

LRTD

切削條件表

Milling Conditions

被切削材 Work Material

碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron
S50C / Fc250 / SS400 : 1.1210 / 0.6025 / 1.0036 : 1050 / NO.35 / A570 Gr.45 (~HRc22)

冷卻方式 Coolant Type

濕式切削 Wet coolant

| 型號 Type NO. | 刀具伸長量 Extension Length(mm) | 切削速度 (m/min) Cutting Speed | 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 |
|----------------|----------------------------------|----------------------------------|---------------------------------------|--------------------------|------------------------------|------------------------------|----------------------|
| LRTD0405 | 40 | 70 | 5400~5800 | 1000~1200 | 0.07~0.1 | 2~4 | 溝銑 (SLOTTING) |
| LRTD0405 | 40 | 115 | 9000~10000 | 1200~1600 | 0.07~0.1 | 0.07~0.1 | 3D銑 (3D MILLING) |
| LRTD0410 | 40 | 70 | 5400~5800 | 1000~1200 | 0.07~0.1 | 1~4 | 溝銑 (SLOTTING) |
| LRTD0410 | 40 | 115 | 9000~10000 | 1200~1600 | 0.07~0.1 | 0.07~0.1 | 3D銑 (3D MILLING) |
| LRTD0602 | 40 | 75 | 4000~4600 | 600~800 | 0.15~0.2 | 5~6 | 溝銑 (SLOTTING) |
| LRTD0602 | 40 | 95 | 5000~5500 | 1200~1400 | 0.07~0.1 | 5~6 | 溝銑 (SLOTTING) |
| LRTD0602 | 40 | 60 | 3200~3600 | 1000~1200 | 6~12 | 0.15~0.2 | 側銑 (SIDE MILLING) |
| LRTD0602 | 40 | 60 | 3200~3600 | 600~800 | 6~12 | 0.07~0.1 | 側銑 (SIDE MILLING) |
| LRTD0602 | 40 | 90 | 4800~5400 | 1800~2200 | 0.15~0.2 | 0.15~0.2 | 3D銑 (3D MILLING) |
| LRTD0602 | 40 | 135 | 7200~7600 | 1200~1600 | 0.07~0.1 | 0.07~0.1 | 3D銑 (3D MILLING) |
| LRTD0603 | 40 | 75 | 4000~4600 | 600~800 | 0.15~0.2 | 5~6 | 溝銑 (SLOTTING) |
| LRTD0603 | 40 | 95 | 5000~5500 | 1200~1400 | 0.07~0.1 | 5~6 | 溝銑 (SLOTTING) |
| LRTD0603 | 40 | 60 | 3200~3600 | 1000~1200 | 6~12 | 0.15~0.2 | 側銑 (SIDE MILLING) |
| LRTD0603 | 40 | 60 | 3200~3600 | 600~800 | 6~12 | 0.07~0.1 | 側銑 (SIDE MILLING) |
| LRTD0603 | 40 | 90 | 4800~5400 | 1800~2200 | 0.15~0.2 | 0.15~0.2 | 3D銑 (3D MILLING) |
| LRTD0603 | 40 | 135 | 7200~7600 | 1200~1600 | 0.07~0.1 | 0.07~0.1 | 3D銑 (3D MILLING) |
| LRTD0605 | 40 | 75 | 4000~4600 | 600~800 | 0.15~0.2 | 4~6 | 溝銑 (SLOTTING) |
| LRTD0605 | 40 | 95 | 5000~5500 | 1200~1400 | 0.07~0.1 | 4~6 | 溝銑 (SLOTTING) |
| LRTD0605 | 40 | 60 | 3200~3600 | 1000~1200 | 6~12 | 0.15~0.2 | 側銑 (SIDE MILLING) |
| LRTD0605 | 40 | 60 | 3200~3600 | 600~800 | 6~12 | 0.07~0.1 | 側銑 (SIDE MILLING) |
| LRTD0605 | 40 | 90 | 4800~5400 | 1800~2200 | 0.15~0.2 | 0.15~0.2 | 3D銑 (3D MILLING) |
| LRTD0605 | 40 | 135 | 7200~7600 | 1200~1600 | 0.07~0.1 | 0.07~0.1 | 3D銑 (3D MILLING) |
| LRTD0610 | 40 | 75 | 4000~4600 | 600~800 | 0.15~0.2 | 3~6 | 溝銑 (SLOTTING) |
| LRTD0610 | 40 | 95 | 5000~5500 | 1200~1400 | 0.07~0.1 | 3~6 | 溝銑 (SLOTTING) |
| LRTD0610 | 40 | 60 | 3200~3600 | 1000~1200 | 6~12 | 0.15~0.2 | 側銑 (SIDE MILLING) |
| LRTD0610 | 40 | 60 | 3200~3600 | 600~800 | 6~12 | 0.07~0.1 | 側銑 (SIDE MILLING) |
| LRTD0610 | 40 | 90 | 4800~5400 | 1800~2200 | 0.15~0.2 | 0.15~0.2 | 3D銑 (3D MILLING) |
| LRTD0610 | 40 | 135 | 7200~7600 | 1200~1600 | 0.07~0.1 | 0.07~0.1 | 3D銑 (3D MILLING) |
| LRTD0803 | 50 | 65 | 2500~3000 | 800~1000 | 0.2~0.25 | 7~8 | 溝銑 (SLOTTING) |
| LRTD0803 | 50 | 75 | 3000~3500 | 600~800 | 0.08~0.12 | 7~8 | 溝銑 (SLOTTING) |
| LRTD0803 | 50 | 90 | 3500~4000 | 500~800 | 8~16 | 0.2~0.25 | 側銑 (SIDE MILLING) |
| LRTD0803 | 50 | 65 | 2500~3000 | 500~800 | 8~16 | 0.08~0.12 | 側銑 (SIDE MILLING) |
| LRTD0803 | 50 | 115 | 4500~5200 | 1000~1400 | 0.2~0.25 | 0.2~0.25 | 3D銑 (3D MILLING) |
| LRTD0803 | 50 | 165 | 6500~7000 | 1000~1400 | 0.08~0.12 | 0.08~0.12 | 3D銑 (3D MILLING) |
| LRTD0805 | 50 | 65 | 2500~3000 | 800~1000 | 0.2~0.25 | 6~8 | 溝銑 (SLOTTING) |
| LRTD0805 | 50 | 75 | 3000~3500 | 600~800 | 0.08~0.12 | 6~8 | 溝銑 (SLOTTING) |
| LRTD0805 | 50 | 90 | 3500~4000 | 500~800 | 8~16 | 0.2~0.25 | 側銑 (SIDE MILLING) |
| LRTD0805 | 50 | 65 | 2500~3000 | 500~800 | 8~16 | 0.08~0.12 | 側銑 (SIDE MILLING) |
| LRTD0805 | 50 | 115 | 4500~5200 | 1000~1400 | 0.2~0.25 | 0.2~0.25 | 3D銑 (3D MILLING) |
| LRTD0805 | 50 | 165 | 6500~7000 | 1000~1400 | 0.08~0.12 | 0.08~0.12 | 3D銑 (3D MILLING) |

LRTD

切削條件表

Milling Conditions

被切削材 Work Material

碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron
 S50C / Fc250 / SS400 : 1.1210 / 0.6025 / 1.0036 : 1050 / NO.35 / A570 Gr.45 (~HRc22)

冷卻方式 Coolant Type

濕式切削 Wet coolant

| 型號 Type NO. | 刀具伸長量 Extension Length(mm) | 切削速度 (m/min) Cutting Speed | 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 |
|----------------|----------------------------------|----------------------------------|---------------------------------------|--------------------------|------------------------------|------------------------------|----------------------|
| LRTD0810 | 50 | 65 | 2500~3000 | 800~1000 | 0.2~0.25 | 5~8 | 溝銼 (SLOTTING) |
| LRTD0810 | 50 | 75 | 3000~3500 | 600~800 | 0.08~0.12 | 5~8 | 溝銼 (SLOTTING) |
| LRTD0810 | 50 | 90 | 3500~4000 | 500~800 | 8~16 | 0.2~0.25 | 側銼 (SIDE MILLING) |
| LRTD0810 | 50 | 65 | 2500~3000 | 500~800 | 8~16 | 0.08~0.12 | 側銼 (SIDE MILLING) |
| LRTD0810 | 50 | 115 | 4500~5200 | 1000~1400 | 0.2~0.25 | 0.2~0.25 | 3D銼 (3D MILLING) |
| LRTD0810 | 50 | 165 | 6500~7000 | 1000~1400 | 0.08~0.12 | 0.08~0.12 | 3D銼 (3D MILLING) |
| LRTD1002 | 60 | 65 | 2000~2400 | 800~1000 | 0.25~0.3 | 9~10 | 溝銼 (SLOTTING) |
| LRTD1002 | 60 | 75 | 2400~2800 | 500~800 | 0.08~0.13 | 9~10 | 溝銼 (SLOTTING) |
| LRTD1002 | 60 | 90 | 2800~3200 | 500~800 | 10~20 | 0.25~0.3 | 側銼 (SIDE MILLING) |
| LRTD1002 | 60 | 65 | 2000~2400 | 500~800 | 10~20 | 0.1~0.15 | 側銼 (SIDE MILLING) |
| LRTD1002 | 60 | 115 | 3600~4200 | 1000~1400 | 0.25~0.3 | 0.25~0.3 | 3D銼 (3D MILLING) |
| LRTD1002 | 60 | 165 | 5200~5600 | 1000~1400 | 0.08~0.13 | 0.08~0.13 | 3D銼 (3D MILLING) |
| LRTD1003 | 60 | 65 | 2000~2400 | 800~1000 | 0.25~0.3 | 9~10 | 溝銼 (SLOTTING) |
| LRTD1003 | 60 | 75 | 2400~2800 | 500~800 | 0.08~0.13 | 9~10 | 溝銼 (SLOTTING) |
| LRTD1003 | 60 | 90 | 2800~3200 | 500~800 | 10~20 | 0.25~0.3 | 側銼 (SIDE MILLING) |
| LRTD1003 | 60 | 65 | 2000~2400 | 500~800 | 10~20 | 0.1~0.15 | 側銼 (SIDE MILLING) |
| LRTD1003 | 60 | 115 | 3600~4200 | 1000~1400 | 0.25~0.3 | 0.25~0.3 | 3D銼 (3D MILLING) |
| LRTD1003 | 60 | 165 | 5200~5600 | 1000~1400 | 0.08~0.13 | 0.08~0.13 | 3D銼 (3D MILLING) |
| LRTD1005 | 60 | 65 | 2000~2400 | 800~1000 | 0.25~0.3 | 10~20 | 溝銼 (SLOTTING) |
| LRTD1005 | 60 | 75 | 2400~2800 | 500~800 | 0.08~0.13 | 10~20 | 溝銼 (SLOTTING) |
| LRTD1005 | 60 | 90 | 2800~3200 | 500~800 | 10~20 | 0.25~0.3 | 側銼 (SIDE MILLING) |
| LRTD1005 | 60 | 65 | 2000~2400 | 500~800 | 10~20 | 0.08~0.13 | 側銼 (SIDE MILLING) |
| LRTD1005 | 60 | 115 | 3600~4200 | 1000~1400 | 0.25~0.3 | 0.25~0.3 | 3D銼 (3D MILLING) |
| LRTD1005 | 60 | 165 | 5200~5600 | 1000~1400 | 0.08~0.13 | 0.08~0.13 | 3D銼 (3D MILLING) |
| LRTD1010 | 60 | 65 | 2000~2400 | 800~1000 | 0.25~0.3 | 7~10 | 溝銼 (SLOTTING) |
| LRTD1010 | 60 | 75 | 2400~2800 | 500~800 | 0.08~0.13 | 7~10 | 溝銼 (SLOTTING) |
| LRTD1010 | 60 | 90 | 2800~3200 | 500~800 | 10~20 | 0.25~0.3 | 側銼 (SIDE MILLING) |
| LRTD1010 | 60 | 65 | 2000~2400 | 500~800 | 10~20 | 0.1~0.15 | 側銼 (SIDE MILLING) |
| LRTD1010 | 60 | 115 | 3600~4200 | 1000~1400 | 0.25~0.3 | 0.25~0.3 | 3D銼 (3D MILLING) |
| LRTD1010 | 60 | 165 | 5200~5600 | 1000~1400 | 0.08~0.13 | 0.08~0.13 | 3D銼 (3D MILLING) |
| LRTD1020 | 60 | 65 | 2000~2400 | 800~1000 | 0.25~0.3 | 5~10 | 溝銼 (SLOTTING) |
| LRTD1020 | 60 | 75 | 2400~2800 | 500~800 | 0.08~0.13 | 5~10 | 溝銼 (SLOTTING) |
| LRTD1020 | 60 | 90 | 2800~3200 | 500~800 | 10~20 | 0.25~0.3 | 側銼 (SIDE MILLING) |
| LRTD1020 | 60 | 65 | 2000~2400 | 500~800 | 10~20 | 0.1~0.15 | 側銼 (SIDE MILLING) |
| LRTD1020 | 60 | 115 | 3600~4200 | 1000~1400 | 0.25~0.3 | 0.25~0.3 | 3D銼 (3D MILLING) |
| LRTD1020 | 60 | 165 | 5200~5600 | 1000~1400 | 0.08~0.13 | 0.08~0.13 | 3D銼 (3D MILLING) |

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切削條件表

Milling Conditions

被切削材 Work Material

碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron
S50C / Fc250 / SS400 : 1.1210 / 0.6025 / 1.0036 : 1050 / NO.35 / A570 Gr.45 (~HRC22)

冷卻方式 Coolant Type

濕式切削 Wet coolant

| 型號 Type NO. | 刀具伸長量 Extension Length(mm) | 切削速度 (m/min) Cutting Speed | 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 |
|----------------|----------------------------------|----------------------------------|---------------------------------------|--------------------------|------------------------------|------------------------------|----------------------|
| LRTD1205 | 60 | 75 | 2000~2400 | 800~1200 | 0.25~0.3 | 10~12 | 溝銑 (SLOTTING) |
| LRTD1205 | 60 | 105 | 2800~3200 | 800~1000 | 0.1~0.15 | 10~12 | 溝銑 (SLOTTING) |
| LRTD1205 | 60 | 80 | 1900~2300 | 800~1000 | 12~24 | 0.2~0.3 | 側銑 (SIDE MILLING) |
| LRTD1205 | 60 | 80 | 1900~2300 | 400~600 | 12~24 | 0.1~0.15 | 側銑 (SIDE MILLING) |
| LRTD1205 | 60 | 150 | 4000~4500 | 1400~1800 | 0.25~0.3 | 0.25~0.3 | 3D銑 (3D MILLING) |
| LRTD1205 | 60 | 170 | 4500~5000 | 1200~1600 | 0.1~0.15 | 0.1~0.15 | 3D銑 (3D MILLING) |
| LRTD1210 | 60 | 75 | 2000~2400 | 800~1200 | 0.25~0.3 | 9~12 | 溝銑 (SLOTTING) |
| LRTD1210 | 60 | 105 | 2800~3200 | 800~1000 | 0.1~0.15 | 9~12 | 溝銑 (SLOTTING) |
| LRTD1210 | 60 | 80 | 1900~2300 | 800~1000 | 12~24 | 0.25~0.3 | 側銑 (SIDE MILLING) |
| LRTD1210 | 60 | 80 | 1900~2300 | 400~600 | 12~24 | 0.1~0.15 | 側銑 (SIDE MILLING) |
| LRTD1210 | 60 | 150 | 4000~4500 | 1400~1800 | 0.25~0.3 | 0.25~0.3 | 3D銑 (3D MILLING) |
| LRTD1210 | 60 | 170 | 4500~5000 | 1200~1600 | 0.1~0.15 | 0.1~0.15 | 3D銑 (3D MILLING) |
| LRTD1220 | 60 | 75 | 2000~2400 | 800~1200 | 0.25~0.3 | 7~12 | 溝銑 (SLOTTING) |
| LRTD1220 | 60 | 105 | 2800~3200 | 800~1000 | 0.1~0.15 | 7~12 | 溝銑 (SLOTTING) |
| LRTD1220 | 60 | 80 | 1900~2300 | 800~1000 | 12~24 | 0.25~0.3 | 側銑 (SIDE MILLING) |
| LRTD1220 | 60 | 80 | 1900~2300 | 400~600 | 12~24 | 0.1~0.15 | 側銑 (SIDE MILLING) |
| LRTD1220 | 60 | 150 | 4000~4500 | 1400~1800 | 0.25~0.3 | 0.25~0.3 | 3D銑 (3D MILLING) |
| LRTD1220 | 60 | 170 | 4500~5000 | 1200~1600 | 0.1~0.15 | 0.1~0.15 | 3D銑 (3D MILLING) |
| LRTD1610 | 100 | 75 | 1500~1800 | 700~1100 | 0.3~0.35 | 13~16 | 溝銑 (SLOTTING) |
| LRTD1610 | 100 | 90 | 1800~2100 | 400~600 | 0.12~0.17 | 13~16 | 溝銑 (SLOTTING) |
| LRTD1610 | 100 | 75 | 1500~1800 | 600~800 | 16~32 | 0.3~0.35 | 側銑 (SIDE MILLING) |
| LRTD1610 | 100 | 75 | 1500~1800 | 400~600 | 16~32 | 0.12~0.17 | 側銑 (SIDE MILLING) |
| LRTD1610 | 100 | 150 | 3000~3400 | 1400~1800 | 0.3~0.35 | 0.3~0.35 | 3D銑 (3D MILLING) |
| LRTD1610 | 100 | 170 | 3400~3800 | 800~1200 | 0.12~0.17 | 0.12~0.17 | 3D銑 (3D MILLING) |
| LRTD1620 | 100 | 75 | 1500~1800 | 700~1100 | 0.3~0.35 | 11~16 | 溝銑 (SLOTTING) |
| LRTD1620 | 100 | 90 | 1800~2100 | 400~600 | 0.12~0.17 | 11~16 | 溝銑 (SLOTTING) |
| LRTD1620 | 100 | 75 | 1500~1800 | 600~800 | 16~32 | 0.3~0.35 | 側銑 (SIDE MILLING) |
| LRTD1620 | 100 | 75 | 1500~1800 | 400~600 | 16~32 | 0.12~0.17 | 側銑 (SIDE MILLING) |
| LRTD1620 | 100 | 150 | 3000~3400 | 1400~1800 | 0.3~0.35 | 0.3~0.35 | 3D銑 (3D MILLING) |
| LRTD1620 | 100 | 170 | 3400~3800 | 800~1200 | 0.12~0.17 | 0.12~0.17 | 3D銑 (3D MILLING) |

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切削條件表

Milling Conditions

被切削材 Work Material

合金工具鋼 / 碳工具鋼 : Alloy Tool Steels / Carbon Tool Steels
P20 / P5 / SK3 / SKD61 / SKD11 : 1.2311 / 1.1545 / 1.2379 / 1.2344 : H13 / D2 (HRc23~32)

冷卻方式 Coolant Type

濕式切削 Wet coolant

| 型號 Type NO. | 刀具伸長量 Extension Length(mm) | 切削速度 (m/min) Cutting Speed | 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 |
|----------------|----------------------------------|----------------------------------|---------------------------------------|--------------------------|------------------------------|------------------------------|----------------------|
| LRTD0405 | 40 | 65 | 5000~5500 | 800~1000 | 0.07~0.1 | 1~4 | 溝銑 (SLOTTING) |
| LRTD0405 | 40 | 115 | 9000~10000 | 1000~1400 | 0.07~0.1 | 0.07~0.1 | 3D銑 (3D MILLING) |
| LRTD0410 | 40 | 65 | 5000~5500 | 800~1000 | 0.07~0.1 | 1~4 | 溝銑 (SLOTTING) |
| LRTD0410 | 40 | 115 | 9000~10000 | 1000~1400 | 0.07~0.1 | 0.07~0.1 | 3D銑 (3D MILLING) |
| LRTD0602 | 40 | 70 | 3600~4000 | 600~800 | 0.15~0.2 | 5~6 | 溝銑 (SLOTTING) |
| LRTD0602 | 40 | 85 | 4500~5000 | 1000~1200 | 0.07~0.1 | 5~6 | 溝銑 (SLOTTING) |
| LRTD0602 | 40 | 30 | 1600~2000 | 200~400 | 6~12 | 0.15~0.2 | 側銑 (SIDE MILLING) |
| LRTD0602 | 40 | 50 | 2700~3200 | 400~600 | 6~12 | 0.07~0.1 | 側銑 (SIDE MILLING) |
| LRTD0602 | 40 | 90 | 4800~5400 | 1000~1400 | 0.15~0.2 | 0.15~0.2 | 3D銑 (3D MILLING) |
| LRTD0602 | 40 | 130 | 6800~7200 | 1200~1600 | 0.07~0.1 | 0.07~0.1 | 3D銑 (3D MILLING) |
| LRTD0603 | 40 | 70 | 3600~4000 | 600~800 | 0.15~0.2 | 5~6 | 溝銑 (SLOTTING) |
| LRTD0603 | 40 | 85 | 4500~5000 | 1000~1200 | 0.07~0.1 | 5~6 | 溝銑 (SLOTTING) |
| LRTD0603 | 40 | 30 | 1600~2000 | 200~400 | 6~12 | 0.15~0.2 | 側銑 (SIDE MILLING) |
| LRTD0603 | 40 | 50 | 2700~3200 | 400~600 | 6~12 | 0.07~0.1 | 側銑 (SIDE MILLING) |
| LRTD0603 | 40 | 90 | 4800~5400 | 1000~1400 | 0.15~0.2 | 0.15~0.2 | 3D銑 (3D MILLING) |
| LRTD0603 | 40 | 130 | 6800~7200 | 1200~1600 | 0.07~0.1 | 0.07~0.1 | 3D銑 (3D MILLING) |
| LRTD0605 | 40 | 70 | 3600~4000 | 600~800 | 0.15~0.2 | 4~6 | 溝銑 (SLOTTING) |
| LRTD0605 | 40 | 85 | 4500~5000 | 1000~1200 | 0.07~0.1 | 4~6 | 溝銑 (SLOTTING) |
| LRTD0605 | 40 | 30 | 1600~2000 | 200~400 | 6~12 | 0.15~0.2 | 側銑 (SIDE MILLING) |
| LRTD0605 | 40 | 50 | 2700~3200 | 400~600 | 6~12 | 0.07~0.1 | 側銑 (SIDE MILLING) |
| LRTD0605 | 40 | 90 | 4800~5400 | 1000~1400 | 0.15~0.2 | 0.15~0.2 | 3D銑 (3D MILLING) |
| LRTD0605 | 40 | 130 | 6800~7200 | 1200~1600 | 0.07~0.1 | 0.07~0.1 | 3D銑 (3D MILLING) |
| LRTD0610 | 40 | 70 | 3600~4000 | 600~800 | 0.15~0.2 | 3~6 | 溝銑 (SLOTTING) |
| LRTD0610 | 40 | 85 | 4500~5000 | 1000~1200 | 0.07~0.1 | 3~6 | 溝銑 (SLOTTING) |
| LRTD0610 | 40 | 30 | 1600~2000 | 200~400 | 6~12 | 0.15~0.2 | 側銑 (SIDE MILLING) |
| LRTD0610 | 40 | 50 | 2700~3200 | 400~600 | 6~12 | 0.07~0.1 | 側銑 (SIDE MILLING) |
| LRTD0610 | 40 | 90 | 4800~5400 | 1000~1400 | 0.15~0.2 | 0.15~0.2 | 3D銑 (3D MILLING) |
| LRTD0610 | 40 | 130 | 6800~7200 | 1200~1600 | 0.07~0.1 | 0.07~0.1 | 3D銑 (3D MILLING) |
| LRTD0803 | 50 | 65 | 2400~2800 | 600~800 | 0.2~0.25 | 7~8 | 溝銑 (SLOTTING) |
| LRTD0803 | 50 | 90 | 3500~4000 | 500~700 | 0.08~0.12 | 7~8 | 溝銑 (SLOTTING) |
| LRTD0803 | 50 | 35 | 1200~1600 | 250~350 | 8~16 | 0.2~0.25 | 側銑 (SIDE MILLING) |
| LRTD0803 | 50 | 50 | 1800~2200 | 400~600 | 8~16 | 0.08~0.12 | 側銑 (SIDE MILLING) |
| LRTD0803 | 50 | 115 | 4500~5200 | 800~1000 | 0.2~0.25 | 0.2~0.25 | 3D銑 (3D MILLING) |
| LRTD0803 | 50 | 150 | 5700~6300 | 800~1200 | 0.08~0.12 | 0.08~0.12 | 3D銑 (3D MILLING) |
| LRTD0805 | 50 | 65 | 2400~2800 | 600~800 | 0.2~0.25 | 6~8 | 溝銑 (SLOTTING) |
| LRTD0805 | 50 | 90 | 3500~4000 | 500~700 | 0.08~0.12 | 6~8 | 溝銑 (SLOTTING) |
| LRTD0805 | 50 | 35 | 1200~1600 | 250~350 | 8~16 | 0.2~0.25 | 側銑 (SIDE MILLING) |
| LRTD0805 | 50 | 50 | 1800~2200 | 400~600 | 8~16 | 0.08~0.12 | 側銑 (SIDE MILLING) |
| LRTD0805 | 50 | 115 | 4500~5200 | 800~1000 | 0.2~0.25 | 0.2~0.25 | 3D銑 (3D MILLING) |
| LRTD0805 | 50 | 150 | 5700~6300 | 800~1200 | 0.08~0.12 | 0.08~0.12 | 3D銑 (3D MILLING) |

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Milling Conditions

被切削材 Work Material

合金工具鋼 / 碳工具鋼 / Alloy Tool Steels / Carbon Tool Steels
P20 / P5 / SK3 / SKD61 / SKD11 : 1.2311 / 1.1545 / 1.2379 / 1.2344 : H13 / D2 (HRC23~32)

冷卻方式 Coolant Type

濕式切削 Wet coolant

| 型號 Type NO. | 刀具伸長量 Extension Length(mm) | 切削速度 (m/min) Cutting Speed | 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 |
|----------------|----------------------------------|----------------------------------|---------------------------------------|--------------------------|------------------------------|------------------------------|----------------------|
| LRTD0810 | 50 | 65 | 2400~2800 | 600~800 | 0.2~0.25 | 5~8 | 溝銑 (SLOTTING) |
| LRTD0810 | 50 | 90 | 3500~4000 | 500~700 | 0.08~0.12 | 5~8 | 溝銑 (SLOTTING) |
| LRTD0810 | 50 | 35 | 1200~1600 | 250~350 | 8~16 | 0.2~0.25 | 側銑 (SIDE MILLING) |
| LRTD0810 | 50 | 50 | 1800~2200 | 400~600 | 8~16 | 0.08~0.12 | 側銑 (SIDE MILLING) |
| LRTD0810 | 50 | 115 | 4500~5200 | 800~1000 | 0.2~0.25 | 0.2~0.25 | 3D銑 (3D MILLING) |
| LRTD0810 | 50 | 150 | 5700~6300 | 800~1200 | 0.08~0.12 | 0.08~0.12 | 3D銑 (3D MILLING) |
| LRTD1002 | 60 | 65 | 2000~2400 | 600~800 | 0.25~0.3 | 9~10 | 溝銑 (SLOTTING) |
| LRTD1002 | 60 | 90 | 2800~3200 | 500~700 | 0.08~0.13 | 9~10 | 溝銑 (SLOTTING) |
| LRTD1002 | 60 | 35 | 1000~1300 | 200~300 | 10~20 | 0.2~0.25 | 側銑 (SIDE MILLING) |
| LRTD1002 | 60 | 40 | 1200~1600 | 400~600 | 10~20 | 0.08~0.13 | 側銑 (SIDE MILLING) |
| LRTD1002 | 60 | 115 | 3600~4000 | 800~1000 | 0.25~0.3 | 0.25~0.3 | 3D銑 (3D MILLING) |
| LRTD1002 | 60 | 150 | 4800~5200 | 800~1200 | 0.08~0.13 | 0.08~0.13 | 3D銑 (3D MILLING) |
| LRTD1003 | 60 | 65 | 2000~2400 | 600~800 | 0.25~0.3 | 8~10 | 溝銑 (SLOTTING) |
| LRTD1003 | 60 | 90 | 2800~3200 | 500~700 | 0.08~0.13 | 8~10 | 溝銑 (SLOTTING) |
| LRTD1003 | 60 | 35 | 1000~1300 | 200~300 | 10~20 | 0.2~0.25 | 側銑 (SIDE MILLING) |
| LRTD1003 | 60 | 40 | 1200~1600 | 400~600 | 10~20 | 0.08~0.13 | 側銑 (SIDE MILLING) |
| LRTD1003 | 60 | 115 | 3600~4000 | 800~1000 | 0.25~0.3 | 0.25~0.3 | 3D銑 (3D MILLING) |
| LRTD1003 | 60 | 150 | 4800~5200 | 800~1200 | 0.08~0.13 | 0.08~0.13 | 3D銑 (3D MILLING) |
| LRTD1005 | 60 | 65 | 2000~2400 | 600~800 | 0.25~0.3 | 8~10 | 溝銑 (SLOTTING) |
| LRTD1005 | 60 | 90 | 2800~3200 | 500~700 | 0.08~0.13 | 8~10 | 溝銑 (SLOTTING) |
| LRTD1005 | 60 | 35 | 1000~1300 | 200~300 | 10~20 | 0.2~0.25 | 側銑 (SIDE MILLING) |
| LRTD1005 | 60 | 40 | 1200~1600 | 400~600 | 10~20 | 0.08~0.13 | 側銑 (SIDE MILLING) |
| LRTD1005 | 60 | 115 | 3600~4000 | 800~1000 | 0.25~0.3 | 0.25~0.3 | 3D銑 (3D MILLING) |
| LRTD1005 | 60 | 150 | 4800~5200 | 800~1200 | 0.08~0.13 | 0.08~0.13 | 3D銑 (3D MILLING) |
| LRTD1010 | 60 | 65 | 2000~2400 | 600~800 | 0.25~0.3 | 7~10 | 溝銑 (SLOTTING) |
| LRTD1010 | 60 | 90 | 2800~3200 | 500~700 | 0.08~0.13 | 7~10 | 溝銑 (SLOTTING) |
| LRTD1010 | 60 | 35 | 1000~1300 | 200~300 | 10~20 | 0.2~0.25 | 側銑 (SIDE MILLING) |
| LRTD1010 | 60 | 40 | 1200~1600 | 400~600 | 10~20 | 0.08~0.13 | 側銑 (SIDE MILLING) |
| LRTD1010 | 60 | 115 | 3600~4000 | 800~1000 | 0.25~0.3 | 0.25~0.3 | 3D銑 (3D MILLING) |
| LRTD1010 | 60 | 150 | 4800~5200 | 800~1200 | 0.08~0.13 | 0.08~0.13 | 3D銑 (3D MILLING) |
| LRTD1020 | 60 | 65 | 2000~2400 | 600~800 | 0.25~0.3 | 5~10 | 溝銑 (SLOTTING) |
| LRTD1020 | 60 | 90 | 2800~3200 | 500~700 | 0.08~0.13 | 5~10 | 溝銑 (SLOTTING) |
| LRTD1020 | 60 | 35 | 1000~1300 | 200~300 | 10~20 | 0.2~0.25 | 側銑 (SIDE MILLING) |
| LRTD1020 | 60 | 40 | 1200~1600 | 400~600 | 10~20 | 0.08~0.13 | 側銑 (SIDE MILLING) |
| LRTD1020 | 60 | 115 | 3600~4000 | 800~1000 | 0.25~0.3 | 0.25~0.3 | 3D銑 (3D MILLING) |
| LRTD1020 | 60 | 150 | 4800~5200 | 800~1200 | 0.08~0.13 | 0.08~0.13 | 3D銑 (3D MILLING) |

LRTD

切削條件表

Milling Conditions

被切削材 Work Material

合金工具鋼 / 碳工具鋼 : Alloy Tool Steels / Carbon Tool Steels
P20 / P5 / SK3 / SKD61 / SKD11 : 1.2311 / 1.1545 / 1.2379 / 1.2344 : H13 / D2 (HRC23~32)

冷卻方式 Coolant Type

濕式切削 Wet coolant

| 型號 Type NO. | 刀具伸長量 Extension Length(mm) | 切削速度 (m/min) Cutting Speed | 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 |
|----------------|----------------------------------|----------------------------------|---------------------------------------|--------------------------|------------------------------|------------------------------|----------------------|
| LRTD1205 | 60 | 70 | 1800~2200 | 800~1000 | 0.25~0.3 | 10~12 | 溝銑 (SLOTTING) |
| LRTD1205 | 60 | 95 | 2500~2800 | 600~800 | 0.1~0.15 | 10~12 | 溝銑 (SLOTTING) |
| LRTD1205 | 60 | 30 | 700~1000 | 200~300 | 12~24 | 0.15~0.25 | 側銑 (SIDE MILLING) |
| LRTD1205 | 60 | 45 | 1100~1400 | 300~450 | 12~24 | 0.1~0.15 | 側銑 (SIDE MILLING) |
| LRTD1205 | 60 | 150 | 4000~4500 | 800~1000 | 0.25~0.3 | 0.25~0.3 | 3D銑 (3D MILLING) |
| LRTD1205 | 60 | 150 | 4000~4500 | 1000~1400 | 0.1~0.15 | 0.1~0.15 | 3D銑 (3D MILLING) |
| LRTD1210 | 60 | 70 | 1800~2200 | 800~1000 | 0.25~0.3 | 9~12 | 溝銑 (SLOTTING) |
| LRTD1210 | 60 | 95 | 2500~2800 | 600~800 | 0.1~0.15 | 9~12 | 溝銑 (SLOTTING) |
| LRTD1210 | 60 | 30 | 700~1000 | 200~300 | 12~24 | 0.15~0.25 | 側銑 (SIDE MILLING) |
| LRTD1210 | 60 | 45 | 1100~1400 | 300~450 | 12~24 | 0.1~0.15 | 側銑 (SIDE MILLING) |
| LRTD1210 | 60 | 150 | 4000~4500 | 800~1000 | 0.25~0.3 | 0.25~0.3 | 3D銑 (3D MILLING) |
| LRTD1210 | 60 | 150 | 4000~4500 | 1000~1400 | 0.1~0.15 | 0.1~0.15 | 3D銑 (3D MILLING) |
| LRTD1220 | 60 | 70 | 1800~2200 | 800~1000 | 0.25~0.3 | 7~12 | 溝銑 (SLOTTING) |
| LRTD1220 | 60 | 95 | 2500~2800 | 600~800 | 0.1~0.15 | 7~12 | 溝銑 (SLOTTING) |
| LRTD1220 | 60 | 30 | 700~1000 | 200~300 | 12~24 | 0.15~0.25 | 側銑 (SIDE MILLING) |
| LRTD1220 | 60 | 45 | 1100~1400 | 300~450 | 12~24 | 0.1~0.15 | 側銑 (SIDE MILLING) |
| LRTD1220 | 60 | 150 | 4000~4500 | 800~1000 | 0.25~0.3 | 0.25~0.3 | 3D銑 (3D MILLING) |
| LRTD1220 | 60 | 150 | 4000~4500 | 1000~1400 | 0.1~0.15 | 0.1~0.15 | 3D銑 (3D MILLING) |
| LRTD1610 | 100 | 70 | 1200~1600 | 600~900 | 0.3~0.35 | 13~16 | 溝銑 (SLOTTING) |
| LRTD1610 | 100 | 85 | 1500~1800 | 300~500 | 0.12~0.17 | 13~16 | 溝銑 (SLOTTING) |
| LRTD1610 | 100 | 30 | 500~800 | 200~350 | 16~32 | 0.3~0.35 | 側銑 (SIDE MILLING) |
| LRTD1610 | 100 | 45 | 800~1100 | 200~350 | 16~32 | 0.12~0.17 | 側銑 (SIDE MILLING) |
| LRTD1610 | 100 | 150 | 3000~3400 | 1200~1600 | 0.3~0.35 | 0.3~0.35 | 3D銑 (3D MILLING) |
| LRTD1610 | 100 | 150 | 3000~3400 | 700~1000 | 0.12~0.17 | 0.12~0.17 | 3D銑 (3D MILLING) |
| LRTD1620 | 100 | 70 | 1200~1600 | 600~900 | 0.3~0.35 | 11~16 | 溝銑 (SLOTTING) |
| LRTD1620 | 100 | 85 | 1500~1800 | 300~500 | 0.12~0.17 | 11~16 | 溝銑 (SLOTTING) |
| LRTD1620 | 100 | 30 | 500~800 | 200~350 | 16~32 | 0.3~0.35 | 側銑 (SIDE MILLING) |
| LRTD1620 | 100 | 45 | 800~1100 | 200~350 | 16~32 | 0.12~0.17 | 側銑 (SIDE MILLING) |
| LRTD1620 | 100 | 150 | 3000~3400 | 1200~1600 | 0.3~0.35 | 0.3~0.35 | 3D銑 (3D MILLING) |
| LRTD1620 | 100 | 150 | 3000~3400 | 700~1000 | 0.12~0.17 | 0.12~0.17 | 3D銑 (3D MILLING) |

LRTD

切削條件表

Milling Conditions

被切削材 Work Material

調質鋼 / 預硬鋼 : Prehardened Steels
NAK80 : 1.2083 : AISI420 : M310 (HRC36~45)

冷卻方式 Coolant Type

濕式切削 Wet coolant

| 型號 Type NO. | 刀具伸長量 Extension Length(mm) | 切削速度 (m/min) Cutting Speed | 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 |
|----------------|----------------------------------|----------------------------------|---------------------------------------|--------------------------|------------------------------|------------------------------|----------------------|
| LRTD0405 | 40 | 65 | 5000~5500 | 800~1000 | 0.07~0.1 | 1~4 | 溝銼 (SLOTTING) |
| LRTD0405 | 40 | 115 | 9000~10000 | 1000~1400 | 0.07~0.1 | 0.07~0.1 | 3D銼 (3D MILLING) |
| LRTD0410 | 40 | 65 | 5000~5500 | 800~1000 | 0.07~0.1 | 1~4 | 溝銼 (SLOTTING) |
| LRTD0410 | 40 | 115 | 9000~10000 | 1000~1400 | 0.07~0.1 | 0.07~0.1 | 3D銼 (3D MILLING) |
| LRTD0602 | 40 | 70 | 3600~4000 | 600~800 | 0.15~0.2 | 5~6 | 溝銼 (SLOTTING) |
| LRTD0602 | 40 | 85 | 4500~5000 | 1000~1200 | 0.07~0.1 | 5~6 | 溝銼 (SLOTTING) |
| LRTD0602 | 40 | 30 | 1600~2000 | 200~400 | 6~12 | 0.15~0.2 | 側銼 (SIDE MILLING) |
| LRTD0602 | 40 | 50 | 2700~3200 | 400~600 | 6~12 | 0.07~0.1 | 側銼 (SIDE MILLING) |
| LRTD0602 | 40 | 90 | 4800~5400 | 1000~1400 | 0.15~0.2 | 0.15~0.2 | 3D銼 (3D MILLING) |
| LRTD0602 | 40 | 130 | 6800~7200 | 1200~1600 | 0.07~0.1 | 0.07~0.1 | 3D銼 (3D MILLING) |
| LRTD0603 | 40 | 70 | 3600~4000 | 600~800 | 0.15~0.2 | 5~6 | 溝銼 (SLOTTING) |
| LRTD0603 | 40 | 85 | 4500~5000 | 1000~1200 | 0.07~0.1 | 5~6 | 溝銼 (SLOTTING) |
| LRTD0603 | 40 | 30 | 1600~2000 | 200~400 | 6~12 | 0.15~0.2 | 側銼 (SIDE MILLING) |
| LRTD0603 | 40 | 50 | 2700~3200 | 400~600 | 6~12 | 0.07~0.1 | 側銼 (SIDE MILLING) |
| LRTD0603 | 40 | 90 | 4800~5400 | 1000~1400 | 0.15~0.2 | 0.15~0.2 | 3D銼 (3D MILLING) |
| LRTD0603 | 40 | 130 | 6800~7200 | 1200~1600 | 0.07~0.1 | 0.07~0.1 | 3D銼 (3D MILLING) |
| LRTD0605 | 40 | 70 | 3600~4000 | 600~800 | 0.15~0.2 | 4~6 | 溝銼 (SLOTTING) |
| LRTD0605 | 40 | 85 | 4500~5000 | 1000~1200 | 0.07~0.1 | 4~6 | 溝銼 (SLOTTING) |
| LRTD0605 | 40 | 30 | 1600~2000 | 200~400 | 6~12 | 0.15~0.2 | 側銼 (SIDE MILLING) |
| LRTD0605 | 40 | 50 | 2700~3200 | 400~600 | 6~12 | 0.07~0.1 | 側銼 (SIDE MILLING) |
| LRTD0605 | 40 | 90 | 4800~5400 | 1000~1400 | 0.15~0.2 | 0.15~0.2 | 3D銼 (3D MILLING) |
| LRTD0605 | 40 | 130 | 6800~7200 | 1200~1600 | 0.07~0.1 | 0.07~0.1 | 3D銼 (3D MILLING) |
| LRTD0610 | 40 | 70 | 3600~4000 | 600~800 | 0.15~0.2 | 3~6 | 溝銼 (SLOTTING) |
| LRTD0610 | 40 | 85 | 4500~5000 | 1000~1200 | 0.07~0.1 | 3~6 | 溝銼 (SLOTTING) |
| LRTD0610 | 40 | 30 | 1600~2000 | 200~400 | 6~12 | 0.15~0.2 | 側銼 (SIDE MILLING) |
| LRTD0610 | 40 | 50 | 2700~3200 | 400~600 | 6~12 | 0.07~0.1 | 側銼 (SIDE MILLING) |
| LRTD0610 | 40 | 90 | 4800~5400 | 1000~1400 | 0.15~0.2 | 0.15~0.2 | 3D銼 (3D MILLING) |
| LRTD0610 | 40 | 130 | 6800~7200 | 1200~1600 | 0.07~0.1 | 0.07~0.1 | 3D銼 (3D MILLING) |
| LRTD0803 | 50 | 65 | 2400~2800 | 600~800 | 0.2~0.25 | 7~8 | 溝銼 (SLOTTING) |
| LRTD0803 | 50 | 90 | 3500~4000 | 500~700 | 0.08~0.12 | 7~8 | 溝銼 (SLOTTING) |
| LRTD0803 | 50 | 35 | 1200~1600 | 250~350 | 8~16 | 0.2~0.25 | 側銼 (SIDE MILLING) |
| LRTD0803 | 50 | 50 | 1800~2200 | 400~600 | 8~16 | 0.08~0.12 | 側銼 (SIDE MILLING) |
| LRTD0803 | 50 | 115 | 4500~5200 | 800~1000 | 0.2~0.25 | 0.2~0.25 | 3D銼 (3D MILLING) |
| LRTD0803 | 50 | 150 | 5700~6300 | 800~1200 | 0.08~0.12 | 0.08~0.12 | 3D銼 (3D MILLING) |
| LRTD0805 | 50 | 65 | 2400~2800 | 600~800 | 0.2~0.25 | 6~8 | 溝銼 (SLOTTING) |
| LRTD0805 | 50 | 90 | 3500~4000 | 500~700 | 0.08~0.12 | 6~8 | 溝銼 (SLOTTING) |
| LRTD0805 | 50 | 35 | 1200~1600 | 250~350 | 8~16 | 0.2~0.25 | 側銼 (SIDE MILLING) |
| LRTD0805 | 50 | 50 | 1800~2200 | 400~600 | 8~16 | 0.08~0.12 | 側銼 (SIDE MILLING) |
| LRTD0805 | 50 | 115 | 4500~5200 | 800~1000 | 0.2~0.25 | 0.2~0.25 | 3D銼 (3D MILLING) |
| LRTD0805 | 50 | 150 | 5700~6300 | 800~1200 | 0.08~0.12 | 0.08~0.12 | 3D銼 (3D MILLING) |

LRTD

切削條件表

Milling Conditions

被切削材 Work Material

調質鋼 / 預硬鋼 : Prehardened Steels
NAK80 : 1.2083 : AISI420 : M310 (HRc36~45)

冷卻方式 Coolant Type

濕式切削 Wet coolant

| 型號 Type NO. | 刀具伸長量 Extension Length(mm) | 切削速度 (m/min) Cutting Speed | 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 |
|----------------|----------------------------------|----------------------------------|---------------------------------------|--------------------------|------------------------------|------------------------------|----------------------|
| LRTD0810 | 50 | 65 | 2400~2800 | 600~800 | 0.2~0.25 | 5~8 | 溝銑 (SLOTTING) |
| LRTD0810 | 50 | 90 | 3500~4000 | 500~700 | 0.08~0.12 | 5~8 | 溝銑 (SLOTTING) |
| LRTD0810 | 50 | 35 | 1200~1600 | 250~350 | 8~16 | 0.2~0.25 | 側銑 (SIDE MILLING) |
| LRTD0810 | 50 | 50 | 1800~2200 | 400~600 | 8~16 | 0.08~0.12 | 側銑 (SIDE MILLING) |
| LRTD0810 | 50 | 115 | 4500~5200 | 800~1000 | 0.2~0.25 | 0.2~0.25 | 3D銑 (3D MILLING) |
| LRTD0810 | 50 | 150 | 5700~6300 | 800~1200 | 0.08~0.12 | 0.08~0.12 | 3D銑 (3D MILLING) |
| LRTD1002 | 60 | 65 | 2000~2400 | 600~800 | 0.25~0.3 | 9~10 | 溝銑 (SLOTTING) |
| LRTD1002 | 60 | 90 | 2800~3200 | 500~700 | 0.08~0.13 | 9~10 | 溝銑 (SLOTTING) |
| LRTD1002 | 60 | 35 | 1000~1300 | 200~300 | 10~20 | 0.2~0.25 | 側銑 (SIDE MILLING) |
| LRTD1002 | 60 | 40 | 1200~1600 | 400~600 | 10~20 | 0.08~0.13 | 側銑 (SIDE MILLING) |
| LRTD1002 | 60 | 115 | 3600~4000 | 800~1000 | 0.25~0.3 | 0.25~0.3 | 3D銑 (3D MILLING) |
| LRTD1002 | 60 | 150 | 4800~5200 | 800~1200 | 0.08~0.13 | 0.08~0.13 | 3D銑 (3D MILLING) |
| LRTD1003 | 60 | 65 | 2000~2400 | 600~800 | 0.25~0.3 | 8~10 | 溝銑 (SLOTTING) |
| LRTD1003 | 60 | 90 | 2800~3200 | 500~700 | 0.08~0.13 | 8~10 | 溝銑 (SLOTTING) |
| LRTD1003 | 60 | 35 | 1000~1300 | 200~300 | 10~20 | 0.2~0.25 | 側銑 (SIDE MILLING) |
| LRTD1003 | 60 | 40 | 1200~1600 | 400~600 | 10~20 | 0.08~0.13 | 側銑 (SIDE MILLING) |
| LRTD1003 | 60 | 115 | 3600~4000 | 800~1000 | 0.25~0.3 | 0.25~0.3 | 3D銑 (3D MILLING) |
| LRTD1003 | 60 | 150 | 4800~5200 | 800~1200 | 0.08~0.13 | 0.08~0.13 | 3D銑 (3D MILLING) |
| LRTD1005 | 60 | 65 | 2000~2400 | 600~800 | 0.25~0.3 | 8~10 | 溝銑 (SLOTTING) |
| LRTD1005 | 60 | 90 | 2800~3200 | 500~700 | 0.08~0.13 | 8~10 | 溝銑 (SLOTTING) |
| LRTD1005 | 60 | 35 | 1000~1300 | 200~300 | 10~20 | 0.2~0.25 | 側銑 (SIDE MILLING) |
| LRTD1005 | 60 | 40 | 1200~1600 | 400~600 | 10~20 | 0.08~0.13 | 側銑 (SIDE MILLING) |
| LRTD1005 | 60 | 115 | 3600~4000 | 800~1000 | 0.25~0.3 | 0.25~0.3 | 3D銑 (3D MILLING) |
| LRTD1005 | 60 | 150 | 4800~5200 | 800~1200 | 0.08~0.13 | 0.08~0.13 | 3D銑 (3D MILLING) |
| LRTD1010 | 60 | 65 | 2000~2400 | 600~800 | 0.25~0.3 | 7~10 | 溝銑 (SLOTTING) |
| LRTD1010 | 60 | 90 | 2800~3200 | 500~700 | 0.08~0.13 | 7~10 | 溝銑 (SLOTTING) |
| LRTD1010 | 60 | 35 | 1000~1300 | 200~300 | 10~20 | 0.2~0.25 | 側銑 (SIDE MILLING) |
| LRTD1010 | 60 | 40 | 1200~1600 | 400~600 | 10~20 | 0.08~0.13 | 側銑 (SIDE MILLING) |
| LRTD1010 | 60 | 115 | 3600~4000 | 800~1000 | 0.25~0.3 | 0.25~0.3 | 3D銑 (3D MILLING) |
| LRTD1010 | 60 | 150 | 4800~5200 | 800~1200 | 0.08~0.13 | 0.08~0.13 | 3D銑 (3D MILLING) |
| LRTD1020 | 60 | 65 | 2000~2400 | 600~800 | 0.25~0.3 | 5~10 | 溝銑 (SLOTTING) |
| LRTD1020 | 60 | 90 | 2800~3200 | 500~700 | 0.08~0.13 | 5~10 | 溝銑 (SLOTTING) |
| LRTD1020 | 60 | 35 | 1000~1300 | 200~300 | 10~20 | 0.2~0.25 | 側銑 (SIDE MILLING) |
| LRTD1020 | 60 | 40 | 1200~1600 | 400~600 | 10~20 | 0.08~0.13 | 側銑 (SIDE MILLING) |
| LRTD1020 | 60 | 115 | 3600~4000 | 800~1000 | 0.25~0.3 | 0.25~0.3 | 3D銑 (3D MILLING) |
| LRTD1020 | 60 | 150 | 4800~5200 | 800~1200 | 0.08~0.13 | 0.08~0.13 | 3D銑 (3D MILLING) |

LRTD

切削條件表

Milling Conditions

被切削材 Work Material

調質鋼 / 預硬鋼 : Prehardened Steels
NAK80 : 1.2083 : AISI420 : M310 (HRC36~45)

冷卻方式 Coolant Type

濕式切削 Wet coolant

| 型號 Type NO. | 刀具伸長量 Extension Length(mm) | 切削速度 (m/min) Cutting Speed | 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 |
|----------------|----------------------------------|----------------------------------|---------------------------------------|--------------------------|------------------------------|------------------------------|----------------------|
| LRTD1205 | 60 | 70 | 1800~2200 | 800~1000 | 0.25~0.3 | 10~12 | 溝銑 (SLOTTING) |
| LRTD1205 | 60 | 95 | 2500~2800 | 600~800 | 0.1~0.15 | 10~12 | 溝銑 (SLOTTING) |
| LRTD1205 | 60 | 30 | 700~1000 | 200~300 | 12~24 | 0.15~0.25 | 側銑 (SIDE MILLING) |
| LRTD1205 | 60 | 45 | 1100~1400 | 300~450 | 12~24 | 0.1~0.15 | 側銑 (SIDE MILLING) |
| LRTD1205 | 60 | 150 | 4000~4500 | 800~1000 | 0.25~0.3 | 0.25~0.3 | 3D銑 (3D MILLING) |
| LRTD1205 | 60 | 150 | 4000~4500 | 1000~1400 | 0.1~0.15 | 0.1~0.15 | 3D銑 (3D MILLING) |
| LRTD1210 | 60 | 70 | 1800~2200 | 800~1000 | 0.25~0.3 | 9~12 | 溝銑 (SLOTTING) |
| LRTD1210 | 60 | 95 | 2500~2800 | 600~800 | 0.1~0.15 | 9~12 | 溝銑 (SLOTTING) |
| LRTD1210 | 60 | 30 | 700~1000 | 200~300 | 12~24 | 0.15~0.25 | 側銑 (SIDE MILLING) |
| LRTD1210 | 60 | 45 | 1100~1400 | 300~450 | 12~24 | 0.1~0.15 | 側銑 (SIDE MILLING) |
| LRTD1210 | 60 | 150 | 4000~4500 | 800~1000 | 0.25~0.3 | 0.25~0.3 | 3D銑 (3D MILLING) |
| LRTD1210 | 60 | 150 | 4000~4500 | 1000~1400 | 0.1~0.15 | 0.1~0.15 | 3D銑 (3D MILLING) |
| LRTD1220 | 60 | 70 | 1800~2200 | 800~1000 | 0.25~0.3 | 7~12 | 溝銑 (SLOTTING) |
| LRTD1220 | 60 | 95 | 2500~2800 | 600~800 | 0.1~0.15 | 7~12 | 溝銑 (SLOTTING) |
| LRTD1220 | 60 | 30 | 700~1000 | 200~300 | 12~24 | 0.15~0.25 | 側銑 (SIDE MILLING) |
| LRTD1220 | 60 | 45 | 1100~1400 | 300~450 | 12~24 | 0.1~0.15 | 側銑 (SIDE MILLING) |
| LRTD1220 | 60 | 150 | 4000~4500 | 800~1000 | 0.25~0.3 | 0.25~0.3 | 3D銑 (3D MILLING) |
| LRTD1220 | 60 | 150 | 4000~4500 | 1000~1400 | 0.1~0.15 | 0.1~0.15 | 3D銑 (3D MILLING) |
| LRTD1610 | 100 | 70 | 1200~1600 | 600~900 | 0.3~0.35 | 13~16 | 溝銑 (SLOTTING) |
| LRTD1610 | 100 | 85 | 1500~1800 | 300~500 | 0.12~0.17 | 13~16 | 溝銑 (SLOTTING) |
| LRTD1610 | 100 | 30 | 500~800 | 200~350 | 16~32 | 0.3~0.35 | 側銑 (SIDE MILLING) |
| LRTD1610 | 100 | 45 | 800~1100 | 200~350 | 16~32 | 0.12~0.17 | 側銑 (SIDE MILLING) |
| LRTD1610 | 100 | 150 | 3000~3400 | 1200~1600 | 0.3~0.35 | 0.3~0.35 | 3D銑 (3D MILLING) |
| LRTD1610 | 100 | 150 | 3000~3400 | 700~1000 | 0.12~0.17 | 0.12~0.17 | 3D銑 (3D MILLING) |
| LRTD1620 | 100 | 70 | 1200~1600 | 600~900 | 0.3~0.35 | 11~16 | 溝銑 (SLOTTING) |
| LRTD1620 | 100 | 85 | 1500~1800 | 300~500 | 0.12~0.17 | 11~16 | 溝銑 (SLOTTING) |
| LRTD1620 | 100 | 30 | 500~800 | 200~350 | 16~32 | 0.3~0.35 | 側銑 (SIDE MILLING) |
| LRTD1620 | 100 | 45 | 800~1100 | 200~350 | 16~32 | 0.12~0.17 | 側銑 (SIDE MILLING) |
| LRTD1620 | 100 | 150 | 3000~3400 | 1200~1600 | 0.3~0.35 | 0.3~0.35 | 3D銑 (3D MILLING) |
| LRTD1620 | 100 | 150 | 3000~3400 | 700~1000 | 0.12~0.17 | 0.12~0.17 | 3D銑 (3D MILLING) |

LRTD

切削條件表

Milling Conditions

被切削材 Work Material

熱處理鋼 : Hardened Steels

SKD61/ STAVAX / 17-4PH : 1.2083 / 1.2344 / 1.4542 : H13 / 420 (HRC48~54)

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 (m/min) Cutting Speed | 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 |
|----------------|----------------------------------|----------------------------------|---------------------------------------|--------------------------|------------------------------|------------------------------|----------------------|
| LRTD0405 | 40 | 60 | 4500~5000 | 600~800 | 0.05~0.07 | 2~4 | 溝銑 (SLOTTING) |
| LRTD0405 | 40 | 100 | 8000~9000 | 600~800 | 0.05~0.07 | 0.05~0.07 | 3D銑 (3D MILLING) |
| LRTD0410 | 40 | 60 | 4500~5000 | 600~800 | 0.05~0.07 | 2~4 | 溝銑 (SLOTTING) |
| LRTD0410 | 40 | 100 | 8000~9000 | 600~800 | 0.05~0.07 | 0.05~0.07 | 3D銑 (3D MILLING) |
| LRTD0602 | 40 | 85 | 4500~5000 | 600~800 | 0.06~0.08 | 5~6 | 溝銑 (SLOTTING) |
| LRTD0602 | 40 | 50 | 2700~3200 | 400~600 | 6~12 | 0.06~0.08 | 側銑 (SIDE MILLING) |
| LRTD0602 | 40 | 120 | 6200~6600 | 800~1000 | 0.06~0.08 | 0.06~0.08 | 3D銑 (3D MILLING) |
| LRTD0603 | 40 | 85 | 4500~5000 | 600~800 | 0.06~0.08 | 5~6 | 溝銑 (SLOTTING) |
| LRTD0603 | 40 | 50 | 2700~3200 | 400~600 | 6~12 | 0.06~0.08 | 側銑 (SIDE MILLING) |
| LRTD0603 | 40 | 120 | 6200~6600 | 800~1000 | 0.06~0.08 | 0.06~0.08 | 3D銑 (3D MILLING) |
| LRTD0605 | 40 | 85 | 4500~5000 | 600~800 | 0.06~0.08 | 4~6 | 溝銑 (SLOTTING) |
| LRTD0605 | 40 | 50 | 2700~3200 | 400~600 | 6~12 | 0.06~0.08 | 側銑 (SIDE MILLING) |
| LRTD0605 | 40 | 120 | 6200~6600 | 800~1000 | 0.06~0.08 | 0.06~0.08 | 3D銑 (3D MILLING) |
| LRTD0610 | 40 | 85 | 4500~5000 | 600~800 | 0.06~0.08 | 3~6 | 溝銑 (SLOTTING) |
| LRTD0610 | 40 | 50 | 2700~3200 | 400~600 | 6~12 | 0.06~0.08 | 側銑 (SIDE MILLING) |
| LRTD0610 | 40 | 120 | 6200~6600 | 800~1000 | 0.06~0.08 | 0.06~0.08 | 3D銑 (3D MILLING) |
| LRTD0803 | 50 | 90 | 3500~4000 | 450~650 | 0.08~0.12 | 7~8 | 溝銑 (SLOTTING) |
| LRTD0803 | 50 | 50 | 1800~2200 | 300~500 | 8~16 | 0.08~0.12 | 側銑 (SIDE MILLING) |
| LRTD0803 | 50 | 120 | 4600~5000 | 800~1100 | 0.08~0.12 | 0.08~0.12 | 3D銑 (3D MILLING) |
| LRTD0805 | 50 | 90 | 3500~4000 | 450~650 | 0.08~0.12 | 6~8 | 溝銑 (SLOTTING) |
| LRTD0805 | 50 | 50 | 1800~2200 | 300~500 | 8~16 | 0.08~0.12 | 側銑 (SIDE MILLING) |
| LRTD0805 | 50 | 120 | 4600~5000 | 800~1100 | 0.08~0.12 | 0.08~0.12 | 3D銑 (3D MILLING) |
| LRTD0810 | 50 | 90 | 3500~4000 | 450~650 | 0.08~0.12 | 5~8 | 溝銑 (SLOTTING) |
| LRTD0810 | 50 | 50 | 1800~2200 | 300~500 | 8~16 | 0.08~0.12 | 側銑 (SIDE MILLING) |
| LRTD0810 | 50 | 120 | 4600~5000 | 800~1100 | 0.08~0.12 | 0.08~0.12 | 3D銑 (3D MILLING) |
| LRTD1002 | 60 | 90 | 2800~3200 | 400~600 | 0.08~0.12 | 9~10 | 溝銑 (SLOTTING) |
| LRTD1002 | 60 | 60 | 1800~2200 | 400~600 | 10~20 | 0.08~0.12 | 側銑 (SIDE MILLING) |
| LRTD1002 | 60 | 125 | 4000~4500 | 800~1000 | 0.08~0.12 | 0.08~0.12 | 3D銑 (3D MILLING) |
| LRTD1003 | 60 | 90 | 2800~3200 | 400~600 | 0.08~0.12 | 8~10 | 溝銑 (SLOTTING) |
| LRTD1003 | 60 | 60 | 1800~2200 | 400~600 | 10~20 | 0.08~0.12 | 側銑 (SIDE MILLING) |
| LRTD1003 | 60 | 125 | 4000~4500 | 800~1000 | 0.08~0.12 | 0.08~0.12 | 3D銑 (3D MILLING) |
| LRTD1005 | 60 | 90 | 2800~3200 | 400~600 | 0.08~0.12 | 8~10 | 溝銑 (SLOTTING) |
| LRTD1005 | 60 | 60 | 1800~2200 | 400~600 | 10~20 | 0.08~0.12 | 側銑 (SIDE MILLING) |
| LRTD1005 | 60 | 125 | 4000~4500 | 800~1000 | 0.08~0.12 | 0.08~0.12 | 3D銑 (3D MILLING) |
| LRTD1010 | 60 | 90 | 2800~3200 | 400~600 | 0.08~0.12 | 7~10 | 溝銑 (SLOTTING) |
| LRTD1010 | 60 | 60 | 1800~2200 | 400~600 | 10~20 | 0.08~0.12 | 側銑 (SIDE MILLING) |
| LRTD1010 | 60 | 125 | 4000~4500 | 800~1000 | 0.08~0.12 | 0.08~0.12 | 3D銑 (3D MILLING) |
| LRTD1020 | 60 | 90 | 2800~3200 | 400~600 | 0.08~0.12 | 5~10 | 溝銑 (SLOTTING) |
| LRTD1020 | 60 | 60 | 1800~2200 | 400~600 | 10~20 | 0.08~0.12 | 側銑 (SIDE MILLING) |
| LRTD1020 | 60 | 125 | 4000~4500 | 800~1000 | 0.08~0.12 | 0.08~0.12 | 3D銑 (3D MILLING) |

LRTD

切削條件表

Milling Conditions

被切削材 Work Material

熱處理鋼 : *Hardened Steels*
SKD61/ STAVAX / 17-4PH : 1.2083 / 1.2344 / 1.4542 : H13 / 420 (HRc48-54)

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 (m/min) Cutting Speed | 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 |
|----------------|----------------------------------|----------------------------------|---------------------------------------|--------------------------|------------------------------|------------------------------|----------------------|
| LRTD1205 | 60 | 75 | 2000~2400 | 400~600 | 0.1~0.15 | 10~12 | 溝銼 (SLOTTING) |
| LRTD1205 | 60 | 70 | 1800~2200 | 350~500 | 12~24 | 0.1~0.15 | 側銼 (SIDE MILLING) |
| LRTD1205 | 60 | 120 | 3200~3600 | 600~800 | 0.1~0.15 | 0.1~0.15 | 3D銼 (3D MILLING) |
| LRTD1210 | 60 | 75 | 2000~2400 | 400~600 | 0.1~0.15 | 9~12 | 溝銼 (SLOTTING) |
| LRTD1210 | 60 | 70 | 1800~2200 | 350~500 | 12~24 | 0.1~0.15 | 側銼 (SIDE MILLING) |
| LRTD1210 | 60 | 120 | 3200~3600 | 600~800 | 0.1~0.15 | 0.1~0.15 | 3D銼 (3D MILLING) |
| LRTD1210 | 60 | 75 | 2000~2400 | 400~600 | 0.1~0.15 | 7~12 | 溝銼 (SLOTTING) |
| LRTD1210 | 60 | 70 | 1800~2200 | 350~500 | 12~24 | 0.1~0.15 | 側銼 (SIDE MILLING) |
| LRTD1210 | 60 | 120 | 3200~3600 | 600~800 | 0.1~0.15 | 0.1~0.15 | 3D銼 (3D MILLING) |
| LRTD1610 | 100 | 75 | 1300~1700 | 300~500 | 0.12~0.17 | 13~16 | 溝銼 (SLOTTING) |
| LRTD1610 | 100 | 60 | 1000~1300 | 200~350 | 16~32 | 0.12~0.17 | 側銼 (SIDE MILLING) |
| LRTD1610 | 100 | 120 | 2200~2600 | 700~900 | 0.12~0.17 | 0.12~0.17 | 3D銼 (3D MILLING) |
| LRTD1620 | 100 | 75 | 1300~1700 | 300~500 | 0.12~0.17 | 11~16 | 溝銼 (SLOTTING) |
| LRTD1620 | 100 | 60 | 1000~1300 | 200~350 | 16~32 | 0.12~0.17 | 側銼 (SIDE MILLING) |
| LRTD1620 | 100 | 120 | 2200~2600 | 700~900 | 0.12~0.17 | 0.12~0.17 | 3D銼 (3D MILLING) |