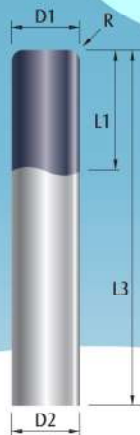


超微粒圓鼻角立銑刀 End Mills

經濟型系列
Economy Series

Corner Radius

	乾式切削 Dry Machining
	油霧切削 MQL (Mist)
	水溶性切削 Emulsion Machining
	油性切削 Oil Machining
	精銑 Finishing
	中銑 Semi-finishing
	粗銑 Roughing



產品規格 / SPECIFICATIONS

型號 Type No.	D1 直徑 Diameter	R R角 Corner R	L1 刃長 Flute Length	L3 全長 O.A.L.	D2 柄徑 Shank Dia.
DRA0205	2.0	0.5	6	50	4
DRA0305	3.0	0.5	8	50	3
DRA0405	4.0	0.5	10	50	4
DRA0410	4.0	1.0	10	50	4
DRA0505	5.0	0.5	13	50	6
DRA0510	5.0	1.0	13	50	6
DRA0605	6.0	0.5	16	50	6
DRA0610	6.0	1.0	16	50	6
DRA0805	8.0	0.5	19	60	8
DRA0810	8.0	1.0	19	60	8
DRA1005	10.0	0.5	25	75	10
DRA1010	10.0	1.0	25	75	10
DRA1015	10.0	1.5	25	75	10
DRA1020	10.0	2.0	25	75	10
DRA1210	12.0	1.0	30	75	12
DRA1220	12.0	2.0	30	75	12

unit : mm

直徑 D1	R公差值 R Tolerance	直徑公差值 D1 Tolerance	柄徑 D2	柄徑公差值 D2 Tolerance
2.0	-0.02 0	0 -0.02	Ø3	0 -0.006
3.0	-0.02 0	0 -0.02	Ø4	0 -0.008
4.0	-0.02 0	0 -0.02	Ø6	0 -0.008
5.0	-0.02 0	0 -0.02	Ø8	0 -0.009
6.0	-0.02 0	0 -0.025	Ø10	0 -0.009
8.0	-0.02 0	0 -0.03	Ø12	0 -0.011
10.0	-0.02 0	0 -0.035		
12.0	-0.02 0	0 -0.035		

unit : mm

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 ⁻¹)	進給速度 Feed (mm/min)	加工深度 (Aa) Depth of Cut	加工寬度 (Ap) Width of Cut	加工方式 Milling Type
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 ⁻¹)	進給速度 Feed (mm/min)	加工深度 (Aa) Depth of Cut	加工寬度 (Ap) Width of Cut	加工方式 Milling Type
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 ⁻¹)	進給速度 Feed (mm/min)	加工深度 (Aa) Depth of Cut	加工寬度 (Ap) Width of Cut	加工方式 Milling Type
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 ⁻¹)	進給速度 Feed (mm/min)	加工深度 (Aa) Depth of Cut	加工寬度 (Ap) Width of Cut	加工方式 Milling Type
DRA1220	40	75	2000~2500	800~1100	0.2~0.25	7~12	溝銑 (Slotting)
DRA1220	40	150	4000~4500	800~1000	0.05~0.12	7~12	溝銑 (Slotting)
DRA1220	40	105	2800~3200	600~800	12~24	0.2~0.25	側銑 (Side milling)
DRA1220	40	105	2800~3200	400~600	12~24	0.05~0.12	側銑 (Side milling)
DRA1220	40	150	4000~4500	1400~1600	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DRA1220	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 ⁻¹)	進給速度 Feed (mm/min)	加工深度 (Aa) Depth of Cut	加工寬度 (Ap) Width of Cut	加工方式 Milling Type
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 ⁻¹)	進給速度 Feed (mm/min)	加工深度 (Aa) Depth of Cut	加工寬度 (Ap) Width of Cut	加工方式 Milling Type
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 ⁻¹)	進給速度 Feed (mm/min)	加工深度 (Aa) Depth of Cut	加工寬度 (Ap) Width of Cut	加工方式 Milling Type
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 ⁻¹)	進給速度 Feed (mm/min)	加工深度 (Aa) Depth of Cut	加工寬度 (Ap) Width of Cut	加工方式 Milling Type
DRA1220	40	75	2000~2400	700~1000	0.2~0.25	7~12	溝銑 (Slotting)
DRA1220	40	145	3800~4200	800~1000	0.05~0.12	7~12	溝銑 (Slotting)
DRA1220	40	70	1800~2200	600~800	12~24	0.2~0.25	側銑 (Side milling)
DRA1220	40	70	1800~2200	400~600	12~24	0.05~0.12	側銑 (Side milling)
DRA1220	40	140	3600~4000	1200~1400	0.2~0.25	0.2~0.25	3D 銑 (3D milling)
DRA1220	40	150	4500~5000	1300~1600	0.05~0.12	0.05~0.12	3D 銑 (3D milling)