

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
UNBX100404	11	60	17000~18000	600~800	0.015~0.035	1	溝銑 SLOTTING
UNBX100404	11	60	17000~18000	900~1100	0.02~0.04	0.04~0.08	3D銑 3D MILLING
UNBX100604	13	60	17000~18000	500~700	0.015~0.035	1	溝銑 SLOTTING
UNBX100604	13	60	17000~18000	800~1000	0.02~0.04	0.04~0.08	3D銑 3D MILLING
UNBX100804	15	60	17000~18000	400~600	0.015~0.035	1	溝銑 SLOTTING
UNBX100804	15	60	17000~18000	700~900	0.02~0.04	0.04~0.08	3D銑 3D MILLING
UNBX101004	17	60	17000~18000	300~500	0.01~0.025	1	溝銑 SLOTTING
UNBX101004	17	60	17000~18000	600~800	0.02~0.03	0.04~0.06	3D銑 3D MILLING
UNBX101204	19	60	17000~18000	300~500	0.01~0.025	1	溝銑 SLOTTING
UNBX101204	19	60	17000~18000	600~800	0.01~0.025	0.02~0.05	3D銑 3D MILLING
UNBX150604	13	80	16000~17000	600~800	0.02~0.04	1.5	溝銑 SLOTTING
UNBX150604	13	80	16000~17000	900~1100	0.03~0.05	0.06~0.1	3D銑 3D MILLING
UNBX150804	15	80	16000~17000	500~700	0.02~0.04	1.5	溝銑 SLOTTING
UNBX150804	15	80	16000~17000	800~1000	0.03~0.05	0.06~0.1	3D銑 3D MILLING
UNBX151004	17	80	16000~17000	400~600	0.015~0.035	1.5	溝銑 SLOTTING
UNBX151004	17	80	16000~17000	700~900	0.02~0.04	0.04~0.08	3D銑 3D MILLING
UNBX151204	19	80	16000~17000	300~500	0.015~0.035	1.5	溝銑 SLOTTING
UNBX151204	19	80	16000~17000	600~800	0.02~0.04	0.04~0.08	3D銑 3D MILLING
UNBX151604	23	80	16000~17000	200~400	0.015~0.035	1.5	溝銑 SLOTTING
UNBX151604	23	80	16000~17000	500~700	0.02~0.04	0.04~0.08	3D銑 3D MILLING
UNBX200804	14	100	15000~16000	600~800	0.03~0.06	2	溝銑 SLOTTING
UNBX200804	14	100	15000~16000	1000~1400	0.03~0.06	0.06~0.12	3D銑 3D MILLING
UNBX201004	16	100	15000~16000	600~800	0.03~0.06	2	溝銑 SLOTTING
UNBX201004	16	100	15000~16000	1000~1200	0.03~0.06	0.06~0.12	3D銑 3D MILLING
UNBX201204	18	100	15000~16000	500~700	0.03~0.06	2	溝銑 SLOTTING
UNBX201204	18	100	15000~16000	900~1100	0.03~0.06	0.06~0.12	3D銑 3D MILLING
UNBX201604	22	100	15000~16000	500~700	0.02~0.05	2	溝銑 SLOTTING
UNBX201604	22	100	15000~16000	900~1100	0.02~0.04	0.04~0.08	3D銑 3D MILLING
UNBX202004	26	100	15000~16000	400~600	0.02~0.05	2	溝銑 SLOTTING
UNBX202004	26	100	15000~16000	700~900	0.02~0.04	0.04~0.08	3D銑 3D MILLING
UNBX300804	19	145	14000~15000	900~1100	0.04~0.08	3	溝銑 SLOTTING
UNBX300804	19	145	14000~15000	1400~1800	0.04~0.08	0.08~0.16	3D銑 3D MILLING
UNBX301004	21	145	14000~15000	900~1100	0.04~0.08	3	溝銑 SLOTTING
UNBX301004	21	145	14000~15000	1400~1800	0.04~0.08	0.08~0.16	3D銑 3D MILLING
UNBX301204	23	145	14000~15000	800~1000	0.04~0.08	3	溝銑 SLOTTING
UNBX301204	23	145	14000~15000	1300~1700	0.04~0.08	0.08~0.16	3D銑 3D MILLING
UNBX301604	27	145	14000~15000	700~900	0.03~0.06	3	溝銑 SLOTTING
UNBX301604	27	145	14000~15000	1200~1600	0.03~0.07	0.06~0.14	3D銑 3D MILLING
UNBX302004	31	145	14000~15000	700~900	0.02~0.05	3	溝銑 SLOTTING
UNBX302004	31	145	14000~15000	1200~1600	0.02~0.06	0.04~0.12	3D銑 3D MILLING
UNBX302504	36	145	14000~15000	600~800	0.01~0.03	3	溝銑 SLOTTING
UNBX302504	36	145	14000~15000	1100~1500	0.02~0.05	0.04~0.1	3D銑 3D MILLING
UNBX401004	26	165	11000~13000	1100~1500	0.04~0.08	4	溝銑 SLOTTING
UNBX401004	26	165	11000~13000	1600~2000	0.04~0.09	0.08~0.18	3D銑 3D MILLING
UNBX401204	28	165	11000~13000	1100~1500	0.04~0.08	4	溝銑 SLOTTING
UNBX401204	28	165	11000~13000	1600~2000	0.04~0.09	0.08~0.18	3D銑 3D MILLING
UNBX401604	32	165	11000~13000	1000~1400	0.03~0.06	4	溝銑 SLOTTING
UNBX401604	32	165	11000~13000	1600~2000	0.03~0.08	0.06~0.16	3D銑 3D MILLING
UNBX402004	36	165	11000~13000	1000~1200	0.03~0.06	4	溝銑 SLOTTING
UNBX402004	36	165	11000~13000	1400~1800	0.02~0.05	0.04~0.1	3D銑 3D MILLING
UNBX402504	41	165	11000~13000	800~1000	0.03~0.06	4	溝銑 SLOTTING
UNBX402504	41	165	11000~13000	1200~1600	0.02~0.05	0.04~0.1	3D銑 3D MILLING

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
UNBX100404	11	50	15000~16000	400~600	0.01~0.025	1	溝銑 SLOTTING
UNBX100404	11	50	15000~16000	700~900	0.01~0.03	0.02~0.06	3D銑 3D MILLING
UNBX100604	13	50	15000~16000	400~600	0.01~0.025	1	溝銑 SLOTTING
UNBX100604	13	50	15000~16000	700~900	0.01~0.03	0.02~0.06	3D銑 3D MILLING
UNBX100804	15	50	15000~16000	300~500	0.01~0.025	1	溝銑 SLOTTING
UNBX100804	15	50	15000~16000	600~800	0.01~0.03	0.02~0.06	3D銑 3D MILLING
UNBX101004	17	50	15000~16000	200~400	0.01~0.02	1	溝銑 SLOTTING
UNBX101004	17	50	15000~16000	400~600	0.008~0.015	0.016~0.03	3D銑 3D MILLING
UNBX101204	19	50	15000~16000	200~400	0.01~0.02	1	溝銑 SLOTTING
UNBX101204	19	50	15000~16000	400~600	0.008~0.015	0.016~0.03	3D銑 3D MILLING
UNBX150604	13	65	13000~14000	500~700	0.01~0.03	1.5	溝銑 SLOTTING
UNBX150604	13	65	13000~14000	800~1000	0.02~0.04	0.04~0.08	3D銑 3D MILLING
UNBX150804	15	65	13000~14000	400~600	0.01~0.03	1.5	溝銑 SLOTTING
UNBX150804	15	65	13000~14000	700~900	0.02~0.04	0.04~0.08	3D銑 3D MILLING
UNBX151004	17	65	13000~14000	300~500	0.01~0.02	1.5	溝銑 SLOTTING
UNBX151004	17	65	13000~14000	600~800	0.02~0.03	0.04~0.06	3D銑 3D MILLING
UNBX151204	19	65	13000~14000	300~500	0.01~0.02	1.5	溝銑 SLOTTING
UNBX151204	19	65	13000~14000	600~800	0.02~0.03	0.04~0.06	3D銑 3D MILLING
UNBX151604	23	65	13000~14000	200~400	0.01~0.02	1.5	溝銑 SLOTTING
UNBX151604	23	65	13000~14000	500~700	0.01~0.02	0.02~0.04	3D銑 3D MILLING
UNBX200804	14	85	12000~13000	500~700	0.02~0.05	2	溝銑 SLOTTING
UNBX200804	14	85	12000~13000	700~1100	0.02~0.05	0.04~0.1	3D銑 3D MILLING
UNBX201004	16	85	12000~13000	500~700	0.02~0.05	2	溝銑 SLOTTING
UNBX201004	16	85	12000~13000	700~1100	0.02~0.05	0.04~0.1	3D銑 3D MILLING
UNBX201204	18	85	12000~13000	400~600	0.02~0.04	2	溝銑 SLOTTING
UNBX201204	18	85	12000~13000	600~1000	0.02~0.05	0.04~0.1	3D銑 3D MILLING
UNBX201604	22	85	12000~13000	300~500	0.01~0.03	2	溝銑 SLOTTING
UNBX201604	22	85	12000~13000	500~900	0.01~0.04	0.02~0.08	3D銑 3D MILLING
UNBX202004	26	85	12000~13000	200~400	0.01~0.02	2	溝銑 SLOTTING
UNBX202004	26	85	12000~13000	400~800	0.01~0.03	0.02~0.06	3D銑 3D MILLING
UNBX300804	19	115	10000~12000	800~1000	0.03~0.06	3	溝銑 SLOTTING
UNBX300804	19	115	10000~12000	1300~1700	0.03~0.07	0.06~0.14	3D銑 3D MILLING
UNBX301004	21	115	10000~12000	800~1000	0.03~0.06	3	溝銑 SLOTTING
UNBX301004	21	115	10000~12000	1300~1700	0.03~0.07	0.06~0.14	3D銑 3D MILLING
UNBX301204	23	115	10000~12000	700~900	0.03~0.06	3	溝銑 SLOTTING
UNBX301204	23	115	10000~12000	1200~1600	0.03~0.07	0.06~0.14	3D銑 3D MILLING
UNBX301604	27	115	10000~12000	600~800	0.02~0.05	3	溝銑 SLOTTING
UNBX301604	27	115	10000~12000	1000~1400	0.02~0.05	0.04~0.1	3D銑 3D MILLING
UNBX302004	31	115	10000~12000	500~700	0.02~0.04	3	溝銑 SLOTTING
UNBX302004	31	115	10000~12000	1000~1400	0.02~0.04	0.04~0.08	3D銑 3D MILLING
UNBX302504	36	115	10000~12000	400~600	0.02~0.04	3	溝銑 SLOTTING
UNBX302504	36	115	10000~12000	600~1000	0.02~0.04	0.04~0.08	3D銑 3D MILLING
UNBX401004	26	115	7000~9000	800~1200	0.03~0.07	4	溝銑 SLOTTING
UNBX401004	26	115	7000~9000	1200~1600	0.04~0.08	0.08~0.16	3D銑 3D MILLING
UNBX401204	28	115	7000~9000	800~1200	0.03~0.07	4	溝銑 SLOTTING
UNBX401204	28	115	7000~9000	1200~1600	0.04~0.08	0.08~0.16	3D銑 3D MILLING
UNBX401604	32	115	7000~9000	600~1000	0.02~0.06	4	溝銑 SLOTTING
UNBX401604	32	115	7000~9000	1000~1400	0.03~0.07	0.06~0.14	3D銑 3D MILLING
UNBX402004	36	115	7000~9000	600~800	0.02~0.05	4	溝銑 SLOTTING
UNBX402004	36	115	7000~9000	800~1200	0.02~0.06	0.04~0.12	3D銑 3D MILLING
UNBX402504	41	115	7000~9000	500~700	0.02~0.05	4	溝銑 SLOTTING
UNBX402504	41	115	7000~9000	600~1000	0.02~0.06	0.04~0.12	3D銑 3D MILLING