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# Экономсерия

# DB 2T

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron S50C / Fc250 / SS440 : 1.1210 / 0.6025 / 1.0036 : 1050 / N0.35 / A570 Gr.45 (~HRC22)					
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 <sup>-1</sup> )	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
DB0102	10	60	18000~20000	600~900	0.05~0.08	0.12~0.16	3D 銑 (3D milling)
DB0102	10	60	18000~20000	800~1200	0.02~0.04	0.04~0.08	3D 銑 (3D milling)
DB0152	10	90	18000~20000	600~900	0.05~0.09	0.14~0.18	3D 銑 (3D milling)
DB0152	10	90	18000~20000	800~1200	0.03~0.05	0.06~0.1	3D 銑 (3D milling)
DB0202	12	120	18000~20000	600~900	0.05~0.09	0.14~0.18	3D 銑 (3D milling)
DB0202	12	120	18000~20000	800~1200	0.03~0.05	0.06~0.1	3D 銑 (3D milling)
DB0252	12	135	17000~18000	600~900	0.06~0.1	0.16~0.2	3D 銑 (3D milling)
DB0252	12	135	17000~18000	800~1200	0.04~0.06	0.08~0.12	3D 銑 (3D milling)
DB0302	13	150	16000~17000	600~900	0.07~0.12	0.2~0.24	3D 銑 (3D milling)
DB0302	13	150	16000~17000	800~1200	0.05~0.07	0.1~0.14	3D 銑 (3D milling)
DB0402	15	190	15000~16000	600~900	0.1~0.14	0.22~0.26	3D 銑 (3D milling)
DB0402	15	190	15000~16000	900~1300	0.06~0.08	0.14~0.22	3D 銑 (3D milling)
DB0502	18	220	14000~15000	600~900	0.1~0.16	0.26~0.32	3D 銑 (3D milling)
DB0502	18	220	14000~15000	1000~1400	0.07~0.09	0.14~0.18	3D 銑 (3D milling)
DB0602	20	245	13000~14000	800~1200	0.15~0.2	0.3~0.4	3D 銑 (3D milling)
DB0602	20	245	13000~14000	1200~1600	0.07~0.11	0.14~0.22	3D 銑 (3D milling)
DB0802	30	255	10000~11000	900~1200	0.1~0.23	0.36~0.46	3D 銑 (3D milling)
DB0802	30	255	10000~11000	1300~1700	0.08~0.13	0.16~0.26	3D 銑 (3D milling)
DB1002	35	285	8700~9200	900~1200	0.2~0.28	0.46~0.56	3D 銑 (3D milling)
DB1002	35	285	8700~9200	1300~1700	0.1~0.15	0.2~0.3	3D 銑 (3D milling)
DB1202	40	265	7000~8000	900~1200	0.2~0.3	0.54~0.64	3D 銑 (3D milling)
DB1202	40	265	7000~8000	1200~1600	0.15~0.2	0.3~0.4	3D 銑 (3D milling)
DB1602	50	255	5000~6000	700~1100	0.3~0.4	0.7~0.8	3D 銑 (3D milling)
DB1602	50	255	5000~6000	1000~1400	0.15~0.2	0.36~0.46	3D 銑 (3D milling)

# DB 2T

## 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 (HRC 36~45)					
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 <sup>-1</sup> )	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
DB0102	10	60	18000~20000	300~600	0.05~0.08	0.12~0.16	3D 銑 (3D milling)
DB0102	10	60	18000~20000	600~900	0.02~0.04	0.04~0.08	3D 銑 (3D milling)
DB0152	10	90	18000~20000	300~600	0.05~0.09	0.14~0.18	3D 銑 (3D milling)
DB0152	10	90	18000~20000	600~900	0.03~0.05	0.06~0.1	3D 銑 (3D milling)
DB0202	12	120	18000~20000	300~600	0.05~0.09	0.14~0.18	3D 銑 (3D milling)
DB0202	12	120	18000~20000	600~900	0.03~0.05	0.06~0.1	3D 銑 (3D milling)
DB0252	12	135	17000~18000	300~600	0.05~0.09	0.14~0.18	3D 銑 (3D milling)
DB0252	12	135	17000~18000	600~900	0.03~0.05	0.06~0.1	3D 銑 (3D milling)
DB0302	13	150	16000~17000	300~600	0.06~0.11	0.18~0.22	3D 銑 (3D milling)
DB0302	13	150	16000~17000	600~900	0.04~0.06	0.08~0.12	3D 銑 (3D milling)
DB0402	15	175	14000~15000	400~700	0.1~0.13	0.22~0.26	3D 銑 (3D milling)
DB0402	15	175	14000~15000	800~1200	0.06~0.08	0.14~0.22	3D 銑 (3D milling)
DB0502	18	205	13000~14000	500~800	0.1~0.13	0.22~0.26	3D 銑 (3D milling)
DB0502	18	205	13000~14000	900~1300	0.06~0.08	0.14~0.22	3D 銑 (3D milling)
DB0602	20	230	12000~13000	600~900	0.1~0.16	0.26~0.32	3D 銑 (3D milling)
DB0602	20	230	12000~13000	900~1300	0.07~0.11	0.14~0.22	3D 銑 (3D milling)
DB0802	30	255	10000~11000	700~1100	0.1~0.2	0.3~0.4	3D 銑 (3D milling)
DB0802	30	255	10000~11000	1000~1400	0.08~0.12	0.16~0.24	3D 銑 (3D milling)
DB1002	35	285	8700~9200	700~1100	0.2~0.25	0.4~0.5	3D 銑 (3D milling)
DB1002	35	285	8700~9200	1000~1400	0.1~0.15	0.2~0.3	3D 銑 (3D milling)
DB1202	40	260	6500~7500	600~900	0.2~0.28	0.4~0.56	3D 銑 (3D milling)
DB1202	40	260	6500~7500	1000~1400	0.15~0.2	0.2~0.3	3D 銑 (3D milling)
DB1602	50	275	5000~6000	500~700	0.2~0.32	0.54~0.64	3D 銑 (3D milling)
DB1602	50	275	5000~6000	800~1100	0.15~0.2	0.3~0.4	3D 銑 (3D milling)

# DHB.DIB<sup>2T</sup>

## 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		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 <sup>-1</sup> )	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
DHB0202	40	100	15000~16000	900~1200	0.03~0.05	0.06~0.1	3D 銑 (3D milling)
DHB0252	40	125	15000~16000	1000~1300	0.03~0.05	0.06~0.1	3D 銑 (3D milling)
DHB0302	40	130	13000~14000	1000~1300	0.04~0.05	0.08~0.1	3D 銑 (3D milling)
DHB0402	40	150	11500~12500	1000~1300	0.04~0.08	0.12~0.16	3D 銑 (3D milling)
DHB0502	40	175	10000~11000	1100~1400	0.04~0.08	0.12~0.16	3D 銑 (3D milling)
DHB0602	40	160	7800~8300	1300~1700	0.1~0.15	0.24~0.3	3D 銑 (3D milling)
DHB0602	40	175	8800~9300	1400~1800	0.05~0.09	0.14~0.18	3D 銑 (3D milling)
DHB0802	40	235	8700~9200	1300~1700	0.12~0.2	0.32~0.4	3D 銑 (3D milling)
DHB0802	40	265	9500~10500	1400~1800	0.05~0.1	0.16~0.2	3D 銑 (3D milling)
DIB0202	50	150	11500~12000	700~1000	0.04~0.06	0.08~0.12	3D 銑 (3D milling)
DIB0302	50	150	11500~12000	800~1100	0.04~0.06	0.08~0.12	3D 銑 (3D milling)
DIB0402	50	150	11500~12000	900~1200	0.04~0.06	0.08~0.12	3D 銑 (3D milling)
DIB0602	50	230	11000~12000	900~1200	0.06~0.08	0.12~0.16	3D 銑 (3D milling)
DIB0802	50	185	6700~7300	900~1200	0.15~0.2	0.3~0.4	3D 銑 (3D milling)
DIB0802	50	225	8300~8800	1000~1400	0.06~0.1	0.16~0.2	3D 銑 (3D milling)
DIB1002	60	290	8700~9200	1000~1400	0.09~0.14	0.18~0.28	3D 銑 (3D milling)
DIB1202	60	325	8200~8600	900~1200	0.2~0.25	0.4~0.5	3D 銑 (3D milling)
DIB1202	60	325	8200~8600	1000~1400	0.1~0.15	0.2~0.3	3D 銑 (3D milling)

# DE 2T

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron					
		S50C / Fc250 / SS440 : 1.1210 / 0.6025 / 1.0036 : 1050 / N0.35 / A570 Gr.45 (~HRC22)					
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 <sup>-1</sup> )	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
DE0102	12	30	9000~10000	600~900	0.05~0.1	1	溝銑 (Slotting)
DE0102	12	30	9000~10000	700~1000	0.1~0.15	1	溝銑 (Slotting)
DE0102	12	30	9000~10000	400~700	1~2	0.05~0.1	側銑 (Side milling)
DE0102	12	30	9000~10000	300~600	1~2	0.1~0.15	側銑 (Side milling)
DE0152	14	45	9000~10000	600~900	0.05~0.1	1.5	溝銑 (Slotting)
DE0152	14	45	9000~10000	700~1000	0.15~0.2	1.5	溝銑 (Slotting)
DE0152	14	45	9000~10000	400~700	3	0.05~0.1	側銑 (Side milling)
DE0152	14	45	9000~10000	300~600	3	0.15~0.2	側銑 (Side milling)
DE0202	16	55	8700~9200	600~900	0.05~0.1	2	溝銑 (Slotting)
DE0202	16	55	8700~9200	700~1000	0.15~0.2	2	溝銑 (Slotting)
DE0202	16	55	8700~9200	400~700	4	0.05~0.1	側銑 (Side milling)
DE0202	16	55	8700~9200	300~600	4	0.15~0.2	側銑 (Side milling)
DE0252	16	65	8000~8500	600~900	0.05~0.1	2.5	溝銑 (Slotting)
DE0252	16	65	8000~8500	700~1000	0.15~0.2	2.5	溝銑 (Slotting)
DE0252	16	65	8000~8500	500~800	5	0.05~0.1	側銑 (Side milling)
DE0252	16	65	8000~8500	400~700	5	0.15~0.2	側銑 (Side milling)
DE0302	18	75	7500~8000	600~900	0.05~0.1	3	溝銑 (Slotting)
DE0302	18	75	7500~8000	700~1000	0.15~0.2	3	溝銑 (Slotting)
DE0302	18	75	7500~8000	500~800	6	0.05~0.1	側銑 (Side milling)
DE0302	18	75	7500~8000	400~700	6	0.15~0.2	側銑 (Side milling)
DE0402	20	75	5700~6200	600~900	0.05~0.1	4	溝銑 (Slotting)
DE0402	20	75	5700~6200	800~1100	0.2~0.3	4	溝銑 (Slotting)
DE0402	20	75	5700~6200	600~900	8	0.05~0.1	側銑 (Side milling)
DE0402	20	75	5700~6200	800~1100	8	0.2~0.3	側銑 (Side milling)
DE0502	20	80	4800~5300	600~900	0.05~0.1	5	溝銑 (Slotting)
DE0502	20	80	4800~5300	800~1100	0.2~0.3	5	溝銑 (Slotting)
DE0502	20	80	4800~5300	600~900	10	0.05~0.1	側銑 (Side milling)
DE0502	20	80	4800~5300	800~1100	10	0.2~0.3	側銑 (Side milling)

# DE<sup>2T</sup>

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron S50C / Fc250 / SS440 : 1.1210 / 0.6025 / 1.0036 : 1050 / N0.35 / A570 Gr.45 (~HRC22)					
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 <sup>-1</sup> )	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
DE0602	23	80	4000~4500	600~900	0.05~0.15	6	溝銑 (Slotting)
DE0602	23	80	4000~4500	800~1100	0.7~1	6	溝銑 (Slotting)
DE0602	23	80	4000~4500	600~900	12	0.05~0.15	側銑 (Side milling)
DE0602	23	80	4000~4500	800~1100	12	0.3~0.4	側銑 (Side milling)
DE0802	30	90	2700~3200	600~900	0.05~0.15	8	溝銑 (Slotting)
DE0802	30	90	2700~3200	600~900	0.7~1	8	溝銑 (Slotting)
DE0802	30	90	2700~3200	500~800	16	0.05~0.15	側銑 (Side milling)
DE0802	30	90	2700~3200	900~1200	16	0.4~0.5	側銑 (Side milling)
DE1002	35	85	2500~3000	600~900	0.05~0.15	10	溝銑 (Slotting)
DE1002	35	85	2500~3000	700~1100	0.7~1	10	溝銑 (Slotting)
DE1002	35	70	2000~2500	400~700	20	0.05~0.15	側銑 (Side milling)
DE1002	35	70	2000~2500	700~1100	20	0.4~0.5	側銑 (Side milling)
DE1202	37	105	2500~3000	600~900	0.05~0.15	12	溝銑 (Slotting)
DE1202	37	85	2000~2500	400~600	0.7~1	12	溝銑 (Slotting)
DE1202	37	115	2800~3300	400~600	24	0.05~0.15	側銑 (Side milling)
DE1202	37	115	2800~3300	600~900	24	0.4~0.5	側銑 (Side milling)
DE1602	50	100	1800~2300	400~600	0.05~0.15	16	溝銑 (Slotting)
DE1602	50	85	1500~2000	400~600	0.9~1.2	16	溝銑 (Slotting)
DE1602	50	115	2000~2500	400~600	32	0.05~0.15	側銑 (Side milling)
DE1602	50	115	2000~2500	500~800	32	0.4~0.5	側銑 (Side milling)

# DE 2T

## 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		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 <sup>-1</sup> )	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
DE0102	14	30	9000~10000	500~800	0.05~0.1	1	溝銑 (Slotting)
DE0102	14	30	9000~10000	600~900	0.1~0.15	1	溝銑 (Slotting)
DE0102	14	30	9000~10000	300~600	1~2	0.05~0.1	側銑 (Side milling)
DE0102	14	30	9000~10000	300~500	1~2	0.1~0.15	側銑 (Side milling)
DE0152	14	45	9000~10000	500~800	0.05~0.1	1.5	溝銑 (Slotting)
DE0152	14	45	9000~10000	600~900	0.15~0.2	1.5	溝銑 (Slotting)
DE0152	14	45	9000~10000	300~600	3	0.05~0.1	側銑 (Side milling)
DE0152	14	45	9000~10000	300~500	3	0.15~0.2	側銑 (Side milling)
DE0202	16	55	8700~9200	500~800	0.05~0.1	2	溝銑 (Slotting)
DE0202	16	55	8700~9200	600~900	0.15~0.2	2	溝銑 (Slotting)
DE0202	16	55	8700~9200	300~600	4	0.05~0.1	側銑 (Side milling)
DE0202	16	55	8700~9200	300~500	4	0.15~0.2	側銑 (Side milling)
DE0252	16	65	8000~8500	500~800	0.05~0.1	2.5	溝銑 (Slotting)
DE0252	16	65	8000~8500	600~900	0.15~0.2	2.5	溝銑 (Slotting)
DE0252	16	65	8000~8500	300~600	5	0.05~0.1	側銑 (Side milling)
DE0252	16	65	8000~8500	300~500	5	0.15~0.2	側銑 (Side milling)
DE0302	18	75	7500~8000	500~800	0.05~0.1	3	溝銑 (Slotting)
DE0302	18	75	7500~8000	600~900	0.15~0.2	3	溝銑 (Slotting)
DE0302	18	75	7500~8000	400~700	6	0.05~0.1	側銑 (Side milling)
DE0302	18	75	7500~8000	400~700	6	0.15~0.2	側銑 (Side milling)
DE0402	20	75	5700~6200	500~800	0.05~0.1	4	溝銑 (Slotting)
DE0402	20	75	5700~6200	700~1000	0.2~0.3	4	溝銑 (Slotting)
DE0402	20	75	5700~6200	500~800	8	0.05~0.1	側銑 (Side milling)
DE0402	20	75	5700~6200	600~900	8	0.2~0.3	側銑 (Side milling)
DE0502	20	80	4800~5300	500~800	0.05~0.1	5	溝銑 (Slotting)
DE0502	20	80	4800~5300	700~1000	0.2~0.3	5	溝銑 (Slotting)
DE0502	20	80	4800~5300	500~800	10	0.05~0.1	側銑 (Side milling)
DE0502	20	80	4800~5300	600~900	10	0.2~0.3	側銑 (Side milling)

# DE<sup>2T</sup>

## 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		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 <sup>-1</sup> )	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
DE0602	23	80	4000~4500	500~800	0.05~0.15	6	溝銑 (Slotting)
DE0602	23	80	4000~4500	700~1000	0.7~1	6	溝銑 (Slotting)
DE0602	23	80	4000~4500	500~800	12	0.05~0.15	側銑 (Side milling)
DE0602	23	80	4000~4500	600~900	12	0.3~0.4	側銑 (Side milling)
DE0802	30	75	2700~3200	500~800	0.05~0.15	8	溝銑 (Slotting)
DE0802	30	75	2700~3200	500~800	0.7~1	8	溝銑 (Slotting)
DE0802	30	75	2700~3200	400~700	16	0.05~0.15	側銑 (Side milling)
DE0802	30	75	2700~3200	700~1000	16	0.4~0.5	側銑 (Side milling)
DE1002	35	100	3000~3500	500~800	0.05~0.15	10	溝銑 (Slotting)
DE1002	35	75	2200~2700	600~900	0.7~1	10	溝銑 (Slotting)
DE1002	35	100	3000~3500	400~600	20	0.05~0.15	側銑 (Side milling)
DE1002	35	70	2000~2500	600~900	20	0.4~0.5	側銑 (Side milling)
DE1202	37	105	2500~3000	500~800	0.05~0.15	12	溝銑 (Slotting)
DE1202	37	85	2000~2500	300~500	0.7~1	12	溝銑 (Slotting)
DE1202	37	115	2800~3300	300~500	24	0.05~0.15	側銑 (Side milling)
DE1202	37	115	2800~3300	500~800	24	0.4~0.5	側銑 (Side milling)
DE1602	50	100	1800~2300	300~500	0.05~0.15	16	溝銑 (Slotting)
DE1602	50	85	1500~2000	300~500	0.9~1.2	16	溝銑 (Slotting)
DE1602	50	115	2000~2500	300~500	32	0.05~0.15	側銑 (Side milling)
DE1602	50	115	2000~2500	400~600	32	0.4~0.5	側銑 (Side milling)

# DHE 2T

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron					
		S50C / Fc250 / SS440 : 1.1210 / 0.6025 / 1.0036 : 1050 / N0.35 / A570 Gr.45 (~HRC22)					
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 <sup>-1</sup> )	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
DHE0302	18	75	7500~8000	600~900	0.05~0.1	3	溝銑 (Slotting)
DHE0302	18	75	7500~8000	700~1000	0.15~0.2	3	溝銑 (Slotting)
DHE0302	18	75	7500~8000	500~800	6	0.05~0.1	側銑 (Side milling)
DHE0302	18	75	7500~8000	400~700	6	0.15~0.2	側銑 (Side milling)
DHE0302	30	50	5000~5500	400~600	0.03~0.07	3	溝銑 (Slotting)
DHE0302	30	45	4500~5000	250~450	3~6	0.03~0.07	側銑 (Side milling)
DHE0402	20	80	6000~6500	600~900	0.05~0.1	4	溝銑 (Slotting)
DHE0402	20	80	6000~6500	800~1100	0.2~0.3	4	溝銑 (Slotting)
DHE0402	20	80	6000~6500	600~900	8	0.05~0.1	側銑 (Side milling)
DHE0402	20	80	6000~6500	800~1100	8	0.2~0.3	側銑 (Side milling)
DHE0402	40	40	3000~3500	400~600	0.05~0.1	3	溝銑 (Slotting)
DHE0402	40	35	2500~3000	250~450	4~8	0.05~0.1	側銑 (Side milling)
DHE0502	20	90	5500~6000	600~900	0.05~0.1	5	溝銑 (Slotting)
DHE0502	20	90	5500~6000	800~1100	0.2~0.3	5	溝銑 (Slotting)
DHE0502	20	90	5500~6000	600~900	10	0.05~0.1	側銑 (Side milling)
DHE0502	20	90	5500~6000	800~1100	10	0.2~0.3	側銑 (Side milling)
DHE0502	40	70	4000~4500	400~600	0.05~0.15	4	溝銑 (Slotting)
DHE0502	40	55	3200~3700	250~450	5~10	0.05~0.15	側銑 (Side milling)
DHE0602	23	90	4500~5000	600~900	0.05~0.15	6	溝銑 (Slotting)
DHE0602	23	90	4500~5000	800~1100	0.7~1	6	溝銑 (Slotting)
DHE0602	23	90	4500~5000	600~900	12	0.05~0.15	側銑 (Side milling)
DHE0602	23	90	4500~5000	800~1100	12	0.3~0.4	側銑 (Side milling)
DHE0602	40	70	3500~4000	600~900	0.05~0.15	5	溝銑 (Slotting)
DHE0602	40	70	3500~4000	300~500	6~12	0.05~0.15	側銑 (Side milling)
DHE0802	30	90	3300~3800	600~900	0.05~0.15	8	溝銑 (Slotting)
DHE0802	30	90	3300~3800	600~900	0.7~1	8	溝銑 (Slotting)
DHE0802	30	90	3300~3800	500~800	16	0.05~0.15	側銑 (Side milling)
DHE0802	30	90	3300~3800	900~1200	16	0.4~0.5	側銑 (Side milling)
DHE0802	45	70	2500~3000	700~900	0.05~0.15	7	溝銑 (Slotting)
DHE0802	45	70	2500~3000	400~600	8~16	0.05~0.15	側銑 (Side milling)

# DHE<sup>2T</sup>

## 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		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 <sup>-1</sup> )	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
DHE0302	18	75	7500~8000	500~800	0.05~0.1	3	溝銑 (Slotting)
DHE0302	18	75	7500~8000	600~900	0.15~0.2	3	溝銑 (Slotting)
DHE0302	18	75	7500~8000	400~700	6	0.05~0.1	側銑 (Side milling)
DHE0302	18	75	7500~8000	400~700	6	0.15~0.2	側銑 (Side milling)
DHE0302	30	40	4000~4500	300~500	0.03~0.07	3	溝銑 (Slotting)
DHE0302	30	35	3500~4000	250~400	3~6	0.03~0.07	側銑 (Side milling)
DHE0402	20	75	5700~6200	500~800	0.05~0.1	4	溝銑 (Slotting)
DHE0402	20	75	5700~6200	700~1000	0.2~0.3	4	溝銑 (Slotting)
DHE0402	20	75	5700~6200	500~800	8	0.05~0.1	側銑 (Side milling)
DHE0402	20	75	5700~6200	600~900	8	0.2~0.3	側銑 (Side milling)
DHE0402	40	35	2700~3200	300~500	0.05~0.1	3	溝銑 (Slotting)
DHE0402	40	30	2400~2800	200~400	4~8	0.05~0.1	側銑 (Side milling)
DHE0502	20	80	4800~5300	500~800	0.05~0.1	5	溝銑 (Slotting)
DHE0502	20	80	4800~5300	700~1000	0.2~0.3	5	溝銑 (Slotting)
DHE0502	20	80	4800~5300	500~800	10	0.05~0.1	側銑 (Side milling)
DHE0502	20	80	4800~5300	600~900	10	0.2~0.3	側銑 (Side milling)
DHE0502	40	65	3700~4200	350~550	0.05~0.15	4	溝銑 (Slotting)
DHE0502	40	50	3000~3500	200~400	5~10	0.05~0.15	側銑 (Side milling)
DHE0602	23	80	4000~4500	500~800	0.05~0.15	6	溝銑 (Slotting)
DHE0602	23	80	4000~4500	700~1000	0.7~1	6	溝銑 (Slotting)
DHE0602	23	80	4000~4500	500~800	12	0.05~0.15	側銑 (Side milling)
DHE0602	23	80	4000~4500	600~900	12	0.3~0.4	側銑 (Side milling)
DHE0602	40	70	3500~4000	600~800	0.05~0.15	5	溝銑 (Slotting)
DHE0602	40	70	3500~4000	300~450	6~12	0.05~0.15	側銑 (Side milling)
DHE0802	30	75	2700~3200	500~800	0.05~0.15	8	溝銑 (Slotting)
DHE0802	30	75	2700~3200	500~800	0.7~1	8	溝銑 (Slotting)
DHE0802	30	75	2700~3200	400~700	16	0.05~0.15	側銑 (Side milling)
DHE0802	30	75	2700~3200	700~1000	16	0.4~0.5	側銑 (Side milling)
DHE0802	45	60	2000~2500	600~800	0.05~0.15	7	溝銑 (Slotting)
DHE0802	45	60	2000~2500	300~450	8~16	0.05~0.15	側銑 (Side milling)

# DIE 2T

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron					
		S50C / Fc250 / SS440 : 1.1210 / 0.6025 / 1.0036 : 1050 / N0.35 / A570 Gr.45 (~HRC22)					
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 <sup>-1</sup> )	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
DIE0302	50	50	5000~5500	400~600	0.03~0.07	3	溝銑 (Slotting)
DIE0402	50	50	3800~4300	400~600	0.05~0.1	4	溝銑 (Slotting)
DIE0502	50	70	4000~4500	400~600	0.05~0.15	5	溝銑 (Slotting)
DIE0502	50	55	3200~3700	250~450	5~10	0.05~0.1	側銑 (Side milling)
DIE0602	50	70	3500~4000	600~900	0.05~0.15	6	溝銑 (Slotting)
DIE0602	50	55	2800~3200	300~500	6~12	0.05~0.1	側銑 (Side milling)
DIE0802	55	70	2500~3000	700~900	0.05~0.15	8	溝銑 (Slotting)
DIE0802	55	60	2200~2600	350~450	8~16	0.05~0.15	側銑 (Side milling)
DIE1002	60	70	2100~2400	600~800	0.05~0.15	10	溝銑 (Slotting)
DIE1002	60	60	1700~2000	250~350	10~20	0.05~0.15	側銑 (Side milling)
DIE1202	60	70	1700~2000	600~800	0.05~0.15	12	溝銑 (Slotting)
DIE1202	60	60	1500~1800	250~350	12~24	0.05~0.15	側銑 (Side milling)

# DIE<sup>2T</sup>

## 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		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 <sup>-1</sup> )	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
DIE0302	50	40	4000~4500	300~500	0.03~0.07	3	溝銑 (Slotting)
DIE0402	50	40	3000~3500	300~500	0.05~0.1	4	溝銑 (Slotting)
DIE0502	50	65	3700~4200	350~550	0.05~0.15	5	溝銑 (Slotting)
DIE0502	50	50	3000~3500	200~400	5~10	0.05~0.1	側銑 (Side milling)
DIE0602	50	70	3500~4000	600~800	0.05~0.15	6	溝銑 (Slotting)
DIE0602	50	50	2500~3000	300~450	6~12	0.05~0.1	側銑 (Side milling)
DIE0802	55	60	2200~2600	600~800	0.05~0.15	8	溝銑 (Slotting)
DIE0802	55	60	2200~2600	300~400	8~16	0.05~0.15	側銑 (Side milling)
DIE1002	60	70	2100~2400	600~700	0.05~0.15	10	溝銑 (Slotting)
DIE1002	60	60	1700~2000	200~300	10~20	0.05~0.15	側銑 (Side milling)
DIE1202	60	70	1700~2000	600~700	0.05~0.15	12	溝銑 (Slotting)
DIE1202	60	60	1500~1800	200~300	12~24	0.05~0.15	側銑 (Side milling)

# DE 4T

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron					
		S50C / Fc250 / SS440 : 1.1210 / 0.6025 / 1.0036 : 1050 / N0.35 / A570 Gr.45 (~HRC22)					
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 <sup>-1</sup> )	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
DE0104	9	65	20000	1000~1300	0.03~0.05	1	溝銑 (Slotting)
DE0104	9	65	20000	500~700	0.05~0.1	1	溝銑 (Slotting)
DE0104	9	65	20000	500~800	1~2	0.03~0.05	側銑 (Side milling)
DE0104	9	65	20000	700~900	1~2	0.05~0.1	側銑 (Side milling)
DE0104	9	65	20000	500~700	1~2	0.15~0.2	側銑 (Side milling)
DE0154	9	80	17000	1000~1300	0.03~0.05	1.5	溝銑 (Slotting)
DE0154	9	80	17000	500~700	0.1~0.15	1.5	溝銑 (Slotting)
DE0154	9	80	17000	500~800	1.5~3	0.03~0.05	側銑 (Side milling)
DE0154	9	80	17000	700~900	1.5~3	0.1~0.15	側銑 (Side milling)
DE0154	9	80	17000	500~700	1.5~3	0.15~0.25	側銑 (Side milling)
DE0204	11	95	15000	1000~1300	0.03~0.05	2	溝銑 (Slotting)
DE0204	11	90	14300	500~700	0.1~0.15	2	溝銑 (Slotting)
DE0204	11	95	15000	500~800	2~4	0.03~0.05	側銑 (Side milling)
DE0204	11	90	14300	700~900	2~4	0.1~0.15	側銑 (Side milling)
DE0204	11	90	14300	500~700	2~4	0.2~0.3	側銑 (Side milling)
DE0254	12	110	14000	1000~1300	0.04~0.06	2.5	溝銑 (Slotting)
DE0254	12	90	11400	500~700	0.4~0.5	2.5	溝銑 (Slotting)
DE0254	12	110	14000	500~800	2.5~5	0.04~0.06	側銑 (Side milling)
DE0254	12	90	11400	700~900	2.5~5	0.2~0.3	側銑 (Side milling)
DE0254	12	90	11400	500~700	2.5~5	0.4~0.5	側銑 (Side milling)
DE0304	15	115	12200	1000~1300	0.04~0.06	3	溝銑 (Slotting)
DE0304	15	90	9500	500~700	0.8~0.9	3	溝銑 (Slotting)
DE0304	15	115	12200	500~800	3~6	0.04~0.06	側銑 (Side milling)
DE0304	15	90	9500	700~900	3~6	0.4~0.6	側銑 (Side milling)
DE0304	15	90	9500	500~700	3~6	0.8~0.9	側銑 (Side milling)

# DE 4T

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron S50C / Fc250 / SS440 : 1.1210 / 0.6025 / 1.0036 : 1050 / N0.35 / A570 Gr.45 (~HRC22)					
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 <sup>-1</sup> )	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
DE0404	16	125	10000	1000~1300	0.04~0.07	4	溝銑 (Slotting)
DE0404	16	100	8000	500~700	1~1.2	4	溝銑 (Slotting)
DE0404	16	125	10000	500~800	4~8	0.04~0.07	側銑 (Side milling)
DE0404	16	100	8000	800~1100	4~8	0.6~0.7	側銑 (Side milling)
DE0404	16	100	8000	500~700	4~8	1~1.2	側銑 (Side milling)
DE0504	19	125	8000	1000~1300	0.05~0.08	5	溝銑 (Slotting)
DE0504	19	100	6400	500~700	1.3~1.5	5	溝銑 (Slotting)
DE0504	19	125	8000	500~800	5~10	0.05~0.08	側銑 (Side milling)
DE0504	19	100	6400	800~1100	5~10	0.8~1	側銑 (Side milling)
DE0504	19	100	6400	500~700	5~10	1.3~1.5	側銑 (Side milling)
DE0604	21	125	6600	1000~1300	0.05~0.1	6	溝銑 (Slotting)
DE0604	21	100	5300	600~800	1.5~1.8	6	溝銑 (Slotting)
DE0604	21	125	6600	500~800	6~12	0.05~0.1	側銑 (Side milling)
DE0604	21	100	5300	800~1100	6~12	0.8~1.2	側銑 (Side milling)
DE0604	21	100	5300	600~800	6~12	1.5~1.8	側銑 (Side milling)
DE0804	27	125	5000	900~1200	0.05~0.12	8	溝銑 (Slotting)
DE0804	27	100	4000	600~800	2~2.4	8	溝銑 (Slotting)
DE0804	27	125	5000	500~700	8~16	0.05~0.12	側銑 (Side milling)
DE0804	27	100	4000	800~1100	8~16	1~1.5	側銑 (Side milling)
DE0804	27	100	4000	600~800	8~16	2~2.4	側銑 (Side milling)
DE1004	34	125	4000	800~1100	0.05~0.15	10	溝銑 (Slotting)
DE1004	34	100	3200	700~900	2~3	10	溝銑 (Slotting)
DE1004	34	125	4000	500~700	10~20	0.05~0.2	側銑 (Side milling)
DE1004	34	130	4200	900~1200	10~20	1.3~1.5	側銑 (Side milling)
DE1004	34	115	3600	700~900	10~20	2~3	側銑 (Side milling)

# DE 4T

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron					
		S50C / Fc250 / SS440 : 1.1210 / 0.6025 / 1.0036 : 1050 / N0.35 / A570 Gr.45 (~HRC22)					
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 <sup>-1</sup> )	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
DE1204	37	125	3300	700~1000	0.05~0.15	12	溝銑 (Slotting)
DE1204	37	100	2650	500~700	3~3.6	12	溝銑 (Slotting)
DE1204	37	125	3300	400~600	12~24	0.05~0.15	側銑 (Side milling)
DE1204	37	100	2650	700~900	12~24	1.5~2	側銑 (Side milling)
DE1204	37	100	2650	500~700	12~24	3~3.6	側銑 (Side milling)
DE1604	50	125	2500	500~800	0.05~0.2	16	溝銑 (Slotting)
DE1604	50	100	2000	200~350	3~4	16	溝銑 (Slotting)
DE1604	50	100	2000	350~550	16~32	0.05~0.2	側銑 (Side milling)
DE1604	50	100	2000	600~800	16~32	1~2	側銑 (Side milling)
DE1604	50	100	2000	200~400	16~32	3~4	側銑 (Side milling)
DE2004	50	125	2000	400~700	0.05~0.25	20	溝銑 (Slotting)
DE2004	50	100	1600	200~350	3~4	20	溝銑 (Slotting)
DE2004	50	100	1600	250~450	20~40	0.05~0.25	側銑 (Side milling)
DE2004	50	100	1600	350~500	20~40	2~3	側銑 (Side milling)
DE2004	50	100	1600	250~400	20~40	3~4	側銑 (Side milling)

# DE 4T

## 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		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 <sup>-1</sup> )	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
DE0104	9	65	20000	1000~1300	0.03~0.05	1	溝銑 (Slotting)
DE0104	9	65	20000	400~600	0.05~0.1	1	溝銑 (Slotting)
DE0104	9	65	20000	500~800	1~2	0.03~0.05	側銑 (Side milling)
DE0104	9	65	20000	600~800	1~2	0.05~0.1	側銑 (Side milling)
DE0104	9	65	20000	400~600	1~2	0.15~0.2	側銑 (Side milling)
DE0154	9	80	17000	1000~1300	0.03~0.05	1.5	溝銑 (Slotting)
DE0154	9	80	17000	400~600	0.1~0.15	1.5	溝銑 (Slotting)
DE0154	9	80	17000	500~800	1.5~3	0.03~0.05	側銑 (Side milling)
DE0154	9	80	17000	600~800	1.5~3	0.1~0.15	側銑 (Side milling)
DE0154	9	80	17000	400~600	1.5~3	0.15~0.25	側銑 (Side milling)
DE0204	11	95	15000	1000~1300	0.03~0.05	2	溝銑 (Slotting)
DE0204	11	90	14300	400~600	0.1~0.15	2	溝銑 (Slotting)
DE0204	11	95	15000	500~800	2~4	0.03~0.05	側銑 (Side milling)
DE0204	11	90	14300	600~800	2~4	0.1~0.15	側銑 (Side milling)
DE0204	11	90	14300	400~600	2~4	0.2~0.3	側銑 (Side milling)
DE0254	12	110	14000	1000~1300	0.04~0.06	2.5	溝銑 (Slotting)
DE0254	12	90	11400	400~600	0.4~0.5	2.5	溝銑 (Slotting)
DE0254	12	110	14000	500~800	2.5~5	0.04~0.06	側銑 (Side milling)
DE0254	12	90	11400	600~800	2.5~5	0.2~0.3	側銑 (Side milling)
DE0254	12	90	11400	400~600	2.5~5	0.4~0.5	側銑 (Side milling)
DE0304	15	115	12200	1000~1300	0.04~0.06	3	溝銑 (Slotting)
DE0304	15	90	9500	400~600	0.8~0.9	3	溝銑 (Slotting)
DE0304	15	105	11100	500~800	3~6	0.04~0.06	側銑 (Side milling)
DE0304	15	90	9500	600~800	3~6	0.4~0.6	側銑 (Side milling)
DE0304	15	90	9500	400~600	3~6	0.8~0.9	側銑 (Side milling)

# DE 4T

## 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		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 <sup>-1</sup> )	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
DE0404	16	115	9200	1000~1300	0.04~0.07	4	溝銑 (Slotting)
DE0404	16	100	8000	400~600	1~1.2	4	溝銑 (Slotting)
DE0404	16	105	8400	500~800	4~8	0.04~0.07	側銑 (Side milling)
DE0404	16	100	8000	600~900	4~8	0.6~0.7	側銑 (Side milling)
DE0404	16	100	8000	400~600	4~8	1~1.2	側銑 (Side milling)
DE0504	19	115	7300	1000~1300	0.05~0.08	5	溝銑 (Slotting)
DE0504	19	100	6400	400~600	1.3~1.5	5	溝銑 (Slotting)
DE0504	19	105	6700	500~800	5~10	0.05~0.08	側銑 (Side milling)
DE0504	19	100	6400	600~900	5~10	0.8~1	側銑 (Side milling)
DE0504	19	100	6400	400~600	5~10	1.3~1.5	側銑 (Side milling)
DE0604	21	115	6100	1000~1300	0.05~0.1	6	溝銑 (Slotting)
DE0604	21	100	5300	500~700	1.5~1.8	6	溝銑 (Slotting)
DE0604	21	105	5600	500~800	6~12	0.05~0.1	側銑 (Side milling)
DE0604	21	100	5300	700~1000	6~12	0.8~1.2	側銑 (Side milling)
DE0604	21	100	5300	500~700	6~12	1.5~1.8	側銑 (Side milling)
DE0804	27	120	4800	900~1200	0.05~0.12	8	溝銑 (Slotting)
DE0804	27	105	4200	500~700	2~2.4	8	溝銑 (Slotting)
DE0804	27	105	4200	500~700	8~16	0.05~0.12	側銑 (Side milling)
DE0804	27	105	4200	700~1000	8~16	1~1.5	側銑 (Side milling)
DE0804	27	105	4200	500~700	8~16	2~2.4	側銑 (Side milling)
DE1004	34	110	3500	800~1100	0.05~0.15	10	溝銑 (Slotting)
DE1004	34	110	3500	600~800	2~3	10	溝銑 (Slotting)
DE1004	34	110	3500	500~700	10~20	0.05~0.2	側銑 (Side milling)
DE1004	34	110	3500	800~1100	10~20	1.3~1.5	側銑 (Side milling)
DE1004	34	110	3500	600~800	10~20	2~3	側銑 (Side milling)

# DE 4T

## 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		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 <sup>-1</sup> )	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
DE1204	37	115	3000	700~1000	0.05~0.15	12	溝銑 (Slotting)
DE1204	37	95	2500	400~600	3~3.6	12	溝銑 (Slotting)
DE1204	37	95	2500	400~600	12~24	0.05~0.15	側銑 (Side milling)
DE1204	37	95	2500	500~800	12~24	1.5~2	側銑 (Side milling)
DE1204	37	95	2500	400~600	12~24	3~3.6	側銑 (Side milling)
DE1604	50	115	2300	500~800	0.05~0.2	16	溝銑 (Slotting)
DE1604	50	95	1900	150~300	3~4	16	溝銑 (Slotting)
DE1604	50	95	1900	350~550	16~32	0.05~0.2	側銑 (Side milling)
DE1604	50	95	1900	500~700	16~32	1~2	側銑 (Side milling)
DE1604	50	95	1900	150~350	16~32	3~4	側銑 (Side milling)
DE2004	50	115	1850	400~700	0.05~0.25	20	溝銑 (Slotting)
DE2004	50	95	1500	150~300	3~4	20	溝銑 (Slotting)
DE2004	50	95	1500	250~450	20~40	0.05~0.25	側銑 (Side milling)
DE2004	50	95	1500	250~450	20~40	2~3	側銑 (Side milling)
DE2004	50	95	1500	150~300	20~40	3~4	側銑 (Side milling)

# DHE 4T

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron S50C / Fc250 / SS440 : 1.1210 / 0.6025 / 1.0036 : 1050 / N0.35 / A570 Gr.45 (~HRC22)					
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 <sup>-1</sup> )	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
DHE0304	15	115	12000	1000~1300	0.05~0.1	3	溝銑 (Slotting)
DHE0304	15	90	9500	600~900	0.3~0.4	3	溝銑 (Slotting)
DHE0304	15	115	12000	600~900	3~6	0.05~0.1	側銑 (Side milling)
DHE0304	15	90	9500	600~900	3~6	0.3~0.4	側銑 (Side milling)
DHE0304	30	50	5300	500~700	0.03~0.07	3	溝銑 (Slotting)
DHE0304	30	50	5300	800~1000	0.05~0.12	3	溝銑 (Slotting)
DHE0304	30	45	4800	300~500	3~6	0.03~0.07	側銑 (Side milling)
DHE0304	30	45	4800	500~700	3~6	0.07~0.12	側銑 (Side milling)
DHE0404	20	100	8000	800~1000	0.05~0.1	3	溝銑 (Slotting)
DHE0404	20	100	8000	900~1200	0.3~0.4	4	溝銑 (Slotting)
DHE0404	20	90	7500	500~700	4~8	0.05~0.1	側銑 (Side milling)
DHE0404	20	90	7500	900~1200	4~8	0.3~0.4	側銑 (Side milling)
DHE0404	40	40	3200	500~700	0.05~0.1	3	溝銑 (Slotting)
DHE0404	40	40	3200	800~1000	0.08~0.15	4	溝銑 (Slotting)
DHE0404	40	35	2800	250~450	4~8	0.05~0.1	側銑 (Side milling)
DHE0404	40	35	2800	500~700	4~8	0.08~0.15	側銑 (Side milling)
DHE0504	21	125	8000	1100~1300	0.05~0.13	4	溝銑 (Slotting)
DHE0504	21	100	6400	800~1100	0.4~0.6	5	溝銑 (Slotting)
DHE0504	21	125	8000	600~800	5~10	0.05~0.13	側銑 (Side milling)
DHE0504	21	100	6400	800~1100	5~10	0.4~0.6	側銑 (Side milling)
DHE0504	35	80	5100	600~800	0.05~0.15	4	溝銑 (Slotting)
DHE0504	35	65	4200	800~1000	0.2~0.3	5	溝銑 (Slotting)
DHE0504	35	55	3500	250~450	5~10	0.05~0.15	側銑 (Side milling)
DHE0504	35	60	3800	600~800	5~10	0.2~0.3	側銑 (Side milling)

# DHE<sup>4T</sup>

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron S50C / Fc250 / SS440 : 1.1210 / 0.6025 / 1.0036 : 1050 / N0.35 / A570 Gr.45 (~HRC22)					
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 <sup>-1</sup> )	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
DHE0604	21	125	6600	1000~1300	0.05~0.15	5	溝銑 (Slotting)
DHE0604	21	100	5300	800~1100	0.8~1	6	溝銑 (Slotting)
DHE0604	21	125	6600	600~800	6~12	0.05~0.15	側銑 (Side milling)
DHE0604	21	100	5300	800~1100	6~12	0.8~1	側銑 (Side milling)
DHE0604	35	90	4800	800~1000	0.05~0.15	5	溝銑 (Slotting)
DHE0604	35	75	4000	1100~1400	0.3~0.5	6	溝銑 (Slotting)
DHE0604	35	65	3400	450~650	6~12	0.05~0.15	側銑 (Side milling)
DHE0604	35	70	3800	800~1000	6~12	0.3~0.5	側銑 (Side milling)
DHE0804	27	125	5000	1000~1200	0.05~0.15	7	溝銑 (Slotting)
DHE0804	27	100	4000	800~1100	1~1.2	8	溝銑 (Slotting)
DHE0804	27	125	5000	600~900	8~16	0.05~0.15	側銑 (Side milling)
DHE0804	27	100	4000	800~1100	8~16	1~1.2	側銑 (Side milling)
DHE0804	42	70	2700	700~900	0.05~0.15	7	溝銑 (Slotting)
DHE0804	42	50	2000	800~1000	0.4~0.6	8	溝銑 (Slotting)
DHE0804	42	65	2500	400~600	8~16	0.05~0.15	側銑 (Side milling)
DHE0804	42	50	2000	800~1000	8~16	0.4~0.6	側銑 (Side milling)

# DHE 4T

## 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 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 <sup>-1</sup> )	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
DHE0304	15	115	12000	900~1200	0.05~0.1	3	溝銑 (Slotting)
DHE0304	15	90	9500	500~800	0.3~0.4	3	溝銑 (Slotting)
DHE0304	15	105	11000	500~800	3~6	0.05~0.1	側銑 (Side milling)
DHE0304	15	90	9500	500~800	3~6	0.3~0.4	側銑 (Side milling)
DHE0304	30	40	4200	400~600	0.03~0.07	3	溝銑 (Slotting)
DHE0304	30	40	4200	700~900	0.05~0.12	3	溝銑 (Slotting)
DHE0304	30	35	3700	250~400	3~6	0.03~0.07	側銑 (Side milling)
DHE0304	30	35	3700	400~600	3~6	0.07~0.12	側銑 (Side milling)
DHE0404	20	100	8000	700~900	0.05~0.1	3	溝銑 (Slotting)
DHE0404	20	100	8000	800~1100	0.3~0.4	4	溝銑 (Slotting)
DHE0404	20	90	7500	400~600	4~8	0.05~0.1	側銑 (Side milling)
DHE0404	20	90	7500	800~1100	4~8	0.3~0.4	側銑 (Side milling)
DHE0404	40	35	3000	400~600	0.05~0.1	3	溝銑 (Slotting)
DHE0404	40	35	3000	700~900	0.08~0.15	4	溝銑 (Slotting)
DHE0404	40	30	2600	200~400	4~8	0.05~0.1	側銑 (Side milling)
DHE0404	40	30	2600	400~600	4~8	0.08~0.15	側銑 (Side milling)
DHE0504	21	115	7300	1000~1200	0.05~0.13	4	溝銑 (Slotting)
DHE0504	21	100	6400	700~1000	0.4~0.6	5	溝銑 (Slotting)
DHE0504	21	105	6700	500~700	5~10	0.05~0.13	側銑 (Side milling)
DHE0504	21	100	6400	700~1000	5~10	0.4~0.6	側銑 (Side milling)
DHE0504	35	80	5100	500~700	0.05~0.15	4	溝銑 (Slotting)
DHE0504	35	60	3800	700~900	0.2~0.3	5	溝銑 (Slotting)
DHE0504	35	50	3200	200~400	5~10	0.05~0.15	側銑 (Side milling)
DHE0504	35	55	3500	500~700	5~10	0.2~0.3	側銑 (Side milling)

# DHE<sup>4T</sup>

## 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		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 <sup>-1</sup> )	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
DHE0604	21	115	6100	900~1200	0.05~0.15	5	溝銑 (Slotting)
DHE0604	21	100	5300	700~1000	0.8~1	6	溝銑 (Slotting)
DHE0604	21	105	5600	500~700	6~12	0.05~0.15	側銑 (Side milling)
DHE0604	21	100	5300	700~1000	6~12	0.8~1	側銑 (Side milling)
DHE0604	35	90	4800	700~900	0.05~0.15	5	溝銑 (Slotting)
DHE0604	35	70	3800	1000~1300	0.3~0.5	6	溝銑 (Slotting)
DHE0604	35	60	3200	400~600	6~12	0.05~0.15	側銑 (Side milling)
DHE0604	35	65	3600	700~900	6~12	0.3~0.5	側銑 (Side milling)
DHE0804	27	120	4800	900~1100	0.05~0.15	7	溝銑 (Slotting)
DHE0804	27	105	4200	700~1000	1~1.2	8	溝銑 (Slotting)
DHE0804	27	105	4200	500~800	8~16	0.05~0.15	側銑 (Side milling)
DHE0804	27	105	4200	700~1000	8~16	1~1.2	側銑 (Side milling)
DHE0804	42	60	2400	600~800	0.05~0.15	7	溝銑 (Slotting)
DHE0804	42	50	2000	700~900	0.4~0.6	8	溝銑 (Slotting)
DHE0804	42	50	2000	300~500	8~16	0.05~0.15	側銑 (Side milling)
DHE0804	42	45	1700	700~900	8~16	0.4~0.6	側銑 (Side milling)

# DIE 4T

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron					
		S50C / Fc250 / SS440 : 1.1210 / 0.6025 / 1.0036 : 1050 / N0.35 / A570 Gr.45 (~HRc22)					
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 <sup>-1</sup> )	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
DIE0404	28	50	4000	800~1000	0~0.1	4	溝銑 (Slotting)
DIE0404	28	50	3800	1100~1300	0.1~0.2	4	溝銑 (Slotting)
DIE0404	28	40	3200	300~500	4~8	0~0.1	側銑 (Side milling)
DIE0404	28	40	3200	500~700	4	0.1~0.2	側銑 (Side milling)
DIE0404	28	40	3200	400~600	4	0.2~0.3	側銑 (Side milling)
DIE0404	40	40	3200	500~700	0~0.08	4	溝銑 (Slotting)
DIE0404	40	40	3200	800~1000	0.08~0.15	4	溝銑 (Slotting)
DIE0404	40	35	2800	250~450	4~8	0~0.08	側銑 (Side milling)
DIE0404	40	35	2800	400~600	4	0.08~0.15	側銑 (Side milling)
DIE0404	40	35	2800	300~500	4	0.15~0.2	側銑 (Side milling)
DIE0604	30	90	4800	850~1100	0.05~0.15	6	溝銑 (Slotting)
DIE0604	30	75	4000	1400~1600	0~1	6	溝銑 (Slotting)
DIE0604	30	65	3400	450~650	6~12	0.05~0.15	側銑 (Side milling)
DIE0604	30	70	3800	1400~1600	6	0~1	側銑 (Side milling)
DIE0604	30	70	3800	1100~1300	6	1~2	側銑 (Side milling)
DIE0604	50	55	2800	600~800	0.05~0.15	6	溝銑 (Slotting)
DIE0604	50	55	3000	1200~1400	0.15~0.25	6	溝銑 (Slotting)
DIE0604	50	45	2400	400~600	6~12	0.05~0.15	側銑 (Side milling)
DIE0604	50	40	2100	500~700	6~12	0.15~0.25	側銑 (Side milling)
DIE0604	50	40	2100	300~500	6~12	0.25~0.5	側銑 (Side milling)
DIE0804	45	70	2700	700~900	0.05~0.15	8	溝銑 (Slotting)
DIE0804	45	50	2000	900~1100	0~0.5	8	溝銑 (Slotting)
DIE0804	45	65	2500	500~700	8~16	0.05~0.15	側銑 (Side milling)
DIE0804	45	50	2000	800~1000	8	0~0.5	側銑 (Side milling)
DIE0804	45	50	2000	700~900	8	0.5~1	側銑 (Side milling)
DIE0804	60	55	2200	700~900	0.05~0.15	8	溝銑 (Slotting)
DIE0804	60	40	1600	800~1000	0~0.5	8	溝銑 (Slotting)
DIE0804	60	55	2000	400~600	8~16	0.05~0.15	側銑 (Side milling)
DIE0804	60	40	1600	1000~1200	8	0~0.3	側銑 (Side milling)
DIE0804	60	35	1400	600~800	8	0.3~0.6	側銑 (Side milling)

# DIE 4T

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron					
		S50C / Fc250 / SS440 : 1.1210 / 0.6025 / 1.0036 : 1050 / N0.35 / A570 Gr.45 (~HRC22)					
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 <sup>-1</sup> )	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
DIE1004	50	115	3600	900~1100	0.05~0.15	10	溝銑 (Slotting)
DIE1004	50	65	2000	500~700	0~1	10	溝銑 (Slotting)
DIE1004	50	90	2800	400~600	10	0.05~0.15	側銑 (Side milling)
DIE1004	50	50	1650	700~900	10~20	0~1.5	側銑 (Side milling)
DIE1004	50	50	1650	500~700	10~20	1.5~3	側銑 (Side milling)
DIE1004	70	55	1700	500~700	0.05~0.15	10	溝銑 (Slotting)
DIE1004	70	50	1600	700~900	0~0.5	10	溝銑 (Slotting)
DIE1004	70	65	2000	350~550	10	0.05~0.15	側銑 (Side milling)
DIE1004	70	50	1600	1100~1300	10	0~0.5	側銑 (Side milling)
DIE1004	70	50	1600	1000~1200	10	0.5~0.8	側銑 (Side milling)
DIE1204	50	115	3000	900~1100	0.05~0.2	12	溝銑 (Slotting)
DIE1204	50	90	2400	1000~1200	0~0.5	12	溝銑 (Slotting)
DIE1204	50	90	2400	400~600	12~24	0.05~0.2	側銑 (Side milling)
DIE1204	50	90	2400	400~600	12~24	0~0.5	側銑 (Side milling)
DIE1204	50	85	2200	300~500	12~24	0.5~1	側銑 (Side milling)
DIE1204	70	75	2000	600~800	0.05~0.2	12	溝銑 (Slotting)
DIE1204	70	55	1500	800~1000	0.2~0.4	12	溝銑 (Slotting)
DIE1204	70	60	1600	300~500	12~24	0.05~0.2	側銑 (Side milling)
DIE1204	70	55	1500	600~800	12~24	0.2~0.4	側銑 (Side milling)
DIE1204	70	45	1200	300~500	12	0.4~0.8	側銑 (Side milling)

# DIE 4T

## 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		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 <sup>-1</sup> )	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
DIE0404	28	45	3600	700~900	0~0.1	4	溝銑 (Slotting)
DIE0404	28	45	3600	900~1100	0.1~0.2	4	溝銑 (Slotting)
DIE0404	28	35	3000	300~500	4~8	0~0.1	側銑 (Side milling)
DIE0404	28	35	3000	400~600	4~8	0.1~0.2	側銑 (Side milling)
DIE0404	28	35	3000	300~500	4~8	0.2~0.3	側銑 (Side milling)
DIE0404	40	35	3000	300~500	0~0.07	4	溝銑 (Slotting)
DIE0404	40	35	3000	500~700	0~0.1	4	溝銑 (Slotting)
DIE0404	40	30	2600	200~400	4~8	0~0.08	側銑 (Side milling)
DIE0404	40	30	2600	300~500	4	0~0.1	側銑 (Side milling)
DIE0404	40	30	2400	200~400	4	0.1~0.15	側銑 (Side milling)
DIE0604	30	90	4800	850~1100	0.05~0.15	6	溝銑 (Slotting)
DIE0604	30	70	3800	1400~1600	0~0.5	6	溝銑 (Slotting)
DIE0604	30	60	3200	450~650	6~12	0.05~0.15	側銑 (Side milling)
DIE0604	30	65	3600	800~1000	6	0~0.5	側銑 (Side milling)
DIE0604	30	65	3600	600~800	6	0.5~1	側銑 (Side milling)
DIE0604	50	45	2500	400~600	0.05~0.1	6	溝銑 (Slotting)
DIE0604	50	45	2500	700~900	0.1~0.15	6	溝銑 (Slotting)
DIE0604	50	40	2000	250~400	6~12	0.05~0.1	側銑 (Side milling)
DIE0604	50	35	1800	200~300	6~12	0.1~0.15	側銑 (Side milling)
DIE0604	50	35	1800	200~250	6~12	0.15~0.2	側銑 (Side milling)
DIE0804	45	60	2400	600~800	0.05~0.15	8	溝銑 (Slotting)
DIE0804	45	50	2000	800~1000	0~0.5	8	溝銑 (Slotting)
DIE0804	45	50	2000	400~600	8~16	0.05~0.15	側銑 (Side milling)
DIE0804	45	45	1700	700~900	8	0~0.5	側銑 (Side milling)
DIE0804	45	40	1600	600~750	8	0.5~1	側銑 (Side milling)
DIE0804	60	50	2000	550~750	0.05~0.15	8	溝銑 (Slotting)
DIE0804	60	45	1700	900~1100	0~0.3	8	溝銑 (Slotting)
DIE0804	60	45	1700	300~450	8~16	0.05~0.15	側銑 (Side milling)
DIE0804	60	40	1500	900~1100	8	0~0.3	側銑 (Side milling)
DIE0804	60	40	1350	700~900	8	0.3~0.5	側銑 (Side milling)

# DIE 4T

## 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		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 <sup>-1</sup> )	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
DIE1004	50	100	3200	800~1000	0.05~0.15	10	溝銑 (Slotting)
DIE1004	50	60	1900	600~800	0~0.5	10	溝銑 (Slotting)
DIE1004	50	70	2000	400~600	10~20	0.05~0.15	側銑 (Side milling)
DIE1004	50	45	1400	600~800	10~20	0~0.5	側銑 (Side milling)
DIE1004	50	40	1250	450~650	10~20	0.5~1	側銑 (Side milling)
DIE1004	70	50	1600	450~650	0.05~0.15	10	溝銑 (Slotting)
DIE1004	70	45	1400	700~900	0.15~0.25	10	溝銑 (Slotting)
DIE1004	70	50	1600	300~500	10~20	0.05~0.15	側銑 (Side milling)
DIE1004	70	45	1400	500~700	10~20	0.15~0.3	側銑 (Side milling)
DIE1004	70	45	1400	400~600	10~20	0.3~0.4	側銑 (Side milling)
DIE1204	50	110	2900	900~1100	0.05~0.2	12	溝銑 (Slotting)
DIE1204	50	80	2100	900~1100	0.2~0.4	12	溝銑 (Slotting)
DIE1204	50	75	2000	400~600	12~24	0.05~0.2	側銑 (Side milling)
DIE1204	50	75	2000	400~600	12~24	0.2~0.4	側銑 (Side milling)
DIE1204	50	75	2000	300~450	12~24	0.4~0.8	側銑 (Side milling)
DIE1204	70	70	1900	600~800	0.05~0.2	12	溝銑 (Slotting)
DIE1204	70	50	1400	900~1100	0.2~0.3	12	溝銑 (Slotting)
DIE1204	70	55	1500	250~450	12~24	0.05~0.2	側銑 (Side milling)
DIE1204	70	55	1500	500~700	12~24	0.2~0.3	側銑 (Side milling)
DIE1204	70	50	1400	400~600	12~24	0.3~0.4	側銑 (Side milling)

# DRA

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron					
		S50C / Fc250 / SS440 : 1.1210 / 0.6025 / 1.0036 : 1050 / N0.35 / A570 Gr.45 (~HRc22)					
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 <sup>-1</sup> )	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
DRA0205	12	60	9000~9500	600~800	0.09~0.13	1~2	溝銑 (Slotting)
DRA0205	12	60	9000~9500	700~900	0.04~0.06	1~2	溝銑 (Slotting)
DRA0205	12	60	9000~9500	800~1000	2~4	0.1~0.15	側銑 (Side milling)
DRA0205	12	60	9000~9500	600~800	2~4	0.04~0.06	側銑 (Side milling)
DRA0205	12	60	9000~9500	1000~1300	0.1~0.15	0.1~0.15	3D 銑 (3D milling)
DRA0205	12	60	9000~9500	1000~1200	0.04~0.06	0.04~0.06	3D 銑 (3D milling)
DRA0305	12	85	8800~9300	700~900	0.1~0.15	1~3	溝銑 (Slotting)
DRA0305	12	85	8800~9300	800~1000	0.05~0.07	1~3	溝銑 (Slotting)
DRA0305	12	85	8800~9300	900~1100	3~6	0.1~0.15	側銑 (Side milling)
DRA0305	12	85	8800~9300	800~1000	3~6	0.05~0.07	側銑 (Side milling)
DRA0305	12	85	8800~9300	1000~1200	0.1~0.15	0.1~0.15	3D 銑 (3D milling)
DRA0305	12	85	8800~9300	1000~1200	0.05~0.07	0.05~0.07	3D 銑 (3D milling)
DRA0405	14	100	8000~8400	600~800	0.1~0.15	2~4	溝銑 (Slotting)
DRA0405	14	100	8000~8400	800~1000	0.05~0.07	2~4	溝銑 (Slotting)
DRA0405	14	85	6500~7000	800~1000	4~8	0.1~0.15	側銑 (Side milling)
DRA0405	14	85	6500~7000	600~800	4~8	0.05~0.07	側銑 (Side milling)
DRA0405	14	110	8700~9200	800~1000	0.1~0.15	0.1~0.15	3D 銑 (3D milling)
DRA0405	14	110	8700~9200	1000~1200	0.05~0.07	0.05~0.07	3D 銑 (3D milling)
DRA0410	14	100	8000~8400	700~900	0.1~0.15	1~4	溝銑 (Slotting)
DRA0410	14	100	8000~8400	800~1000	0.05~0.07	1~4	溝銑 (Slotting)
DRA0410	14	85	6500~7000	800~1000	4~8	0.1~0.15	側銑 (Side milling)
DRA0410	14	85	6500~7000	600~800	4~8	0.05~0.07	側銑 (Side milling)
DRA0410	14	110	8700~9200	900~1100	0.1~0.15	0.1~0.15	3D 銑 (3D milling)
DRA0410	14	110	8700~9200	1100~1400	0.05~0.07	0.05~0.07	3D 銑 (3D milling)
DRA0505	17	95	5800~6300	900~1100	0.13~0.18	3~5	溝銑 (Slotting)
DRA0505	17	120	7300~7800	800~1200	0.05~0.08	3~5	溝銑 (Slotting)
DRA0505	17	95	5800~6300	800~1000	5~10	0.13~0.18	側銑 (Side milling)
DRA0505	17	95	5800~6300	600~800	5~10	0.05~0.08	側銑 (Side milling)
DRA0505	17	135	8300~8800	1400~1800	0.13~0.18	0.13~0.18	3D 銑 (3D milling)
DRA0505	17	135	8300~8800	1300~1700	0.05~0.08	0.05~0.08	3D 銑 (3D milling)

# DRA

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron					
		S50C / Fc250 / SS440 : 1.1210 / 0.6025 / 1.0036 : 1050 / N0.35 / A570 Gr.45 (~HRc22)					
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 <sup>-1</sup> )	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
DRA0510	17	95	5800~6300	900~1100	0.13~0.18	2~5	溝銑 (Slotting)
DRA0510	17	120	7300~7800	800~1200	0.05~0.08	2~5	溝銑 (Slotting)
DRA0510	17	95	5800~6300	800~1000	5~10	0.13~0.18	側銑 (Side milling)
DRA0510	17	95	5800~6300	600~800	5~10	0.05~0.08	側銑 (Side milling)
DRA0510	17	135	8300~8800	1400~1800	0.13~0.18	0.13~0.18	3D 銑 (3D milling)
DRA0510	17	135	8300~8800	1300~1700	0.05~0.08	0.05~0.08	3D 銑 (3D milling)
DRA0605	20	95	4800~5200	900~1100	0.13~0.18	4~6	溝銑 (Slotting)
DRA0605	20	120	6200~6600	800~1200	0.05~0.08	4~6	溝銑 (Slotting)
DRA0605	20	95	4800~5200	800~1000	6~12	0.13~0.18	側銑 (Side milling)
DRA0605	20	95	4800~5200	600~800	6~12	0.05~0.08	側銑 (Side milling)
DRA0605	20	135	7200~7600	1400~1800	0.13~0.18	0.13~0.18	3D 銑 (3D milling)
DRA0605	20	135	7200~7600	1300~1700	0.05~0.08	0.05~0.08	3D 銑 (3D milling)
DRA0610	20	80	4200~4600	900~1100	0.13~0.18	3~6	溝銑 (Slotting)
DRA0610	20	130	6800~7200	800~1200	0.05~0.08	3~6	溝銑 (Slotting)
DRA0610	20	95	5000~5500	800~1000	6~12	0.13~0.18	側銑 (Side milling)
DRA0610	20	95	5000~5500	600~800	6~12	0.05~0.08	側銑 (Side milling)
DRA0610	20	135	7200~7600	1400~1800	0.13~0.18	0.13~0.18	3D 銑 (3D milling)
DRA0610	20	135	7200~7600	1300~1700	0.05~0.08	0.05~0.08	3D 銑 (3D milling)
DRA0805	30	125	5000~5600	900~1100	0.18~0.23	6~8	溝銑 (Slotting)
DRA0805	30	135	5200~5600	600~800	0.05~0.1	6~8	溝銑 (Slotting)
DRA0805	30	90	3500~4000	700~1000	8~16	0.18~0.23	側銑 (Side milling)
DRA0805	30	90	3500~4000	600~800	8~16	0.05~0.1	側銑 (Side milling)
DRA0805	30	150	6000~6600	1600~2000	0.18~0.23	0.18~0.23	3D 銑 (3D milling)
DRA0805	30	190	7500~8000	1100~1500	0.05~0.1	0.05~0.1	3D 銑 (3D milling)
DRA0810	30	125	5000~5600	900~1100	0.18~0.23	5~8	溝銑 (Slotting)
DRA0810	30	135	5200~5600	600~800	0.05~0.1	5~8	溝銑 (Slotting)
DRA0810	30	90	3500~4000	600~1000	8~16	0.18~0.23	側銑 (Side milling)
DRA0810	30	90	3500~4000	600~800	8~16	0.05~0.1	側銑 (Side milling)
DRA0810	30	150	6000~6600	1600~2000	0.18~0.23	0.18~0.23	3D 銑 (3D milling)
DRA0810	30	190	7500~8000	1000~1400	0.05~0.1	0.05~0.1	3D 銑 (3D milling)

# DRA

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron					
		S50C / Fc250 / SS440 : 1.1210 / 0.6025 / 1.0036 : 1050 / N0.35 / A570 Gr.45 (~HRc22)					
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 <sup>-1</sup> )	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
DRA1005	35	125	4000~4500	800~1200	0.2~0.25	8~10	溝銑 (Slotting)
DRA1005	35	135	4200~4600	600~800	0.05~0.1	8~10	溝銑 (Slotting)
DRA1005	35	90	2800~3200	600~900	10~20	0.2~0.25	側銑 (Side milling)
DRA1005	35	90	2800~3200	600~800	10~20	0.05~0.1	側銑 (Side milling)
DRA1005	35	150	4800~5400	1600~2000	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DRA1005	35	190	6000~6500	1200~1600	0.05~0.1	0.05~0.1	3D 銑 (3D milling)
DRA1010	35	125	4000~4500	800~1200	0.2~0.25	7~10	溝銑 (Slotting)
DRA1010	35	135	4200~4600	600~800	0.05~0.1	7~10	溝銑 (Slotting)
DRA1010	35	90	2800~3200	600~900	10~20	0.2~0.25	側銑 (Side milling)
DRA1010	35	90	2800~3200	600~800	10~20	0.05~0.1	側銑 (Side milling)
DRA1010	35	150	4800~5400	1600~2000	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DRA1010	35	190	6000~6500	1200~1600	0.05~0.1	0.05~0.1	3D 銑 (3D milling)
DRA1015	35	125	4000~4500	800~1200	0.2~0.25	6~10	溝銑 (Slotting)
DRA1015	35	135	4200~4600	600~800	0.05~0.1	6~10	溝銑 (Slotting)
DRA1015	35	90	2800~3200	600~900	10~20	0.2~0.25	側銑 (Side milling)
DRA1015	35	90	2800~3200	600~800	10~20	0.05~0.1	側銑 (Side milling)
DRA1015	35	150	4800~5400	1600~2000	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DRA1015	35	190	6000~6500	1200~1600	0.05~0.1	0.05~0.1	3D 銑 (3D milling)
DRA1020	35	125	4000~4500	800~1200	0.2~0.25	5~10	溝銑 (Slotting)
DRA1020	35	135	4200~4600	600~800	0.05~0.1	5~10	溝銑 (Slotting)
DRA1020	35	90	2800~3200	600~900	10~20	0.2~0.25	側銑 (Side milling)
DRA1020	35	90	2800~3200	600~800	10~20	0.05~0.1	側銑 (Side milling)
DRA1020	35	150	4800~5400	1600~2000	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DRA1020	35	190	6000~6500	1200~1600	0.05~0.1	0.05~0.1	3D 銑 (3D milling)
DRA1210	40	75	2000~2500	800~1100	0.2~0.25	9~12	溝銑 (Slotting)
DRA1210	40	150	4000~4500	800~1000	0.07~0.12	9~12	溝銑 (Slotting)
DRA1210	40	105	2800~3200	600~800	12~24	0.2~0.25	側銑 (Side milling)
DRA1210	40	105	2800~3200	400~600	12~24	0.07~0.12	側銑 (Side milling)
DRA1210	40	150	4000~4500	1400~1600	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DRA1210	40	170	4500~5000	1300~1600	0.07~0.12	0.07~0.12	3D 銑 (3D milling)

# DRA

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron S50C / Fc250 / SS440 : 1.1210 / 0.6025 / 1.0036 : 1050 / N0.35 / A570 Gr.45 (~HRc22)					
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 <sup>-1</sup> )	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
<b>DRA1220</b>	40	75	2000~2500	800~1100	0.2~0.25	7~12	溝銑 (Slotting)
<b>DRA1220</b>	40	150	4000~4500	800~1000	0.05~0.12	7~12	溝銑 (Slotting)
<b>DRA1220</b>	40	105	2800~3200	600~800	12~24	0.2~0.25	側銑 (Side milling)
<b>DRA1220</b>	40	105	2800~3200	400~600	12~24	0.05~0.12	側銑 (Side milling)
<b>DRA1220</b>	40	150	4000~4500	1400~1600	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
<b>DRA1220</b>	40	170	4500~5000	1300~1600	0.05~0.12	0.05~0.12	3D 銑 (3D milling)

# DRA

## 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 (HRC 36~45)					
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 <sup>-1</sup> )	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
DRA0205	12	60	9000~9500	500~700	0.09~0.13	1~2	溝銑 (Slotting)
DRA0205	12	60	9000~9500	600~800	0.04~0.06	1~2	溝銑 (Slotting)
DRA0205	12	60	9000~9500	700~900	2~4	0.1~0.15	側銑 (Side milling)
DRA0205	12	60	9000~9500	600~800	2~4	0.04~0.06	側銑 (Side milling)
DRA0205	12	60	9000~9500	900~1200	0.1~0.15	0.1~0.15	3D 銑 (3D milling)
DRA0205	12	60	9000~9500	1000~1200	0.04~0.06	0.04~0.06	3D 銑 (3D milling)
DRA0305	12	85	8800~9300	600~800	0.1~0.15	1~3	溝銑 (Slotting)
DRA0305	12	85	8800~9300	700~900	0.05~0.07	1~3	溝銑 (Slotting)
DRA0305	12	85	8800~9300	800~1000	3~6	0.1~0.15	側銑 (Side milling)
DRA0305	12	85	8800~9300	800~1000	3~6	0.05~0.07	側銑 (Side milling)
DRA0305	12	85	8800~9300	900~1100	0.1~0.15	0.1~0.15	3D 銑 (3D milling)
DRA0305	12	85	8800~9300	1000~1200	0.05~0.07	0.05~0.07	3D 銑 (3D milling)
DRA0405	14	95	7800~8200	600~800	0.1~0.15	2~4	溝銑 (Slotting)
DRA0405	14	100	8000~8400	800~1000	0.05~0.07	2~4	溝銑 (Slotting)
DRA0405	14	85	6500~7000	800~1000	4~8	0.1~0.15	側銑 (Side milling)
DRA0405	14	85	6500~7000	600~800	4~8	0.05~0.07	側銑 (Side milling)
DRA0405	14	110	8700~9200	800~1000	0.1~0.15	0.1~0.15	3D 銑 (3D milling)
DRA0405	14	110	8700~9200	1000~1200	0.05~0.07	0.05~0.07	3D 銑 (3D milling)
DRA0410	14	95	7800~8200	600~800	0.1~0.15	1~4	溝銑 (Slotting)
DRA0410	14	100	8000~8400	800~1000	0.05~0.07	1~4	溝銑 (Slotting)
DRA0410	14	85	6500~7000	800~1000	4~8	0.1~0.15	側銑 (Side milling)
DRA0410	14	85	6500~7000	600~800	4~8	0.05~0.07	側銑 (Side milling)
DRA0410	14	110	8700~9200	900~1100	0.1~0.15	0.1~0.15	3D 銑 (3D milling)
DRA0410	14	110	8700~9200	1000~1200	0.05~0.07	0.05~0.07	3D 銑 (3D milling)
DRA0505	17	85	5200~5700	800~1000	0.13~0.18	3~5	溝銑 (Slotting)
DRA0505	17	120	7300~7800	800~1200	0.05~0.08	3~5	溝銑 (Slotting)
DRA0505	17	85	5200~5700	800~1000	5~10	0.13~0.18	側銑 (Side milling)
DRA0505	17	95	5800~6300	600~800	5~10	0.05~0.08	側銑 (Side milling)
DRA0505	17	135	8300~8800	1000~1200	0.13~0.18	0.13~0.18	3D 銑 (3D milling)
DRA0505	17	135	8300~8800	1300~1700	0.05~0.08	0.05~0.08	3D 銑 (3D milling)

# DRA

## 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 (HRC 36~45)					
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 <sup>-1</sup> )	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
DRA0510	17	85	5200~5700	800~1000	0.13~0.18	2~5	溝銑 (Slotting)
DRA0510	17	120	7300~7800	800~1200	0.05~0.08	2~5	溝銑 (Slotting)
DRA0510	17	85	5200~5700	800~1000	5~10	0.13~0.18	側銑 (Side milling)
DRA0510	17	95	5800~6300	600~800	5~10	0.05~0.08	側銑 (Side milling)
DRA0510	17	135	8300~8800	1000~1200	0.13~0.18	0.13~0.18	3D 銑 (3D milling)
DRA0510	17	135	8300~8800	1300~1700	0.05~0.08	0.05~0.08	3D 銑 (3D milling)
DRA0605	20	85	4200~4700	800~1000	0.13~0.18	4~6	溝銑 (Slotting)
DRA0605	20	115	5700~6200	800~1200	0.05~0.08	4~6	溝銑 (Slotting)
DRA0605	20	85	4200~4600	800~1000	6~12	0.13~0.18	側銑 (Side milling)
DRA0605	20	90	4400~4800	600~800	6~12	0.05~0.08	側銑 (Side milling)
DRA0605	20	135	7200~7600	1100~1400	0.13~0.18	0.13~0.18	3D 銑 (3D milling)
DRA0605	20	135	7200~7600	1300~1700	0.05~0.08	0.05~0.08	3D 銑 (3D milling)
DRA0610	20	85	4200~4700	800~1000	0.13~0.18	3~6	溝銑 (Slotting)
DRA0610	20	115	5700~6200	800~1200	0.05~0.08	3~6	溝銑 (Slotting)
DRA0610	20	85	4200~4600	800~1000	6~12	0.13~0.18	側銑 (Side milling)
DRA0610	20	90	4400~4800	600~800	6~12	0.05~0.08	側銑 (Side milling)
DRA0610	20	135	7200~7600	1100~1400	0.13~0.18	0.13~0.18	3D 銑 (3D milling)
DRA0610	20	135	7200~7600	1300~1700	0.05~0.08	0.05~0.08	3D 銑 (3D milling)
DRA0805	30	100	3800~4300	800~1000	0.18~0.23	6~8	溝銑 (Slotting)
DRA0805	30	135	5200~5600	600~800	0.05~0.1	6~8	溝銑 (Slotting)
DRA0805	30	80	3000~3500	700~1000	8~16	0.18~0.23	側銑 (Side milling)
DRA0805	30	90	3400~3800	600~800	8~16	0.05~0.1	側銑 (Side milling)
DRA0805	30	105	4000~4500	1300~1700	0.18~0.23	0.18~0.23	3D 銑 (3D milling)
DRA0805	30	185	7200~7700	1100~1500	0.05~0.1	0.05~0.1	3D 銑 (3D milling)
DRA0810	30	100	3800~4300	800~1000	0.18~0.23	5~8	溝銑 (Slotting)
DRA0810	30	135	5200~5600	600~800	0.05~0.1	5~8	溝銑 (Slotting)
DRA0810	30	80	3000~3500	700~1000	8~16	0.18~0.23	側銑 (Side milling)
DRA0810	30	90	3400~3800	600~800	8~16	0.05~0.1	側銑 (Side milling)
DRA0810	30	105	4000~4500	1300~1700	0.18~0.23	0.18~0.23	3D 銑 (3D milling)
DRA0810	30	185	7000~7700	1100~1500	0.05~0.1	0.05~0.1	3D 銑 (3D milling)

# DRA

## 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 (HRC 36~45)					
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 <sup>-1</sup> )	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
DRA1005	35	100	3000~3400	800~1100	0.2~0.25	8~10	溝銑 (Slotting)
DRA1005	35	135	4200~4600	600~800	0.05~0.1	8~10	溝銑 (Slotting)
DRA1005	35	80	2400~2800	600~900	10~20	0.2~0.25	側銑 (Side milling)
DRA1005	35	90	2800~3200	600~800	10~20	0.05~0.1	側銑 (Side milling)
DRA1005	35	105	3200~3600	1300~1700	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DRA1005	35	185	5800~6200	1200~1600	0.05~0.1	0.05~0.1	3D 銑 (3D milling)
DRA1010	35	100	3000~3400	800~1100	0.2~0.25	7~10	溝銑 (Slotting)
DRA1010	35	135	4200~4600	600~800	0.05~0.1	7~10	溝銑 (Slotting)
DRA1010	35	80	2400~2800	600~900	10~20	0.2~0.25	側銑 (Side milling)
DRA1010	35	90	2800~3200	600~800	10~20	0.05~0.1	側銑 (Side milling)
DRA1010	35	105	3200~3600	1300~1700	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DRA1010	35	185	5800~6200	1200~1600	0.05~0.1	0.05~0.1	3D 銑 (3D milling)
DRA1015	35	100	3000~3400	800~1100	0.2~0.25	6~10	溝銑 (Slotting)
DRA1015	35	135	4200~4600	600~800	0.05~0.1	6~10	溝銑 (Slotting)
DRA1015	35	80	2400~2800	600~900	10~20	0.2~0.25	側銑 (Side milling)
DRA1015	35	90	2800~3200	600~800	10~20	0.05~0.1	側銑 (Side milling)
DRA1015	35	105	3200~3600	1300~1700	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DRA1015	35	185	5800~6200	1200~1600	0.05~0.1	0.05~0.1	3D 銑 (3D milling)
DRA1020	35	100	3000~3400	800~1100	0.2~0.25	5~10	溝銑 (Slotting)
DRA1020	35	135	4200~4600	600~800	0.05~0.1	5~10	溝銑 (Slotting)
DRA1020	35	80	2400~2800	600~900	10~20	0.2~0.25	側銑 (Side milling)
DRA1020	35	90	2800~3200	600~800	10~20	0.05~0.1	側銑 (Side milling)
DRA1020	35	105	3200~3600	1300~1700	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DRA1020	35	185	5800~6200	1200~1600	0.05~0.1	0.05~0.1	3D 銑 (3D milling)
DRA1210	40	75	2000~2400	700~1000	0.2~0.25	9~12	溝銑 (Slotting)
DRA1210	40	145	3800~4200	800~1000	0.07~0.12	9~12	溝銑 (Slotting)
DRA1210	40	70	1800~2200	600~800	12~24	0.2~0.25	側銑 (Side milling)
DRA1210	40	70	1800~2200	400~600	12~24	0.07~0.12	側銑 (Side milling)
DRA1210	40	140	3600~4000	1200~1400	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DRA1210	40	150	4500~5000	1300~1600	0.07~0.12	0.07~0.12	3D 銑 (3D milling)

# DRA

## 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 (HRC 36~45)					
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 <sup>-1</sup> )	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
<b>DRA1220</b>	40	75	2000~2400	700~1000	0.2~0.25	7~12	溝銑 (Slotting)
<b>DRA1220</b>	40	145	3800~4200	800~1000	0.05~0.12	7~12	溝銑 (Slotting)
<b>DRA1220</b>	40	70	1800~2200	600~800	12~24	0.2~0.25	側銑 (Side milling)
<b>DRA1220</b>	40	70	1800~2200	400~600	12~24	0.05~0.12	側銑 (Side milling)
<b>DRA1220</b>	40	140	3600~4000	1200~1400	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
<b>DRA1220</b>	40	150	4500~5000	1300~1600	0.05~0.12	0.05~0.12	3D 銑 (3D milling)

# DLRA

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron					
		S50C / Fc250 / SS440 : 1.1210 / 0.6025 / 1.0036 : 1050 / N0.35 / A570 Gr.45 (~HRc22)					
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 <sup>-1</sup> )	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
DLRA0405	40	70	5400~5800	700~900	0.06~0.08	1~4	溝銑 (Slotting)
DLRA0405	40	90	7000~7400	1100~1300	0.06~0.08	0.06~0.08	3D 銑 (3D milling)
DLRA0605	40	80	4000~4400	600~800	0.15~0.18	4~6	溝銑 (Slotting)
DLRA0605	40	75	3800~4200	400~600	0.06~0.08	4~6	溝銑 (Slotting)
DLRA0605	40	45	2000~2400	600~800	6~12	0.15~0.18	側銑 (Side milling)
DLRA0605	40	65	3200~3600	400~700	6~12	0.06~0.08	側銑 (Side milling)
DLRA0605	40	90	4500~5000	1300~1500	0.15~0.18	0.15~0.18	3D 銑 (3D milling)
DLRA0605	40	120	6300~6800	1200~1400	0.06~0.08	0.06~0.08	3D 銑 (3D milling)
DLRA0610	40	80	4000~4400	600~800	0.15~0.18	4~6	溝銑 (Slotting)
DLRA0610	40	75	3800~4200	400~600	0.06~0.08	4~6	溝銑 (Slotting)
DLRA0610	40	45	2000~2400	600~800	6~12	0.15~0.18	側銑 (Side milling)
DLRA0610	40	65	3200~3600	400~700	6~12	0.06~0.08	側銑 (Side milling)
DLRA0610	40	90	4500~5000	1300~1500	0.15~0.18	0.15~0.18	3D 銑 (3D milling)
DLRA0610	40	120	6300~6800	1200~1400	0.06~0.08	0.06~0.08	3D 銑 (3D milling)
DLRA0805	50	65	2400~2900	500~700	0.2~0.25	6~8	溝銑 (Slotting)
DLRA0805	50	65	2400~2900	400~600	0.07~0.1	6~8	溝銑 (Slotting)
DLRA0805	50	65	2400~2900	500~700	8~16	0.2~0.25	側銑 (Side milling)
DLRA0805	50	65	2400~2900	400~600	8~16	0.07~0.1	側銑 (Side milling)
DLRA0805	50	120	4500~5000	1200~1400	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DLRA0805	50	120	4500~5000	1100~1300	0.07~0.1	0.07~0.1	3D 銑 (3D milling)
DLRA0810	50	65	2400~2900	500~700	0.2~0.25	5~8	溝銑 (Slotting)
DLRA0810	50	65	2400~2900	400~600	0.07~0.1	5~8	溝銑 (Slotting)
DLRA0810	50	65	2400~2900	500~700	8~16	0.2~0.25	側銑 (Side milling)
DLRA0810	50	65	2400~2900	400~600	8~16	0.07~0.1	側銑 (Side milling)
DLRA0810	50	120	4500~5000	1200~1400	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DLRA0810	50	120	4500~5000	1100~1300	0.07~0.1	0.07~0.1	3D 銑 (3D milling)
DLRA1005	60	65	1800~2200	400~600	0.2~0.25	8~10	溝銑 (Slotting)
DLRA1005	60	65	1800~2300	400~600	0.07~0.1	8~10	溝銑 (Slotting)
DLRA1005	60	65	1800~2200	400~600	10~20	0.2~0.25	側銑 (Side milling)
DLRA1005	60	65	1800~2200	400~600	10~20	0.07~0.1	側銑 (Side milling)
DLRA1005	60	95	2700~3200	1000~1200	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DLRA1005	60	120	3600~4000	900~1100	0.07~0.1	0.07~0.1	3D 銑 (3D milling)

# DLRA

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron					
		S50C / Fc250 / SS440 : 1.1210 / 0.6025 / 1.0036 : 1050 / N0.35 / A570 Gr.45 (~HRc22)					
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 <sup>-1</sup> )	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
DLRA1010	60	65	1800~2200	400~600	0.2~0.25	7~10	溝銑 (Slotting)
DLRA1010	60	65	1800~2300	400~600	0.07~0.1	7~10	溝銑 (Slotting)
DLRA1010	60	65	1800~2200	400~600	10~20	0.2~0.25	側銑 (Side milling)
DLRA1010	60	65	1800~2200	400~600	10~20	0.07~0.1	側銑 (Side milling)
DLRA1010	60	95	2700~3200	1000~1200	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DLRA1010	60	120	3600~4000	900~1100	0.07~0.1	0.07~0.1	3D 銑 (3D milling)
DLRA1020	60	65	1800~2200	400~600	0.2~0.25	6~10	溝銑 (Slotting)
DLRA1020	60	65	1800~2300	400~600	0.07~0.1	6~10	溝銑 (Slotting)
DLRA1020	60	65	1800~2200	400~600	10~20	0.2~0.25	側銑 (Side milling)
DLRA1020	60	65	1800~2200	400~600	10~20	0.07~0.1	側銑 (Side milling)
DLRA1020	60	95	2700~3200	1000~1200	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DLRA1020	60	120	3600~4000	900~1100	0.07~0.1	0.07~0.1	3D 銑 (3D milling)
DLRA1210	60	80	1900~2200	800~1000	0.2~0.25	9~12	溝銑 (Slotting)
DLRA1210	60	85	2000~2400	600~800	0.07~0.12	9~12	溝銑 (Slotting)
DLRA1210	60	80	1800~2200	400~600	12~24	0.2~0.25	側銑 (Side milling)
DLRA1210	60	95	2200~2700	400~600	12~24	0.07~0.12	側銑 (Side milling)
DLRA1210	60	160	4000~4500	1000~1200	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DLRA1210	60	160	4000~4500	900~1100	0.07~0.12	0.07~0.12	3D 銑 (3D milling)
DLRA1220	60	80	1900~2200	800~1000	0.2~0.25	7~12	溝銑 (Slotting)
DLRA1220	60	85	2000~2400	600~800	0.07~0.12	7~12	溝銑 (Slotting)
DLRA1220	60	80	1800~2200	400~600	12~24	0.2~0.25	側銑 (Side milling)
DLRA1220	60	95	2200~2700	400~600	12~24	0.07~0.12	側銑 (Side milling)
DLRA1220	60	160	4000~4500	1000~1200	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DLRA1220	60	160	4000~4500	900~1100	0.07~0.12	0.07~0.12	3D 銑 (3D milling)

# DLRA

## 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 (HRC 36~45)					
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 <sup>-1</sup> )	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
DLRA0405	40	55	4200~4600	600~800	0.06~0.08	1~4	溝銑 (Slotting)
DLRA0405	40	90	7000~7400	1000~1200	0.06~0.08	0.06~0.08	3D 銑 (3D milling)
DLRA0605	40	60	3000~3400	500~700	0.15~0.18	4~6	溝銑 (Slotting)
DLRA0605	40	75	3800~4200	600~800	0.06~0.08	4~6	溝銑 (Slotting)
DLRA0605	40	50	2400~2800	300~500	6~12	0.06~0.08	側銑 (Side milling)
DLRA0605	40	80	4000~4500	1100~1300	0.15~0.18	0.15~0.18	3D 銑 (3D milling)
DLRA0605	40	115	6000~5000	1000~1200	0.06~0.08	0.06~0.08	3D 銑 (3D milling)
DLRA0610	40	60	3000~3400	500~700	0.15~0.18	4~6	溝銑 (Slotting)
DLRA0610	40	75	3800~4200	600~800	0.06~0.08	4~6	溝銑 (Slotting)
DLRA0610	40	50	2400~2800	300~500	6~12	0.06~0.08	側銑 (Side milling)
DLRA0610	40	80	4000~4500	1100~1300	0.15~0.18	0.15~0.18	3D 銑 (3D milling)
DLRA0610	40	115	6000~5000	1000~1200	0.06~0.08	0.06~0.08	3D 銑 (3D milling)
DLRA0805	50	60	2200~2700	500~700	0.2~0.25	6~8	溝銑 (Slotting)
DLRA0805	50	60	2200~2700	400~600	0.07~0.1	6~8	溝銑 (Slotting)
DLRA0805	50	60	2200~2700	400~600	8~16	0.07~0.1	側銑 (Side milling)
DLRA0805	50	110	4200~4700	1100~1300	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DLRA0805	50	110	4200~4700	1000~1200	0.07~0.1	0.07~0.1	3D 銑 (3D milling)
DLRA0810	50	60	2200~2700	500~700	0.2~0.25	5~8	溝銑 (Slotting)
DLRA0810	50	60	2200~2700	400~600	0.07~0.1	5~8	溝銑 (Slotting)
DLRA0810	50	60	2200~2700	400~600	8~16	0.07~0.1	側銑 (Side milling)
DLRA0810	50	110	4200~4700	1100~1300	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DLRA0810	50	110	4200~4700	1000~1200	0.07~0.1	0.07~0.1	3D 銑 (3D milling)
DLRA1005	60	70	2000~2400	500~700	0.2~0.25	8~10	溝銑 (Slotting)
DLRA1005	60	90	2600~3000	400~600	0.07~0.1	8~10	溝銑 (Slotting)
DLRA1005	60	45	1200~1600	350~500	10~20	0.07~0.1	側銑 (Side milling)
DLRA1005	60	105	3200~3600	800~1000	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DLRA1005	60	110	3400~3800	800~1000	0.07~0.1	0.07~0.1	3D 銑 (3D milling)
DLRA1010	60	70	2000~2400	500~700	0.2~0.25	7~10	溝銑 (Slotting)
DLRA1010	60	90	2600~3000	400~600	0.07~0.1	7~10	溝銑 (Slotting)
DLRA1010	60	45	1200~1600	350~500	10~20	0.07~0.1	側銑 (Side milling)
DLRA1010	60	105	3200~3600	800~1000	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DLRA1010	60	110	3400~3800	800~1000	0.07~0.1	0.07~0.1	3D 銑 (3D milling)

# DLRA

## 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 (HRC 36~45)					
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 <sup>-1</sup> )	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
DLRA1020	60	70	2000~2400	500~700	0.2~0.25	5~10	溝銑 (Slotting)
DLRA1020	60	90	2600~3000	400~600	0.07~0.1	5~10	溝銑 (Slotting)
DLRA1020	60	45	1200~1600	350~500	10~20	0.07~0.1	側銑 (Side milling)
DLRA1020	60	105	3200~3600	800~1000	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DLRA1020	60	110	3400~3800	800~1000	0.07~0.1	0.07~0.1	3D 銑 (3D milling)
DLRA1210	60	80	1800~2200	600~800	0.2~0.25	9~12	溝銑 (Slotting)
DLRA1210	60	95	2300~2700	500~700	0.07~0.12	9~12	溝銑 (Slotting)
DLRA1210	60	45	1000~1300	250~400	12~24	0.07~0.12	側銑 (Side milling)
DLRA1210	60	150	3700~4200	800~1000	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DLRA1210	60	150	3700~4200	800~1000	0.07~0.12	0.07~0.12	3D 銑 (3D milling)
DLRA1220	60	80	1800~2200	600~800	0.2~0.25	7~12	溝銑 (Slotting)
DLRA1220	60	95	2300~2700	500~700	0.07~0.12	7~12	溝銑 (Slotting)
DLRA1220	60	45	1000~1300	250~400	12~24	0.07~0.12	側銑 (Side milling)
DLRA1220	60	150	3700~4200	800~1000	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DLRA1220	60	150	3700~4200	800~1000	0.07~0.12	0.07~0.12	3D 銑 (3D milling)

# DRD

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron					
		S50C / Fc250 / SS440 : 1.1210 / 0.6025 / 1.0036 : 1050 / N0.35 / A570 Gr.45 (~HRc22)					
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 <sup>-1</sup> )	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
DRD0305	12	85	9000~10000	900~1100	0.1~0.15	1~3	溝銑 (Slotting)
DRD0305	12	85	9000~10000	800~1000	0.05~0.08	1~3	溝銑 (Slotting)
DRD0305	12	80	8500~9000	1100~1300	3~6	0.1~0.15	側銑 (Side milling)
DRD0305	12	80	8500~9000	800~1000	3~6	0.06~0.08	側銑 (Side milling)
DRD0305	12	85	9000~10000	1100~1400	0.1~0.15	0.1~0.15	3D 銑 (3D milling)
DRD0305	12	85	9000~10000	1100~1400	0.05~0.08	0.05~0.08	3D 銑 (3D milling)
DRD0405	14	100	8000~8400	1000~1200	0.12~0.17	2~4	溝銑 (Slotting)
DRD0405	14	100	8000~8400	1000~1200	0.05~0.1	2~4	溝銑 (Slotting)
DRD0405	14	85	6800~7200	1000~1200	4~8	0.12~0.17	側銑 (Side milling)
DRD0405	14	85	6500~7500	800~1000	4~8	0.05~0.1	側銑 (Side milling)
DRD0405	14	110	8700~9200	1000~1200	0.12~0.17	0.12~0.17	3D 銑 (3D milling)
DRD0405	14	110	8700~9200	1200~1600	0.05~0.1	0.05~0.1	3D 銑 (3D milling)
DRD0505	17	90	5800~6400	1200~1400	0.12~0.17	3~5	溝銑 (Slotting)
DRD0505	17	130	8000~8500	1000~1400	0.05~0.1	3~5	溝銑 (Slotting)
DRD0505	17	95	6000~7000	1000~1200	5~10	0.12~0.17	側銑 (Side milling)
DRD0505	17	95	6000~7000	800~1000	5~10	0.05~0.1	側銑 (Side milling)
DRD0505	17	135	8500~9000	1400~1800	0.12~0.17	0.12~0.17	3D 銑 (3D milling)
DRD0505	17	135	8500~9000	1300~1600	0.05~0.1	0.05~0.1	3D 銑 (3D milling)
DRD0510	17	90	5800~6400	1200~1400	0.12~0.17	2~5	溝銑 (Slotting)
DRD0510	17	130	8000~8500	1000~1400	0.05~0.1	2~5	溝銑 (Slotting)
DRD0510	17	95	6000~7000	1000~1200	5~10	0.12~0.17	側銑 (Side milling)
DRD0510	17	95	6000~7000	800~1000	5~10	0.05~0.1	側銑 (Side milling)
DRD0510	17	135	8500~9000	1400~1800	0.12~0.17	0.12~0.17	3D 銑 (3D milling)
DRD0510	17	135	8500~9000	1300~1600	0.05~0.1	0.05~0.1	3D 銑 (3D milling)
DRD0605	20	90	4800~5400	1200~1400	0.15~0.2	4~6	溝銑 (Slotting)
DRD0605	20	130	6800~7200	1400~1600	0.05~0.1	4~6	溝銑 (Slotting)
DRD0605	20	95	5000~6000	1000~1200	6~12	0.15~0.2	側銑 (Side milling)
DRD0605	20	95	5000~6000	800~1000	6~12	0.05~0.1	側銑 (Side milling)
DRD0605	20	160	8500~9000	1600~2000	0.15~0.2	0.15~0.2	3D 銑 (3D milling)
DRD0605	20	160	8500~9000	1600~2000	0.05~0.1	0.05~0.1	3D 銑 (3D milling)

# DRD

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron					
		S50C / Fc250 / SS440 : 1.1210 / 0.6025 / 1.0036 : 1050 / N0.35 / A570 Gr.45 (~HRc22)					
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 <sup>-1</sup> )	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
DRD0610	20	90	4800~5400	1400~1600	0.15~0.2	3~6	溝銑 (Slotting)
DRD0610	20	130	6800~7200	1400~1600	0.05~0.1	3~6	溝銑 (Slotting)
DRD0610	20	95	5000~6000	1000~1200	6~12	0.15~0.2	側銑 (Side milling)
DRD0610	20	95	5000~6000	800~1000	6~12	0.05~0.1	側銑 (Side milling)
DRD0610	20	160	8500~9000	1600~2000	0.15~0.2	0.15~0.2	3D 銑 (3D milling)
DRD0610	20	160	8500~9000	1600~2000	0.05~0.1	0.05~0.1	3D 銑 (3D milling)
DRD0805	30	135	5200~5800	1000~1400	0.2~0.25	6~8	溝銑 (Slotting)
DRD0805	30	145	5800~6200	1000~1200	0.06~0.11	6~8	溝銑 (Slotting)
DRD0805	30	90	3500~4000	1000~1200	8~16	0.2~0.25	側銑 (Side milling)
DRD0805	30	90	3500~4000	700~1000	8~16	0.06~0.11	側銑 (Side milling)
DRD0805	30	190	7500~8500	1600~2000	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DRD0805	30	190	7500~8500	1400~1800	0.06~0.11	0.06~0.11	3D 銑 (3D milling)
DRD0810	30	135	5200~5800	1000~1400	0.2~0.25	5~8	溝銑 (Slotting)
DRD0810	30	145	5800~6200	1000~1200	0.06~0.11	5~8	溝銑 (Slotting)
DRD0810	30	90	3500~4000	1000~1200	8~16	0.2~0.25	側銑 (Side milling)
DRD0810	30	90	3500~4000	700~1000	8~16	0.06~0.11	側銑 (Side milling)
DRD0810	30	190	7500~8500	1600~2000	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DRD0810	30	190	7500~8500	1400~1800	0.06~0.11	0.06~0.11	3D 銑 (3D milling)
DRD1010	35	135	4200~4700	1200~1600	0.2~0.3	7~10	溝銑 (Slotting)
DRD1010	35	145	4500~5000	800~1000	0.05~0.12	7~10	溝銑 (Slotting)
DRD1010	35	90	2800~3200	800~1200	10~20	0.2~0.3	側銑 (Side milling)
DRD1010	35	90	2800~3200	700~900	10~20	0.05~0.12	側銑 (Side milling)
DRD1010	35	190	6000~7000	1600~2000	0.2~0.3	0.2~0.3	3D 銑 (3D milling)
DRD1010	35	190	6000~7000	1400~1800	0.05~0.12	0.05~0.12	3D 銑 (3D milling)
DRD1020	35	135	4200~4700	1200~1600	0.2~0.3	5~10	溝銑 (Slotting)
DRD1020	35	145	4500~5000	800~1000	0.05~0.12	5~10	溝銑 (Slotting)
DRD1020	35	90	2800~3200	800~1200	10~20	0.2~0.3	側銑 (Side milling)
DRD1020	35	90	2800~3200	700~900	10~20	0.05~0.12	側銑 (Side milling)
DRD1020	35	190	6000~7000	1600~2000	0.2~0.3	0.2~0.3	3D 銑 (3D milling)
DRD1020	35	190	6000~7000	1400~1800	0.05~0.12	0.05~0.12	3D 銑 (3D milling)

# DRD

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron					
		S50C / Fc250 / SS440 : 1.1210 / 0.6025 / 1.0036 : 1050 / N0.35 / A570 Gr.45 (~HRc22)					
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 <sup>-1</sup> )	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
DRD1030	35	135	4200~4700	1200~1600	0.2~0.3	3~10	溝銑 (Slotting)
DRD1030	35	145	4500~5000	800~1000	0.05~0.12	3~10	溝銑 (Slotting)
DRD1030	35	90	2800~3200	800~1200	10~20	0.2~0.3	側銑 (Side milling)
DRD1030	35	90	2800~3200	700~900	10~20	0.05~0.12	側銑 (Side milling)
DRD1030	35	190	6000~7000	1600~2000	0.2~0.3	0.2~0.3	3D 銑 (3D milling)
DRD1030	35	190	6000~7000	1400~1800	0.05~0.12	0.05~0.12	3D 銑 (3D milling)
DRD1210	40	145	3800~4200	1200~1600	0.2~0.3	9~12	溝銑 (Slotting)
DRD1210	40	150	4000~4500	1400~1600	0.1~0.15	9~12	溝銑 (Slotting)
DRD1210	40	105	2800~3200	1000~1200	12~24	0.2~0.3	側銑 (Side milling)
DRD1210	40	105	2800~3200	600~800	12~24	0.1~0.15	側銑 (Side milling)
DRD1210	40	170	4500~5000	1600~2000	0.2~0.3	0.2~0.3	3D 銑 (3D milling)
DRD1210	40	190	5000~5500	1400~1800	0.1~0.15	0.1~0.15	3D 銑 (3D milling)
DRD1220	40	145	3800~4200	1200~1600	0.25~0.3	7~12	溝銑 (Slotting)
DRD1220	40	150	4000~4500	1400~1600	0.1~0.15	7~12	溝銑 (Slotting)
DRD1220	40	105	2800~3200	1000~1200	12~24	0.25~0.3	側銑 (Side milling)
DRD1220	40	105	2800~3200	600~800	12~24	0.1~0.15	側銑 (Side milling)
DRD1220	40	170	4500~5000	1600~2000	0.25~0.3	0.25~0.3	3D 銑 (3D milling)
DRD1220	40	190	5000~5500	1400~1800	0.1~0.15	0.1~0.15	3D 銑 (3D milling)
DRD1230	40	145	3800~4200	1200~1600	0.25~0.3	5~12	溝銑 (Slotting)
DRD1230	40	150	4000~4500	1400~1600	0.1~0.15	5~12	溝銑 (Slotting)
DRD1230	40	105	2800~3200	1000~1200	12~24	0.25~0.3	側銑 (Side milling)
DRD1230	40	105	2800~3200	600~800	12~24	0.1~0.15	側銑 (Side milling)
DRD1230	40	170	4500~5000	1600~2000	0.25~0.3	0.25~0.3	3D 銑 (3D milling)
DRD1230	40	190	5000~5500	1400~1800	0.1~0.15	0.1~0.15	3D 銑 (3D milling)

# DRD

## 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 (HRC 36~45)					
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 <sup>-1</sup> )	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
DRD0305	12	85	9000~10000	800~1000	0.1~0.15	1~3	溝銑 (Slotting)
DRD0305	12	85	9000~10000	800~1000	0.05~0.08	1~3	溝銑 (Slotting)
DRD0305	12	80	8500~9000	1000~1200	3~6	0.1~0.15	側銑 (Side milling)
DRD0305	12	80	8500~9000	700~900	3~6	0.06~0.08	側銑 (Side milling)
DRD0305	12	85	9000~10000	1000~1200	0.1~0.15	0.1~0.15	3D 銑 (3D milling)
DRD0305	12	85	9000~10000	1000~1200	0.05~0.08	0.05~0.08	3D 銑 (3D milling)
DRD0405	14	100	8000~8400	800~1000	0.12~0.17	2~4	溝銑 (Slotting)
DRD0405	14	100	8000~8400	800~1000	0.05~0.1	2~4	溝銑 (Slotting)
DRD0405	14	85	6800~7200	800~1000	4~8	0.12~0.17	側銑 (Side milling)
DRD0405	14	85	6500~7000	500~700	4~8	0.05~0.1	側銑 (Side milling)
DRD0405	14	110	8700~9200	800~1000	0.12~0.17	0.12~0.17	3D 銑 (3D milling)
DRD0405	14	110	8700~9200	1000~1200	0.05~0.1	0.05~0.1	3D 銑 (3D milling)
DRD0505	17	90	5800~6400	800~1000	0.12~0.17	3~5	溝銑 (Slotting)
DRD0505	17	115	7200~7600	1000~1200	0.05~0.1	3~5	溝銑 (Slotting)
DRD0505	17	85	5400~6000	800~1000	5~10	0.12~0.17	側銑 (Side milling)
DRD0505	17	90	5800~6400	600~800	5~10	0.05~0.1	側銑 (Side milling)
DRD0505	17	130	8000~8500	800~1200	0.12~0.17	0.12~0.17	3D 銑 (3D milling)
DRD0505	17	130	8000~8500	1000~1400	0.05~0.1	0.05~0.1	3D 銑 (3D milling)
DRD0510	17	90	5800~6400	800~1000	0.12~0.17	2~5	溝銑 (Slotting)
DRD0510	17	115	7200~7600	1000~1200	0.05~0.1	2~5	溝銑 (Slotting)
DRD0510	17	85	5400~6000	800~1000	5~10	0.12~0.17	側銑 (Side milling)
DRD0510	17	90	5800~6400	600~800	5~10	0.05~0.1	側銑 (Side milling)
DRD0510	17	130	8000~8500	800~1200	0.12~0.17	0.12~0.17	3D 銑 (3D milling)
DRD0510	17	130	8000~8500	1000~1400	0.05~0.1	0.05~0.1	3D 銑 (3D milling)
DRD0605	20	90	4800~5400	1000~1400	0.15~0.2	4~6	溝銑 (Slotting)
DRD0605	20	115	6000~6400	1200~1400	0.05~0.1	4~6	溝銑 (Slotting)
DRD0605	20	85	4500~5000	800~1000	6~12	0.15~0.2	側銑 (Side milling)
DRD0605	20	90	4800~5200	600~800	6~12	0.05~0.1	側銑 (Side milling)
DRD0605	20	160	8500~9000	1000~1400	0.15~0.2	0.15~0.2	3D 銑 (3D milling)
DRD0605	20	160	8500~9000	1400~1800	0.05~0.1	0.05~0.1	3D 銑 (3D milling)

# DRD

## 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 (HRC 36~45)					
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 <sup>-1</sup> )	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
DRD0610	20	90	4800~5400	1000~1400	0.15~0.2	3~6	溝銑 (Slotting)
DRD0610	20	115	6000~6400	1200~1400	0.05~0.1	3~6	溝銑 (Slotting)
DRD0610	20	85	4500~5000	800~1000	6~12	0.15~0.2	側銑 (Side milling)
DRD0610	20	90	4800~5200	600~800	6~12	0.05~0.1	側銑 (Side milling)
DRD0610	20	160	8500~9000	1000~1400	0.15~0.2	0.15~0.2	3D 銑 (3D milling)
DRD0610	20	160	8500~9000	1400~1800	0.05~0.1	0.05~0.1	3D 銑 (3D milling)
DRD0805	30	100	4000~4500	700~1000	0.2~0.25	6~8	溝銑 (Slotting)
DRD0805	30	140	5500~6000	800~1000	0.06~0.11	6~8	溝銑 (Slotting)
DRD0805	30	90	3500~4000	700~900	8~16	0.2~0.25	側銑 (Side milling)
DRD0805	30	90	3500~4000	600~800	8~16	0.06~0.11	側銑 (Side milling)
DRD0805	30	100	4000~4500	1400~1800	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DRD0805	30	185	7200~7700	1200~1600	0.06~0.11	0.06~0.11	3D 銑 (3D milling)
DRD0810	30	100	4000~4500	700~1000	0.2~0.25	5~8	溝銑 (Slotting)
DRD0810	30	140	5500~6000	800~1000	0.06~0.11	5~8	溝銑 (Slotting)
DRD0810	30	90	3500~4000	700~900	8~16	0.2~0.25	側銑 (Side milling)
DRD0810	30	90	3500~4000	600~800	8~16	0.06~0.11	側銑 (Side milling)
DRD0810	30	100	4000~4500	1400~1800	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DRD0810	30	185	7200~7700	1200~1600	0.06~0.11	0.06~0.11	3D 銑 (3D milling)
DRD1010	35	100	3200~3600	800~1100	0.2~0.3	7~10	溝銑 (Slotting)
DRD1010	35	140	4400~4800	800~1000	0.05~0.12	7~10	溝銑 (Slotting)
DRD1010	35	90	2800~3200	700~1000	10~20	0.2~0.3	側銑 (Side milling)
DRD1010	35	90	2800~3200	600~800	10~20	0.05~0.12	側銑 (Side milling)
DRD1010	35	100	3200~3600	1400~1800	0.2~0.3	0.2~0.3	3D 銑 (3D milling)
DRD1010	35	185	5800~6200	1200~1600	0.05~0.12	0.05~0.12	3D 銑 (3D milling)
DRD1020	35	100	3200~3600	800~1100	0.2~0.3	5~10	溝銑 (Slotting)
DRD1020	35	140	4400~4800	800~1000	0.05~0.12	5~10	溝銑 (Slotting)
DRD1020	35	90	2800~3200	700~1000	10~20	0.2~0.3	側銑 (Side milling)
DRD1020	35	90	2800~3200	600~800	10~20	0.05~0.12	側銑 (Side milling)
DRD1020	35	100	3200~3600	1400~1800	0.2~0.3	0.2~0.3	3D 銑 (3D milling)
DRD1020	35	185	5800~6200	1200~1600	0.05~0.12	0.05~0.12	3D 銑 (3D milling)

# DRD

## 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 (HRC 36~45)					
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 <sup>-1</sup> )	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
DRD1030	35	100	3200~3600	800~1100	0.2~0.3	3~10	溝銑 (Slotting)
DRD1030	35	140	4400~4800	800~1000	0.05~0.12	3~10	溝銑 (Slotting)
DRD1030	35	90	2800~3200	700~1000	10~20	0.2~0.3	側銑 (Side milling)
DRD1030	35	90	2800~3200	600~800	10~20	0.05~0.12	側銑 (Side milling)
DRD1030	35	100	3200~3600	1400~1800	0.2~0.3	0.2~0.3	3D 銑 (3D milling)
DRD1030	35	185	5800~6200	1200~1600	0.05~0.12	0.05~0.12	3D 銑 (3D milling)
DRD1210	40	90	2400~2800	800~1000	0.2~0.3	9~12	溝銑 (Slotting)
DRD1210	40	145	3800~4200	1200~1400	0.1~0.15	9~12	溝銑 (Slotting)
DRD1210	40	70	1800~2200	600~800	12~24	0.2~0.3	側銑 (Side milling)
DRD1210	40	75	1900~2300	400~600	12~24	0.1~0.15	側銑 (Side milling)
DRD1210	40	150	4000~4400	1200~1400	0.2~0.3	0.2~0.3	3D 銑 (3D milling)
DRD1210	40	180	4700~5200	1200~1600	0.1~0.15	0.1~0.15	3D 銑 (3D milling)
DRD1220	40	90	2400~2800	800~1000	0.25~0.3	7~12	溝銑 (Slotting)
DRD1220	40	145	3800~4200	1200~1400	0.1~0.15	7~12	溝銑 (Slotting)
DRD1220	40	70	1800~2200	600~800	12~24	0.25~0.3	側銑 (Side milling)
DRD1220	40	75	1900~2300	400~600	12~24	0.1~0.15	側銑 (Side milling)
DRD1220	40	150	4000~4400	1200~1400	0.25~0.3	0.25~0.3	3D 銑 (3D milling)
DRD1220	40	180	4700~5200	1200~1600	0.1~0.15	0.1~0.15	3D 銑 (3D milling)
DRD1230	40	90	2400~2800	800~1000	0.25~0.3	5~12	溝銑 (Slotting)
DRD1230	40	145	3800~4200	1200~1400	0.1~0.15	5~12	溝銑 (Slotting)
DRD1230	40	70	1800~2200	600~800	12~24	0.25~0.3	側銑 (Side milling)
DRD1230	40	75	1900~2300	400~600	12~24	0.1~0.15	側銑 (Side milling)
DRD1230	40	150	4000~4400	1200~1400	0.25~0.3	0.25~0.3	3D 銑 (3D milling)
DRD1230	40	180	4700~5200	1200~1600	0.1~0.15	0.1~0.15	3D 銑 (3D milling)

# DLRD

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron					
		S50C / Fc250 / SS440 : 1.1210 / 0.6025 / 1.0036 : 1050 / N0.35 / A570 Gr.45 (~HRc22)					
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 <sup>-1</sup> )	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
DLRD0605	40	75	4000~4600	600~800	0.15~0.2	4~6	溝銑 (Slotting)
DLRD0605	40	95	5000~5500	1200~1400	0.07~0.1	4~6	溝銑 (Slotting)
DLRD0605	40	60	3200~3600	1000~1200	6~12	0.15~0.2	側銑 (Side milling)
DLRD0605	40	60	3200~3600	600~800	6~12	0.07~0.1	側銑 (Side milling)
DLRD0605	40	90	4800~5400	1800~2200	0.15~0.2	0.15~0.2	3D 銑 (3D milling)
DLRD0605	40	135	7200~7600	1200~1600	0.07~0.1	0.07~0.1	3D 銑 (3D milling)
DLRD0610	40	75	4000~4600	600~800	0.15~0.2	3~6	溝銑 (Slotting)
DLRD0610	40	95	5000~5500	1200~1400	0.07~0.1	3~6	溝銑 (Slotting)
DLRD0610	40	60	3200~3600	1000~1200	6~12	0.15~0.2	側銑 (Side milling)
DLRD0610	40	60	3200~3600	600~800	6~12	0.07~0.1	側銑 (Side milling)
DLRD0610	40	90	4800~5400	1800~2200	0.15~0.2	0.15~0.2	3D 銑 (3D milling)
DLRD0610	40	135	7200~7600	1200~1600	0.07~0.1	0.07~0.1	3D 銑 (3D milling)
DLRD0805	50	65	2500~3000	800~1000	0.2~0.25	6~8	溝銑 (Slotting)
DLRD0805	50	75	3000~3500	600~800	0.08~0.12	6~8	溝銑 (Slotting)
DLRD0805	50	90	3500~4000	500~800	8~16	0.2~0.25	側銑 (Side milling)
DLRD0805	50	65	2500~3000	500~800	8~16	0.08~0.12	側銑 (Side milling)
DLRD0805	50	115	4500~5200	1000~1400	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DLRD0805	50	165	6500~7000	1000~1400	0.08~0.12	0.08~0.12	3D 銑 (3D milling)
DLRD0810	50	65	2500~3000	800~1000	0.2~0.25	5~8	溝銑 (Slotting)
DLRD0810	50	75	3000~3500	600~800	0.08~0.12	5~8	溝銑 (Slotting)
DLRD0810	50	90	3500~4000	500~800	8~16	0.2~0.25	側銑 (Side milling)
DLRD0810	50	65	2500~3000	500~800	8~16	0.08~0.12	側銑 (Side milling)
DLRD0810	50	115	4500~5200	1000~1400	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DLRD0810	50	165	6500~7000	1000~1400	0.08~0.12	0.08~0.12	3D 銑 (3D milling)
DLRD1005	60	65	2000~2400	800~1000	0.25~0.3	10~20	溝銑 (Slotting)
DLRD1005	60	75	2400~2800	500~800	0.08~0.13	10~20	溝銑 (Slotting)
DLRD1005	60	90	2800~3200	500~800	10~20	0.25~0.3	側銑 (Side milling)
DLRD1005	60	65	2000~2400	500~800	10~20	0.08~0.13	側銑 (Side milling)
DLRD1005	60	115	3600~4200	1000~1400	0.25~0.3	0.25~0.3	3D 銑 (3D milling)
DLRD1005	60	165	5200~5600	1000~1400	0.08~0.13	0.08~0.13	3D 銑 (3D milling)

# DLRD

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron					
		S50C / Fc250 / SS440 : 1.1210 / 0.6025 / 1.0036 : 1050 / N0.35 / A570 Gr.45 (~HRc22)					
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 <sup>-1</sup> )	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
DLRD1010	60	65	2000~2400	800~1000	0.25~0.3	7~10	溝銑 (Slotting)
DLRD1010	60	75	2400~2800	500~800	0.08~0.13	7~10	溝銑 (Slotting)
DLRD1010	60	90	2800~3200	500~800	10~20	0.25~0.3	側銑 (Side milling)
DLRD1010	60	65	2000~2400	500~800	10~20	0.1~0.15	側銑 (Side milling)
DLRD1010	60	115	3600~4200	1000~1400	0.25~0.3	0.25~0.3	3D 銑 (3D milling)
DLRD1010	60	165	5200~5600	1000~1400	0.08~0.13	0.08~0.13	3D 銑 (3D milling)
DLRD1020	60	65	2000~2400	800~1000	0.25~0.3	5~10	溝銑 (Slotting)
DLRD1020	60	75	2400~2800	500~800	0.08~0.13	5~10	溝銑 (Slotting)
DLRD1020	60	90	2800~3200	500~800	10~20	0.25~0.3	側銑 (Side milling)
DLRD1020	60	65	2000~2400	500~800	10~20	0.1~0.15	側銑 (Side milling)
DLRD1020	60	115	3600~4200	1000~1400	0.25~0.3	0.25~0.3	3D 銑 (3D milling)
DLRD1020	60	165	5200~5600	1000~1400	0.08~0.13	0.08~0.13	3D 銑 (3D milling)
DLRD1210	60	75	2000~2400	800~1200	0.25~0.3	9~12	溝銑 (Slotting)
DLRD1210	60	105	2800~3200	800~1000	0.1~0.15	9~12	溝銑 (Slotting)
DLRD1210	60	80	1900~2300	800~1000	12~24	0.25~0.3	側銑 (Side milling)
DLRD1210	60	80	1900~2300	400~600	12~24	0.1~0.15	側銑 (Side milling)
DLRD1210	60	150	4000~4500	1400~1800	0.25~0.3	0.25~0.3	3D 銑 (3D milling)
DLRD1210	60	170	4500~5000	1200~1600	0.1~0.15	0.1~0.15	3D 銑 (3D milling)
DLRD1220	60	75	2000~2400	800~1200	0.25~0.3	7~12	溝銑 (Slotting)
DLRD1220	60	105	2800~3200	800~1000	0.1~0.15	7~12	溝銑 (Slotting)
DLRD1220	60	80	1900~2300	800~1000	12~24	0.25~0.3	側銑 (Side milling)
DLRD1220	60	80	1900~2300	400~600	12~24	0.1~0.15	側銑 (Side milling)
DLRD1220	60	150	4000~4500	1400~1800	0.25~0.3	0.25~0.3	3D 銑 (3D milling)
DLRD1220	60	170	4500~5000	1200~1600	0.1~0.15	0.1~0.15	3D 銑 (3D milling)

# DLRD

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron					
		S50C / Fc250 / SS440 : 1.1210 / 0.6025 / 1.0036 : 1050 / N0.35 / A570 Gr.45 (~HRc22)					
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 <sup>-1</sup> )	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
<b>DLRD1610</b>	100	75	1500~1800	700~1100	0.3~0.35	13~16	溝銑 (Slotting)
<b>DLRD1610</b>	100	90	1800~2100	400~600	0.12~0.17	13~16	溝銑 (Slotting)
<b>DLRD1610</b>	100	75	1500~1800	600~800	16~32	0.3~0.35	側銑 (Side milling)
<b>DLRD1610</b>	100	75	1500~1800	400~600	16~32	0.12~0.17	側銑 (Side milling)
<b>DLRD1610</b>	100	150	3000~3400	1400~1800	0.3~0.35	0.3~0.35	3D 銑 (3D milling)
<b>DLRD1610</b>	100	170	3400~3800	800~1200	0.12~0.17	0.12~0.17	3D 銑 (3D milling)
<b>DLRD1620</b>	100	75	1500~1800	700~1100	0.3~0.35	11~16	溝銑 (Slotting)
<b>DLRD1620</b>	100	90	1800~2100	400~600	0.12~0.17	11~16	溝銑 (Slotting)
<b>DLRD1620</b>	100	75	1500~1800	600~800	16~32	0.3~0.35	側銑 (Side milling)
<b>DLRD1620</b>	100	75	1500~1800	400~600	16~32	0.12~0.17	側銑 (Side milling)
<b>DLRD1620</b>	100	150	3000~3400	1400~1800	0.3~0.35	0.3~0.35	3D 銑 (3D milling)
<b>DLRD1620</b>	100	170	3400~3800	800~1200	0.12~0.17	0.12~0.17	3D 銑 (3D milling)

# DLRD

## 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 (HRC 36~45)					
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 <sup>-1</sup> )	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
DLRD0605	40	70	3600~4000	600~800	0.15~0.2	4~6	溝銑 (Slotting)
DLRD0605	40	85	4500~5000	1000~1200	0.07~0.1	4~6	溝銑 (Slotting)
DLRD0605	40	30	1600~2000	200~400	6~12	0.15~0.2	側銑 (Side milling)
DLRD0605	40	50	2700~3200	400~600	6~12	0.07~0.1	側銑 (Side milling)
DLRD0605	40	90	4800~5400	1000~1400	0.15~0.2	0.15~0.2	3D 銑 (3D milling)
DLRD0605	40	130	6800~7200	1200~1600	0.07~0.1	0.07~0.1	3D 銑 (3D milling)
DLRD0610	40	70	3600~4000	600~800	0.15~0.2	3~6	溝銑 (Slotting)
DLRD0610	40	85	4500~5000	1000~1200	0.07~0.1	3~6	溝銑 (Slotting)
DLRD0610	40	30	1600~2000	200~400	6~12	0.15~0.2	側銑 (Side milling)
DLRD0610	40	50	2700~3200	400~600	6~12	0.07~0.1	側銑 (Side milling)
DLRD0610	40	90	4800~5400	1000~1400	0.15~0.2	0.15~0.2	3D 銑 (3D milling)
DLRD0610	40	130	6800~7200	1200~1600	0.07~0.1	0.07~0.1	3D 銑 (3D milling)
DLRD0805	50	65	2400~2800	600~800	0.2~0.25	6~8	溝銑 (Slotting)
DLRD0805	50	90	3500~4000	500~700	0.08~0.12	6~8	溝銑 (Slotting)
DLRD0805	50	35	1200~1600	250~350	8~16	0.2~0.25	側銑 (Side milling)
DLRD0805	50	50	1800~2200	400~600	8~16	0.08~0.12	側銑 (Side milling)
DLRD0805	50	115	4500~5200	800~1000	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DLRD0805	50	150	5700~6300	800~1200	0.08~0.12	0.08~0.12	3D 銑 (3D milling)
DLRD0810	50	65	2400~2800	600~800	0.2~0.25	5~8	溝銑 (Slotting)
DLRD0810	50	90	3500~4000	500~700	0.08~0.12	5~8	溝銑 (Slotting)
DLRD0810	50	35	1200~1600	250~350	8~16	0.2~0.25	側銑 (Side milling)
DLRD0810	50	50	1800~2200	400~600	8~16	0.08~0.12	側銑 (Side milling)
DLRD0810	50	115	4500~5200	800~1000	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DLRD0810	50	150	5700~6300	800~1200	0.08~0.12	0.08~0.12	3D 銑 (3D milling)
DLRD1005	60	65	2000~2400	600~800	0.25~0.3	8~10	溝銑 (Slotting)
DLRD1005	60	90	2800~3200	500~700	0.08~0.13	8~10	溝銑 (Slotting)
DLRD1005	60	35	1000~1300	200~300	10~20	0.2~0.25	側銑 (Side milling)
DLRD1005	60	40	1200~1600	400~600	10~20	0.08~0.13	側銑 (Side milling)
DLRD1005	60	115	3600~4000	800~1000	0.25~0.3	0.25~0.3	3D 銑 (3D milling)
DLRD1005	60	150	4800~5200	800~1200	0.08~0.13	0.08~0.13	3D 銑 (3D milling)

# DLRD

## 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 (HRC 36~45)					
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 <sup>-1</sup> )	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
DLRD1010	60	65	2000~2400	600~800	0.25~0.3	7~10	溝銑 (Slotting)
DLRD1010	60	90	2800~3200	500~700	0.08~0.13	7~10	溝銑 (Slotting)
DLRD1010	60	35	1000~1300	200~300	10~20	0.2~0.25	側銑 (Side milling)
DLRD1010	60	40	1200~1600	400~600	10~20	0.08~0.13	側銑 (Side milling)
DLRD1010	60	115	3600~4000	800~1000	0.25~0.3	0.25~0.3	3D 銑 (3D milling)
DLRD1010	60	150	4800~5200	800~1200	0.08~0.13	0.08~0.13	3D 銑 (3D milling)
DLRD1020	60	65	2000~2400	600~800	0.25~0.3	5~10	溝銑 (Slotting)
DLRD1020	60	90	2800~3200	500~700	0.08~0.13	5~10	溝銑 (Slotting)
DLRD1020	60	35	1000~1300	200~300	10~20	0.2~0.25	側銑 (Side milling)
DLRD1020	60	40	1200~1600	400~600	10~20	0.08~0.13	側銑 (Side milling)
DLRD1020	60	115	3600~4000	800~1000	0.25~0.3	0.25~0.3	3D 銑 (3D milling)
DLRD1020	60	150	4800~5200	800~1200	0.08~0.13	0.08~0.13	3D 銑 (3D milling)
DLRD1210	60	70	1800~2200	800~1000	0.25~0.3	9~12	溝銑 (Slotting)
DLRD1210	60	95	2500~2800	600~800	0.1~0.15	9~12	溝銑 (Slotting)
DLRD1210	60	30	700~1000	200~300	12~24	0.15~0.25	側銑 (Side milling)
DLRD1210	60	45	1100~1400	300~450	12~24	0.1~0.15	側銑 (Side milling)
DLRD1210	60	150	4000~4500	800~1000	0.25~0.3	0.25~0.3	3D 銑 (3D milling)
DLRD1210	60	150	4000~4500	1000~1400	0.1~0.15	0.1~0.15	3D 銑 (3D milling)
DLRD1220	60	70	1800~2200	800~1000	0.25~0.3	7~12	溝銑 (Slotting)
DLRD1220	60	95	2500~2800	600~800	0.1~0.15	7~12	溝銑 (Slotting)
DLRD1220	60	30	700~1000	200~300	12~24	0.15~0.25	側銑 (Side milling)
DLRD1220	60	45	1100~1400	300~450	12~24	0.1~0.15	側銑 (Side milling)
DLRD1220	60	150	4000~4500	800~1000	0.25~0.3	0.25~0.3	3D 銑 (3D milling)
DLRD1220	60	150	4000~4500	1000~1400	0.1~0.15	0.1~0.15	3D 銑 (3D milling)

# DLRD

## 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 (HRC 36~45)					
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 <sup>-1</sup> )	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
<b>DLRD1610</b>	100	70	1200~1600	600~900	0.3~0.35	13~16	溝銑 (Slotting)
<b>DLRD1610</b>	100	85	1500~1800	300~500	0.12~0.17	13~16	溝銑 (Slotting)
<b>DLRD1610</b>	100	30	500~800	200~350	16~32	0.3~0.35	側銑 (Side milling)
<b>DLRD1610</b>	100	45	800~1100	200~350	16~32	0.12~0.17	側銑 (Side milling)
<b>DLRD1610</b>	100	150	3000~3400	1200~1600	0.3~0.35	0.3~0.35	3D 銑 (3D milling)
<b>DLRD1610</b>	100	150	3000~3400	700~1000	0.12~0.17	0.12~0.17	3D 銑 (3D milling)
<b>DLRD1620</b>	100	70	1200~1600	600~900	0.3~0.35	11~16	溝銑 (Slotting)
<b>DLRD1620</b>	100	85	1500~1800	300~500	0.12~0.17	11~16	溝銑 (Slotting)
<b>DLRD1620</b>	100	30	500~800	200~350	16~32	0.3~0.35	側銑 (Side milling)
<b>DLRD1620</b>	100	45	800~1100	200~350	16~32	0.12~0.17	側銑 (Side milling)
<b>DLRD1620</b>	100	150	3000~3400	1200~1600	0.3~0.35	0.3~0.35	3D 銑 (3D milling)
<b>DLRD1620</b>	100	150	3000~3400	700~1000	0.12~0.17	0.12~0.17	3D 銑 (3D milling)

# DC 2T

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		鋁合金 : Aluminum Alloy 5052 / 6061 / 7075					
冷卻方式 Coolant Type		溼式切削 Wet 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 <sup>-1</sup> )	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
DC0202	9	60	9000~9500	900~1300	0.05~0.08	1.5~2	溝銑 (Slotting)
DC0202	9	60	9000~9500	1300~1700	0.1~0.2	2	溝銑 (Slotting)
DC0202	9	60	9000~9500	800~1100	0.4~0.6	2	溝銑 (Slotting)
DC0202	9	60	9000~9500	1000~1400	2~4	0.05~0.08	側銑 (Side milling)
DC0202	9	60	9000~9500	1500~1900	2~4	0.2~0.3	側銑 (Side milling)
DC0302	12	85	8500~9000	900~1300	0.05~0.1	2.5~3	溝銑 (Slotting)
DC0302	12	85	8500~9000	1300~1700	0.2~0.4	3	溝銑 (Slotting)
DC0302	12	85	8500~9000	800~1100	0.4~0.8	3	溝銑 (Slotting)
DC0302	12	85	8500~9000	1000~1400	3~6	0.05~0.1	側銑 (Side milling)
DC0302	12	85	8500~9000	1500~1900	3~6	0.4~0.6	側銑 (Side milling)
DC0402	15	110	8500~9000	900~1300	0.05~0.12	3~4	溝銑 (Slotting)
DC0402	15	110	8500~9000	1300~1700	0.3~0.6	4	溝銑 (Slotting)
DC0402	15	110	8500~9000	800~1100	0.6~1.2	4	溝銑 (Slotting)
DC0402	15	110	8500~9000	1000~1400	4~8	0.05~0.12	側銑 (Side milling)
DC0402	15	110	8500~9000	1500~1900	4~8	0.5~0.7	側銑 (Side milling)
DC0502	19	140	8500~9000	1100~1500	0.05~0.12	4~5	溝銑 (Slotting)
DC0502	19	140	8500~9000	2000~2400	0.4~0.7	5	溝銑 (Slotting)
DC0502	19	140	8500~9000	1100~1500	0.7~1.5	5	溝銑 (Slotting)
DC0502	19	140	8500~9000	1000~1400	5~10	0.05~0.12	側銑 (Side milling)
DC0502	19	140	8500~9000	1500~1900	5~10	0.7~1	側銑 (Side milling)
DC0602	21	165	8500~9000	1200~1600	0.05~0.15	5~6	溝銑 (Slotting)
DC0602	21	165	8500~9000	2000~2400	0.5~1	6	溝銑 (Slotting)
DC0602	21	165	8500~9000	1000~1400	1~2	6	溝銑 (Slotting)
DC0602	21	165	8500~9000	1000~1400	6~12	0.05~0.15	側銑 (Side milling)
DC0602	21	165	8500~9000	1800~2200	6~12	0.8~1.2	側銑 (Side milling)

# DC 2T

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		鋁合金 : Aluminum Alloy 5052 / 6061 / 7075					
冷卻方式 Coolant Type		溼式切削 Wet 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 <sup>-1</sup> )	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
DC0802	25	200	7800~8300	1200~1600	0.05~0.15	6~8	溝銑 (Slotting)
DC0802	25	200	7800~8300	2000~2400	1~1.5	8	溝銑 (Slotting)
DC0802	25	200	7800~8300	1000~1400	2~3	8	溝銑 (Slotting)
DC0802	25	200	7800~8300	1000~1400	8~16	0.05~0.15	側銑 (Side milling)
DC0802	25	200	7800~8300	1800~2200	8~16	1~1.5	側銑 (Side milling)
DC1002	30	250	7800~8300	1200~1600	0.05~0.15	8~10	溝銑 (Slotting)
DC1002	30	250	7800~8300	2000~2400	1~1.5	10	溝銑 (Slotting)
DC1002	30	250	7800~8300	1000~1400	2~3	10	溝銑 (Slotting)
DC1002	30	250	7800~8300	1000~1400	10~20	0.05~0.15	側銑 (Side milling)
DC1002	30	250	7800~8300	1800~2200	10~20	1~1.5	側銑 (Side milling)
DC1202	35	225	5800~6300	1200~1600	0.05~0.15	10~12	溝銑 (Slotting)
DC1202	35	225	5800~6300	2000~2400	1~1.5	12	溝銑 (Slotting)
DC1202	35	225	5800~6300	1000~1400	2~3	12	溝銑 (Slotting)
DC1202	35	225	5800~6300	1000~1400	12~24	0.05~0.15	側銑 (Side milling)
DC1202	35	225	5800~6300	1800~2200	12~24	1~1.5	側銑 (Side milling)
DC1602	55	225	4200~4700	800~1200	0.05~0.15	14~16	溝銑 (Slotting)
DC1602	55	225	4200~4700	1400~1800	1~1.5	14~16	溝銑 (Slotting)
DC1602	55	225	4200~4700	800~1200	2~3	14~16	溝銑 (Slotting)
DC1602	55	225	4200~4700	700~1100	16~32	0.05~0.15	側銑 (Side milling)
DC1602	55	225	4200~4700	1400~1800	16~32	1~1.5	側銑 (Side milling)
DC2002	65	225	3300~3800	700~1100	0.05~0.15	18~20	溝銑 (Slotting)
DC2002	65	225	3300~3800	1200~1600	1~1.5	18~20	溝銑 (Slotting)
DC2002	65	225	3300~3800	800~1200	2~3	18~20	溝銑 (Slotting)
DC2002	65	225	3300~3800	700~1100	20~40	0.05~0.15	側銑 (Side milling)
DC2002	65	225	3300~3800	1200~1600	20~40	1.5~2	側銑 (Side milling)

# DC 3T

建議機器轉速 RPM = 10000 (min<sup>-1</sup>) 以下  
 < Be used under the machine of RPM = 10000 (min<sup>-1</sup>) >

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		鋁合金 : Aluminum Alloy 5052 / 6061 / 7075					
冷卻方式 Coolant Type		溼式切削 Wet 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 <sup>-1</sup> )	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
DC0203	14	60	9500~10000	600~1000	0.05~0.1	2	溝銑 (Slotting)
DC0203	14	60	9500~10000	1000~1400	0.2	2	溝銑 (Slotting)
DC0203	14	60	9500~10000	600~1000	2	0.05~0.1	側銑 (Side milling)
DC0203	14	60	9500~10000	1200~1600	2	0.4	側銑 (Side milling)
DC0203	14	60	9500~10000	400~800	4	0.05~0.1	側銑 (Side milling)
DC0203	14	60	9500~10000	700~1100	4	0.2	側銑 (Side milling)
DC0303	16	90	9500~10000	700~1100	0.05~0.1	3	溝銑 (Slotting)
DC0303	16	90	9500~10000	1200~1600	0.3	3	溝銑 (Slotting)
DC0303	16	90	9500~10000	700~1100	3	0.05~0.1	側銑 (Side milling)
DC0303	16	90	9500~10000	1400~1800	3	0.4	側銑 (Side milling)
DC0303	16	90	9500~10000	400~800	6	0.05~0.1	側銑 (Side milling)
DC0303	16	90	9500~10000	800~1200	6	0.3	側銑 (Side milling)
DC0403	16	120	9500~10000	800~1200	0.05~0.1	4	溝銑 (Slotting)
DC0403	16	120	9500~10000	1200~1600	0.4	4	溝銑 (Slotting)
DC0403	16	120	9500~10000	800~1200	4	0.05~0.1	側銑 (Side milling)
DC0403	16	120	9500~10000	1400~1800	4	0.4	側銑 (Side milling)
DC0403	16	120	9500~10000	400~800	8	0.05~0.1	側銑 (Side milling)
DC0403	16	120	9500~10000	800~1200	8	0.4	側銑 (Side milling)
DC0503	16	155	9500~10000	800~1200	0.05~0.15	5	溝銑 (Slotting)
DC0503	16	155	9500~10000	1400~1800	0.4	5	溝銑 (Slotting)
DC0503	16	155	9500~10000	800~1200	5	0.05~0.15	側銑 (Side milling)
DC0503	16	155	9500~10000	1600~2000	5	0.4	側銑 (Side milling)
DC0503	16	155	9500~10000	400~800	10	0.05~0.15	側銑 (Side milling)
DC0503	16	155	9500~10000	1000~1400	10	0.4	側銑 (Side milling)

# DC 3T

建議機器轉速 RPM = 10000 (min<sup>-1</sup>) 以下  
 < Be used under the machine of RPM = 10000 (min<sup>-1</sup>) >

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		鋁合金 : Aluminum Alloy 5052 / 6061 / 7075					
冷卻方式 Coolant Type		溼式切削 Wet 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 <sup>-1</sup> )	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
DC0603	20	175	9000~9500	800~1200	0.05~0.15	6	溝銼 (Slotting)
DC0603	20	185	9500~10000	1600~2000	0.5	6	溝銼 (Slotting)
DC0603	20	175	9000~9500	800~1200	6	0.05~0.15	側銼 (Side milling)
DC0603	20	185	9500~10000	1800~2200	6	0.5	側銼 (Side milling)
DC0603	20	175	9000~9500	600~800	12	0.05~0.15	側銼 (Side milling)
DC0603	20	185	9500~10000	1200~1600	12	0.5	側銼 (Side milling)
DC0803	25	230	8800~9300	1000~1400	0.05~0.15	8	溝銼 (Slotting)
DC0803	25	230	8800~9300	1800~2200	0.5	8	溝銼 (Slotting)
DC0803	25	230	8800~9300	1000~1400	8	0.05~0.15	側銼 (Side milling)
DC0803	25	230	8800~9300	2000~2400	8	0.5	側銼 (Side milling)
DC0803	25	230	8800~9300	800~1200	8	1	側銼 (Side milling)
DC0803	25	230	8800~9300	800~1200	16	0.05~0.15	側銼 (Side milling)
DC0803	25	230	8800~9300	1400~1800	16	0.5	側銼 (Side milling)
DC1003	30	285	8800~9300	1000~1400	0.05~0.15	10	溝銼 (Slotting)
DC1003	30	285	8800~9300	2000~2400	0.5	10	溝銼 (Slotting)
DC1003	30	285	8800~9300	1000~1400	10	0.05~0.15	側銼 (Side milling)
DC1003	30	285	8800~9300	1600~2000	10	0.5~1	側銼 (Side milling)
DC1003	30	285	8800~9300	1000~1400	10	1.5~2	側銼 (Side milling)
DC1003	30	285	8800~9300	800~1200	20	0.05~0.15	側銼 (Side milling)
DC1003	30	285	8800~9300	600~1000	20	0.5~1	側銼 (Side milling)
DC1203	35	275	7000~7500	800~1200	0.05~0.15	12	溝銼 (Slotting)
DC1203	35	275	7000~7500	1600~2000	0.5	12	溝銼 (Slotting)
DC1203	35	275	7000~7500	1000~1400	12	0.05~0.15	側銼 (Side milling)
DC1203	35	275	7000~7500	1600~2000	12	0.5	側銼 (Side milling)
DC1203	35	275	7000~7500	1200~1600	12	1~1.5	側銼 (Side milling)
DC1203	35	275	7000~7500	800~1200	24	0.05~0.15	側銼 (Side milling)
DC1203	35	275	7000~7500	800~1200	24	1~1.5	側銼 (Side milling)

# DC 3T

建議機器轉速 RPM = 10000 (min<sup>-1</sup>) 以下  
 < Be used under the machine of RPM = 10000 (min<sup>-1</sup>) >

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material	鋁合金 : Aluminum Alloy 5052 / 6061 / 7075						
冷卻方式 Coolant Type	溼式切削 Wet 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 <sup>-1</sup> )	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
DC1603	55	265	5000~5500	600~1000	0.05~0.15	16	溝銑 (Slotting)
DC1603	55	265	5000~5500	1000~1400	0.5	16	溝銑 (Slotting)
DC1603	55	265	5000~5500	600~1000	16	0.05~0.15	側銑 (Side milling)
DC1603	55	265	5000~5500	1000~1400	16	0.5	側銑 (Side milling)
DC1603	55	265	5000~5500	400~800	32	0.05~0.15	側銑 (Side milling)
DC1603	55	265	5000~5500	300~700	32	0.5	側銑 (Side milling)

# DBC

建議機器轉速 RPM = 10000 (min<sup>-1</sup>) 以下  
 < Be used under the machine of RPM = 10000 (min<sup>-1</sup>) >

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		鋁合金 : Aluminum Alloy 5052 / 6061 / 7075					
冷卻方式 Coolant Type		溼式切削 Wet 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 <sup>-1</sup> )	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
DBC0102	10	30	9500~10000	600~1000	0.08~0.11	0.15~0.18	3D 銑 (3D milling)
DBC0102	10	30	9500~10000	1000~1400	0.03~0.05	0.05~0.08	3D 銑 (3D milling)
DBC0152	12	45	9500~10000	800~1200	0.08~0.11	0.15~0.18	3D 銑 (3D milling)
DBC0152	12	45	9500~10000	1200~1600	0.03~0.05	0.05~0.08	3D 銑 (3D milling)
DBC0202	12	60	9000~9500	1000~1400	0.1~0.13	0.2~0.25	3D 銑 (3D milling)
DBC0202	12	60	9000~9500	1600~2000	0.04~0.06	0.06~0.1	3D 銑 (3D milling)
DBC0302	14	85	9000~9500	1100~1500	0.12~0.15	0.23~0.28	3D 銑 (3D milling)
DBC0302	14	85	9000~9500	1800~2200	0.05~0.07	0.8~0.12	3D 銑 (3D milling)
DBC0402	14	115	9000~9500	1400~1800	0.15~0.18	0.3~0.4	3D 銑 (3D milling)
DBC0402	14	115	9000~9500	1800~2200	0.06~0.08	0.1~0.13	3D 銑 (3D milling)
DBC0602	20	160	8500~9000	1400~1800	0.2~0.25	0.4~0.5	3D 銑 (3D milling)
DBC0602	20	170	9000~9500	1800~2200	0.08~0.1	0.12~0.15	3D 銑 (3D milling)
DBC0802	25	200	8000~8500	1600~2000	0.25~0.3	0.5~0.6	3D 銑 (3D milling)
DBC0802	25	230	9000~9500	2000~2400	0.08~0.13	0.15~0.2	3D 銑 (3D milling)
DBC1002	35	255	8000~8500	1600~2000	0.3~0.35	0.7~0.8	3D 銑 (3D milling)
DBC1002	35	285	9000~9500	2000~2400	0.1~0.15	0.18~0.23	3D 銑 (3D milling)
DBC1202	40	290	7700~8200	1600~2000	0.4~0.45	0.8~1	3D 銑 (3D milling)
DBC1202	40	290	7700~8200	2000~2400	0.13~0.16	0.2~0.25	3D 銑 (3D milling)

# DBC

建議機器轉速 RPM = 20000 (min<sup>-1</sup>) 以下  
 < Be used under the machine of RPM = 20000 (min<sup>-1</sup>) >

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		鋁合金 : Aluminum Alloy 5052 / 6061 / 7075					
冷卻方式 Coolant Type		溼式切削 Wet 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 <sup>-1</sup> )	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
DBC0102	10	65	19000~20000	800~1200	0.08~0.11	0.15~0.18	3D 銑 (3D milling)
DBC0102	10	65	19000~20000	1200~1600	0.03~0.05	0.05~0.08	3D 銑 (3D milling)
DBC0152	12	90	18000~19000	1000~1400	0.08~0.11	0.15~0.18	3D 銑 (3D milling)
DBC0152	12	90	18000~19000	1400~1800	0.03~0.05	0.05~0.08	3D 銑 (3D milling)
DBC0202	12	120	18000~19000	1200~1600	0.1~0.13	0.2~0.25	3D 銑 (3D milling)
DBC0202	12	120	18000~19000	1800~2200	0.04~0.06	0.06~0.1	3D 銑 (3D milling)
DBC0302	14	160	17000~18000	1300~1700	0.12~0.15	0.23~0.28	3D 銑 (3D milling)
DBC0302	14	160	17000~18000	2000~2400	0.05~0.07	0.8~0.12	3D 銑 (3D milling)
DBC0402	14	200	16000~17000	1600~2000	0.15~0.18	0.3~0.4	3D 銑 (3D milling)
DBC0402	14	200	16000~17000	2000~2400	0.06~0.08	0.1~0.13	3D 銑 (3D milling)
DBC0602	20	285	15000~16000	1600~2000	0.2~0.25	0.4~0.5	3D 銑 (3D milling)
DBC0602	20	285	15000~16000	2000~2400	0.08~0.1	0.12~0.15	3D 銑 (3D milling)
DBC0802	25	330	13000~14000	2000~2400	0.25~0.3	0.5~0.6	3D 銑 (3D milling)
DBC0802	25	330	13000~14000	2400~2800	0.08~0.13	0.15~0.2	3D 銑 (3D milling)
DBC1002	35	380	12000~13000	2000~2400	0.3~0.35	0.7~0.8	3D 銑 (3D milling)
DBC1002	35	380	12000~13000	2400~2800	0.1~0.15	0.18~0.23	3D 銑 (3D milling)
DBC1202	40	415	11000~12000	2000~2400	0.4~0.45	0.8~1	3D 銑 (3D milling)
DBC1202	40	415	11000~12000	2400~2800	0.13~0.16	0.2~0.25	3D 銑 (3D milling)

# DB 4T

## 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 / N0.35 / A570 Gr.45 (~HRC22)					
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 <sup>-1</sup> )	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
DB0104	10	60	18000~20000	800~1200	0.06~0.08	0.12~0.16	3D 銑 (3D milling)
DB0104	10	60	18000~20000	1100~1500	0.02~0.04	0.04~0.08	3D 銑 (3D milling)
DB0154	10	90	18000~20000	800~1200	0.07~0.09	0.14~0.18	3D 銑 (3D milling)
DB0154	10	90	18000~20000	1100~1500	0.03~0.05	0.06~0.1	3D 銑 (3D milling)
DB0204	12	120	18000~20000	800~1200	0.07~0.09	0.14~0.18	3D 銑 (3D milling)
DB0204	12	120	18000~20000	1100~1500	0.03~0.05	0.06~0.1	3D 銑 (3D milling)
DB0304	13	150	16000~17000	800~1200	0.1~0.12	0.2~0.24	3D 銑 (3D milling)
DB0304	13	150	16000~17000	1100~1500	0.05~0.07	0.1~0.14	3D 銑 (3D milling)
DB0404	15	190	15000~16000	800~1200	0.11~0.13	0.22~0.26	3D 銑 (3D milling)
DB0404	15	190	15000~16000	1200~1600	0.06~0.08	0.14~0.22	3D 銑 (3D milling)
DB0504	18	220	14000~15000	800~1200	0.13~0.16	0.26~0.32	3D 銑 (3D milling)
DB0504	18	220	14000~15000	1200~1600	0.07~0.09	0.14~0.18	3D 銑 (3D milling)
DB0604	20	245	13000~14000	1100~1500	0.15~0.2	0.3~0.4	3D 銑 (3D milling)
DB0604	20	245	13000~14000	1400~1800	0.07~0.11	0.14~0.22	3D 銑 (3D milling)
DB0804	25	305	12000~13000	1100~1500	0.18~0.23	0.36~0.46	3D 銑 (3D milling)
DB0804	25	305	12000~13000	1500~1900	0.08~0.13	0.16~0.26	3D 銑 (3D milling)
DB1004	35	285	8700~9200	1100~1500	0.23~0.28	0.46~0.56	3D 銑 (3D milling)
DB1004	35	285	8700~9200	1500~1900	0.1~0.15	0.2~0.3	3D 銑 (3D milling)
DB1204	40	265	7000~8000	1100~1500	0.27~0.32	0.54~0.64	3D 銑 (3D milling)
DB1204	40	265	7000~8000	1500~1900	0.15~0.2	0.3~0.4	3D 銑 (3D milling)
DB1604	50	255	5000~6000	900~1200	0.35~0.4	0.7~0.8	3D 銑 (3D milling)
DB1604	50	255	5000~6000	1200~1600	0.18~0.23	0.36~0.46	3D 銑 (3D milling)

# DB 4T

## 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 (Hrc 36~45)					
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 <sup>-1</sup> )	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
DB0104	10	50	16000~17000	400~700	0.06~0.08	0.12~0.16	3D 銑 (3D milling)
DB0104	10	50	16000~17000	700~1000	0.02~0.04	0.04~0.08	3D 銑 (3D milling)
DB0154	10	80	16000~17000	400~700	0.07~0.09	0.14~0.18	3D 銑 (3D milling)
DB0154	10	80	16000~17000	700~1000	0.03~0.05	0.06~0.1	3D 銑 (3D milling)
DB0204	12	100	15000~16000	400~700	0.07~0.09	0.14~0.18	3D 銑 (3D milling)
DB0204	12	100	15000~16000	700~1000	0.03~0.05	0.06~0.1	3D 銑 (3D milling)
DB0304	13	135	14000~15000	400~700	0.09~0.11	0.18~0.22	3D 銑 (3D milling)
DB0304	13	135	14000~15000	700~1000	0.04~0.06	0.08~0.12	3D 銑 (3D milling)
DB0404	15	170	13000~14000	500~800	0.11~0.13	0.22~0.26	3D 銑 (3D milling)
DB0404	15	170	13000~14000	1000~1400	0.06~0.08	0.14~0.22	3D 銑 (3D milling)
DB0504	18	195	12000~13000	600~900	0.11~0.13	0.22~0.26	3D 銑 (3D milling)
DB0504	18	195	12000~13000	1000~1400	0.06~0.08	0.14~0.22	3D 銑 (3D milling)
DB0604	20	215	11000~12000	700~1000	0.15~0.18	0.3~0.36	3D 銑 (3D milling)
DB0604	20	215	11000~12000	1100~1500	0.07~0.11	0.14~0.22	3D 銑 (3D milling)
DB0804	25	240	9000~10000	900~1200	0.15~0.2	0.3~0.4	3D 銑 (3D milling)
DB0804	25	240	9000~10000	1200~1600	0.08~0.12	0.16~0.24	3D 銑 (3D milling)
DB1004	35	235	7000~8000	900~1200	0.2~0.25	0.4~0.5	3D 銑 (3D milling)
DB1004	35	235	7000~8000	1200~1600	0.1~0.15	0.2~0.3	3D 銑 (3D milling)
DB1204	40	190	5000~6000	800~1100	0.27~0.32	0.54~0.64	3D 銑 (3D milling)
DB1204	40	190	5000~6000	1200~1600	0.15~0.2	0.3~0.4	3D 銑 (3D milling)
DB1604	50	255	4500~5500	600~900	0.3~0.35	0.6~0.7	3D 銑 (3D milling)
DB1604	50	255	4500~5500	1000~1300	0.15~0.23	0.36~0.46	3D 銑 (3D milling)