

產品規格表 **P105-106**
Specification page

● P-UCRS 2 Flutes Cutting Condition 標準切削

| Working material hardness 被切削材硬度 | ~HRC30 | | ~HRC50 | | ~HRC60 | |
|-------------------------------------|----------------------------|---------------------|------------------------|---------------------|------------------------|---------------------|
| | Rotational speed 轉速 | Feeding speed 進給 | Rotational speed 轉速 | Feeding speed 進給 | Rotational speed 轉速 | Feeding speed 進給 |
| | Diameter × Radius D × R | RPM 轉/分 | mm/min. mm/分 | RPM 轉/分 | mm/min. mm/分 | RPM 轉/分 |
| D1.0 x 0.1R | 15840 | 784 | 11600 | 520 | 7840 | 360 |
| D1.0 x 0.2R | 15840 | 784 | 11600 | 520 | 7840 | 360 |
| D1.0 x 0.3R | 15840 | 784 | 11600 | 520 | 7840 | 360 |
| D1.5 x 0.2R | 14000 | 960 | 11040 | 560 | 6800 | 400 |
| D1.5 x 0.3R | 14000 | 960 | 11040 | 560 | 6800 | 400 |
| D2.0 x 0.1R | 12800 | 1200 | 10080 | 720 | 4760 | 400 |
| D2.0 x 0.2R | 12800 | 1200 | 10080 | 720 | 5760 | 400 |
| D2.0 x 0.3R | 12800 | 1200 | 10080 | 720 | 5760 | 400 |
| D3.0 x 0.1R | 9100 | 1260 | 6860 | 840 | 5250 | 350 |
| D3.0 x 0.2R | 9100 | 1260 | 6860 | 840 | 5250 | 350 |
| D3.0 x 0.3R | 9100 | 1260 | 6860 | 840 | 5250 | 350 |
| D4.0 x 0.2R | 8750 | 1400 | 6860 | 735 | 4760 | 350 |
| D4.0 x 0.3R | 8750 | 1400 | 6510 | 735 | 4760 | 350 |
| D2.0 x 0.5R | 11200 | 840 | 9100 | 630 | 6440 | 420 |
| D3.0 x 0.5R | 9100 | 1400 | 6860 | 1050 | 5250 | 350 |
| D4.0 x 0.5R | 8750 | 1400 | 6510 | 735 | 4760 | 350 |
| D6.0 x 0.5R | 8050 | 2100 | 6160 | 1400 | 3220 | 525 |
| D8.0 x 0.5R | 6055 | 2380 | 3745 | 1190 | 2695 | 574 |
| D10.0 x 0.5R | 3850 | 1960 | 2240 | 770 | 1155 | 406 |
| D12.0 x 0.5R | 3255 | 2030 | 1540 | 665 | 910 | 371 |
| D3.0 x 1R | 10465 | 1610 | 7889 | 1208 | 6038 | 403 |
| D4.0 x 1R | 10063 | 1610 | 7487 | 846 | 5474 | 403 |
| D6.0 x 1R | 9258 | 2415 | 7084 | 1610 | 3703 | 604 |
| D8.0 x 1R | 6964 | 2737 | 4307 | 1369 | 3100 | 660 |
| D10.0 x 1R | 4428 | 2240 | 2576 | 886 | 1329 | 467 |
| D12.0 x 1R | 3744 | 2335 | 1771 | 998 | 1047 | 427 |
| D6.0 x 1.5R | 9660 | 2520 | 7392 | 1680 | 3864 | 630 |
| D8.0 x 1.5R | 7266 | 2856 | 4494 | 1428 | 3234 | 689 |
| D10.0 x 1.5R | 4620 | 2352 | 2688 | 924 | 1386 | 487 |
| D12.0 x 1.5R | 3906 | 2436 | 1848 | 798 | 1092 | 445 |
| D6.0 x 2R | 10465 | 2730 | 8008 | 1820 | 4186 | 683 |
| D8.0 x 2R | 7872 | 3094 | 4869 | 1547 | 3504 | 746 |
| D10.0 x 2R | 5005 | 2548 | 2945 | 1001 | 1502 | 528 |
| D12.0 x 2R | 4232 | 2639 | 5005 | 865 | 1183 | 482 |
| D8.0 x 3R | 8175 | 3213 | 5056 | 1607 | 3640 | 775 |
| D10.0 x 3R | 5198 | 2646 | 3024 | 1040 | 1560 | 548 |
| D12.0 x 3R | 4395 | 2741 | 2079 | 898 | 1229 | 501 |