
| DE0804 | 27 | 125 | 5000 | 900~1200 | 0.05~0.12 | 8 | 溝銑 (Slotting) |
| DE0804 | 27 | 100 | 4000 | 600~800 | 2~2.4 | 8 | 溝銑 (Slotting) |
| DE0804 | 27 | 125 | 5000 | 500~700 | 8~16 | 0.05~0.12 | 側銑 (Side milling) |
| DE0804 | 27 | 100 | 4000 | 800~1100 | 8~16 | 1~1.5 | 側銑 (Side milling) |
| DE0804 | 27 | 100 | 4000 | 600~800 | 8~16 | 2~2.4 | 側銑 (Side milling) |
| DE1004 | 34 | 125 | 4000 | 800~1100 | 0.05~0.15 | 10 | 溝銑 (Slotting) |
| DE1004 | 34 | 100 | 3200 | 700~900 | 2~3 | 10 | 溝銑 (Slotting) |
| DE1004 | 34 | 125 | 4000 | 500~700 | 10~20 | 0.05~0.2 | 側銑 (Side milling) |
| DE1004 | 34 | 130 | 4200 | 900~1200 | 10~20 | 1.3~1.5 | 側銑 (Side milling) |
| DE1004 | 34 | 115 | 3600 | 700~900 | 10~20 | 2~3 | 側銑 (Side milling) |

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| 被切削材 Work Material | | 碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron S50C / Fc250 / SS440 : 1.1210 / 0.6025 / 1.0036 : 1050 / N0.35 / A570 Gr.45 (~HRc22) | | | | | |
|--------------------|----------------------------|--|---------------------------------|--------------------|------------------------|------------------------|-------------------|
| 冷卻方式 Coolant Type | | 乾式切削 Dry coolant | | | | | |
| 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 |
| DE1204 | 37 | 125 | 3300 | 700~1000 | 0.05~0.15 | 12 | 溝銑 (Slotting) |
| DE1204 | 37 | 100 | 2650 | 500~700 | 3~3.6 | 12 | 溝銑 (Slotting) |
| DE1204 | 37 | 125 | 3300 | 400~600 | 12~24 | 0.05~0.15 | 側銑 (Side milling) |
| DE1204 | 37 | 100 | 2650 | 700~900 | 12~24 | 1.5~2 | 側銑 (Side milling) |
| DE1204 | 37 | 100 | 2650 | 500~700 | 12~24 | 3~3.6 | 側銑 (Side milling) |
| DE1604 | 50 | 125 | 2500 | 500~800 | 0.05~0.2 | 16 | 溝銑 (Slotting) |
| DE1604 | 50 | 100 | 2000 | 200~350 | 3~4 | 16 | 溝銑 (Slotting) |
| DE1604 | 50 | 100 | 2000 | 350~550 | 16~32 | 0.05~0.2 | 側銑 (Side milling) |
| DE1604 | 50 | 100 | 2000 | 600~800 | 16~32 | 1~2 | 側銑 (Side milling) |
| DE1604 | 50 | 100 | 2000 | 200~400 | 16~32 | 3~4 | 側銑 (Side milling) |
| DE2004 | 50 | 125 | 2000 | 400~700 | 0.05~0.25 | 20 | 溝銑 (Slotting) |
| DE2004 | 50 | 100 | 1600 | 200~350 | 3~4 | 20 | 溝銑 (Slotting) |
| DE2004 | 50 | 100 | 1600 | 250~450 | 20~40 | 0.05~0.25 | 側銑 (Side milling) |
| DE2004 | 50 | 100 | 1600 | 350~500 | 20~40 | 2~3 | 側銑 (Side milling) |
| DE2004 | 50 | 100 | 1600 | 250~400 | 20~40 | 3~4 | 側銑 (Side milling) |

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切削條件表 MILLING CONDITIONS

| 被切削材 Work Material | | 合金工具鋼 / 碳工具鋼 : Alloy Tool Steels / Carbon Tool Steels P20 / P5 / SK3 / SKD61 / SKD11 : 1.2311 / 1.1545 / 1.2379 / 1.2344 : H13 / D2 (HRc23~32) | | | | | |
|--------------------|----------------------------|---|---------------------------------|--------------------|------------------------|------------------------|-------------------|
| 冷卻方式 Coolant Type | | 乾式切削 Dry coolant | | | | | |
| Type NO. | 刀具伸長量 Extension Length(mm) | 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 |
| DE0104 | 9 | 65 | 20000 | 1000~1300 | 0.03~0.05 | 1 | 溝銑 (Slotting) |
| DE0104 | 9 | 65 | 20000 | 400~600 | 0.05~0.1 | 1 | 溝銑 (Slotting) |
| DE0104 | 9 | 65 | 20000 | 500~800 | 1~2 | 0.03~0.05 | 側銑 (Side milling) |
| DE0104 | 9 | 65 | 20000 | 600~800 | 1~2 | 0.05~0.1 | 側銑 (Side milling) |
| DE0104 | 9 | 65 | 20000 | 400~600 | 1~2 | 0.15~0.2 | 側銑 (Side milling) |
| DE0154 | 9 | 80 | 17000 | 1000~1300 | 0.03~0.05 | 1.5 | 溝銑 (Slotting) |
| DE0154 | 9 | 80 | 17000 | 400~600 | 0.1~0.15 | 1.5 | 溝銑 (Slotting) |
| DE0154 | 9 | 80 | 17000 | 500~800 | 1.5~3 | 0.03~0.05 | 側銑 (Side milling) |
| DE0154 | 9 | 80 | 17000 | 600~800 | 1.5~3 | 0.1~0.15 | 側銑 (Side milling) |
| DE0154 | 9 | 80 | 17000 | 400~600 | 1.5~3 | 0.15~0.25 | 側銑 (Side milling) |
| DE0204 | 11 | 95 | 15000 | 1000~1300 | 0.03~0.05 | 2 | 溝銑 (Slotting) |
| DE0204 | 11 | 90 | 14300 | 400~600 | 0.1~0.15 | 2 | 溝銑 (Slotting) |
| DE0204 | 11 | 95 | 15000 | 500~800 | 2~4 | 0.03~0.05 | 側銑 (Side milling) |
| DE0204 | 11 | 90 | 14300 | 600~800 | 2~4 | 0.1~0.15 | 側銑 (Side milling) |
| DE0204 | 11 | 90 | 14300 | 400~600 | 2~4 | 0.2~0.3 | 側銑 (Side milling) |
| DE0254 | 12 | 110 | 14000 | 1000~1300 | 0.04~0.06 | 2.5 | 溝銑 (Slotting) |
| DE0254 | 12 | 90 | 11400 | 400~600 | 0.4~0.5 | 2.5 | 溝銑 (Slotting) |
| DE0254 | 12 | 110 | 14000 | 500~800 | 2.5~5 | 0.04~0.06 | 側銑 (Side milling) |
| DE0254 | 12 | 90 | 11400 | 600~800 | 2.5~5 | 0.2~0.3 | 側銑 (Side milling) |
| DE0254 | 12 | 90 | 11400 | 400~600 | 2.5~5 | 0.4~0.5 | 側銑 (Side milling) |
| DE0304 | 15 | 115 | 12200 | 1000~1300 | 0.04~0.06 | 3 | 溝銑 (Slotting) |
| DE0304 | 15 | 90 | 9500 | 400~600 | 0.8~0.9 | 3 | 溝銑 (Slotting) |
| DE0304 | 15 | 105 | 11100 | 500~800 | 3~6 | 0.04~0.06 | 側銑 (Side milling) |
| DE0304 | 15 | 90 | 9500 | 600~800 | 3~6 | 0.4~0.6 | 側銑 (Side milling) |
| DE0304 | 15 | 90 | 9500 | 400~600 | 3~6 | 0.8~0.9 | 側銑 (Side milling) |

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| 被切削材 Work Material | | 合金工具鋼 / 碳工具鋼 : Alloy Tool Steels / Carbon Tool Steels P20 / P5 / SK3 / SKD61 / SKD11 : 1.2311 / 1.1545 / 1.2379 / 1.2344 : H13 / D2 (HRc23~32) | | | | | |
|--------------------|----------------------------|---|---------------------------------|--------------------|------------------------|------------------------|-------------------|
| 冷卻方式 Coolant Type | | 乾式切削 Dry coolant | | | | | |
| Type NO. | 刀具伸長量 Extension Length(mm) | 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 |
| DE0404 | 16 | 115 | 9200 | 1000~1300 | 0.04~0.07 | 4 | 溝銑 (Slotting) |
| DE0404 | 16 | 100 | 8000 | 400~600 | 1~1.2 | 4 | 溝銑 (Slotting) |
| DE0404 | 16 | 105 | 8400 | 500~800 | 4~8 | 0.04~0.07 | 側銑 (Side milling) |
| DE0404 | 16 | 100 | 8000 | 600~900 | 4~8 | 0.6~0.7 | 側銑 (Side milling) |
| DE0404 | 16 | 100 | 8000 | 400~600 | 4~8 | 1~1.2 | 側銑 (Side milling) |
| DE0504 | 19 | 115 | 7300 | 1000~1300 | 0.05~0.08 | 5 | 溝銑 (Slotting) |
| DE0504 | 19 | 100 | 6400 | 400~600 | 1.3~1.5 | 5 | 溝銑 (Slotting) |
| DE0504 | 19 | 105 | 6700 | 500~800 | 5~10 | 0.05~0.08 | 側銑 (Side milling) |
| DE0504 | 19 | 100 | 6400 | 600~900 | 5~10 | 0.8~1 | 側銑 (Side milling) |
| DE0504 | 19 | 100 | 6400 | 400~600 | 5~10 | 1.3~1.5 | 側銑 (Side milling) |
| DE0604 | 21 | 115 | 6100 | 1000~1300 | 0.05~0.1 | 6 | 溝銑 (Slotting) |
| DE0604 | 21 | 100 | 5300 | 500~700 | 1.5~1.8 | 6 | 溝銑 (Slotting) |
| DE0604 | 21 | 105 | 5600 | 500~800 | 6~12 | 0.05~0.1 | 側銑 (Side milling) |
| DE0604 | 21 | 100 | 5300 | 700~1000 | 6~12 | 0.8~1.2 | 側銑 (Side milling) |
| DE0604 | 21 | 100 | 5300 | 500~700 | 6~12 | 1.5~1.8 | 側銑 (Side milling) |
| DE0804 | 27 | 120 | 4800 | 900~1200 | 0.05~0.12 | 8 | 溝銑 (Slotting) |
| DE0804 | 27 | 105 | 4200 | 500~700 | 2~2.4 | 8 | 溝銑 (Slotting) |
| DE0804 | 27 | 105 | 4200 | 500~700 | 8~16 | 0.05~0.12 | 側銑 (Side milling) |
| DE0804 | 27 | 105 | 4200 | 700~1000 | 8~16 | 1~1.5 | 側銑 (Side milling) |
| DE0804 | 27 | 105 | 4200 | 500~700 | 8~16 | 2~2.4 | 側銑 (Side milling) |
| DE1004 | 34 | 110 | 3500 | 800~1100 | 0.05~0.15 | 10 | 溝銑 (Slotting) |
| DE1004 | 34 | 110 | 3500 | 600~800 | 2~3 | 10 | 溝銑 (Slotting) |
| DE1004 | 34 | 110 | 3500 | 500~700 | 10~20 | 0.05~0.2 | 側銑 (Side milling) |
| DE1004 | 34 | 110 | 3500 | 800~1100 | 10~20 | 1.3~1.5 | 側銑 (Side milling) |
| DE1004 | 34 | 110 | 3500 | 600~800 | 10~20 | 2~3 | 側銑 (Side milling) |

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|--------------------|----------------------------|---|---------------------------------|--------------------|------------------------|------------------------|-------------------|
| 冷卻方式 Coolant Type | | 乾式切削 Dry coolant | | | | | |
| 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 |
| DE1204 | 37 | 115 | 3000 | 700~1000 | 0.05~0.15 | 12 | 溝銑 (Slotting) |
| DE1204 | 37 | 95 | 2500 | 400~600 | 3~3.6 | 12 | 溝銑 (Slotting) |
| DE1204 | 37 | 95 | 2500 | 400~600 | 12~24 | 0.05~0.15 | 側銑 (Side milling) |
| DE1204 | 37 | 95 | 2500 | 500~800 | 12~24 | 1.5~2 | 側銑 (Side milling) |
| DE1204 | 37 | 95 | 2500 | 400~600 | 12~24 | 3~3.6 | 側銑 (Side milling) |
| DE1604 | 50 | 115 | 2300 | 500~800 | 0.05~0.2 | 16 | 溝銑 (Slotting) |
| DE1604 | 50 | 95 | 1900 | 150~300 | 3~4 | 16 | 溝銑 (Slotting) |
| DE1604 | 50 | 95 | 1900 | 350~550 | 16~32 | 0.05~0.2 | 側銑 (Side milling) |
| DE1604 | 50 | 95 | 1900 | 500~700 | 16~32 | 1~2 | 側銑 (Side milling) |
| DE1604 | 50 | 95 | 1900 | 150~350 | 16~32 | 3~4 | 側銑 (Side milling) |
| DE2004 | 50 | 115 | 1850 | 400~700 | 0.05~0.25 | 20 | 溝銑 (Slotting) |
| DE2004 | 50 | 95 | 1500 | 150~300 | 3~4 | 20 | 溝銑 (Slotting) |
| DE2004 | 50 | 95 | 1500 | 250~450 | 20~40 | 0.05~0.25 | 側銑 (Side milling) |
| DE2004 | 50 | 95 | 1500 | 250~450 | 20~40 | 2~3 | 側銑 (Side milling) |
| DE2004 | 50 | 95 | 1500 | 150~300 | 20~40 | 3~4 | 側銑 (Side milling) |