

Alloy Tool Steels / Carbon Tool Steels P20 / P5 / SK3 / SKD61 / SKD11 : 1.2311 / 1.1545 / 1.2379 / 1.2344 : H13 / D2 HRC(23~32)									
Type NO.	Extension	Length	(m/min) Cutting Speed	Speed (mim ⁻¹)	Feed (mm/min)	(Aa) Cut of depth	(Ap) Cut of width	Coolant	Cutting method
ULE0604	50mm		65	3400~3800	600~800	0.05~0.1	4~6	Wet	
ULE0604	50mm		50	2600~3000	300~500	12	0.05~0.1	Wet	Side milling (finishing)
ULE0804	50mm		60	2400~2800	800~1000	0.05~0.1	6~8	Wet	Slot milling (finishing)
ULE0804	50mm		45	1800~2200	300~450	16	0.05~0.1	Wet	Side milling (finishing)
ULE1004	50mm		120	3800~4200	1000~1200	0.05~0.1	8~10	Wet	Slot milling (finishing)
ULE1004	50mm		50	1600~2000	250~400	20	0.05~0.1	Wet	Side milling (finishing)
ULE1204	60mm		105	2800~3200	1000~1200	0.05~0.1	10~12	Wet	Slot milling (finishing)
ULE1204	60mm		50	1200~1500	200~350	24	0.05~0.1	Wet	Side milling (finishing)
ULE1604X	100mm		105	2100~2500	900~1100	0.07~0.15	13~16	Wet	Slot milling (finishing)
ULE1604X	100mm		50	800~1100	180~300	32	0.05~0.1	Wet	Side milling (finishing)
ULE2004X	100mm		105	2100~2500	700~900	0.07~0.15	14~20	Wet	Slot milling (finishing)
ULE2004X	100mm		50	700~900	150~220	35	0.05~0.1	Wet	Side milling (finishing)
Prehardened Steels NAK80 : 1.2083 : AISI420 : M310 (HRC36~45)									
Type NO.	Extension	Length	(m/min) Cutting Speed	Speed (mim ⁻¹)	Feed (mm/min)	(Aa) Cut of depth	(Ap) Cut of width	Coolant	Cutting method
ULE0604	50mm		65	3400~3800	600~800	0.05~0.1	4~6	Wet	Slot milling (finishing)
ULE0604	50mm		45	2600~3000	300~450	12	0.05~0.1	Wet	Side milling (finishing)
ULE0804	50mm		60	2400~2800	700~900	0.05~0.1	6~8	Wet	Slot milling (finishing)
ULE0804	50mm		40	1800~2200	250~400	16	0.05~0.1	Wet	Side milling (finishing)
ULE1004	50mm		120	3800~4200	900~1100	0.05~0.1	8~10	Wet	Slot milling (finishing)
ULE1004	50mm		50	1600~2000	220~350	20	0.05~0.1	Wet	Side milling (finishing)

ULE1204	60mm	105	2800~3200	900~1100	0.05~0.1	10~12	Wet	Slot milling (finishing)	
ULE1204	60mm	40	900~1200	180~300	24	0.05~0.1	Wet	Side milling (finishing)	
ULE1604X	100mm	105	2100~2500	800~1000	0.07~0.15	13~16	Wet	Slot milling (finishing)	
ULE1604X	100mm	40	700~900	150~250	32	0.05~0.1	Wet	Side milling (finishing)	
ULE2004X	100mm	105	2100~2500	600~800	0.07~0.15	14~20	Wet	Slot milling (finishing)	
ULE2004X	100mm	40	500~750	120~200	35	0.05~0.1	Wet	Side milling (finishing)	
Hardened Steels SKD61/ STAVAX / 17-4PH : 1.2083 / 1.2344 / 1.4542 : H13 / 420 (HRC48~54)									
Type NO.	Extension	Length	(m/min) Cutting Speed	Speed (mim ⁻¹)	Feed (mm/min)	(Aa) Cut of depth	(Ap) Cut of width	Coolant	Cutting method
ULE0604	50mm		45	2400~2800	400~600	0.05~0.1	4~6	Dry air // MQL	Slot milling (finishing)
ULE0604	50mm		45	2400~2800	200~300	12	0.05~0.1	Dry air // MQL	Side milling (finishing)
ULE0804	50mm		40	1800~2200	400~600	0.05~0.1	6~8	Dry air // MQL	Slot milling (finishing)
ULE0804	50mm		40	1800~2200	200~350	16	0.05~0.1	Dry air // MQL	Side milling (finishing)
ULE1004	50mm		50	1400~1800	400~600	0.05~0.1	8~10	Dry air // MQL	Slot milling (finishing)
ULE1004	50mm		50	1600~2000	180~280	20	0.05~0.1	Dry air // MQL	Side milling (finishing)
ULE1204	60mm		50	1200~1500	400~600	0.05~0.1	10~12	Dry air // MQL	Slot milling (finishing)
ULE1204	60mm		30	700~1000	150~250	24	0.05~0.1	Dry air // MQL	Side milling (finishing)
ULE1604X	100mm		50	900~1200	300~500	0.07~0.12	13~16	Dry air // MQL	Slot milling (finishing)
ULE1604X	100mm		30	500~700	120~220	32	0.05~0.1	Dry air // MQL	Side milling (finishing)
ULE2004X	100mm		50	700~1000	300~400	0.07~0.12	14~20	Dry air // MQL	Slot milling (finishing)
ULE2004X	100mm		30	400~650	100~150	35	0.05~0.1	Dry air // MQL	Side milling (finishing)