

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 / NO.35 / A570 Gr.45 (~HRc22)							
型號 Type NO.	刀具伸長量 Extension Length	切削速度 (m/min) Cutting Speed	迴轉速度 Speed (min <sup>-1</sup> )	進給速度 Feed (mm/min)	加工深度(A a) Cut of depth	加工寬度 (Ap) Cut of width	冷卻方式 Coolant way	加工方式 Milling Type
UEF0605	29mm	140	6500~8000	2500~3000	16	0.3~0.4	濕式Wet Coolant	擺線側銑 side milling side
UEF0605	29mm	140	6000~8000	1400~1800	16	0.5~0.6	濕式Wet Coolant	側銑 side milling
UEF0605	29mm	100	5000~5500	300~500	16	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)
UEF0605M	34mm	120	5500~7000	2000~2500	22	0.3~0.35	濕式Wet Coolant	擺線側銑 side milling side
UEF0605M	34mm	100	4500~6000	1300~1600	22	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF0605M	34mm	45	2000~2500	250~350	22	0.04~0.06	濕式Wet Coolant	側銑 side milling(精銑)
UEF0605L	40mm	90	4000~5500	1500~2000	28	0.2~0.3	濕式Wet Coolant	擺線側銑 side milling side
UEF0605L	40mm	85	4000~5000	1100~1300	28	0.3~0.4	濕式Wet Coolant	側銑 side milling
UEF0605L	40mm	40	1800~2300	200~350	28	0.03~0.05	濕式Wet Coolant	側銑 side milling(精銑)
UEF0805	32mm	135	4500~5500	1500~2000	22	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF0805	32mm	100	3500~4500	600~900	22	0.7~0.8	濕式Wet Coolant	擺線側銑 side milling side

UEF0805	32mm	135	4500~5500	1500~2000	22	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF0805	32mm	100	3500~4500	600~900	22	0.7~0.8	濕式Wet Coolant	側銑 side milling
UEF0805	32mm	85	2800~3800	300~450	22	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)
UEF0805M	40mm	115	4000~5200	1300~1700	30	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF0805M	40mm	80	2800~3600	500~800	30	0.6~0.7	濕式Wet Coolant	擺線側銑 side milling side
UEF0805M	40mm	115	4000~5200	1500~2000	30	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF0805M	40mm	80	2800~3600	500~800	30	0.7~0.8	濕式Wet Coolant	側銑 side milling
UEF0805M	40mm	75	2500~3300	300~450	30	0.05~0.08	濕式Wet Coolant	側銑 side milling(精銑)
UEF0805L	50mm	85	2800~4000	1200~1600	38	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF0805L	50mm	65	2200~2800	500~800	38	0.7~0.8	濕式Wet Coolant	擺線側銑 side milling side
UEF0805L	50mm	85	2800~4000	1200~1600	38	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF0805L	50mm	65	2200~2800	500~800	38	0.6~0.8	濕式Wet Coolant	側銑 side milling
UEF0805L	50mm	70	2200~3200	270~450	38	0.05~0.08	濕式Wet Coolant	側銑 side milling(精銑)
UEF1005	37mm	170	4500~6000	1500~2000	30	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF1005	37mm	170	4500~6000	1300~1800	20	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1005	37mm	170	4500~6000	900~1300	30	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1005	37mm	170	4500~6000	1500~1800	30	0.4~0.5	濕式Wet Coolant	側銑 side milling
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UEF1005	37mm	105	2800~3800	300~500	30	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)
UEF1005M	50mm	145	4000~5000	1100~1600	38	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF1005M	50mm	140	3800~5000	700~1000	38	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1005M	50mm	145	4000~5000	1100~1600	38	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF1005M	50mm	140	3800~5000	700~1000	38	0.8~1	濕式Wet Coolant	側銑 side milling
UEF1005M	50mm	90	2200~3200	270~450	38	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)
UEF1005L	60mm	120	3300~4300	900~1300	48	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF1005L	60mm	105	2800~3800	500~800	48	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1005L	60mm	145	4000~5000	1200~1700	48	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF1005L	60mm	105	2800~3800	500~800	48	0.8~1	濕式Wet Coolant	側銑 side milling
UEF1005L	60mm	70	1800~2600	200~300	48	0.05~0.08	濕式Wet Coolant	側銑 side milling(精銑)
UEF1205	50mm	175	4000~5200	1500~2000	34	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF1205	50mm	130	3600~4600	700~1000	34	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1205	50mm	175	4000~5200	1300~1800	34	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF1205	50mm	130	3600~4600	700~1000	34	0.8~1	濕式Wet Coolant	側銑 side milling
UEF1205	50mm	85	1800~2600	200~300	34	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)



被切削材 Work Material	鉻鉬合金鋼 SCM440 : 1.7225 : 4140 : 42CrMoA (HRc25~28)							
型號 Type NO.	刀具伸長量 Extension Length	切削速度 (m/min) Cutting Speed	迴轉速度 Speed (min <sup>-1</sup> )	進給速度 Feed (mm/min)	加工深度(A a) Cut of depth	加工寬度 (Ap) Cut of width	冷卻方式 Coolant way	加工方式 Milling Type
UEF0605	29mm	140	6500~8000	2400~2900	16	0.3~0.4	濕式Wet Coolant	擺線側銑 side milling side
UEF0605	29mm	140	6000~8000	1300~1800	16	0.5~0.6	濕式Wet Coolant	側銑 side milling
UEF0605	29mm	100	5000~5500	300~500	16	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)
UEF0605M	34mm	120	5500~7000	2000~2500	22	0.3~0.35	濕式Wet Coolant	擺線側銑 side milling side
UEF0605M	34mm	100	4500~6000	1200~1600	22	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF0605M	34mm	45	2000~2500	250~350	22	0.04~0.06	濕式Wet Coolant	側銑 side milling(精銑)
UEF0605L	40mm	90	4000~5500	1500~2000	28	0.2~0.3	濕式Wet Coolant	擺線側銑 side milling side
UEF0605L	40mm	85	4000~5000	1000~1300	28	0.3~0.4	濕式Wet Coolant	側銑 side milling
UEF0605L	40mm	40	1800~2300	200~350	28	0.03~0.05	濕式Wet Coolant	側銑 side milling(精銑)
UEF0805	32mm	135	4500~5500	1500~1900	22	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF0805	32mm	100	3500~4500	500~900	22	0.7~0.8	濕式Wet Coolant	擺線側銑 side milling side

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UEF0805	32mm	100	3500~4500	500~900	22	0.7~0.8	濕式Wet Coolant	側銑 side milling
UEF0805	32mm	85	2800~3800	300~450	22	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)
UEF0805M	40mm	115	4000~5200	1300~1700	30	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF0805M	40mm	80	2800~3600	450~800	30	0.6~0.7	濕式Wet Coolant	擺線側銑 side milling side
UEF0805M	40mm	115	4000~5200	1500~2000	30	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF0805M	40mm	80	2800~3600	450~800	30	0.7~0.8	濕式Wet Coolant	側銑 side milling
UEF0805M	40mm	75	2500~3300	300~450	30	0.05~0.08	濕式Wet Coolant	側銑 side milling(精銑)
UEF0805L	50mm	85	2800~4000	1200~1600	38	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF0805L	50mm	65	2200~2800	450~800	38	0.7~0.8	濕式Wet Coolant	擺線側銑 side milling side
UEF0805L	50mm	85	2800~4000	1200~1600	38	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF0805L	50mm	65	2200~2800	450~800	38	0.6~0.8	濕式Wet Coolant	側銑 side milling
UEF0805L	50mm	70	2200~3200	270~450	38	0.05~0.08	濕式Wet Coolant	側銑 side milling(精銑)
UEF1005	37mm	170	4500~6000	1500~1900	30	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF1005	37mm	170	4500~6000	1300~1800	20	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1005	37mm	170	4500~6000	900~1300	30	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1005	37mm	170	4500~6000	1500~1800	30	0.4~0.5	濕式Wet Coolant	側銑 side milling
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UEF1005	37mm	105	2800~3800	300~500	30	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)
UEF1005M	50mm	145	4000~5000	1100~1600	38	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF1005M	50mm	140	3800~5000	600~1000	38	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1005M	50mm	145	4000~5000	1100~1600	38	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF1005M	50mm	140	3800~5000	600~1000	38	0.8~1	濕式Wet Coolant	側銑 side milling
UEF1005M	50mm	90	2200~3200	270~450	38	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)
UEF1005L	60mm	120	3300~4300	900~1300	48	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF1005L	60mm	105	2800~3800	500~800	48	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1005L	60mm	145	4000~5000	1200~1700	48	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF1005L	60mm	105	2800~3800	500~800	48	0.8~1	濕式Wet Coolant	側銑 side milling
UEF1005L	60mm	70	1800~2600	200~300	48	0.05~0.08	濕式Wet Coolant	側銑 side milling(精銑)
UEF1205	50mm	175	4000~5200	140~1900	34	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF1205	50mm	130	3600~4600	600~1000	34	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1205	50mm	175	4000~5200	1300~1800	34	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF1205	50mm	130	3600~4600	600~1000	34	0.8~1	濕式Wet Coolant	側銑 side milling
UEF1205	50mm	85	1800~2600	200~300	34	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)





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 HRC(23~32)							
型號 Type NO.	刀具伸長量 Extension Length	切削速度 (m/min) Cutting Speed	迴轉速度 Speed (min <sup>-1</sup> )	進給速度 Feed (mm/min)	加工深度 (Aa) Cut of depth	加工寬度 (Ap) Cut of width	冷卻方式 Coolant way	加工方式 Milling Type
UEF0605	29mm	140	6500~8000	2300~2800	16	0.3~0.4	濕式Wet Coolant	擺線側銑 side milling side
UEF0605	29mm	140	6000~8000	1300~1800	16	0.5~0.6	濕式Wet Coolant	側銑 side milling
UEF0605	29mm	100	5000~5500	300~500	16	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)
UEF0605M	34mm	120	5500~7000	2000~2500	22	0.3~0.35	濕式Wet Coolant	擺線側銑 side milling side
UEF0605M	34mm	100	4500~6000	1200~1600	22	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF0605M	34mm	45	2000~2500	250~350	22	0.04~0.06	濕式Wet Coolant	側銑 side milling(精銑)
UEF0605L	40mm	90	4000~5500	1500~2000	28	0.2~0.3	濕式Wet Coolant	擺線側銑 side milling side
UEF0605L	40mm	85	4000~5000	1000~1300	28	0.3~0.4	濕式Wet Coolant	側銑 side milling
UEF0605L	40mm	40	1800~2300	200~350	28	0.03~0.05	濕式Wet Coolant	側銑 side milling(精銑)
UEF0805	32mm	135	4500~5500	1400~1800	22	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF0805	32mm	100	3500~4500	500~900	22	0.7~0.8	濕式Wet Coolant	擺線側銑 side milling side

UEF0805	32mm	135	4500~5500	1400~1800	22	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF0805	32mm	100	3500~4500	500~900	22	0.7~0.8	濕式Wet Coolant	側銑 side milling
UEF0805	32mm	85	2800~3800	300~450	22	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)
UEF0805M	40mm	115	4000~5200	1300~1700	30	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF0805M	40mm	80	2800~3600	450~800	30	0.6~0.7	濕式Wet Coolant	擺線側銑 side milling side
UEF0805M	40mm	115	4000~5200	1500~2000	30	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF0805M	40mm	80	2800~3600	450~800	30	0.7~0.8	濕式Wet Coolant	側銑 side milling
UEF0805M	40mm	75	2500~3300	300~450	30	0.05~0.08	濕式Wet Coolant	側銑 side milling(精銑)
UEF0805L	50mm	85	2800~4000	1200~1600	38	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF0805L	50mm	65	2200~2800	450~800	38	0.7~0.8	濕式Wet Coolant	擺線側銑 side milling side
UEF0805L	50mm	85	2800~4000	1200~1600	38	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF0805L	50mm	65	2200~2800	450~800	38	0.6~0.8	濕式Wet Coolant	側銑 side milling
UEF0805L	50mm	70	2200~3200	270~450	38	0.05~0.08	濕式Wet Coolant	側銑 side milling(精銑)
UEF1005	37mm	170	4500~6000	1400~1800	30	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF1005	37mm	170	4500~6000	1300~1800	20	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1005	37mm	170	4500~6000	900~1300	30	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
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UEF1005L	60mm	120	3300~4300	900~1300	48	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
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UEF1205	50mm	175	4000~5200	1300~1800	34	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF1205	50mm	130	3600~4600	600~1000	34	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
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沃斯田鐵系不銹鋼 : Stainless Steels SUS304 : 1.4301 : AISI 304 HRc(26~30)								
被切削材 Work Material								
型號 Type NO.	刀具伸長量 Extension Length	切削速度 (m/min) Cutting Speed	迴轉速度 Speed (min <sup>-1</sup> )	進給速度 Feed (mm/min)	加工深度 (Aa) Cut of depth	加工寬度 (Ap) Cut of width	冷卻方式 Coolant way	加工方式 Milling Type
UEF0605	29mm	140	6500~8000	2300~2800	16	0.3~0.4	濕式Wet Coolant	擺線側銑 side milling side
UEF0605	29mm	140	6000~8000	1300~1800	16	0.5~0.6	濕式Wet Coolant	側銑 side milling
UEF0605	29mm	100	5000~5500	300~500	16	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)
UEF0605M	34mm	120	5500~7000	2000~2500	22	0.3~0.35	濕式Wet Coolant	擺線側銑 side milling side
UEF0605M	34mm	100	4500~6000	1200~1600	22	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF0605M	34mm	45	2000~2500	250~350	22	0.04~0.06	濕式Wet Coolant	側銑 side milling(精銑)
UEF0605L	40mm	90	4000~5500	1500~2000	28	0.2~0.3	濕式Wet Coolant	擺線側銑 side milling side
UEF0605L	40mm	85	4000~5000	1000~1300	28	0.3~0.4	濕式Wet Coolant	側銑 side milling
UEF0605L	40mm	40	1800~2300	200~350	28	0.03~0.05	濕式Wet Coolant	側銑 side milling(精銑)
UEF0805	32mm	135	4500~5500	1400~1800	22	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF0805	32mm	100	3500~4500	500~900	22	0.7~0.8	濕式Wet Coolant	擺線側銑 side milling side

UEF0805	32mm	135	4500~5500	1400~1800	22	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF0805	32mm	100	3500~4500	500~900	22	0.7~0.8	濕式Wet Coolant	側銑 side milling
UEF0805	32mm	85	2800~3800	300~450	22	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)
UEF0805M	40mm	115	4000~5200	1300~1700	30	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF0805M	40mm	80	2800~3600	450~800	30	0.6~0.7	濕式Wet Coolant	擺線側銑 side milling side
UEF0805M	40mm	115	4000~5200	1500~2000	30	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF0805M	40mm	80	2800~3600	450~800	30	0.7~0.8	濕式Wet Coolant	側銑 side milling
UEF0805M	40mm	75	2500~3300	300~450	30	0.05~0.08	濕式Wet Coolant	側銑 side milling(精銑)
UEF0805L	50mm	85	2800~4000	1200~1600	38	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF0805L	50mm	65	2200~2800	450~800	38	0.7~0.8	濕式Wet Coolant	擺線側銑 side milling side
UEF0805L	50mm	85	2800~4000	1200~1600	38	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF0805L	50mm	65	2200~2800	450~800	38	0.6~0.8	濕式Wet Coolant	側銑 side milling
UEF0805L	50mm	70	2200~3200	270~450	38	0.05~0.08	濕式Wet Coolant	側銑 side milling(精銑)
UEF1005	37mm	170	4500~6000	1400~1800	30	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF1005	37mm	170	4500~6000	1300~1800	20	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1005	37mm	170	4500~6000	900~1300	30	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1005	37mm	170	4500~6000	1500~1800	30	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF1005	37mm	170	4500~6000	1300~1800	20	0.8~1	濕式Wet Coolant	側銑 side milling

UEF1005	37mm	170	4500~6000	1000~1300	30	0.8~1	濕式Wet Coolant	側銑 side milling
UEF1005	37mm	105	2800~3800	300~500	30	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)
UEF1005M	50mm	145	4000~5000	1100~1600	38	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF1005M	50mm	140	3800~5000	600~1000	38	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1005M	50mm	145	4000~5000	1100~1600	38	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF1005M	50mm	140	3800~5000	600~1000	38	0.8~1	濕式Wet Coolant	側銑 side milling
UEF1005M	50mm	90	2200~3200	270~450	38	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)
UEF1005L	60mm	120	3300~4300	900~1300	48	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF1005L	60mm	105	2800~3800	500~800	48	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1005L	60mm	145	4000~5000	1000~1500	48	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF1005L	60mm	105	2800~3800	500~800	48	0.8~1	濕式Wet Coolant	側銑 side milling
UEF1005L	60mm	70	1800~2600	200~300	48	0.05~0.08	濕式Wet Coolant	側銑 side milling(精銑)
UEF1205	50mm	175	4000~5200	1300~1800	34	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF1205	50mm	130	3600~4600	600~1000	34	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1205	50mm	175	4000~5200	1300~1800	34	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF1205	50mm	130	3600~4600	600~1000	34	0.8~1	濕式Wet Coolant	側銑 side milling
UEF1205	50mm	85	1800~2600	200~300	34	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)

UEF1205M	60mm	160	3600~4800	1200~1700	46	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF1205M	60mm	135	3000~4000	600~900	46	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1205M	60mm	160	3600~4800	1200~1700	46	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF1205M	60mm	135	3000~4000	600~900	46	0.8~1	濕式Wet Coolant	側銑 side milling
UEF1205M	60mm	65	1300~2000	180~300	46	0.05~0.08	濕式Wet Coolant	側銑 side milling(精銑)
UEF1605	70mm	170	2800~4000	1100~1500	48	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF1605	70mm	130	2200~3000	500~750	48	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1605	70mm	170	2800~4000	1100~1500	48	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF1605	70mm	130	2200~3000	600~800	48	0.8~1	濕式Wet Coolant	側銑 side milling
UEF1605	70mm	95	1600~2200	250~350	48	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)
UEF1605L	90mm	130	2000~3000	900~1300	65	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF1605L	90mm	95	1500~2200	400~600	65	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1605L	90mm	130	2000~3000	900~1300	65	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF1605L	90mm	95	1500~2200	400~600	65	0.8~1	濕式Wet Coolant	側銑 side milling
UEF1605L	90mm	75	1200~1800	180~280	65	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)

注意: 因UEF//LEF<刃長>有3D//



被切削材 Work Material								
純鈦//鈦合金 : Titanium Alloy // Pure Titanium : 3.7165//3.7035 Ti-6Al-4V, Gr2, Gr5(TC4)								
型號 Type NO.	刀具伸長量 Extension Length	切削速度 (m/min) Cutting Speed	迴轉速度 Speed (min <sup>-1</sup> )	進給速度 Feed (mm/min)	加工深度 (Aa) Cut of depth	加工寬度 (Ap) Cut of width	冷卻方式 Coolant way	加工方式 Milling Type
UEF0605	29mm	140	6500~8000	2200~2700	16	0.3~0.4	濕式Wet Coolant	擺線側銑 side milling side
UEF0605	29mm	140	6000~8000	1300~1800	16	0.5~0.6	濕式Wet Coolant	側銑 side milling
UEF0605	29mm	100	5000~5500	300~500	16	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)
UEF0605M	34mm	120	5500~7000	2000~2400	22	0.3~0.35	濕式Wet Coolant	擺線側銑 side milling side
UEF0605M	34mm	100	4500~6000	1200~1600	22	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF0605M	34mm	45	2000~2500	250~350	22	0.04~0.06	濕式Wet Coolant	側銑 side milling(精銑)
UEF0605L	40mm	90	4000~5500	1500~2000	28	0.2~0.3	濕式Wet Coolant	擺線側銑 side milling side
UEF0605L	40mm	85	4000~5000	1000~1300	28	0.3~0.4	濕式Wet Coolant	側銑 side milling
UEF0605L	40mm	40	1800~2300	200~350	28	0.03~0.05	濕式Wet Coolant	側銑 side milling(精銑)
UEF0805	32mm	135	4500~5500	1400~1700	22	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF0805	32mm	100	3500~4500	500~900	22	0.7~0.8	濕式Wet Coolant	擺線側銑 side milling side

UEF0805	32mm	135	4500~5500	1400~1800	22	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF0805	32mm	100	3500~4500	500~900	22	0.7~0.8	濕式Wet Coolant	側銑 side milling
UEF0805	32mm	85	2800~3800	300~450	22	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)
UEF0805M	40mm	115	4000~5200	1300~1700	30	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF0805M	40mm	80	2800~3600	450~800	30	0.6~0.7	濕式Wet Coolant	擺線側銑 side milling side
UEF0805M	40mm	115	4000~5200	1500~2000	30	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF0805M	40mm	80	2800~3600	450~800	30	0.7~0.8	濕式Wet Coolant	側銑 side milling
UEF0805M	40mm	75	2500~3300	300~450	30	0.05~0.08	濕式Wet Coolant	側銑 side milling(精銑)
UEF0805L	50mm	85	2800~4000	1200~1600	38	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF0805L	50mm	65	2200~2800	450~800	38	0.7~0.8	濕式Wet Coolant	擺線側銑 side milling side
UEF0805L	50mm	85	2800~4000	1200~1600	38	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF0805L	50mm	65	2200~2800	450~800	38	0.6~0.8	濕式Wet Coolant	側銑 side milling
UEF0805L	50mm	70	2200~3200	270~450	38	0.05~0.08	濕式Wet Coolant	側銑 side milling(精銑)
UEF1005	37mm	170	4500~6000	1400~1700	30	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF1005	37mm	170	4500~6000	1300~1800	20	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1005	37mm	170	4500~6000	900~1300	30	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1005	37mm	170	4500~6000	1500~1800	30	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF1005	37mm	170	4500~6000	1300~1800	20	0.8~1	濕式Wet Coolant	側銑 side milling

UEF1005	37mm	170	4500~6000	1000~1300	30	0.8~1	濕式Wet Coolant	側銑 side milling
UEF1005	37mm	105	2800~3800	300~500	30	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)
UEF1005M	50mm	145	4000~5000	1100~1500	38	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF1005M	50mm	140	3800~5000	600~1000	38	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1005M	50mm	140	3800~5000	1100~1600	38	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF1005M	50mm	140	3800~5000	600~1000	38	0.8~1	濕式Wet Coolant	側銑 side milling
UEF1005M	50mm	90	2200~3200	270~450	38	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)
UEF1005L	60mm	120	3300~4300	900~1300	48	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF1005L	60mm	105	2800~3800	500~800	48	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1005L	60mm	120	3300~4300	900~1300	48	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF1005L	60mm	105	2800~3800	500~800	48	0.8~1	濕式Wet Coolant	側銑 side milling
UEF1005L	60mm	70	1800~2600	200~300	48	0.05~0.08	濕式Wet Coolant	側銑 side milling(精銑)
UEF1205	50mm	175	4000~5200	1300~1700	34	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF1205	50mm	130	3600~4600	600~1000	34	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1205	50mm	175	4000~5200	1300~1800	34	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF1205	50mm	130	3600~4600	600~1000	34	0.8~1	濕式Wet Coolant	側銑 side milling
UEF1205	50mm	85	1800~2600	200~300	34	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)

UEF1205M	60mm	160	3600~4800	1200~1700	46	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF1205M	60mm	135	3000~4000	600~900	46	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1205M	60mm	160	3600~4800	1200~1700	46	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF1205M	60mm	135	3000~4000	600~900	46	0.8~1	濕式Wet Coolant	側銑 side milling
UEF1205M	60mm	65	1300~2000	180~300	46	0.05~0.08	濕式Wet Coolant	側銑 side milling(精銑)
UEF1605	70mm	170	2800~4000	1100~1400	48	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF1605	70mm	130	2200~3000	500~750	48	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1605	70mm	170	2800~4000	1100~1500	48	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF1605	70mm	130	2200~3000	600~800	48	0.8~1	濕式Wet Coolant	側銑 side milling
UEF1605	70mm	95	1600~2200	250~350	48	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)
UEF1605L	90mm	130	2000~3000	900~1300	65	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF1605L	90mm	95	1500~2200	400~600	65	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1605L	90mm	130	2000~3000	900~1300	65	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF1605L	90mm	95	1500~2200	400~600	65	0.8~1	濕式Wet Coolant	側銑 side milling
UEF1605L	90mm	75	1200~1800	180~280	65	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)

!D//5D設計,應用於<薄件加工>或<機器剛性不佳>時,需自行調降<切削數據>

被切削材 Work Material	調質鋼 / 預硬鋼 : Prehardened Steels NAK80 : 1.2083 : AISI420 : M310 (HRC36~45)							
型號 Type NO.	刀具伸長量 Extension Length	切削速度 (m/min) Cutting Speed	迴轉速度 Speed (min <sup>-1</sup> )	進給速度 Feed (mm/min)	加工深度 (Aa) Cut of depth	加工寬度 (Ap) Cut of width	冷卻方式 Coolant way	加工方式 Milling Type
UEF0605	29mm	140	6500~8000	2000~2500	16	0.3~0.4	濕式Wet Coolant	擺線側銑 side milling side
UEF0605	29mm	140	6000~8000	1100~1600	16	0.5~0.6	濕式Wet Coolant	側銑 side milling
UEF0605	29mm	100	5000~5500	300~500	16	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)
UEF0605M	34mm	120	5500~7000	1700~2200	22	0.3~0.35	濕式Wet Coolant	擺線側銑 side milling side
UEF0605M	34mm	100	4500~6000	1000~1400	22	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF0605M	34mm	45	2000~2500	250~350	22	0.04~0.06	濕式Wet Coolant	側銑 side milling(精銑)
UEF0605L	40mm	90	4000~5500	1200~1700	28	0.2~0.3	濕式Wet Coolant	擺線側銑 side milling side
UEF0605L	40mm	85	4000~5000	900~1100	28	0.3~0.4	濕式Wet Coolant	側銑 side milling
UEF0605L	40mm	40	1800~2300	200~350	28	0.03~0.05	濕式Wet Coolant	側銑 side milling(精銑)
UEF0805	32mm	135	4500~5500	1200~1600	22	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF0805	32mm	100	3500~4500	500~750	22	0.7~0.8	濕式Wet Coolant	擺線側銑 side milling side

UEF0805	32mm	135	4500~5500	1200~1600	22	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF0805	32mm	100	3500~4500	500~750	22	0.7~0.8	濕式Wet Coolant	側銑 side milling
UEF0805	32mm	85	2800~3800	300~450	22	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)
UEF0805M	40mm	115	4000~5200	1100~1500	30	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF0805M	40mm	80	2800~3600	450~600	30	0.6~0.7	濕式Wet Coolant	擺線側銑 side milling side
UEF0805M	40mm	115	4000~5200	1200~1700	30	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF0805M	40mm	80	2800~3600	450~600	30	0.7~0.8	濕式Wet Coolant	側銑 side milling
UEF0805M	40mm	75	2500~3300	300~450	30	0.05~0.08	濕式Wet Coolant	側銑 side milling(精銑)
UEF0805L	50mm	85	2800~4000	1100~1400	38	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF0805L	50mm	65	2200~2800	450~650	38	0.7~0.8	濕式Wet Coolant	擺線側銑 side milling side
UEF0805L	50mm	85	2800~4000	1200~1500	38	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF0805L	50mm	65	2200~2800	450~650	38	0.6~0.8	濕式Wet Coolant	側銑 side milling
UEF0805L	50mm	70	2200~3200	270~450	38	0.05~0.08	濕式Wet Coolant	側銑 side milling(精銑)
UEF1005	37mm	170	4500~6000	1300~1600	30	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF1005	37mm	170	4500~6000	1000~1400	20	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1005	37mm	170	4500~6000	800~1100	30	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1005	37mm	170	4500~6000	1300~1600	30	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF1005	37mm	170	4500~6000	1100~1600	20	0.8~1	濕式Wet Coolant	側銑 side milling

UEF1005	37mm	170	4500~6000	900~1100	30	0.8~1	濕式Wet Coolant	側銑 side milling
UEF1005	37mm	105	2800~3800	300~500	30	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)
UEF1005M	50mm	145	4000~5000	1100~1400	38	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF1005M	50mm	140	3800~5000	600~800	38	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1005M	50mm	140	3800~5000	1100~1400	38	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF1005M	50mm	140	3800~5000	600~800	38	0.8~1	濕式Wet Coolant	側銑 side milling
UEF1005M	50mm	90	2200~3200	270~450	38	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)
UEF1005L	60mm	120	3300~4300	800~1100	48	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF1005L	60mm	105	2800~3800	500~650	48	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1005L	60mm	120	3300~4300	800~1100	48	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF1005L	60mm	105	2800~3800	500~650	48	0.8~1	濕式Wet Coolant	側銑 side milling
UEF1005L	60mm	70	1800~2600	200~300	48	0.05~0.08	濕式Wet Coolant	側銑 side milling(精銑)
UEF1205	50mm	175	4000~5200	1100~1600	34	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF1205	50mm	130	3600~4600	600~800	34	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1205	50mm	175	4000~5200	1100~1600	34	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF1205	50mm	130	3600~4600	600~800	34	0.8~1	濕式Wet Coolant	側銑 side milling
UEF1205	50mm	85	1800~2600	200~300	34	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)

UEF1205M	60mm	160	3600~4800	1000~1500	46	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF1205M	60mm	135	3000~4000	600~800	46	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1205M	60mm	160	3600~4800	1000~1500	46	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF1205M	60mm	135	3000~4000	600~800	46	0.8~1	濕式Wet Coolant	側銑 side milling
UEF1205M	60mm	65	1300~2000	180~300	46	0.05~0.08	濕式Wet Coolant	側銑 side milling(精銑)
UEF1605	70mm	170	2800~4000	1000~1300	48	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF1605	70mm	130	2200~3000	500~650	48	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1605	70mm	170	2800~4000	1000~1300	48	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF1605	70mm	130	2200~3000	500~650	48	0.8~1	濕式Wet Coolant	側銑 side milling
UEF1605	70mm	95	1600~2200	250~350	48	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)
UEF1605L	90mm	130	2000~3000	900~1100	65	0.4~0.5	濕式Wet Coolant	擺線側銑 side milling side
UEF1605L	90mm	95	1500~2200	400~500	65	0.8~1	濕式Wet Coolant	擺線側銑 side milling side
UEF1605L	90mm	130	2000~3000	900~1100	65	0.4~0.5	濕式Wet Coolant	側銑 side milling
UEF1605L	90mm	95	1500~2200	400~500	65	0.8~1	濕式Wet Coolant	側銑 side milling
UEF1605L	90mm	75	1200~1800	180~280	65	0.05~0.1	濕式Wet Coolant	側銑 side milling(精銑)