MBTA 切削條件表 MILLING CONDITIONS

被切削材 Work Material	耐蝕不鏽鋼 *Stainless Steels* : **SUS316/1.4401, SUS304/1.4301** (HRc30)					
冷卻方式 Coolant Type	濕式切削 Wet coolant					
型號 Type No.	刀具伸長量 Extension Length (mm)	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
MBTA0032	10	24000~26000	200~300	0.01~0.015	0.3	溝銑 SLOTTING
MBTA0032	10	24000~26000	250~350	0.005~0.01	0.3	溝銑 SLOTTING
MBTA0032	10	24000~26000	300~400	0.01~0.015	0.03	3D銑 3D MILLING
MBTA0032	10	24000~26000	350~450	0.005~0.01	0.02	3D銑 3D MILLING
MBTA0042	10	23000~25000	300~400	0.01~0.02	0.4	溝銑 SLOTTING
MBTA0042	10	23000~25000	350~450	0.01~0.015	0.4	溝銑 SLOTTING
MBTA0042	10	23000~25000	400~500	0.01~0.02	0.06	3D銑 3D MILLING
MBTA0042	10	23000~25000	500~600	0.01~0.015	0.03	3D銑 3D MILLING
MBTA0052	10	23000~25000	300~500	0.02~0.03	0.5	溝銑 SLOTTING
MBTA0052	10	23000~25000	500~600	0.015~0.025	0.5	溝銑 SLOTTING
MBTA0052	10	23000~25000	400~600	0.02~0.03	0.06	3D銑 3D MILLING
MBTA0052	10	23000~25000	600~800	0.015~0.025	0.06	3D銑 3D MILLING
MBTA0062	10	22000~24000	400~600	0.03~0.04	0.6	溝銑 SLOTTING
MBTA0062	10	22000~24000	600~900	0.02~0.03	0.6	溝銑 SLOTTING
MBTA0062	10	22000~24000	500~600	0.03~0.04	0.08	3D銑 3D MILLING
MBTA0062	10	22000~24000	600~800	0.02~0.03	0.06	3D銑 3D MILLING
MBTA0072	10	22000~24000	500~700	0.04~0.06	0.7	溝銑 SLOTTING
MBTA0072	10	22000~24000	800~1000	0.03~0.04	0.7	溝銑 SLOTTING
MBTA0072	10	22000~24000	600~800	0.04~0.06	0.12	3D銑 3D MILLING
MBTA0072	10	22000~24000	900~1200	0.03~0.04	0.08	3D銑 3D MILLING
MBTA0082	10	21000~23000	600~800	0.05~0.06	0.8	溝銑 SLOTTING
MBTA0082	10	21000~23000	1000~1200	0.03~0.04	0.8	溝銑 SLOTTING
MBTA0082	10	21000~23000	700~900	0.05~0.06	0.12	3D銑 3D MILLING
MBTA0082	10	21000~23000	1000~1300	0.03~0.04	0.08	3D銑 3D MILLING
MBTA0102	10	18000~20000	700~800	0.05~0.06	1	溝銑 SLOTTING
MBTA0102	10	18000~20000	1200~1400	0.04~0.05	1	溝銑 SLOTTING
MBTA0102	10	18000~20000	900~1100	0.05~0.07	0.14	3D銑 3D MILLING
MBTA0102	10	18000~20000	1300~1500	0.04~0.05	0.1	3D銑 3D MILLING
MBTA0122	10	18000~20000	700~800	0.05~0.06	1.2	溝銑 SLOTTING
MBTA0122	10	18000~20000	1300~1500	0.04~0.05	1.2	溝銑 SLOTTING
MBTA0122	10	18000~20000	900~1100	0.05~0.07	0.14	3D銑 3D MILLING
MBTA0122	10	18000~20000	1400~1600	0.04~0.05	0.1	3D銑 3D MILLING
MBTA0142	10	18000~20000	800~1000	0.05~0.06	1.4	溝銑 SLOTTING
MBTA0142	10	18000~20000	1600~1800	0.04~0.05	1.4	溝銑 SLOTTING
MBTA0142	10	18000~20000	1200~1400	0.05~0.07	0.14	3D銑 3D MILLING
MBTA0142	10	18000~20000	1800~2000	0.04~0.05	0.1	3D銑 3D MILLING
MBTA0162	10	16000~18000	800~1000	0.05~0.06	1.6	溝銑 SLOTTING
MBTA0162	10	16000~18000	1800~2000	0.04~0.05	1.6	溝銑 SLOTTING
MBTA0162	10	16000~18000	1300~1500	0.05~0.07	0.14	3D銑 3D MILLING
MBTA0162	10	16000~18000	2000~2300	0.04~0.05	0.1	3D銑 3D MILLING
MBTA0182	10	15000~17000	900~1100	0.06~0.08	1.8	溝銑 SLOTTING
MBTA0182	10	15000~17000	1800~2000	0.04~0.06	1.8	溝銑 SLOTTING
MBTA0182	10	15000~17000	1400~1700	0.06~0.08	0.16	3D銑 3D MILLING
MBTA0182	10	15000~17000	2200~2500	0.04~0.06	0.12	3D銑 3D MILLING
MBTA0202	11	14000~16000	1000~1200	0.06~0.08	2	溝銑 SLOTTING
MBTA0202	11	14000~16000	2000~2200	0.04~0.06	2	溝銑 SLOTTING
MBTA0202	11	14000~16000	1400~1800	0.06~0.08	0.16	3D銑 3D MILLING
MBTA0202	11	14000~16000	2200~2600	0.04~0.06	0.12	3D銑 3D MILLING
MBTA0302	13	13000~15000	1200~1400	0.08~0.1	3	溝銑 SLOTTING
MBTA0302	13	13000~15000	2000~2200	0.04~0.06	3	溝銑 SLOTTING
MBTA0302	13	13000~15000	1400~1800	0.1~0.12	0.24	3D銑 3D MILLING
MBTA0302	13	13000~15000	2400~2800	0.05~0.07	0.14	3D銑 3D MILLING
MBTA0402	15	13000~15000	1300~1500	0.1~0.12	4	溝銑 SLOTTING
MBTA0402	15	13000~15000	2200~2400	0.05~0.07	4	溝銑 SLOTTING
MBTA0402	15	13000~15000	1400~1800	0.12~0.15	0.3	3D銑 3D MILLING
MBTA0402	15	13000~15000	2600~3000	0.05~0.07	0.14	3D銑 3D MILLING

MBTA 切削條件表 MILLING CONDITIONS

被切削材 Work Material		耐蝕不鏽鋼 *Stainless Steels* : **SUS316/1.4401, SUS304/1.4301** (HRc30)				
冷卻方式 Coolant Type		濕式切削 Wet coolant				
型號 Type No.	刀具伸長量 Extension Length (mm)	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
MBTA0032	10	17000~18000	200~300	0.01~0.015	0.3	溝銑 SLOTTING
MBTA0032	10	17000~18000	250~350	0.005~0.01	0.3	溝銑 SLOTTING
MBTA0032	10	17000~18000	300~400	0.01~0.015	0.03	3D銑 3D MILLING
MBTA0032	10	17000~18000	350~450	0.005~0.01	0.02	3D銑 3D MILLING
MBTA0042	10	17000~18000	300~400	0.01~0.02	0.4	溝銑 SLOTTING
MBTA0042	10	17000~18000	350~450	0.01~0.015	0.4	溝銑 SLOTTING
MBTA0042	10	17000~18000	400~500	0.01~0.02	0.06	3D銑 3D MILLING
MBTA0042	10	17000~18000	500~600	0.01~0.015	0.03	3D銑 3D MILLING
MBTA0052	10	17000~18000	300~500	0.02~0.03	0.5	溝銑 SLOTTING
MBTA0052	10	17000~18000	500~600	0.015~0.025	0.5	溝銑 SLOTTING
MBTA0052	10	17000~18000	400~600	0.02~0.03	0.06	3D銑 3D MILLING
MBTA0052	10	17000~18000	600~800	0.015~0.025	0.06	3D銑 3D MILLING
MBTA0062	10	17000~18000	400~600	0.03~0.04	0.6	溝銑 SLOTTING
MBTA0062	10	17000~18000	600~900	0.02~0.03	0.6	溝銑 SLOTTING
MBTA0062	10	17000~18000	500~600	0.03~0.04	0.08	3D銑 3D MILLING
MBTA0062	10	17000~18000	600~800	0.02~0.03	0.06	3D銑 3D MILLING
MBTA0072	10	17000~18000	500~700	0.04~0.06	0.7	溝銑 SLOTTING
MBTA0072	10	17000~18000	800~1000	0.03~0.04	0.7	溝銑 SLOTTING
MBTA0072	10	17000~18000	600~800	0.04~0.06	0.12	3D銑 3D MILLING
MBTA0072	10	17000~18000	900~1200	0.03~0.04	0.08	3D銑 3D MILLING
MBTA0082	10	17000~18000	600~800	0.05~0.06	0.8	溝銑 SLOTTING
MBTA0082	10	17000~18000	1000~1200	0.03~0.04	0.8	溝銑 SLOTTING
MBTA0082	10	17000~18000	700~900	0.05~0.06	0.12	3D銑 3D MILLING
MBTA0082	10	17000~18000	1000~1300	0.03~0.04	0.08	3D銑 3D MILLING
MBTA0102	10	16000~17000	700~800	0.05~0.06	1	溝銑 SLOTTING
MBTA0102	10	16000~17000	1200~1400	0.04~0.05	1	溝銑 SLOTTING
MBTA0102	10	16000~17000	900~1100	0.05~0.07	0.14	3D銑 3D MILLING
MBTA0102	10	16000~17000	1300~1500	0.04~0.05	0.1	3D銑 3D MILLING
MBTA0122	10	16000~17000	700~800	0.05~0.06	1.2	溝銑 SLOTTING
MBTA0122	10	16000~17000	1300~1500	0.04~0.05	1.2	溝銑 SLOTTING
MBTA0122	10	16000~17000	900~1100	0.05~0.07	0.14	3D銑 3D MILLING
MBTA0122	10	16000~17000	1400~1600	0.04~0.05	0.1	3D銑 3D MILLING
MBTA0142	10	16000~17000	800~1000	0.05~0.06	1.4	溝銑 SLOTTING
MBTA0142	10	16000~17000	1600~1800	0.04~0.05	1.4	溝銑 SLOTTING
MBTA0142	10	16000~17000	1200~1400	0.05~0.07	0.14	3D銑 3D MILLING
MBTA0142	10	16000~17000	1800~2000	0.04~0.05	0.1	3D銑 3D MILLING
MBTA0162	10	16000~17000	800~1000	0.05~0.06	1.6	溝銑 SLOTTING
MBTA0162	10	16000~17000	1800~2000	0.04~0.05	1.6	溝銑 SLOTTING
MBTA0162	10	16000~17000	1300~1500	0.05~0.07	0.14	3D銑 3D MILLING
MBTA0162	10	16000~17000	2000~2300	0.04~0.05	0.1	3D銑 3D MILLING
MBTA0182	10	15000~17000	900~1100	0.06~0.08	1.8	溝銑 SLOTTING
MBTA0182	10	15000~17000	1800~2000	0.04~0.06	1.8	溝銑 SLOTTING
MBTA0182	10	15000~17000	1400~1700	0.06~0.08	0.16	3D銑 3D MILLING
MBTA0182	10	15000~17000	2200~2500	0.04~0.06	0.12	3D銑 3D MILLING
MBTA0202	11	14000~16000	1000~1200	0.06~0.08	2	溝銑 SLOTTING
MBTA0202	11	14000~16000	2000~2200	0.04~0.06	2	溝銑 SLOTTING
MBTA0202	11	14000~16000	1400~1800	0.06~0.08	0.16	3D銑 3D MILLING
MBTA0202	11	14000~16000	2200~2600	0.04~0.06	0.12	3D銑 3D MILLING
MBTA0302	13	13000~15000	1200~1400	0.08~0.1	3	溝銑 SLOTTING
MBTA0302	13	13000~15000	2000~2200	0.04~0.06	3	溝銑 SLOTTING
MBTA0302	13	13000~15000	1400~1800	0.1~0.12	0.24	3D銑 3D MILLING
MBTA0302	13	13000~15000	2400~2800	0.05~0.07	0.14	3D銑 3D MILLING
MBTA0402	15	12000~14000	1300~1500	0.1~0.12	4	溝銑 SLOTTING
MBTA0402	15	12000~14000	2200~2400	0.05~0.07	4	溝銑 SLOTTING
MBTA0402	15	12000~14000	1400~1800	0.12~0.15	0.3	3D銑 3D MILLING
MBTA0402	15	12000~14000	2600~3000	0.05~0.07	0.14	3D銑 3D MILLING

MBTA 切削條件表 MILLING CONDITIONS

被切削材 Work Material	調質鋼、預硬鋼 *Prehardened Steels* : **NAK80, 1.2083** (HRc38)					
冷卻方式 Coolant Type	濕式切削 Wet coolant					
型號 Type No.	刀具伸長量 Extension Length (mm)	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
MBTA0032	10	24000~26000	400~600	0.015~0.02	0.3	溝銑 SLOTTING
MBTA0032	10	24000~26000	500~700	0.01~0.015	0.3	溝銑 SLOTTING
MBTA0032	10	24000~26000	500~600	0.015~0.02	0.04	3D銑 3D MILLING
MBTA0032	10	24000~26000	600~700	0.01~0.015	0.02	3D銑 3D MILLING
MBTA0042	10	23000~25000	400~600	0.015~0.025	0.4	溝銑 SLOTTING
MBTA0042	10	23000~25000	500~700	0.015~0.02	0.4	溝銑 SLOTTING
MBTA0042	10	23000~25000	500~700	0.015~0.025	0.05	3D銑 3D MILLING
MBTA0042	10	23000~25000	600~800	0.015~0.02	0.03	3D銑 3D MILLING
MBTA0052	10	23000~25000	500~700	0.02~0.03	0.5	溝銑 SLOTTING
MBTA0052	10	23000~25000	650~850	0.015~0.02	0.5	溝銑 SLOTTING
MBTA0052	10	23000~25000	650~850	0.02~0.03	0.06	3D銑 3D MILLING
MBTA0052	10	23000~25000	700~800	0.015~0.02	0.04	3D銑 3D MILLING
MBTA0062	10	22000~24000	550~750	0.04~0.06	0.6	溝銑 SLOTTING
MBTA0062	10	22000~24000	700~900	0.025~0.035	0.6	溝銑 SLOTTING
MBTA0062	10	22000~24000	700~900	0.03~0.04	0.1	3D銑 3D MILLING
MBTA0062	10	22000~24000	800~1000	0.025~0.035	0.05	3D銑 3D MILLING
MBTA0072	10	22000~24000	650~800	0.05~0.07	0.7	溝銑 SLOTTING
MBTA0072	10	22000~24000	900~1200	0.03~0.04	0.7	溝銑 SLOTTING
MBTA0072	10	22000~24000	800~1000	0.05~0.07	0.14	3D銑 3D MILLING
MBTA0072	10	22000~24000	1200~1400	0.03~0.04	0.08	3D銑 3D MILLING
MBTA0082	10	21000~23000	750~950	0.05~0.07	0.8	溝銑 SLOTTING
MBTA0082	10	21000~23000	1000~1300	0.03~0.04	0.8	溝銑 SLOTTING
MBTA0082	10	21000~23000	1000~1200	0.05~0.07	0.14	3D銑 3D MILLING
MBTA0082	10	21000~23000	1200~1400	0.03~0.04	0.08	3D銑 3D MILLING
MBTA0102	10	18000~20000	900~1100	0.06~0.07	1	溝銑 SLOTTING
MBTA0102	10	18000~20000	1300~1500	0.04~0.05	1	溝銑 SLOTTING
MBTA0102	10	18000~20000	1300~1500	0.06~0.07	0.14	3D銑 3D MILLING
MBTA0102	10	18000~20000	1600~1800	0.03~0.05	0.1	3D銑 3D MILLING
MBTA0122	10	18000~20000	900~1100	0.06~0.08	1.2	溝銑 SLOTTING
MBTA0122	10	18000~20000	1300~1500	0.04~0.05	1.2	溝銑 SLOTTING
MBTA0122	10	18000~20000	1300~1500	0.06~0.08	0.16	3D銑 3D MILLING
MBTA0122	10	18000~20000	1800~2200	0.03~0.05	0.1	3D銑 3D MILLING
MBTA0142	10	18000~20000	1000~1200	0.06~0.08	1.4	溝銑 SLOTTING
MBTA0142	10	18000~20000	1400~1600	0.04~0.05	1.4	溝銑 SLOTTING
MBTA0142	10	18000~20000	1400~1600	0.07~0.09	0.18	3D銑 3D MILLING
MBTA0142	10	18000~20000	2000~2300	0.04~0.05	0.1	3D銑 3D MILLING
MBTA0162	10	16000~18000	1000~1200	0.07~0.09	1.6	溝銑 SLOTTING
MBTA0162	10	16000~18000	1800~2200	0.04~0.05	1.6	溝銑 SLOTTING
MBTA0162	10	16000~18000	1400~1600	0.08~0.1	0.2	3D銑 3D MILLING
MBTA0162	10	16000~18000	2000~2400	0.04~0.05	0.1	3D銑 3D MILLING
MBTA0182	10	15000~17000	1100~1300	0.08~0.1	1.8	溝銑 SLOTTING
MBTA0182	10	15000~17000	2000~2400	0.04~0.05	1.8	溝銑 SLOTTING
MBTA0182	10	15000~17000	1500~1700	0.1~0.12	0.24	3D銑 3D MILLING
MBTA0182	10	15000~17000	2400~2600	0.05~0.06	0.12	3D銑 3D MILLING
MBTA0202	11	14000~16000	1100~1400	0.08~0.1	2	溝銑 SLOTTING
MBTA0202	11	14000~16000	2200~2600	0.04~0.06	2	溝銑 SLOTTING
MBTA0202	11	14000~16000	1600~1800	0.1~0.12	0.24	3D銑 3D MILLING
MBTA0202	11	14000~16000	2400~2700	0.05~0.07	0.14	3D銑 3D MILLING
MBTA0302	13	13000~15000	1100~1400	0.12~0.15	3	溝銑 SLOTTING
MBTA0302	13	13000~15000	2500~3000	0.05~0.07	3	溝銑 SLOTTING
MBTA0302	13	13000~15000	1600~1800	0.13~0.15	0.3	3D銑 3D MILLING
MBTA0302	13	13000~15000	2800~3000	0.06~0.08	0.16	3D銑 3D MILLING
MBTA0402	15	13000~15000	1100~1400	0.15~0.18	4	溝銑 SLOTTING
MBTA0402	15	13000~15000	2600~3000	0.05~0.07	4	溝銑 SLOTTING
MBTA0402	15	13000~15000	1600~2000	0.14~0.16	0.32	3D銑 3D MILLING
MBTA0402	15	13000~15000	2800~3200	0.06~0.09	0.18	3D銑 3D MILLING

MBTA 切削條件表 MILLING CONDITIONS

被切削材 Work Material	調質鋼、預硬鋼 *Prehardened Steels* : **NAK80, 1.2083** (HRc38)					
冷卻方式 Coolant Type	濕式切削 Wet coolant					
型號 Type No.	刀具伸長量 Extension Length (mm)	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
MBTA0032	10	17000~18000	400~600	0.015~0.02	0.3	溝銑 SLOTTING
MBTA0032	10	17000~18000	500~700	0.01~0.015	0.3	溝銑 SLOTTING
MBTA0032	10	17000~18000	500~600	0.015~0.02	0.04	**3D**銑 3D MILLING
MBTA0032	10	17000~18000	600~700	0.01~0.015	0.02	**3D**銑 3D MILLING
MBTA0042	10	17000~18000	400~600	0.015~0.025	0.4	溝銑 SLOTTING
MBTA0042	10	17000~18000	500~700	0.015~0.02	0.4	溝銑 SLOTTING
MBTA0042	10	17000~18000	500~700	0.015~0.025	0.05	**3D**銑 3D MILLING
MBTA0042	10	17000~18000	600~800	0.015~0.02	0.03	**3D**銑 3D MILLING
MBTA0052	10	17000~18000	500~700	0.02~0.03	0.5	溝銑 SLOTTING
MBTA0052	10	17000~18000	650~850	0.015~0.02	0.5	溝銑 SLOTTING
MBTA0052	10	17000~18000	650~850	0.02~0.03	0.06	**3D**銑 3D MILLING
MBTA0052	10	17000~18000	700~800	0.015~0.02	0.04	**3D**銑 3D MILLING
MBTA0062	10	17000~18000	550~750	0.04~0.06	0.6	溝銑 SLOTTING
MBTA0062	10	17000~18000	700~900	0.025~0.035	0.6	溝銑 SLOTTING
MBTA0062	10	17000~18000	700~900	0.03~0.04	0.1	**3D**銑 3D MILLING
MBTA0062	10	17000~18000	800~1000	0.025~0.035	0.05	**3D**銑 3D MILLING
MBTA0072	10	17000~18000	650~800	0.05~0.07	0.7	溝銑 SLOTTING
MBTA0072	10	17000~18000	900~1200	0.03~0.04	0.7	溝銑 SLOTTING
MBTA0072	10	17000~18000	800~1000	0.05~0.07	0.14	**3D**銑 3D MILLING
MBTA0072	10	17000~18000	1200~1400	0.03~0.04	0.08	**3D**銑 3D MILLING
MBTA0082	10	17000~18000	750~950	0.05~0.07	0.8	溝銑 SLOTTING
MBTA0082	10	17000~18000	1000~1300	0.03~0.04	0.8	溝銑 SLOTTING
MBTA0082	10	17000~18000	1000~1200	0.05~0.07	0.14	**3D**銑 3D MILLING
MBTA0082	10	17000~18000	1200~1400	0.03~0.04	0.08	**3D**銑 3D MILLING
MBTA0102	10	16000~17000	900~1100	0.06~0.07	1	溝銑 SLOTTING
MBTA0102	10	16000~17000	1300~1500	0.04~0.05	1	溝銑 SLOTTING
MBTA0102	10	16000~17000	1300~1500	0.06~0.07	0.14	**3D**銑 3D MILLING
MBTA0102	10	16000~17000	1600~1800	0.03~0.05	0.1	**3D**銑 3D MILLING
MBTA0122	10	16000~17000	900~1100	0.06~0.08	1.2	溝銑 SLOTTING
MBTA0122	10	16000~17000	1300~1500	0.04~0.05	1.2	溝銑 SLOTTING
MBTA0122	10	16000~17000	1300~1500	0.06~0.08	0.16	**3D**銑 3D MILLING
MBTA0122	10	16000~17000	1800~2200	0.03~0.05	0.1	**3D**銑 3D MILLING
MBTA0142	10	16000~17000	1000~1200	0.06~0.08	1.4	溝銑 SLOTTING
MBTA0142	10	16000~17000	1400~1600	0.04~0.05	1.4	溝銑 SLOTTING
MBTA0142	10	16000~17000	1400~1600	0.07~0.09	0.18	**3D**銑 3D MILLING
MBTA0142	10	16000~17000	2000~2300	0.04~0.05	0.1	**3D**銑 3D MILLING
MBTA0162	10	16000~17000	1000~1200	0.07~0.09	1.6	溝銑 SLOTTING
MBTA0162	10	16000~17000	1800~2200	0.04~0.05	1.6	溝銑 SLOTTING
MBTA0162	10	16000~17000	1400~1600	0.08~0.1	0.2	**3D**銑 3D MILLING
MBTA0162	10	16000~17000	2000~2400	0.04~0.05	0.1	**3D**銑 3D MILLING
MBTA0182	10	15000~17000	1100~1300	0.08~0.1	1.8	溝銑 SLOTTING
MBTA0182	10	15000~17000	2000~2400	0.04~0.05	1.8	溝銑 SLOTTING
MBTA0182	10	15000~17000	1500~1700	0.1~0.12	0.24	**3D**銑 3D MILLING
MBTA0182	10	15000~17000	2400~2600	0.05~0.06	0.12	**3D**銑 3D MILLING
MBTA0202	11	14000~16000	1100~1400	0.08~0.1	2	溝銑 SLOTTING
MBTA0202	11	14000~16000	2200~2600	0.04~0.06	2	溝銑 SLOTTING
MBTA0202	11	14000~16000	1600~1800	0.1~0.12	0.24	**3D**銑 3D MILLING
MBTA0202	11	14000~16000	2400~2700	0.05~0.07	0.14	**3D**銑 3D MILLING
MBTA0302	13	13000~15000	1100~1400	0.12~0.15	3	溝銑 SLOTTING
MBTA0302	13	13000~15000	2500~3000	0.05~0.07	3	溝銑 SLOTTING
MBTA0302	13	13000~15000	1600~1800	0.13~0.15	0.3	**3D**銑 3D MILLING
MBTA0302	13	13000~15000	2800~3000	0.06~0.08	0.16	**3D**銑 3D MILLING
MBTA0402	15	12000~14000	1100~1400	0.15~0.18	4	溝銑 SLOTTING
MBTA0402	15	12000~14000	2600~3000	0.05~0.07	4	溝銑 SLOTTING
MBTA0402	15	12000~14000	1600~2000	0.14~0.16	0.32	**3D**銑 3D MILLING
MBTA0402	15	12000~14000	2800~3200	0.06~0.09	0.18	**3D**銑 3D MILLING