

被切削材 Work Material		熱處理鋼 Hardened Steels : SKD61/STAVAX/1.2083/17-4PH (HRC52)					
冷卻方式 Coolant Type		油霧切削 MQL 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 ⁻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
UME0022	12	15	18000~20000	150~300	0.005~0.008	0.2	溝銑 SLOTTING
UME0022	12	15	18000~20000	150~300	0.005~0.008	0.2	溝銑 SLOTTING
UME0032	12	20	18000~20000	150~300	0.005~0.01	0.3	溝銑 SLOTTING
UME0032	12	20	18000~20000	150~300	0.005~0.01	0.3	溝銑 SLOTTING
UME0042	12	25	18000~20000	200~400	0.008~0.015	0.4	溝銑 SLOTTING
UME0042	12	25	18000~20000	200~400	0.008~0.015	0.4	溝銑 SLOTTING
UME0052	12	30	18000~20000	200~400	0.015~0.025	0.5	溝銑 SLOTTING
UME0052	12	30	18000~20000	400~600	0.01~0.015	0.5	溝銑 SLOTTING
UME0062	12	35	16000~18000	200~400	0.02~0.04	0.6	溝銑 SLOTTING
UME0062	12	35	16000~18000	400~600	0.015~0.025	0.6	溝銑 SLOTTING
UME0072	12	40	16000~18000	300~500	0.03~0.05	0.7	溝銑 SLOTTING
UME0072	12	40	16000~18000	600~800	0.015~0.025	0.7	溝銑 SLOTTING
UME0082	12	45	16000~18000	400~600	0.04~0.06	0.8	溝銑 SLOTTING
UME0082	12	45	16000~18000	800~1000	0.015~0.03	0.8	溝銑 SLOTTING
UME0102	12	50	16000~18000	400~600	0.04~0.06	1	溝銑 SLOTTING
UME0102	12	50	16000~18000	800~1000	0.015~0.03	1	溝銑 SLOTTING
UME0122	12	60	16000~18000	400~600	0.04~0.06	1.2	溝銑 SLOTTING
UME0122	12	60	16000~18000	800~1000	0.015~0.03	1.2	溝銑 SLOTTING
UME0152	12	75	15000~16000	600~800	0.05~0.07	1.5	溝銑 SLOTTING
UME0152	12	75	15000~16000	1000~1200	0.015~0.035	1.5	溝銑 SLOTTING
UME0162	13	80	15000~16000	600~800	0.06~0.08	1.6	溝銑 SLOTTING
UME0162	13	80	15000~16000	1000~1200	0.015~0.035	1.6	溝銑 SLOTTING
UME0182	13	90	15000~16000	600~800	0.07~0.09	1.8	溝銑 SLOTTING
UME0182	13	90	15000~16000	1200~1600	0.02~0.04	1.8	溝銑 SLOTTING
UME0202	15	95	13000~15000	600~800	0.08~0.1	2	溝銑 SLOTTING
UME0202	15	95	13000~15000	1200~1600	0.02~0.045	2	溝銑 SLOTTING
UME0252	15	105	11000~13000	800~1000	0.08~0.1	2.5	溝銑 SLOTTING
UME0252	15	105	11000~13000	1400~1800	0.02~0.05	2.5	溝銑 SLOTTING
UME0302	14	105	9000~11000	1000~1200	0.09~0.11	3	溝銑 SLOTTING
UME0302	14	105	9000~11000	1600~2000	0.025~0.06	3	溝銑 SLOTTING
UME0402	15	115	7000~9000	1400~1600	0.12~0.14	4	溝銑 SLOTTING
UME0402	15	115	7000~9000	2000~2400	0.03~0.08	4	溝銑 SLOTTING

附註 Note

UME不適用於SKD11(HRC62)溝銑或面銑，可用於清角

UME is not good at slotting or surfacing on material SKD11 (HRC62), it is suitable for Corner Finishing Milling.