

被切削材 Work Material		熱處理鋼 Hardened Steels :SKD11 / 1.2379/D2 (HRC62)					
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
UNBX0201	12	15	16000~18000	100~200	0.003~0.006	0.2	溝銑 SLOTTING
UNBX0201	12	15	16000~18000	100~200	0.005~0.008	0.01~0.016	3D銑 3D MILLING
UNBX0202	13	15	16000~18000	100~200	0.003~0.006	0.2	溝銑 SLOTTING
UNBX0202	13	15	16000~18000	100~200	0.005~0.008	0.01~0.016	3D銑 3D MILLING
UNBX0301	13	15	15000~16000	100~200	0.003~0.006	0.3	溝銑 SLOTTING
UNBX0301	13	15	15000~16000	100~200	0.005~0.01	0.01~0.02	3D銑 3D MILLING
UNBX0302	14	15	15000~16000	100~200	0.003~0.006	0.3	溝銑 SLOTTING
UNBX0302	14	15	15000~16000	100~200	0.005~0.01	0.01~0.02	3D銑 3D MILLING
UNBX0303	15	15	15000~16000	100~200	0.003~0.006	0.3	溝銑 SLOTTING
UNBX0303	15	15	15000~16000	100~200	0.005~0.01	0.01~0.02	3D銑 3D MILLING
UNBX0402	14	20	15000~16000	100~200	0.005~0.008	0.4	溝銑 SLOTTING
UNBX0402	14	20	15000~16000	150~300	0.005~0.01	0.01~0.02	3D銑 3D MILLING
UNBX0403	15	20	15000~16000	100~200	0.005~0.008	0.4	溝銑 SLOTTING
UNBX0403	15	20	15000~16000	150~300	0.005~0.01	0.01~0.02	3D銑 3D MILLING
UNBX0404	16	20	15000~16000	100~200	0.005~0.008	0.4	溝銑 SLOTTING
UNBX0404	16	20	15000~16000	100~200	0.005~0.01	0.01~0.02	3D銑 3D MILLING
UNBX0502	15	25	15000~16000	150~300	0.005~0.01	0.5	溝銑 SLOTTING
UNBX0502	15	25	15000~16000	150~300	0.005~0.01	0.01~0.02	3D銑 3D MILLING
UNBX0504	17	25	15000~16000	100~200	0.005~0.01	0.5	溝銑 SLOTTING
UNBX0504	17	25	15000~16000	100~200	0.005~0.01	0.01~0.02	3D銑 3D MILLING
UNBX0506	19	25	15000~16000	100~200	0.005~0.01	0.5	溝銑 SLOTTING
UNBX0506	19	25	15000~16000	100~200	0.005~0.01	0.01~0.02	3D銑 3D MILLING
UNBX0602	16	30	14000~15000	150~300	0.005~0.01	0.6	溝銑 SLOTTING
UNBX0602	16	30	14000~15000	150~300	0.005~0.01	0.01~0.02	3D銑 3D MILLING
UNBX0604	18	30	14000~15000	100~200	0.005~0.01	0.6	溝銑 SLOTTING
UNBX0604	18	30	14000~15000	100~200	0.005~0.01	0.01~0.02	3D銑 3D MILLING
UNBX0606	20	30	14000~15000	100~200	0.005~0.01	0.6	溝銑 SLOTTING
UNBX0606	20	30	14000~15000	100~200	0.005~0.01	0.01~0.02	3D銑 3D MILLING
UNBX0804	15	40	14000~15000	200~400	0.01~0.02	0.8	溝銑 SLOTTING
UNBX0804	15	40	14000~15000	200~400	0.008~0.015	0.016~0.03	3D銑 3D MILLING
UNBX0804	15	40	14000~15000	200~400	0.008~0.015	0.016~0.03	3D銑 3D MILLING
UNBX0806	17	40	14000~15000	150~300	0.01~0.02	0.8	溝銑 SLOTTING
UNBX0806	17	40	14000~15000	150~300	0.005~0.015	0.01~0.03	3D銑 3D MILLING
UNBX0806	17	40	14000~15000	150~300	0.005~0.015	0.01~0.03	3D銑 3D MILLING
UNBX0808	19	40	14000~15000	150~300	0.01~0.02	0.8	溝銑 SLOTTING
UNBX0808	19	40	14000~15000	150~300	0.005~0.015	0.01~0.03	3D銑 3D MILLING
UNBX0808	19	40	14000~15000	150~300	0.005~0.015	0.01~0.03	3D銑 3D MILLING
UNBX1004	11	45	13000~14000	200~400	0.01~0.02	1	溝銑 SLOTTING
UNBX1004	11	45	13000~14000	300~500	0.02~0.04	0.04~0.08	3D銑 3D MILLING
UNBX1004	11	45	13000~14000	500~700	0.008~0.015	0.016~0.03	3D銑 3D MILLING
UNBX1006	13	45	13000~14000	200~400	0.01~0.02	1	溝銑 SLOTTING
UNBX1006	13	45	13000~14000	300~500	0.02~0.04	0.04~0.08	3D銑 3D MILLING
UNBX1006	13	45	13000~14000	500~700	0.008~0.015	0.016~0.03	3D銑 3D MILLING
UNBX1008	15	45	13000~14000	200~400	0.01~0.02	1	溝銑 SLOTTING
UNBX1008	15	45	13000~14000	200~400	0.02~0.04	0.04~0.08	3D銑 3D MILLING
UNBX1008	15	45	13000~14000	500~700	0.008~0.015	0.016~0.03	3D銑 3D MILLING
UNBX1010	17	45	13000~14000	200~400	0.01~0.02	1	溝銑 SLOTTING
UNBX1010	17	45	13000~14000	200~400	0.02~0.04	0.04~0.08	3D銑 3D MILLING
UNBX1010	17	45	13000~14000	500~700	0.008~0.015	0.016~0.03	3D銑 3D MILLING
UNBX1012	19	45	13000~14000	150~300	0.01~0.02	1	溝銑 SLOTTING
UNBX1012	19	45	13000~14000	150~300	0.015~0.025	0.03~0.05	3D銑 3D MILLING
UNBX1012	19	45	13000~14000	300~400	0.008~0.015	0.016~0.03	3D銑 3D MILLING

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UNBX1208	15	50	12000~13000	200~400	0.02~0.04	1.2	溝銑 SLOTTING
UNBX1208	15	50	12000~13000	300~500	0.02~0.04	0.04~0.08	3D銑 3D MILLING
UNBX1208	15	50	12000~13000	500~700	0.01~0.02	0.02~0.04	3D銑 3D MILLING
UNBX1212	19	50	12000~13000	200~400	0.01~0.03	1.2	溝銑 SLOTTING
UNBX1212	19	50	12000~13000	200~400	0.008~0.015	0.016~0.03	3D銑 3D MILLING
UNBX1212	19	50	12000~13000	200~400	0.008~0.015	0.016~0.03	3D銑 3D MILLING
UNBX1506	13	60	11000~12000	400~600	0.03~0.05	1.5	溝銑 SLOTTING
UNBX1506	13	60	11000~12000	600~800	0.01~0.03	1.5	溝銑 SLOTTING
UNBX1506	13	60	11000~12000	400~600	0.04~0.06	0.08~0.12	3D銑 3D MILLING
UNBX1506	13	60	11000~12000	700~900	0.01~0.03	0.02~0.06	3D銑 3D MILLING
UNBX1508	14	60	11000~12000	300~500	0.03~0.05	1.5	溝銑 SLOTTING
UNBX1508	14	60	11000~12000	500~700	0.01~0.03	1.5	溝銑 SLOTTING
UNBX1508	14	60	11000~12000	400~600	0.04~0.06	0.08~0.12	3D銑 3D MILLING
UNBX1508	14	60	11000~12000	700~900	0.01~0.03	0.02~0.06	3D銑 3D MILLING
UNBX1510	16	60	11000~12000	300~500	0.02~0.04	1.5	溝銑 SLOTTING
UNBX1510	16	60	11000~12000	500~700	0.01~0.02	1.5	溝銑 SLOTTING
UNBX1510	16	60	11000~12000	300~500	0.03~0.05	0.06~0.1	3D銑 3D MILLING
UNBX1510	16	60	11000~12000	500~700	0.01~0.025	0.02~0.05	3D銑 3D MILLING
UNBX1512	18	60	11000~12000	300~500	0.02~0.04	1.5	溝銑 SLOTTING
UNBX1512	18	60	11000~12000	500~700	0.01~0.02	1.5	溝銑 SLOTTING
UNBX1512	18	60	11000~12000	300~500	0.03~0.05	0.06~0.1	3D銑 3D MILLING
UNBX1512	18	60	11000~12000	500~700	0.01~0.025	0.02~0.05	3D銑 3D MILLING
UNBX1516	22	60	11000~12000	200~400	0.01~0.02	1.5	溝銑 SLOTTING
UNBX1516	22	60	11000~12000	200~400	0.01~0.02	1.5	溝銑 SLOTTING
UNBX1516	22	60	11000~12000	300~500	0.02~0.04	0.04~0.08	3D銑 3D MILLING
UNBX1516	22	60	11000~12000	500~700	0.01~0.02	0.02~0.04	3D銑 3D MILLING
UNBX1520	26	60	11000~12000	150~300	0.01~0.02	1.5	溝銑 SLOTTING
UNBX1520	26	60	11000~12000	150~300	0.01~0.02	1.5	溝銑 SLOTTING
UNBX1520	26	60	11000~12000	150~300	0.02~0.04	0.04~0.08	3D銑 3D MILLING
UNBX1520	26	60	11000~12000	300~500	0.008~0.015	0.016~0.03	3D銑 3D MILLING
UNBX1608	14	60	11000~12000	300~500	0.03~0.05	1.6	溝銑 SLOTTING
UNBX1608	14	60	11000~12000	500~700	0.01~0.03	1.6	溝銑 SLOTTING
UNBX1608	14	60	11000~12000	400~600	0.04~0.06	0.08~0.12	3D銑 3D MILLING
UNBX1608	14	60	11000~12000	700~900	0.015~0.03	0.03~0.06	3D銑 3D MILLING
UNBX1612	16	60	11000~12000	200~400	0.02~0.04	1.6	溝銑 SLOTTING
UNBX1612	16	60	11000~12000	400~600	0.01~0.02	1.6	溝銑 SLOTTING
UNBX1612	16	60	11000~12000	300~500	0.03~0.05	0.06~0.1	3D銑 3D MILLING
UNBX1612	16	60	11000~12000	500~700	0.01~0.03	0.02~0.06	3D銑 3D MILLING
UNBX1616	20	60	11000~12000	200~400	0.01~0.02	1.6	溝銑 SLOTTING
UNBX1616	20	60	11000~12000	200~400	0.01~0.02	1.6	溝銑 SLOTTING
UNBX1616	20	60	11000~12000	200~400	0.01~0.03	0.02~0.06	3D銑 3D MILLING
UNBX1616	20	60	11000~12000	200~400	0.01~0.03	0.02~0.06	3D銑 3D MILLING
UNBX2008	14	70	10000~11000	400~600	0.04~0.06	2	溝銑 SLOTTING
UNBX2008	14	70	10000~11000	700~900	0.01~0.03	2	溝銑 SLOTTING
UNBX2008	14	70	10000~11000	400~600	0.05~0.07	0.1~0.14	3D銑 3D MILLING
UNBX2008	14	70	10000~11000	800~1000	0.015~0.035	0.03~0.07	3D銑 3D MILLING
UNBX2010	16	70	10000~11000	300~500	0.03~0.05	2	溝銑 SLOTTING
UNBX2010	16	70	10000~11000	500~700	0.01~0.03	2	溝銑 SLOTTING
UNBX2010	16	70	10000~11000	400~600	0.04~0.06	0.08~0.12	3D銑 3D MILLING
UNBX2010	16	70	10000~11000	800~1000	0.01~0.03	0.02~0.06	3D銑 3D MILLING
UNBX2012	18	70	10000~11000	300~500	0.03~0.05	2	溝銑 SLOTTING
UNBX2012	18	70	10000~11000	500~700	0.01~0.03	2	溝銑 SLOTTING
UNBX2012	18	70	10000~11000	400~600	0.04~0.06	0.08~0.12	3D銑 3D MILLING
UNBX2012	18	70	10000~11000	800~1000	0.01~0.03	0.02~0.06	3D銑 3D MILLING
UNBX2016	22	70	10000~11000	200~400	0.02~0.04	2	溝銑 SLOTTING
UNBX2016	22	70	10000~11000	400~600	0.01~0.02	2	溝銑 SLOTTING
UNBX2016	22	70	10000~11000	300~500	0.03~0.05	0.09~0.1	3D銑 3D MILLING
UNBX2016	22	70	10000~11000	500~700	0.01~0.03	0.02~0.06	3D銑 3D MILLING

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UNBX2020	26	70	10000~11000	200~400	0.01~0.02	2	溝銑 SLOTTING
UNBX2020	26	70	10000~11000	200~400	0.01~0.02	2	溝銑 SLOTTING
UNBX2020	26	70	10000~11000	200~400	0.01~0.03	0.02~0.06	3D銑 3D MILLING
UNBX2020	26	70	10000~11000	200~400	0.01~0.03	0.02~0.06	3D銑 3D MILLING
UNBX3008	16	85	8000~9000	600~800	0.06~0.08	3	溝銑 SLOTTING
UNBX3008	16	85	8000~9000	1000~1200	0.02~0.04	3	溝銑 SLOTTING
UNBX3008	16	85	8000~9000	600~800	0.09~0.11	0.18~0.22	3D銑 3D MILLING
UNBX3008	16	85	8000~9000	1000~1400	0.03~0.065	0.06~0.13	3D銑 3D MILLING
UNBX3010	18	85	8000~9000	500~700	0.06~0.08	3	溝銑 SLOTTING
UNBX3010	18	85	8000~9000	800~1000	0.02~0.04	3	溝銑 SLOTTING
UNBX3010	18	85	8000~9000	500~700	0.09~0.11	0.18~0.22	3D銑 3D MILLING
UNBX3010	18	85	8000~9000	900~1300	0.03~0.065	0.06~0.13	3D銑 3D MILLING
UNBX3012	20	85	8000~9000	500~700	0.05~0.07	3	溝銑 SLOTTING
UNBX3012	20	85	8000~9000	800~1000	0.02~0.04	3	溝銑 SLOTTING
UNBX3012	20	85	8000~9000	500~700	0.08~0.1	0.16~0.2	3D銑 3D MILLING
UNBX3012	20	85	8000~9000	900~1300	0.02~0.06	0.04~0.12	3D銑 3D MILLING
UNBX3016	24	85	8000~9000	400~600	0.05~0.07	3	溝銑 SLOTTING
UNBX3016	24	85	8000~9000	700~1100	0.015~0.035	3	溝銑 SLOTTING
UNBX3016	24	85	8000~9000	400~600	0.08~0.1	0.16~0.2	3D銑 3D MILLING
UNBX3016	24	85	8000~9000	800~1200	0.02~0.05	0.04~0.1	3D銑 3D MILLING
UNBX3020	28	85	8000~9000	300~500	0.03~0.05	3	溝銑 SLOTTING
UNBX3020	28	85	8000~9000	500~700	0.01~0.03	3	溝銑 SLOTTING
UNBX3020	28	85	8000~9000	400~600	0.06~0.08	0.12~0.16	3D銑 3D MILLING
UNBX3020	28	85	8000~9000	800~1000	0.015~0.035	0.03~0.07	3D銑 3D MILLING
UNBX3025	33	85	8000~9000	200~400	0.02~0.04	3	溝銑 SLOTTING
UNBX3025	33	85	8000~9000	400~600	0.008~0.02	3	溝銑 SLOTTING
UNBX3025	33	85	8000~9000	300~500	0.04~0.06	0.08~0.12	3D銑 3D MILLING
UNBX3025	33	85	8000~9000	700~900	0.01~0.025	0.02~0.05	3D銑 3D MILLING
UNBX4010	20	100	6000~8000	600~800	0.07~0.09	4	溝銑 SLOTTING
UNBX4010	20	100	6000~8000	1000~1400	0.03~0.05	4	溝銑 SLOTTING
UNBX4010	20	100	6000~8000	800~1000	0.11~0.13	0.22~0.26	3D銑 3D MILLING
UNBX4010	20	100	6000~8000	1400~1800	0.035~0.07	0.07~0.14	3D銑 3D MILLING
UNBX4015	25	100	6000~8000	400~600	0.06~0.08	4	溝銑 SLOTTING
UNBX4015	25	100	6000~8000	800~1000	0.025~0.05	4	溝銑 SLOTTING
UNBX4015	25	100	6000~8000	600~800	0.07~0.09	0.14~0.18	3D銑 3D MILLING
UNBX4015	25	100	6000~8000	1200~1600	0.03~0.06	0.06~0.12	3D銑 3D MILLING
UNBX4020	30	100	6000~8000	400~600	0.05~0.07	4	溝銑 SLOTTING
UNBX4020	30	100	6000~8000	800~1000	0.015~0.03	4	溝銑 SLOTTING
UNBX4020	30	100	6000~8000	600~800	0.06~0.08	0.12~0.16	3D銑 3D MILLING
UNBX4020	30	100	6000~8000	1200~1600	0.025~0.05	0.05~0.1	3D銑 3D MILLING
UNBX4025	35	100	6000~8000	300~500	0.04~0.06	4	溝銑 SLOTTING
UNBX4025	35	100	6000~8000	700~900	0.015~0.03	4	溝銑 SLOTTING
UNBX4025	35	100	6000~8000	500~700	0.05~0.07	0.1~0.14	3D銑 3D MILLING
UNBX4025	35	100	6000~8000	900~1100	0.015~0.03	0.03~0.06	3D銑 3D MILLING
UNBX4030	40	100	6000~8000	200~400	0.04~0.06	4	溝銑 SLOTTING
UNBX4030	40	100	6000~8000	500~700	0.015~0.03	4	溝銑 SLOTTING
UNBX4030	40	100	6000~8000	400~600	0.04~0.06	0.08~0.12	3D銑 3D MILLING
UNBX4030	40	100	6000~8000	800~1000	0.01~0.03	0.02~0.06	3D銑 3D MILLING