

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		乾式切削 Dry 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
UNB0502	15	35	18000~20000	200~400	0.005~0.013	0.5	溝銑 SLOTTING 3D銑 3D MILLING
UNB0502	15	35	18000~20000	200~400	0.008~0.015	0.016~0.03	溝銑 SLOTTING 3D銑 3D MILLING
UNB0504	17	35	18000~20000	200~400	0.005~0.013	0.5	溝銑 SLOTTING 3D銑 3D MILLING
UNB0504	17	35	18000~20000	200~400	0.008~0.015	0.016~0.03	溝銑 SLOTTING 3D銑 3D MILLING
UNB0506	19	35	18000~20000	150~300	0.005~0.013	0.5	溝銑 SLOTTING 3D銑 3D MILLING
UNB0506	19	35	18000~20000	200~400	0.005~0.013	0.01~0.026	溝銑 SLOTTING 3D銑 3D MILLING
UNB0604	18	40	18000~20000	200~400	0.005~0.013	0.6	溝銑 SLOTTING 3D銑 3D MILLING
UNB0604	18	40	18000~20000	200~400	0.008~0.015	0.016~0.03	溝銑 SLOTTING 3D銑 3D MILLING
UNB0606	20	40	18000~20000	150~300	0.005~0.013	0.6	溝銑 SLOTTING 3D銑 3D MILLING
UNB0606	20	40	18000~20000	200~400	0.005~0.013	0.01~0.026	溝銑 SLOTTING 3D銑 3D MILLING
UNB0806	17	45	16000~18000	300~500	0.01~0.02	0.8	溝銑 SLOTTING 3D銑 3D MILLING
UNB0806	17	45	16000~18000	300~500	0.015~0.025	0.03~0.05	溝銑 SLOTTING 3D銑 3D MILLING
UNB0806	17	45	16000~18000	500~700	0.005~0.015	0.01~0.03	溝銑 SLOTTING 3D銑 3D MILLING
UNB0808	19	45	16000~18000	200~400	0.01~0.02	0.8	溝銑 SLOTTING 3D銑 3D MILLING
UNB0808	19	45	16000~18000	200~400	0.015~0.025	0.03~0.05	溝銑 SLOTTING 3D銑 3D MILLING
UNB0808	19	45	16000~18000	400~600	0.005~0.015	0.01~0.03	溝銑 SLOTTING 3D銑 3D MILLING
UNB1006	13	50	15000~16000	400~600	0.015~0.035	1	溝銑 SLOTTING 3D銑 3D MILLING
UNB1006	13	50	15000~16000	400~600	0.03~0.05	0.06~0.1	溝銑 SLOTTING 3D銑 3D MILLING
UNB1006	13	50	15000~16000	600~800	0.01~0.03	0.02~0.06	溝銑 SLOTTING 3D銑 3D MILLING
UNB1008	15	50	15000~16000	300~500	0.01~0.03	1	溝銑 SLOTTING 3D銑 3D MILLING
UNB1008	15	50	15000~16000	300~500	0.03~0.05	0.06~0.1	溝銑 SLOTTING 3D銑 3D MILLING
UNB1008	15	50	15000~16000	600~800	0.01~0.02	0.02~0.04	溝銑 SLOTTING 3D銑 3D MILLING
UNB1010	17	50	15000~16000	300~500	0.01~0.03	1	溝銑 SLOTTING 3D銑 3D MILLING
UNB1010	17	50	15000~16000	300~500	0.03~0.05	0.06~0.1	溝銑 SLOTTING 3D銑 3D MILLING
UNB1010	17	50	15000~16000	600~800	0.01~0.02	0.02~0.04	溝銑 SLOTTING 3D銑 3D MILLING
UNB1012	19	50	15000~16000	300~500	0.01~0.03	1	溝銑 SLOTTING 3D銑 3D MILLING
UNB1012	19	50	15000~16000	300~500	0.03~0.05	0.06~0.1	溝銑 SLOTTING 3D銑 3D MILLING
UNB1012	19	50	15000~16000	600~800	0.01~0.02	0.02~0.04	溝銑 SLOTTING 3D銑 3D MILLING
UNB1208	15	60	15000~16000	400~600	0.02~0.04	1.2	溝銑 SLOTTING 3D銑 3D MILLING
UNB1208	15	60	15000~16000	400~600	0.04~0.06	0.08~0.12	溝銑 SLOTTING 3D銑 3D MILLING
UNB1208	15	60	15000~16000	800~1000	0.01~0.025	0.02~0.05	溝銑 SLOTTING 3D銑 3D MILLING
UNB1212	19	60	15000~16000	400~600	0.02~0.04	1.2	溝銑 SLOTTING 3D銑 3D MILLING
UNB1212	19	60	15000~16000	400~600	0.04~0.06	0.08~0.12	溝銑 SLOTTING 3D銑 3D MILLING
UNB1212	19	60	15000~16000	800~1000	0.01~0.025	0.02~0.05	溝銑 SLOTTING 3D銑 3D MILLING
UNB1508	14	70	14000~15000	400~600	0.04~0.06	1.5	溝銑 SLOTTING 3D銑 3D MILLING
UNB1508	14	70	14000~15000	700~900	0.01~0.03	1.5	溝銑 SLOTTING 3D銑 3D MILLING
UNB1508	14	70	14000~15000	400~600	0.05~0.07	0.1~0.14	溝銑 SLOTTING 3D銑 3D MILLING
UNB1508	14	70	14000~15000	800~1000	0.015~0.035	0.03~0.07	溝銑 SLOTTING 3D銑 3D MILLING
UNB1510	16	70	14000~15000	400~600	0.03~0.05	1.5	溝銑 SLOTTING 3D銑 3D MILLING
UNB1510	16	70	14000~15000	600~800	0.01~0.03	1.5	溝銑 SLOTTING 3D銑 3D MILLING
UNB1510	16	70	14000~15000	400~600	0.04~0.06	0.08~0.12	溝銑 SLOTTING 3D銑 3D MILLING
UNB1510	16	70	14000~15000	700~900	0.015~0.035	0.03~0.07	溝銑 SLOTTING 3D銑 3D MILLING
UNB1512	18	70	14000~15000	300~500	0.03~0.05	1.5	溝銑 SLOTTING 3D銑 3D MILLING
UNB1512	18	70	14000~15000	500~700	0.01~0.03	1.5	溝銑 SLOTTING 3D銑 3D MILLING
UNB1512	18	70	14000~15000	400~600	0.04~0.06	0.08~0.12	溝銑 SLOTTING 3D銑 3D MILLING
UNB1512	18	70	14000~15000	600~800	0.015~0.035	0.03~0.07	溝銑 SLOTTING 3D銑 3D MILLING
UNB1516	22	70	14000~15000	300~500	0.02~0.04	1.5	溝銑 SLOTTING 3D銑 3D MILLING
UNB1516	22	70	14000~15000	500~600	0.008~0.02	1.5	溝銑 SLOTTING 3D銑 3D MILLING
UNB1516	22	70	14000~15000	300~500	0.03~0.05	0.06~0.1	溝銑 SLOTTING 3D銑 3D MILLING
UNB1516	22	70	14000~15000	600~800	0.01~0.025	0.02~0.05	溝銑 SLOTTING 3D銑 3D MILLING
UNB1520	26	70	14000~15000	200~400	0.02~0.04	1.5	溝銑 SLOTTING 3D銑 3D MILLING
UNB1520	26	70	14000~15000	400~600	0.008~0.02	1.5	溝銑 SLOTTING 3D銑 3D MILLING
UNB1520	26	70	14000~15000	200~400	0.02~0.04	0.04~0.08	溝銑 SLOTTING 3D銑 3D MILLING
UNB1520	26	70	14000~15000	400~600	0.008~0.02	0.016~0.04	溝銑 SLOTTING 3D銑 3D MILLING
UNB1608	14	75	14000~15000	500~700	0.04~0.06	1.6	溝銑 SLOTTING 3D銑 3D MILLING
UNB1608	14	75	14000~15000	800~1000	0.01~0.03	1.6	溝銑 SLOTTING 3D銑 3D MILLING
UNB1608	14	75	14000~15000	500~700	0.05~0.07	0.1~0.14	溝銑 SLOTTING 3D銑 3D MILLING
UNB1608	14	75	14000~15000	800~1000	0.015~0.035	0.03~0.07	溝銑 SLOTTING 3D銑 3D MILLING

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
UNB1612	16	75	14000~15000	400~600	0.03~0.05	1.6	溝銑 SLOTTING
UNB1612	16	75	14000~15000	600~800	0.01~0.03	1.6	溝銑 SLOTTING
UNB1612	16	75	14000~15000	500~700	0.04~0.06	0.08~0.12	3D銑 3D MILLING
UNB1612	16	75	14000~15000	800~1000	0.015~0.03	0.03~0.06	3D銑 3D MILLING
UNB1616	20	75	14000~15000	300~500	0.02~0.04	1.6	溝銑 SLOTTING
UNB1616	20	75	14000~15000	500~700	0.008~0.02	1.6	溝銑 SLOTTING
UNB1616	20	75	14000~15000	400~600	0.03~0.05	0.06~0.1	3D銑 3D MILLING
UNB1616	20	75	14000~15000	600~800	0.01~0.03	0.02~0.06	3D銑 3D MILLING
UNB2008	14	85	12000~13000	500~700	0.05~0.07	2	溝銑 SLOTTING
UNB2008	14	85	12000~13000	800~1000	0.01~0.03	2	溝銑 SLOTTING
UNB2008	14	85	12000~13000	500~700	0.07~0.09	0.14~0.18	3D銑 3D MILLING
UNB2008	14	85	12000~13000	1100~1300	0.015~0.035	0.03~0.07	3D銑 3D MILLING
UNB2010	16	85	12000~13000	400~600	0.04~0.06	2	溝銑 SLOTTING
UNB2010	16	85	12000~13000	800~1000	0.01~0.03	2	溝銑 SLOTTING
UNB2010	16	85	12000~13000	400~600	0.06~0.08	0.12~0.16	3D銑 3D MILLING
UNB2010	16	85	12000~13000	1000~1200	0.015~0.035	0.03~0.07	3D銑 3D MILLING
UNB2012	18	85	12000~13000	400~600	0.04~0.06	2	溝銑 SLOTTING
UNB2012	18	85	12000~13000	800~1000	0.01~0.03	2	溝銑 SLOTTING
UNB2012	18	85	12000~13000	400~600	0.06~0.08	0.12~0.16	3D銑 3D MILLING
UNB2012	18	85	12000~13000	1000~1200	0.015~0.035	0.03~0.07	3D銑 3D MILLING
UNB2016	22	85	12000~13000	300~500	0.03~0.05	2	溝銑 SLOTTING
UNB2016	22	85	12000~13000	600~800	0.01~0.025	2	溝銑 SLOTTING
UNB2016	22	85	12000~13000	400~600	0.04~0.06	0.08~0.12	3D銑 3D MILLING
UNB2016	22	85	12000~13000	800~1000	0.015~0.03	0.03~0.06	3D銑 3D MILLING
UNB2020	26	85	12000~13000	200~400	0.03~0.05	2	溝銑 SLOTTING
UNB2020	26	85	12000~13000	400~600	0.01~0.025	2	溝銑 SLOTTING
UNB2020	26	85	12000~13000	400~600	0.03~0.05	0.06~0.1	3D銑 3D MILLING
UNB2020	26	85	12000~13000	600~800	0.015~0.03	0.03~0.06	3D銑 3D MILLING
UNB3008	16	105	10000~11000	700~900	0.08~0.1	3	溝銑 SLOTTING
UNB3008	16	105	10000~11000	1200~1600	0.02~0.05	3	溝銑 SLOTTING
UNB3008	16	105	10000~11000	800~1000	0.12~0.14	0.24~0.28	3D銑 3D MILLING
UNB3008	16	105	10000~11000	1400~1800	0.03~0.07	0.06~0.14	3D銑 3D MILLING
UNB3010	18	105	10000~11000	600~800	0.08~0.1	3	溝銑 SLOTTING
UNB3010	18	105	10000~11000	1100~1500	0.02~0.05	3	溝銑 SLOTTING
UNB3010	18	105	10000~11000	700~900	0.12~0.14	0.24~0.28	3D銑 3D MILLING
UNB3010	18	105	10000~11000	1300~1700	0.03~0.07	0.06~0.14	3D銑 3D MILLING
UNB3016	20	105	10000~11000	400~600	0.06~0.08	3	溝銑 SLOTTING
UNB3016	20	105	10000~11000	800~1200	0.015~0.035	3	溝銑 SLOTTING
UNB3016	20	105	10000~11000	600~800	0.1~0.12	0.2~0.24	3D銑 3D MILLING
UNB3016	20	105	10000~11000	1000~1400	0.02~0.05	0.04~0.1	3D銑 3D MILLING
UNB3020	24	105	10000~11000	300~500	0.04~0.06	3	溝銑 SLOTTING
UNB3020	24	105	10000~11000	700~900	0.01~0.03	3	溝銑 SLOTTING
UNB3020	24	105	10000~11000	400~600	0.07~0.09	0.14~0.18	3D銑 3D MILLING
UNB3020	24	105	10000~11000	900~1300	0.015~0.035	0.03~0.07	3D銑 3D MILLING
UNB3025	28	105	10000~11000	200~400	0.04~0.06	3	溝銑 SLOTTING
UNB3025	28	105	10000~11000	600~800	0.01~0.03	3	溝銑 SLOTTING
UNB3025	28	105	10000~11000	400~600	0.06~0.08	0.12~0.16	3D銑 3D MILLING
UNB3025	28	105	10000~11000	800~1200	0.015~0.035	0.03~0.07	3D銑 3D MILLING
UNB4010	20	115	8000~9000	800~1000	0.1~0.12	4	溝銑 SLOTTING
UNB4010	20	115	8000~9000	1400~1800	0.03~0.07	4	溝銑 SLOTTING
UNB4010	20	115	8000~9000	1000~1200	0.14~0.16	0.28~0.32	3D銑 3D MILLING
UNB4010	20	115	8000~9000	1600~2000	0.04~0.09	0.08~0.18	3D銑 3D MILLING
UNB4015	25	115	8000~9000	600~800	0.08~0.1	4	溝銑 SLOTTING
UNB4015	25	115	8000~9000	1200~1600	0.025~0.06	4	溝銑 SLOTTING
UNB4015	25	115	8000~9000	1000~1200	0.1~0.12	0.2~0.24	3D銑 3D MILLING
UNB4015	25	115	8000~9000	1600~2000	0.03~0.06	0.06~0.12	3D銑 3D MILLING
UNB4020	30	115	8000~9000	600~800	0.06~0.08	4	溝銑 SLOTTING
UNB4020	30	115	8000~9000	1000~1400	0.025~0.05	4	溝銑 SLOTTING
UNB4020	30	115	8000~9000	1000~1200	0.08~0.1	0.16~0.2	3D銑 3D MILLING
UNB4020	30	115	8000~9000	1600~2000	0.025~0.05	0.05~0.1	3D銑 3D MILLING
UNB4025	35	115	8000~9000	500~700	0.05~0.07	4	溝銑 SLOTTING
UNB4025	35	115	8000~9000	800~1200	0.015~0.035	4	溝銑 SLOTTING
UNB4025	35	115	8000~9000	800~1000	0.06~0.08	0.12~0.16	3D銑 3D MILLING
UNB4025	35	115	8000~9000	1200~1600	0.025~0.05	0.05~0.1	3D銑 3D MILLING
UNB4030	40	115	8000~9000	400~600	0.04~0.06	4	溝銑 SLOTTING
UNB4030	40	115	8000~9000	700~1100	0.015~0.035	4	溝銑 SLOTTING
UNB4030	40	115	8000~9000	600~800	0.05~0.07	0.1~0.14	3D銑 3D MILLING
UNB4030	40	115	8000~9000	1000~1400	0.015~0.04	0.03~0.08	3D銑 3D MILLING