

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
UXE100401	18	55	15000~17000	400~600	0.04~0.06	1	溝銑 SLOTTING
UXE100401	18	55	15000~17000	800~1200	0.01~0.025	1	溝銑 SLOTTING
UXE100601	20	55	15000~17000	400~600	0.03~0.05	1	溝銑 SLOTTING
UXE100601	20	55	15000~17000	800~1200	0.008~0.02	1	溝銑 SLOTTING
UXE100801	22	55	15000~17000	300~500	0.03~0.05	1	溝銑 SLOTTING
UXE100801	22	55	15000~17000	600~800	0.008~0.02	1	溝銑 SLOTTING
UXE101001	24	55	15000~17000	300~500	0.02~0.04	1	溝銑 SLOTTING
UXE101001	24	55	15000~17000	500~700	0.008~0.02	1	溝銑 SLOTTING
UXE101201	26	55	15000~17000	200~400	0.02~0.04	1	溝銑 SLOTTING
UXE101201	26	55	15000~17000	400~600	0.008~0.02	1	溝銑 SLOTTING
UXE100402	18	55	15000~17000	500~700	0.04~0.06	1	溝銑 SLOTTING
UXE100402	18	55	15000~17000	900~1300	0.01~0.025	1	溝銑 SLOTTING
UXE100602	20	55	15000~17000	500~700	0.03~0.05	1	溝銑 SLOTTING
UXE100602	20	55	15000~17000	900~1300	0.008~0.02	1	溝銑 SLOTTING
UXE100802	22	55	15000~17000	400~600	0.03~0.05	1	溝銑 SLOTTING
UXE100802	22	55	15000~17000	700~900	0.008~0.02	1	溝銑 SLOTTING
UXE101002	24	55	15000~17000	400~600	0.02~0.04	1	溝銑 SLOTTING
UXE101002	24	55	15000~17000	700~900	0.008~0.02	1	溝銑 SLOTTING
UXE101202	26	55	15000~17000	300~500	0.02~0.04	1	溝銑 SLOTTING
UXE101202	26	55	15000~17000	500~700	0.008~0.02	1	溝銑 SLOTTING
UXE150401	18	70	13000~15000	400~600	0.06~0.08	1.5	溝銑 SLOTTING
UXE150401	18	70	13000~15000	800~1200	0.02~0.04	1.5	溝銑 SLOTTING
UXE150601	20	70	13000~15000	400~600	0.05~0.07	1.5	溝銑 SLOTTING
UXE150601	20	70	13000~15000	800~1200	0.015~0.035	1.5	溝銑 SLOTTING
UXE150801	22	70	13000~15000	300~500	0.05~0.07	1.5	溝銑 SLOTTING
UXE150801	22	70	13000~15000	600~800	0.015~0.035	1.5	溝銑 SLOTTING
UXE151001	24	70	13000~15000	300~500	0.04~0.06	1.5	溝銑 SLOTTING
UXE151001	24	70	13000~15000	500~700	0.01~0.025	1.5	溝銑 SLOTTING
UXE151201	26	70	13000~15000	200~400	0.04~0.06	1.5	溝銑 SLOTTING
UXE151201	26	70	13000~15000	400~600	0.01~0.025	1.5	溝銑 SLOTTING
UXE150402	18	70	13000~15000	500~700	0.06~0.08	1.5	溝銑 SLOTTING
UXE150402	18	70	13000~15000	900~1300	0.02~0.04	1.5	溝銑 SLOTTING
UXE150602	20	70	13000~15000	500~700	0.05~0.07	1.5	溝銑 SLOTTING
UXE150602	20	70	13000~15000	900~1300	0.015~0.035	1.5	溝銑 SLOTTING
UXE150802	22	70	13000~15000	400~600	0.05~0.07	1.5	溝銑 SLOTTING
UXE150802	22	70	13000~15000	700~900	0.015~0.035	1.5	溝銑 SLOTTING
UXE151002	24	70	13000~15000	400~600	0.04~0.06	1.5	溝銑 SLOTTING
UXE151002	24	70	13000~15000	700~900	0.01~0.025	1.5	溝銑 SLOTTING
UXE151202	26	70	13000~15000	300~500	0.04~0.06	1.5	溝銑 SLOTTING
UXE151202	26	70	13000~15000	500~700	0.01~0.025	1.5	溝銑 SLOTTING
UXE200801	18	85	11000~13000	500~700	0.1~0.12	2	溝銑 SLOTTING
UXE200801	18	85	11000~13000	1000~1400	0.02~0.06	2	溝銑 SLOTTING
UXE201001	20	85	11000~13000	400~600	0.09~0.11	2	溝銑 SLOTTING
UXE201001	20	85	11000~13000	1000~1400	0.02~0.06	2	溝銑 SLOTTING
UXE201201	22	85	11000~13000	400~600	0.08~0.1	2	溝銑 SLOTTING
UXE201201	22	85	11000~13000	1000~1400	0.02~0.06	2	溝銑 SLOTTING
UXE201601	26	85	11000~13000	400~600	0.06~0.08	2	溝銑 SLOTTING
UXE201601	26	85	11000~13000	1000~1400	0.02~0.04	2	溝銑 SLOTTING

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
UXE202001	30	85	11000~13000	300~500	0.05~0.07	2	溝銑 SLOTTING
UXE202001	30	85	11000~13000	800~1200	0.015~0.035	2	溝銑 SLOTTING
UXE200802	18	85	11000~13000	600~800	0.1~0.12	2	溝銑 SLOTTING
UXE200802	18	85	11000~13000	1200~1600	0.02~0.06	2	溝銑 SLOTTING
UXE201002	20	85	11000~13000	500~700	0.09~0.11	2	溝銑 SLOTTING
UXE201002	20	85	11000~13000	1100~1500	0.02~0.06	2	溝銑 SLOTTING
UXE201202	22	85	11000~13000	500~700	0.08~0.1	2	溝銑 SLOTTING
UXE201202	22	85	11000~13000	1100~1500	0.02~0.06	2	溝銑 SLOTTING
UXE201602	26	85	11000~13000	500~700	0.06~0.08	2	溝銑 SLOTTING
UXE201602	26	85	11000~13000	1100~1500	0.02~0.04	2	溝銑 SLOTTING
UXE202002	30	85	11000~13000	400~600	0.05~0.07	2	溝銑 SLOTTING
UXE202002	30	85	11000~13000	900~1300	0.015~0.035	2	溝銑 SLOTTING
UXE300802	18	105	9000~11000	500~700	0.12~0.14	3	溝銑 SLOTTING
UXE300802	18	105	9000~11000	1100~1500	0.03~0.08	3	溝銑 SLOTTING
UXE301002	20	105	9000~11000	400~600	0.12~0.14	3	溝銑 SLOTTING
UXE301002	20	105	9000~11000	1000~1400	0.03~0.08	3	溝銑 SLOTTING
UXE301202	22	105	9000~11000	400~600	0.12~0.14	3	溝銑 SLOTTING
UXE301202	22	105	9000~11000	1000~1400	0.03~0.08	3	溝銑 SLOTTING
UXE301602	26	105	9000~11000	400~600	0.08~0.1	3	溝銑 SLOTTING
UXE301602	26	105	9000~11000	1000~1400	0.02~0.06	3	溝銑 SLOTTING
UXE302002	30	105	9000~11000	300~500	0.06~0.08	3	溝銑 SLOTTING
UXE302002	30	105	9000~11000	700~900	0.01~0.035	3	溝銑 SLOTTING
UXE300803	18	105	9000~11000	600~800	0.12~0.14	3	溝銑 SLOTTING
UXE300803	18	105	9000~11000	1200~1600	0.03~0.08	3	溝銑 SLOTTING
UXE301003	20	105	9000~11000	500~700	0.12~0.14	3	溝銑 SLOTTING
UXE301003	20	105	9000~11000	1100~1500	0.03~0.08	3	溝銑 SLOTTING
UXE301203	22	105	9000~11000	500~700	0.12~0.14	3	溝銑 SLOTTING
UXE301203	22	105	9000~11000	1100~1500	0.03~0.08	3	溝銑 SLOTTING
UXE301603	26	105	9000~11000	500~700	0.08~0.1	3	溝銑 SLOTTING
UXE301603	26	105	9000~11000	1100~1500	0.02~0.06	3	溝銑 SLOTTING
UXE302003	30	105	9000~11000	400~600	0.06~0.08	3	溝銑 SLOTTING
UXE302003	30	105	9000~11000	800~1000	0.01~0.035	3	溝銑 SLOTTING
UXE401002	20	115	7000~9000	700~900	0.13~0.15	4	溝銑 SLOTTING
UXE401002	20	115	7000~9000	1300~1700	0.03~0.08	4	溝銑 SLOTTING
UXE401202	22	115	7000~9000	700~900	0.12~0.14	4	溝銑 SLOTTING
UXE401202	22	115	7000~9000	1300~1700	0.03~0.08	4	溝銑 SLOTTING
UXE401602	26	115	7000~9000	600~800	0.08~0.1	4	溝銑 SLOTTING
UXE401602	26	115	7000~9000	1200~1600	0.02~0.06	4	溝銑 SLOTTING
UXE402002	30	115	7000~9000	500~700	0.06~0.08	4	溝銑 SLOTTING
UXE402002	30	115	7000~9000	900~1100	0.015~0.04	4	溝銑 SLOTTING
UXE401003	20	115	7000~9000	800~1000	0.14~0.16	4	溝銑 SLOTTING
UXE401003	20	115	7000~9000	1400~1800	0.04~0.09	4	溝銑 SLOTTING
UXE401203	22	115	7000~9000	800~1000	0.13~0.15	4	溝銑 SLOTTING
UXE401203	22	115	7000~9000	1400~1800	0.04~0.09	4	溝銑 SLOTTING
UXE401603	26	115	7000~9000	700~900	0.09~0.11	4	溝銑 SLOTTING
UXE401603	26	115	7000~9000	1300~1700	0.03~0.08	4	溝銑 SLOTTING
UXE402003	30	115	7000~9000	600~800	0.07~0.09	4	溝銑 SLOTTING
UXE402003	30	115	7000~9000	1000~1200	0.02~0.05	4	溝銑 SLOTTING

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
UXE100401	18	40	11000~13000	400~600	0.01~0.03	1	溝銑 SLOTTING
UXE100401	18	40	11000~13000	400~600	0.01~0.03	1	溝銑 SLOTTING
UXE100601	20	40	11000~13000	400~600	0.01~0.03	1	溝銑 SLOTTING
UXE100601	20	40	11000~13000	400~600	0.01~0.03	1	溝銑 SLOTTING
UXE100801	22	40	11000~13000	300~500	0.01~0.03	1	溝銑 SLOTTING
UXE100801	22	40	11000~13000	300~500	0.01~0.03	1	溝銑 SLOTTING
UXE101001	24	40	11000~13000	300~500	0.01~0.03	1	溝銑 SLOTTING
UXE101001	24	40	11000~13000	300~500	0.01~0.03	1	溝銑 SLOTTING
UXE101201	26	40	11000~13000	200~400	0.01~0.025	1	溝銑 SLOTTING
UXE101201	26	40	11000~13000	200~400	0.01~0.025	1	溝銑 SLOTTING
UXE100402	18	40	11000~13000	400~600	0.01~0.03	1	溝銑 SLOTTING
UXE100402	18	40	11000~13000	400~600	0.01~0.03	1	溝銑 SLOTTING
UXE100602	20	40	11000~13000	400~600	0.01~0.03	1	溝銑 SLOTTING
UXE100602	20	40	11000~13000	400~600	0.01~0.03	1	溝銑 SLOTTING
UXE100802	22	40	11000~13000	300~500	0.01~0.03	1	溝銑 SLOTTING
UXE100802	22	40	11000~13000	300~500	0.01~0.03	1	溝銑 SLOTTING
UXE101002	24	40	11000~13000	300~500	0.01~0.03	1	溝銑 SLOTTING
UXE101002	24	40	11000~13000	300~500	0.01~0.03	1	溝銑 SLOTTING
UXE101202	26	40	11000~13000	200~400	0.01~0.025	1	溝銑 SLOTTING
UXE101202	26	40	11000~13000	200~400	0.01~0.025	1	溝銑 SLOTTING
UXE150401	18	55	9000~11000	400~600	0.02~0.04	1.5	溝銑 SLOTTING
UXE150401	18	55	9000~11000	400~600	0.02~0.04	1.5	溝銑 SLOTTING
UXE150601	20	55	9000~11000	400~600	0.02~0.04	1.5	溝銑 SLOTTING
UXE150601	20	55	9000~11000	400~600	0.02~0.04	1.5	溝銑 SLOTTING
UXE150801	22	55	9000~11000	400~600	0.02~0.04	1.5	溝銑 SLOTTING
UXE150801	22	55	9000~11000	400~600	0.02~0.04	1.5	溝銑 SLOTTING
UXE151001	24	55	9000~11000	300~500	0.01~0.025	1.5	溝銑 SLOTTING
UXE151001	24	55	9000~11000	300~500	0.01~0.025	1.5	溝銑 SLOTTING
UXE151201	26	55	9000~11000	300~500	0.01~0.025	1.5	溝銑 SLOTTING
UXE151201	26	55	9000~11000	300~500	0.01~0.025	1.5	溝銑 SLOTTING
UXE150402	18	55	9000~11000	400~600	0.02~0.04	1.5	溝銑 SLOTTING
UXE150402	18	55	9000~11000	400~600	0.02~0.04	1.5	溝銑 SLOTTING
UXE150602	20	55	9000~11000	400~600	0.02~0.04	1.5	溝銑 SLOTTING
UXE150602	20	55	9000~11000	400~600	0.02~0.04	1.5	溝銑 SLOTTING
UXE150802	22	55	9000~11000	400~600	0.02~0.04	1.5	溝銑 SLOTTING
UXE150802	22	55	9000~11000	400~600	0.02~0.04	1.5	溝銑 SLOTTING
UXE151002	24	55	9000~11000	300~500	0.01~0.025	1.5	溝銑 SLOTTING
UXE151002	24	55	9000~11000	300~500	0.01~0.025	1.5	溝銑 SLOTTING
UXE151202	26	55	9000~11000	300~500	0.01~0.025	1.5	溝銑 SLOTTING
UXE151202	26	55	9000~11000	300~500	0.01~0.025	1.5	溝銑 SLOTTING
UXE200801	18	60	7000~9000	500~700	0.04~0.06	2	溝銑 SLOTTING
UXE200801	18	60	7000~9000	800~1000	0.01~0.025	2	溝銑 SLOTTING
UXE201001	20	60	7000~9000	400~600	0.03~0.05	2	溝銑 SLOTTING
UXE201001	20	60	7000~9000	800~1000	0.008~0.02	2	溝銑 SLOTTING
UXE201201	22	60	7000~9000	400~600	0.03~0.05	2	溝銑 SLOTTING
UXE201201	22	60	7000~9000	800~1000	0.008~0.02	2	溝銑 SLOTTING
UXE201601	26	60	7000~9000	400~600	0.02~0.04	2	溝銑 SLOTTING
UXE201601	26	60	7000~9000	800~1000	0.008~0.015	2	溝銑 SLOTTING

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
UXE202001	30	60	7000~9000	300~500	0.02~0.04	2	溝銑 SLOTTING
UXE202001	30	60	7000~9000	600~800	0.008~0.013	2	溝銑 SLOTTING
UXE200802	18	60	7000~9000	500~700	0.04~0.06	2	溝銑 SLOTTING
UXE200802	18	60	7000~9000	800~1000	0.01~0.025	2	溝銑 SLOTTING
UXE201002	20	60	7000~9000	400~600	0.03~0.05	2	溝銑 SLOTTING
UXE201002	20	60	7000~9000	800~1000	0.008~0.02	2	溝銑 SLOTTING
UXE201202	22	60	7000~9000	400~600	0.03~0.05	2	溝銑 SLOTTING
UXE201202	22	60	7000~9000	800~1000	0.008~0.02	2	溝銑 SLOTTING
UXE201602	26	60	7000~9000	400~600	0.02~0.04	2	溝銑 SLOTTING
UXE201602	26	60	7000~9000	800~1000	0.008~0.015	2	溝銑 SLOTTING
UXE202002	30	60	7000~9000	300~500	0.02~0.04	2	溝銑 SLOTTING
UXE202002	30	60	7000~9000	600~800	0.008~0.013	2	溝銑 SLOTTING
UXE300802	18	65	5000~7000	500~700	0.05~0.07	3	溝銑 SLOTTING
UXE300802	18	65	5000~7000	900~1100	0.01~0.03	3	溝銑 SLOTTING
UXE301002	20	65	5000~7000	400~600	0.05~0.07	3	溝銑 SLOTTING
UXE301002	20	65	5000~7000	800~1000	0.01~0.03	3	溝銑 SLOTTING
UXE301202	22	65	5000~7000	400~600	0.05~0.07	3	溝銑 SLOTTING
UXE301202	22	65	5000~7000	800~1000	0.01~0.03	3	溝銑 SLOTTING
UXE301602	26	65	5000~7000	400~600	0.03~0.05	3	溝銑 SLOTTING
UXE301602	26	65	5000~7000	400~600	0.03~0.05	3	溝銑 SLOTTING
UXE302002	30	65	5000~7000	300~500	0.02~0.04	3	溝銑 SLOTTING
UXE302002	30	65	5000~7000	300~500	0.02~0.04	3	溝銑 SLOTTING
UXE300803	18	65	5000~7000	600~800	0.05~0.07	3	溝銑 SLOTTING
UXE300803	18	65	5000~7000	1000~1200	0.01~0.03	3	溝銑 SLOTTING
UXE301003	20	65	5000~7000	500~700	0.05~0.07	3	溝銑 SLOTTING
UXE301003	20	65	5000~7000	900~1100	0.01~0.03	3	溝銑 SLOTTING
UXE301203	22	65	5000~7000	500~700	0.05~0.07	3	溝銑 SLOTTING
UXE301203	22	65	5000~7000	900~1100	0.01~0.03	3	溝銑 SLOTTING
UXE301603	26	65	5000~7000	500~700	0.03~0.05	3	溝銑 SLOTTING
UXE301603	26	65	5000~7000	500~700	0.03~0.05	3	溝銑 SLOTTING
UXE302003	30	65	5000~7000	400~600	0.02~0.04	3	溝銑 SLOTTING
UXE302003	30	65	5000~7000	400~600	0.02~0.04	3	溝銑 SLOTTING
UXE401002	20	65	4000~5000	700~900	0.08~0.1	4	溝銑 SLOTTING
UXE401002	20	65	4000~5000	1100~1300	0.02~0.04	4	溝銑 SLOTTING
UXE401202	22	65	4000~5000	700~900	0.06~0.08	4	溝銑 SLOTTING
UXE401202	22	65	4000~5000	1000~1200	0.02~0.04	4	溝銑 SLOTTING
UXE401602	26	65	4000~5000	600~800	0.05~0.07	4	溝銑 SLOTTING
UXE401602	26	65	4000~5000	900~1100	0.01~0.03	4	溝銑 SLOTTING
UXE402002	30	65	4000~5000	500~700	0.04~0.06	4	溝銑 SLOTTING
UXE402002	30	65	4000~5000	800~1000	0.01~0.03	4	溝銑 SLOTTING
UXE401003	20	65	4000~5000	800~1000	0.08~0.1	4	溝銑 SLOTTING
UXE401003	20	65	4000~5000	1200~1400	0.02~0.04	4	溝銑 SLOTTING
UXE401203	22	65	4000~5000	800~1000	0.06~0.08	4	溝銑 SLOTTING
UXE401203	22	65	4000~5000	1100~1300	0.02~0.04	4	溝銑 SLOTTING
UXE401603	26	65	4000~5000	700~900	0.05~0.07	4	溝銑 SLOTTING
UXE401603	26	65	4000~5000	1000~1200	0.01~0.03	4	溝銑 SLOTTING
UXE402003	30	65	4000~5000	600~800	0.04~0.06	4	溝銑 SLOTTING
UXE402003	30	65	4000~5000	900~1100	0.01~0.03	4	溝銑 SLOTTING