DHF ITALIA

MICRO DIAMETER
LONG NECK SERIES

Guide Lines to Icons

All series good at high speed cutting.

Carbide

Micro grain.

Super micro grain.

Grain Size

Grain size is 0.2 µm.

Grain size is 0.4 µm.

Grain size is 0.6 µm.

Helix Angle

Helix Angle is 15°, 30°, 35°.

Flute

Work Material Hardness

Work material hardness is up to HRC60, HRC65.

Coating

Good at high speed cutting & high hard cutting.
For Dry cutting, MQL and Wet cutting.

Good at high speed cutting & high hard cutting.
For Dry cutting and MQL.

Good at difficult material, for Dry & Wet cutting.

Conner R

Conner Radius.

Shrink Neck

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DHF Italia srl
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MBTA MILLING CONDITIONS

DHF ITALIA

Work Material	*Prehardened Steels* : **NAK80, 1.2083** (HRc38)					
Coolant Type	Wet coolant					
Type No.	Extension Length (mm)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_p) Width of Cut	Milling Type
MBTA0032	10	24000~26000	400~600	0.015~0.02	0.3	SLOTTING
MBTA0032	10	24000~26000	500~700	0.01~0.015	0.3	SLOTTING
MBTA0032	10	24000~26000	500~600	0.015~0.02	0.04	3D MILLING
MBTA0032	10	24000~26000	600~700	0.01~0.015	0.02	3D MILLING
MBTA0042	10	23000~25000	400~600	0.015~0.025	0.4	SLOTTING
MBTA0042	10	23000~25000	500~700	0.015~0.02	0.4	SLOTTING
MBTA0042	10	23000~25000	500~700	0.015~0.025	0.05	3D MILLING
MBTA0042	10	23000~25000	600~800	0.015~0.02	0.03	3D MILLING
MBTA0052	10	23000~25000	500~700	0.02~0.03	0.5	SLOTTING
MBTA0052	10	23000~25000	650~850	0.015~0.02	0.5	SLOTTING
MBTA0052	10	23000~25000	650~850	0.02~0.03	0.06	3D MILLING
MBTA0052	10	23000~25000	700~800	0.015~0.02	0.04	3D MILLING
MBTA0062	10	22000~24000	550~750	0.04~0.06	0.6	SLOTTING
MBTA0062	10	22000~24000	700~900	0.025~0.035	0.6	SLOTTING
MBTA0062	10	22000~24000	700~900	0.03~0.04	0.1	3D MILLING
MBTA0062	10	22000~24000	800~1000	0.025~0.035	0.05	3D MILLING
MBTA0072	10	22000~24000	650~800	0.05~0.07	0.7	SLOTTING
MBTA0072	10	22000~24000	900~1200	0.03~0.04	0.7	SLOTTING
MBTA0072	10	22000~24000	800~1000	0.05~0.07	0.14	3D MILLING
MBTA0072	10	22000~24000	1200~1400	0.03~0.04	0.08	3D MILLING
MBTA0082	10	21000~23000	750~950	0.05~0.07	0.8	SLOTTING
MBTA0082	10	21000~23000	1000~1300	0.03~0.04	0.8	SLOTTING
MBTA0082	10	21000~23000	1000~1200	0.05~0.07	0.14	3D MILLING
MBTA0082	10	21000~23000	1200~1400	0.03~0.04	0.08	3D MILLING
MBTA0102	10	18000~20000	900~1100	0.06~0.07	1	SLOTTING
MBTA0102	10	18000~20000	1300~1500	0.04~0.05	1	SLOTTING
MBTA0102	10	18000~20000	1300~1500	0.06~0.07	0.14	3D MILLING
MBTA0102	10	18000~20000	1600~1800	0.03~0.05	0.1	3D MILLING
MBTA0122	10	18000~20000	900~1100	0.06~0.08	1.2	SLOTTING
MBTA0122	10	18000~20000	1300~1500	0.04~0.05	1.2	SLOTTING
MBTA0122	10	18000~20000	1300~1500	0.06~0.08	0.16	3D MILLING
MBTA0122	10	18000~20000	1800~2200	0.03~0.05	0.1	3D MILLING
MBTA0142	10	18000~20000	1000~1200	0.06~0.08	1.4	SLOTTING
MBTA0142	10	18000~20000	1400~1600	0.04~0.05	1.4	SLOTTING
MBTA0142	10	18000~20000	1400~1600	0.07~0.09	0.18	3D MILLING
MBTA0142	10	18000~20000	2000~2300	0.04~0.05	0.1	3D MILLING
MBTA0162	10	16000~18000	1000~1200	0.07~0.09	1.6	SLOTTING
MBTA0162	10	16000~18000	1800~2200	0.04~0.05	1.6	SLOTTING
MBTA0162	10	16000~18000	1400~1600	0.08~0.1	0.2	3D MILLING
MBTA0162	10	16000~18000	2000~2400	0.04~0.05	0.1	3D MILLING
MBTA0182	10	15000~17000	1100~1300	0.08~0.1	1.8	SLOTTING
MBTA0182	10	15000~17000	2000~2400	0.04~0.05	1.8	SLOTTING
MBTA0182	10	15000~17000	1500~1700	0.1~0.12	0.24	3D MILLING
MBTA0182	10	15000~17000	2400~2600	0.05~0.06	0.12	3D MILLING
MBTA0202	11	14000~16000	1100~1400	0.08~0.1	2	SLOTTING
MBTA0202	11	14000~16000	2200~2600	0.04~0.06	2	SLOTTING
MBTA0202	11	14000~16000	1600~1800	0.1~0.12	0.24	3D MILLING
MBTA0202	11	14000~16000	2400~2700	0.05~0.07	0.14	3D MILLING
MBTA0302	13	13000~15000	1100~1400	0.12~0.15	3	SLOTTING
MBTA0302	13	13000~15000	2500~3000	0.05~0.07	3	SLOTTING
MBTA0302	13	13000~15000	1600~1800	0.13~0.15	0.3	3D MILLING
MBTA0302	13	13000~15000	2800~3000	0.06~0.08	0.16	3D MILLING
MBTA0402	15	13000~15000	1100~1400	0.15~0.18	4	SLOTTING
MBTA0402	15	13000~15000	2600~3000	0.05~0.07	4	SLOTTING
MBTA0402	15	13000~15000	1600~2000	0.14~0.16	0.32	3D MILLING
MBTA0402	15	13000~15000	2800~3200	0.06~0.09	0.18	3D MILLING

MBTA MILLING CONDITIONS

DHF ITALIA

Work Material	*Prehardened Steels :* **NAK80, 1.2083** (HRc38)				
Coolant Type	Wet coolant				
Type No.	Extension Length (mm)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_p) Width of Cut	Milling Type
MBTA0032	10	17000~18000	400~600	0.015~0.02	0.3	SLOTTING
MBTA0032	10	17000~18000	500~700	0.01~0.015	0.3	SLOTTING
MBTA0032	10	17000~18000	500~600	0.015~0.02	0.04	3D MILLING
MBTA0032	10	17000~18000	600~700	0.01~0.015	0.02	3D MILLING
MBTA0042	10	17000~18000	400~600	0.015~0.025	0.4	SLOTTING
MBTA0042	10	17000~18000	500~700	0.015~0.02	0.4	SLOTTING
MBTA0042	10	17000~18000	500~700	0.015~0.025	0.05	3D MILLING
MBTA0042	10	17000~18000	600~800	0.015~0.02	0.03	3D MILLING
MBTA0052	10	17000~18000	500~700	0.02~0.03	0.5	SLOTTING
MBTA0052	10	17000~18000	650~850	0.015~0.02	0.5	SLOTTING
MBTA0052	10	17000~18000	650~850	0.02~0.03	0.06	3D MILLING
MBTA0052	10	17000~18000	700~800	0.015~0.02	0.04	3D MILLING
MBTA0062	10	17000~18000	550~750	0.04~0.06	0.6	SLOTTING
MBTA0062	10	17000~18000	700~900	0.025~0.035	0.6	SLOTTING
MBTA0062	10	17000~18000	700~900	0.03~0.04	0.1	3D MILLING
MBTA0062	10	17000~18000	800~1000	0.025~0.035	0.05	3D MILLING
MBTA0072	10	17000~18000	650~800	0.05~0.07	0.7	SLOTTING
MBTA0072	10	17000~18000	900~1200	0.03~0.04	0.7	SLOTTING
MBTA0072	10	17000~18000	800~1000	0.05~0.07	0.14	3D MILLING
MBTA0072	10	17000~18000	1200~1400	0.03~0.04	0.08	3D MILLING
MBTA0082	10	17000~18000	750~950	0.05~0.07	0.8	SLOTTING
MBTA0082	10	17000~18000	1000~1300	0.03~0.04	0.8	SLOTTING
MBTA0082	10	17000~18000	1000~1200	0.05~0.07	0.14	3D MILLING
MBTA0082	10	17000~18000	1200~1400	0.03~0.04	0.08	3D MILLING
MBTA0102	10	16000~17000	900~1100	0.06~0.07	1	SLOTTING
MBTA0102	10	16000~17000	1300~1500	0.04~0.05	1	SLOTTING
MBTA0102	10	16000~17000	1300~1500	0.06~0.07	0.14	3D MILLING
MBTA0102	10	16000~17000	1600~1800	0.03~0.05	0.1	3D MILLING
MBTA0122	10	16000~17000	900~1100	0.06~0.08	1.2	SLOTTING
MBTA0122	10	16000~17000	1300~1500	0.04~0.05	1.2	SLOTTING
MBTA0122	10	16000~17000	1300~1500	0.06~0.08	0.16	3D MILLING
MBTA0122	10	16000~17000	1800~2200	0.03~0.05	0.1	3D MILLING
MBTA0142	10	16000~17000	1000~1200	0.06~0.08	1.4	SLOTTING
MBTA0142	10	16000~17000	1400~1600	0.04~0.05	1.4	SLOTTING
MBTA0142	10	16000~17000	1400~1600	0.07~0.09	0.18	3D MILLING
MBTA0142	10	16000~17000	2000~2300	0.04~0.05	0.1	3D MILLING
MBTA0162	10	16000~17000	1000~1200	0.07~0.09	1.6	SLOTTING
MBTA0162	10	16000~17000	1800~2200	0.04~0.05	1.6	SLOTTING
MBTA0162	10	16000~17000	1400~1600	0.08~0.1	0.2	3D MILLING
MBTA0162	10	16000~17000	2000~2400	0.04~0.05	0.1	3D MILLING
MBTA0182	10	15000~17000	1100~1300	0.08~0.1	1.8	SLOTTING
MBTA0182	10	15000~17000	2000~2400	0.04~0.05	1.8	SLOTTING
MBTA0182	10	15000~17000	1500~1700	0.1~0.12	0.24	3D MILLING
MBTA0182	10	15000~17000	2400~2600	0.05~0.06	0.12	3D MILLING
MBTA0202	11	14000~16000	1100~1400	0.08~0.1	2	SLOTTING
MBTA0202	11	14000~16000	2200~2600	0.04~0.06	2	SLOTTING
MBTA0202	11	14000~16000	1600~1800	0.1~0.12	0.24	3D MILLING
MBTA0202	11	14000~16000	2400~2700	0.05~0.07	0.14	3D MILLING
MBTA0302	13	13000~15000	1100~1400	0.12~0.15	3	SLOTTING
MBTA0302	13	13000~15000	2500~3000	0.05~0.07	3	SLOTTING
MBTA0302	13	13000~15000	1600~1800	0.13~0.15	0.3	3D MILLING
MBTA0302	13	13000~15000	2800~3000	0.06~0.08	0.16	3D MILLING
MBTA0402	15	12000~14000	1100~1400	0.15~0.18	4	SLOTTING
MBTA0402	15	12000~14000	2600~3000	0.05~0.07	4	SLOTTING
MBTA0402	15	12000~14000	1600~2000	0.14~0.16	0.32	3D MILLING
MBTA0402	15	12000~14000	2800~3200	0.06~0.09	0.18	3D MILLING

MSB MILLING CONDITIONS

DHF ITALIA

Work Material	*Stainless Steels :* **SUS316/1.4401, SUS304/1.4301** (HRc30)					
Coolant Type	Wet coolant					
Type No.	Extension Length (mm)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_p) Width of Cut	Milling Type
MSB0032	10	24000~26000	200~300	0.01~0.015	0.3	SLOTTING
MSB0032	10	24000~26000	250~350	0.005~0.01	0.3	SLOTTING
MSB0032	10	24000~26000	300~400	0.01~0.015	0.03	3D MILLING
MSB0032	10	24000~26000	350~450	0.005~0.01	0.02	3D MILLING
MSB0042	10	23000~25000	300~400	0.01~0.02	0.4	SLOTTING
MSB0042	10	23000~25000	350~450	0.01~0.015	0.4	SLOTTING
MSB0042	10	23000~25000	400~500	0.01~0.02	0.06	3D MILLING
MSB0042	10	23000~25000	500~600	0.01~0.015	0.03	3D MILLING
MSB0052	10	23000~25000	300~500	0.02~0.03	0.5	SLOTTING
MSB0052	10	23000~25000	500~600	0.015~0.025	0.5	SLOTTING
MSB0052	10	23000~25000	400~600	0.02~0.03	0.06	3D MILLING
MSB0052	10	23000~25000	600~800	0.015~0.025	0.06	3D MILLING
MSB0062	10	22000~24000	400~600	0.03~0.04	0.6	SLOTTING
MSB0062	10	22000~24000	600~900	0.02~0.03	0.6	SLOTTING
MSB0062	10	22000~24000	500~600	0.03~0.04	0.08	3D MILLING
MSB0062	10	22000~24000	600~800	0.02~0.03	0.06	3D MILLING
MSB0072	10	22000~24000	500~700	0.04~0.06	0.7	SLOTTING
MSB0072	10	22000~24000	800~1000	0.03~0.04	0.7	SLOTTING
MSB0072	10	22000~24000	600~800	0.04~0.06	0.12	3D MILLING
MSB0072	10	22000~24000	900~1200	0.03~0.04	0.08	3D MILLING
MSB0082	10	21000~23000	600~800	0.05~0.06	0.8	SLOTTING
MSB0082	10	21000~23000	1000~1200	0.03~0.04	0.8	SLOTTING
MSB0082	10	21000~23000	700~900	0.05~0.06	0.12	3D MILLING
MSB0082	10	21000~23000	1000~1300	0.03~0.04	0.08	3D MILLING
MSB0102	10	18000~20000	700~800	0.05~0.06	1	SLOTTING
MSB0102	10	18000~20000	1200~1400	0.04~0.05	1	SLOTTING
MSB0102	10	18000~20000	900~1100	0.05~0.07	0.14	3D MILLING
MSB0102	10	18000~20000	1300~1500	0.04~0.05	0.1	3D MILLING
MSB0122	10	18000~20000	700~800	0.05~0.06	1.2	SLOTTING
MSB0122	10	18000~20000	1300~1500	0.04~0.05	1.2	SLOTTING
MSB0122	10	18000~20000	900~1100	0.05~0.07	0.14	3D MILLING
MSB0122	10	18000~20000	1400~1600	0.04~0.05	0.1	3D MILLING
MSB0142	10	18000~20000	800~1000	0.05~0.06	1.4	SLOTTING
MSB0142	10	18000~20000	1600~1800	0.04~0.05	1.4	SLOTTING
MSB0142	10	18000~20000	1200~1400	0.05~0.07	0.14	3D MILLING
MSB0142	10	18000~20000	1800~2000	0.04~0.05	0.1	3D MILLING
MSB0162	10	16000~18000	800~1000	0.05~0.06	1.6	SLOTTING
MSB0162	10	16000~18000	1800~2000	0.04~0.05	1.6	SLOTTING
MSB0162	10	16000~18000	1300~1500	0.05~0.07	0.14	3D MILLING
MSB0162	10	16000~18000	2000~2300	0.04~0.05	0.1	3D MILLING
MSB0182	10	15000~17000	900~1100	0.06~0.08	1.8	SLOTTING
MSB0182	10	15000~17000	1800~2000	0.04~0.06	1.8	SLOTTING
MSB0182	10	15000~17000	1400~1700	0.06~0.08	0.16	3D MILLING
MSB0182	10	15000~17000	2200~2500	0.04~0.06	0.12	3D MILLING
MSB0202	11	14000~16000	1000~1200	0.06~0.08	2	SLOTTING
MSB0202	11	14000~16000	2000~2200	0.04~0.06	2	SLOTTING
MSB0202	11	14000~16000	1400~1800	0.06~0.08	0.16	3D MILLING
MSB0202	11	14000~16000	2200~2600	0.04~0.06	0.12	3D MILLING
MSB0302	13	13000~15000	1200~1400	0.08~0.1	3	SLOTTING
MSB0302	13	13000~15000	2000~2200	0.04~0.06	3	SLOTTING
MSB0302	13	13000~15000	1400~1800	0.1~0.12	0.24	3D MILLING
MSB0302	13	13000~15000	2400~2800	0.05~0.07	0.14	3D MILLING

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MSB MILLING CONDITIONS

DHF ITALIA

Work Material	*Stainless Steels :* **SUS316/1.4401, SUS304/1.4301** (HRc30)				
Coolant Type	Wet coolant				
Type No.	Extension Length (mm)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_p) Width of Cut	Milling Type
MSB0032	10	17000~18000	200~300	0.01~0.015	0.3	SLOTTING
MSB0032	10	17000~18000	250~350	0.005~0.01	0.3	SLOTTING
MSB0032	10	17000~18000	300~400	0.01~0.015	0.03	3D MILLING
MSB0032	10	17000~18000	350~450	0.005~0.01	0.02	3D MILLING
MSB0042	10	17000~18000	300~400	0.01~0.02	0.4	SLOTTING
MSB0042	10	17000~18000	350~450	0.01~0.015	0.4	SLOTTING
MSB0042	10	17000~18000	400~500	0.01~0.02	0.06	3D MILLING
MSB0042	10	17000~18000	500~600	0.01~0.015	0.03	3D MILLING
MSB0052	10	17000~18000	300~500	0.02~0.03	0.5	SLOTTING
MSB0052	10	17000~18000	500~600	0.015~0.025	0.5	SLOTTING
MSB0052	10	17000~18000	400~600	0.02~0.03	0.06	3D MILLING
MSB0052	10	17000~18000	600~800	0.015~0.025	0.06	3D MILLING
MSB0062	10	17000~18000	400~600	0.03~0.04	0.6	SLOTTING
MSB0062	10	17000~18000	600~900	0.02~0.03	0.6	SLOTTING
MSB0062	10	17000~18000	500~600	0.03~0.04	0.08	3D MILLING
MSB0062	10	17000~18000	600~800	0.02~0.03	0.06	3D MILLING
MSB0072	10	17000~18000	500~700	0.04~0.06	0.7	SLOTTING
MSB0072	10	17000~18000	800~1000	0.03~0.04	0.7	SLOTTING
MSB0072	10	17000~18000	600~800	0.04~0.06	0.12	3D MILLING
MSB0072	10	17000~18000	900~1200	0.03~0.04	0.08	3D MILLING
MSB0082	10	17000~18000	600~800	0.05~0.06	0.8	SLOTTING
MSB0082	10	17000~18000	1000~1200	0.03~0.04	0.8	SLOTTING
MSB0082	10	17000~18000	700~900	0.05~0.06	0.12	3D MILLING
MSB0082	10	17000~18000	1000~1300	0.03~0.04	0.08	3D MILLING
MSB0102	10	16000~17000	700~800	0.05~0.06	1	SLOTTING
MSB0102	10	16000~17000	1200~1400	0.04~0.05	1	SLOTTING
MSB0102	10	16000~17000	900~1100	0.05~0.07	0.14	3D MILLING
MSB0102	10	16000~17000	1300~1500	0.04~0.05	0.1	3D MILLING
MSB0122	10	16000~17000	700~800	0.05~0.06	1.2	SLOTTING
MSB0122	10	16000~17000	1300~1500	0.04~0.05	1.2	SLOTTING
MSB0122	10	16000~17000	900~1100	0.05~0.07	0.14	3D MILLING
MSB0122	10	16000~17000	1400~1600	0.04~0.05	0.1	3D MILLING
MSB0142	10	16000~17000	800~1000	0.05~0.06	1.4	SLOTTING
MSB0142	10	16000~17000	1600~1800	0.04~0.05	1.4	SLOTTING
MSB0142	10	16000~17000	1200~1400	0.05~0.07	0.14	3D MILLING
MSB0142	10	16000~17000	1800~2000	0.04~0.05	0.1	3D MILLING
MSB0162	10	16000~17000	800~1000	0.05~0.06	1.6	SLOTTING
MSB0162	10	16000~17000	1800~2000	0.04~0.05	1.6	SLOTTING
MSB0162	10	16000~17000	1300~1500	0.05~0.07	0.14	3D MILLING
MSB0162	10	16000~17000	2000~2300	0.04~0.05	0.1	3D MILLING
MSB0182	10	15000~17000	900~1100	0.06~0.08	1.8	SLOTTING
MSB0182	10	15000~17000	1800~2000	0.04~0.06	1.8	SLOTTING
MSB0182	10	15000~17000	1400~1700	0.06~0.08	0.16	3D MILLING
MSB0182	10	15000~17000	2200~2500	0.04~0.06	0.12	3D MILLING
MSB0202	11	14000~16000	1000~1200	0.06~0.08	2	SLOTTING
MSB0202	11	14000~16000	2000~2200	0.04~0.06	2	SLOTTING
MSB0202	11	14000~16000	1400~1800	0.06~0.08	0.16	3D MILLING
MSB0202	11	14000~16000	2200~2600	0.04~0.06	0.12	3D MILLING
MSB0302	13	13000~15000	1200~1400	0.08~0.1	3	SLOTTING
MSB0302	13	13000~15000	2000~2200	0.04~0.06	3	SLOTTING
MSB0302	13	13000~15000	1400~1800	0.1~0.12	0.24	3D MILLING
MSB0302	13	13000~15000	2400~2800	0.05~0.07	0.14	3D MILLING

MSB MILLING CONDITIONS

DHF ITALIA

Work Material	*Prehardened Steels* : **NAK80, 1.2083** (HRc38)					
Coolant Type	Wet coolant					
Type No.	Extension Length (mm)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_p) Width of Cut	Milling Type
MSB0032	10	24000~26000	400~600	0.015~0.02	0.3	SLOTTING
MSB0032	10	24000~26000	500~700	0.01~0.015	0.3	SLOTTING
MSB0032	10	24000~26000	500~600	0.015~0.02	0.04	3D MILLING
MSB0032	10	24000~26000	600~700	0.01~0.015	0.02	3D MILLING
MSB0042	10	23000~25000	400~600	0.015~0.025	0.4	SLOTTING
MSB0042	10	23000~25000	500~700	0.015~0.02	0.4	SLOTTING
MSB0042	10	23000~25000	500~700	0.015~0.025	0.05	3D MILLING
MSB0042	10	23000~25000	600~800	0.015~0.02	0.03	3D MILLING
MSB0052	10	23000~25000	500~700	0.02~0.03	0.5	SLOTTING
MSB0052	10	23000~25000	650~850	0.015~0.02	0.5	SLOTTING
MSB0052	10	23000~25000	650~850	0.02~0.03	0.06	3D MILLING
MSB0052	10	23000~25000	700~800	0.015~0.02	0.04	3D MILLING
MSB0062	10	22000~24000	550~750	0.04~0.06	0.6	SLOTTING
MSB0062	10	22000~24000	700~900	0.025~0.035	0.6	SLOTTING
MSB0062	10	22000~24000	700~900	0.03~0.04	0.1	3D MILLING
MSB0062	10	22000~24000	800~1000	0.025~0.035	0.05	3D MILLING
MSB0072	10	22000~24000	650~800	0.05~0.07	0.7	SLOTTING
MSB0072	10	22000~24000	900~1200	0.03~0.04	0.7	SLOTTING
MSB0072	10	22000~24000	800~1000	0.05~0.07	0.14	3D MILLING
MSB0072	10	22000~24000	1200~1400	0.03~0.04	0.08	3D MILLING
MSB0082	10	21000~23000	750~950	0.05~0.07	0.8	SLOTTING
MSB0082	10	21000~23000	1000~1300	0.03~0.04	0.8	SLOTTING
MSB0082	10	21000~23000	1000~1200	0.05~0.07	0.14	3D MILLING
MSB0082	10	21000~23000	1200~1400	0.03~0.04	0.08	3D MILLING
MSB0102	10	18000~20000	900~1100	0.06~0.07	1	SLOTTING
MSB0102	10	18000~20000	1300~1500	0.04~0.05	1	SLOTTING
MSB0102	10	18000~20000	1300~1500	0.06~0.07	0.14	3D MILLING
MSB0102	10	18000~20000	1600~1800	0.03~0.05	0.1	3D MILLING
MSB0122	10	18000~20000	900~1100	0.06~0.08	1.2	SLOTTING
MSB0122	10	18000~20000	1300~1500	0.04~0.05	1.2	SLOTTING
MSB0122	10	18000~20000	1300~1500	0.06~0.08	0.16	3D MILLING
MSB0122	10	18000~20000	1800~2200	0.03~0.05	0.1	3D MILLING
MSB0142	10	18000~20000	1000~1200	0.06~0.08	1.4	SLOTTING
MSB0142	10	18000~20000	1400~1600	0.04~0.05	1.4	SLOTTING
MSB0142	10	18000~20000	1400~1600	0.07~0.09	0.18	3D MILLING
MSB0142	10	18000~20000	2000~2300	0.04~0.05	0.1	3D MILLING
MSB0162	10	16000~18000	1000~1200	0.07~0.09	1.6	SLOTTING
MSB0162	10	16000~18000	1800~2200	0.04~0.05	1.6	SLOTTING
MSB0162	10	16000~18000	1400~1600	0.08~0.1	0.2	3D MILLING
MSB0162	10	16000~18000	2000~2400	0.04~0.05	0.1	3D MILLING
MSB0182	10	15000~17000	1100~1300	0.08~0.1	1.8	SLOTTING
MSB0182	10	15000~17000	2000~2400	0.04~0.05	1.8	SLOTTING
MSB0182	10	15000~17000	1500~1700	0.1~0.12	0.24	3D MILLING
MSB0182	10	15000~17000	2400~2600	0.05~0.06	0.12	3D MILLING
MSB0202	11	14000~16000	1100~1400	0.08~0.1	2	SLOTTING
MSB0202	11	14000~16000	2200~2600	0.04~0.06	2	SLOTTING
MSB0202	11	14000~16000	1600~1800	0.1~0.12	0.24	3D MILLING
MSB0202	11	14000~16000	2400~2700	0.05~0.07	0.14	3D MILLING
MSB0302	13	13000~15000	1100~1400	0.12~0.15	3	SLOTTING
MSB0302	13	13000~15000	2500~3000	0.05~0.07	3	SLOTTING
MSB0302	13	13000~15000	1600~1800	0.13~0.15	0.3	3D MILLING
MSB0302	13	13000~15000	2800~3000	0.06~0.08	0.16	3D MILLING

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MSB MILLING CONDITIONS

DHF ITALIA

Work Material	*Prehardened Steels* : **NAK80, 1.2083** (HRc38)				
Coolant Type	Wet coolant				
Type No.	Extension Length (mm)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_p) Width of Cut	Milling Type
MSB0032	10	17000~18000	400~600	0.015~0.02	0.3	SLOTTING
MSB0032	10	17000~18000	500~700	0.01~0.015	0.3	SLOTTING
MSB0032	10	17000~18000	500~600	0.015~0.02	0.04	3D MILLING
MSB0032	10	17000~18000	600~700	0.01~0.015	0.02	3D MILLING
MSB0042	10	17000~18000	400~600	0.015~0.025	0.4	SLOTTING
MSB0042	10	17000~18000	500~700	0.015~0.02	0.4	SLOTTING
MSB0042	10	17000~18000	500~700	0.015~0.025	0.05	3D MILLING
MSB0042	10	17000~18000	600~800	0.015~0.02	0.03	3D MILLING
MSB0052	10	17000~18000	500~700	0.02~0.03	0.5	SLOTTING
MSB0052	10	17000~18000	650~850	0.015~0.02	0.5	SLOTTING
MSB0052	10	17000~18000	650~850	0.02~0.03	0.06	3D MILLING
MSB0052	10	17000~18000	700~800	0.015~0.02	0.04	3D MILLING
MSB0062	10	17000~18000	550~750	0.04~0.06	0.6	SLOTTING
MSB0062	10	17000~18000	700~900	0.025~0.035	0.6	SLOTTING
MSB0062	10	17000~18000	700~900	0.03~0.04	0.1	3D MILLING
MSB0062	10	17000~18000	800~1000	0.025~0.035	0.05	3D MILLING
MSB0072	10	17000~18000	650~800	0.05~0.07	0.7	SLOTTING
MSB0072	10	17000~18000	900~1200	0.03~0.04	0.7	SLOTTING
MSB0072	10	17000~18000	800~1000	0.05~0.07	0.14	3D MILLING
MSB0072	10	17000~18000	1200~1400	0.03~0.04	0.08	3D MILLING
MSB0082	10	17000~18000	750~950	0.05~0.07	0.8	SLOTTING
MSB0082	10	17000~18000	1000~1300	0.03~0.04	0.8	SLOTTING
MSB0082	10	17000~18000	1000~1200	0.05~0.07	0.14	3D MILLING
MSB0082	10	17000~18000	1200~1400	0.03~0.04	0.08	3D MILLING
MSB0102	10	16000~17000	900~1100	0.06~0.07	1	SLOTTING
MSB0102	10	16000~17000	1300~1500	0.04~0.05	1	SLOTTING
MSB0102	10	16000~17000	1300~1500	0.06~0.07	0.14	3D MILLING
MSB0102	10	16000~17000	1600~1800	0.03~0.05	0.1	3D MILLING
MSB0122	10	16000~17000	900~1100	0.06~0.08	1.2	SLOTTING
MSB0122	10	16000~17000	1300~1500	0.04~0.05	1.2	SLOTTING
MSB0122	10	16000~17000	1300~1500	0.06~0.08	0.16	3D MILLING
MSB0122	10	16000~17000	1800~2200	0.03~0.05	0.1	3D MILLING
MSB0142	10	16000~17000	1000~1200	0.06~0.08	1.4	SLOTTING
MSB0142	10	16000~17000	1400~1600	0.04~0.05	1.4	SLOTTING
MSB0142	10	16000~17000	1400~1600	0.07~0.09	0.18	3D MILLING
MSB0142	10	16000~17000	2000~2300	0.04~0.05	0.1	3D MILLING
MSB0162	10	16000~17000	1000~1200	0.07~0.09	1.6	SLOTTING
MSB0162	10	16000~17000	1800~2200	0.04~0.05	1.6	SLOTTING
MSB0162	10	16000~17000	1400~1600	0.08~0.1	0.2	3D MILLING
MSB0162	10	16000~17000	2000~2400	0.04~0.05	0.1	3D MILLING
MSB0182	10	15000~17000	1100~1300	0.08~0.1	1.8	SLOTTING
MSB0182	10	15000~17000	2000~2400	0.04~0.05	1.8	SLOTTING
MSB0182	10	15000~17000	1500~1700	0.1~0.12	0.24	3D MILLING
MSB0182	10	15000~17000	2400~2600	0.05~0.06	0.12	3D MILLING
MSB0202	11	14000~16000	1100~1400	0.08~0.1	2	SLOTTING
MSB0202	11	14000~16000	2200~2600	0.04~0.06	2	SLOTTING
MSB0202	11	14000~16000	1600~1800	0.1~0.12	0.24	3D MILLING
MSB0202	11	14000~16000	2400~2700	0.05~0.07	0.14	3D MILLING
MSB0302	13	13000~15000	1100~1400	0.12~0.15	3	SLOTTING
MSB0302	13	13000~15000	2500~3000	0.05~0.07	3	SLOTTING
MSB0302	13	13000~15000	1600~1800	0.13~0.15	0.3	3D MILLING
MSB0302	13	13000~15000	2800~3000	0.06~0.08	0.16	3D MILLING

MET MILLING CONDITIONS

DHF ITALIA

Work Material	*Prehardened Steels* : **NAK80, 1.2083** (HRc38)
Coolant Type	Wet coolant

Type No.	Extension Length (mm)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_p) Width of Cut	Milling Type
MET0022	10	24000~26000	250~300	0.005~0.01	0.2	SLOTTING
MET0022	10	24000~26000	250~300	0.005~0.01	0.2	SLOTTING
MET0032	10	24000~26000	300~400	0.01~0.015	0.3	SLOTTING
MET0032	10	24000~26000	400~500	0.005~0.01	0.3	SLOTTING
MET0042	10	23000~25000	400~500	0.02~0.03	0.4	SLOTTING
MET0042	10	23000~25000	500~600	0.01~0.02	0.4	SLOTTING
MET0052	10	23000~25000	500~700	0.03~0.04	0.5	SLOTTING
MET0052	10	23000~25000	800~900	0.01~0.02	0.5	SLOTTING
MET0062	10	22000~24000	500~700	0.04~0.05	0.6	SLOTTING
MET0062	10	22000~24000	800~900	0.03~0.04	0.6	SLOTTING
MET0072	10	22000~24000	600~800	0.04~0.05	0.7	SLOTTING
MET0072	10	22000~24000	800~1000	0.03~0.04	0.7	SLOTTING
MET0082	10	21000~23000	600~800	0.05~0.06	0.8	SLOTTING
MET0082	10	21000~23000	800~1000	0.04~0.05	0.8	SLOTTING
MET0092	10	21000~23000	650~850	0.05~0.06	0.9	SLOTTING
MET0092	10	21000~23000	850~1050	0.04~0.05	0.9	SLOTTING
MET0102	10	19000~21000	700~900	0.05~0.06	1	SLOTTING
MET0102	10	19000~21000	900~1100	0.04~0.05	1	SLOTTING
MET0122	10	19000~21000	700~900	0.06~0.08	1.2	SLOTTING
MET0122	10	19000~21000	900~1100	0.04~0.05	1.2	SLOTTING
MET0142	10	18000~20000	700~900	0.07~0.09	1.4	SLOTTING
MET0142	10	18000~20000	900~1100	0.04~0.05	1.4	SLOTTING
MET0152	10	18000~20000	750~950	0.08~0.1	1.5	SLOTTING
MET0152	10	18000~20000	950~1150	0.05~0.06	1.5	SLOTTING
MET0162	10	17000~19000	800~1000	0.09~0.11	1.6	SLOTTING
MET0162	10	17000~19000	1000~1200	0.05~0.07	1.6	SLOTTING
MET0182	10	15000~17000	900~1000	0.1~0.12	1.8	SLOTTING
MET0182	10	15000~17000	1100~1200	0.06~0.08	1.8	SLOTTING
MET0202	11	15000~17000	900~1100	0.1~0.12	2	SLOTTING
MET0202	11	15000~17000	1100~1300	0.06~0.08	2	SLOTTING
MET0252	13	14000~16000	1300~1500	0.12~0.14	2.5	SLOTTING
MET0252	13	14000~16000	1500~1700	0.07~0.12	2.5	SLOTTING
MET0302	14	14000~16000	1500~1700	0.14~0.16	3	SLOTTING
MET0302	14	14000~16000	1700~1900	0.08~0.13	3	SLOTTING

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MET MILLING CONDITIONS

DHF ITALIA

Work Material	*Prehardened Steels :* **NAK80, 1.2083** (HRc38)				
Coolant Type	Wet coolant				
Type No.	Extension Length (mm)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_p) Width of Cut	Milling Type
MET0022	10	17000~18000	150~200	0.005~0.01	0.2	SLOTTING
MET0022	10	17000~18000	150~200	0.005~0.01	0.2	SLOTTING
MET0032	10	17000~18000	200~300	0.01~0.015	0.3	SLOTTING
MET0032	10	17000~18000	300~400	0.005~0.01	0.3	SLOTTING
MET0042	10	17000~18000	300~400	0.02~0.03	0.4	SLOTTING
MET0042	10	17000~18000	400~500	0.01~0.02	0.4	SLOTTING
MET0052	10	17000~18000	400~600	0.03~0.04	0.5	SLOTTING
MET0052	10	17000~18000	700~800	0.01~0.02	0.5	SLOTTING
MET0062	10	16000~17000	400~600	0.04~0.05	0.6	SLOTTING
MET0062	10	16000~17000	700~800	0.03~0.04	0.6	SLOTTING
MET0072	10	16000~17000	500~700	0.04~0.05	0.7	SLOTTING
MET0072	10	16000~17000	700~900	0.03~0.04	0.7	SLOTTING
MET0082	10	16000~17000	500~700	0.05~0.06	0.8	SLOTTING
MET0082	10	16000~17000	700~900	0.04~0.05	0.8	SLOTTING
MET0092	10	16000~17000	550~750	0.05~0.06	0.9	SLOTTING
MET0092	10	16000~17000	750~950	0.04~0.05	0.9	SLOTTING
MET0102	10	16000~17000	600~800	0.05~0.06	1	SLOTTING
MET0102	10	16000~17000	800~1000	0.04~0.05	1	SLOTTING
MET0122	10	15000~16000	600~800	0.06~0.08	1.2	SLOTTING
MET0122	10	15000~16000	800~1000	0.04~0.05	1.2	SLOTTING
MET0142	10	15000~16000	600~800	0.07~0.09	1.4	SLOTTING
MET0142	10	15000~16000	800~1000	0.04~0.05	1.4	SLOTTING
MET0152	10	15000~16000	650~850	0.08~0.1	1.5	SLOTTING
MET0152	10	15000~16000	850~1050	0.05~0.06	1.5	SLOTTING
MET0162	10	15000~16000	700~900	0.09~0.11	1.6	SLOTTING
MET0162	10	15000~16000	900~1100	0.05~0.07	1.6	SLOTTING
MET0182	10	14000~15000	800~900	0.1~0.12	1.8	SLOTTING
MET0182	10	14000~15000	1000~1100	0.06~0.08	1.8	SLOTTING
MET0202	11	14000~15000	800~1000	0.1~0.12	2	SLOTTING
MET0202	11	14000~15000	1000~1200	0.06~0.08	2	SLOTTING
MET0252	13	11000~12000	1200~1400	0.12~0.14	2.5	SLOTTING
MET0252	13	11000~12000	1400~1600	0.07~0.12	2.5	SLOTTING
MET0302	14	10000~11000	1400~1600	0.14~0.16	3	SLOTTING
MET0302	14	10000~11000	1600~1800	0.08~0.13	3	SLOTTING

UME MILLING CONDITIONS

DHF ITALIA

Work Material	*Hardened Steels :* **SKD61/STAVAX/1.2083/17-4PH** (HRc52)
Coolant Type	MQL coolant

Type No.	Extension Length (mm)	Cutting Speed (m/min)	Speed (min^{-1})	Feed (mm/min)	(Aa) Depth of Cut	(A_P) Width of Cut	Milling Type
UME0022	12	15	18000~20000	150~300	0.005~0.008	0.2	SLOTTING
UME0022	12	15	18000~20000	150~300	0.005~0.008	0.2	SLOTTING
UME0032	12	20	18000~20000	150~300	0.005~0.01	0.3	SLOTTING
UME0032	12	20	18000~20000	150~300	0.005~0.01	0.3	SLOTTING
UME0042	12	25	18000~20000	200~400	0.008~0.015	0.4	SLOTTING
UME0042	12	25	18000~20000	200~400	0.008~0.015	0.4	SLOTTING
UME0052	12	30	18000~20000	200~400	0.015~0.025	0.5	SLOTTING
UME0052	12	30	18000~20000	400~600	0.01~0.015	0.5	SLOTTING
UME0062	12	35	16000~18000	200~400	0.02~0.04	0.6	SLOTTING
UME0062	12	35	16000~18000	400~600	0.015~0.025	0.6	SLOTTING
UME0072	12	40	16000~18000	300~500	0.03~0.05	0.7	SLOTTING
UME0072	12	40	16000~18000	600~800	0.015~0.025	0.7	SLOTTING
UME0082	12	45	16000~18000	400~600	0.04~0.06	0.8	SLOTTING
UME0082	12	45	16000~18000	800~1000	0.015~0.03	0.8	SLOTTING
UME0102	12	50	16000~18000	400~600	0.04~0.06	1	SLOTTING
UME0102	12	50	16000~18000	800~1000	0.015~0.03	1	SLOTTING
UME0122	12	60	16000~18000	400~600	0.04~0.06	1.2	SLOTTING
UME0122	12	60	16000~18000	800~1000	0.015~0.03	1.2	SLOTTING
UME0152	12	75	15000~16000	600~800	0.05~0.07	1.5	SLOTTING
UME0152	12	75	15000~16000	1000~1200	0.015~0.035	1.5	SLOTTING
UME0162	13	80	15000~16000	600~800	0.06~0.08	1.6	SLOTTING
UME0162	13	80	15000~16000	1000~1200	0.015~0.035	1.6	SLOTTING
UME0182	13	90	15000~16000	600~800	0.07~0.09	1.8	SLOTTING
UME0182	13	90	15000~16000	1200~1600	0.02~0.04	1.8	SLOTTING
UME0202	15	95	13000~15000	600~800	0.08~0.1	2	SLOTTING
UME0202	15	95	13000~15000	1200~1600	0.02~0.045	2	SLOTTING
UME0252	15	105	11000~13000	800~1000	0.08~0.1	2.5	SLOTTING
UME0252	15	105	11000~13000	1400~1800	0.02~0.05	2.5	SLOTTING
UME0302	14	105	9000~11000	1000~1200	0.09~0.11	3	SLOTTING
UME0302	14	105	9000~11000	1600~2000	0.025~0.06	3	SLOTTING
UME0402	15	115	7000~9000	1400~1600	0.12~0.14	4	SLOTTING
UME0402	15	115	7000~9000	2000~2400	0.03~0.08	4	SLOTTING

Note	**UME** *is not good at slotting or surfacing on material* **SKD11** *(HRc62), it is suitable for Corner Finishing Milling.*

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META MILLING CONDITIONS

DHF ITALIA

Work Material	*Prehardened Steels :* **NAK80, 1.2083** (HRc38)				
Coolant Type	Wet coolant				
Type No.	Extension Length (mm)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_p) Width of Cut	Milling Type
META0022	10	24000~26000	250~300	0.005~0.01	0.2	SLOTTING
META0022	10	24000~26000	250~300	0.005~0.01	0.2	SLOTTING
META0032	10	24000~26000	300~400	0.01~0.015	0.3	SLOTTING
META0032	10	24000~26000	400~500	0.005~0.01	0.3	SLOTTING
META0042	10	23000~25000	400~500	0.02~0.03	0.4	SLOTTING
META0042	10	23000~25000	500~600	0.01~0.02	0.4	SLOTTING
META0052	10	23000~25000	500~700	0.03~0.04	0.5	SLOTTING
META0052	10	23000~25000	800~900	0.01~0.02	0.5	SLOTTING
META0062	10	22000~24000	500~700	0.04~0.05	0.6	SLOTTING
META0062	10	22000~24000	800~900	0.03~0.04	0.6	SLOTTING
META0072	10	22000~24000	600~800	0.04~0.05	0.7	SLOTTING
META0072	10	22000~24000	800~1000	0.03~0.04	0.7	SLOTTING
META0082	10	21000~23000	600~800	0.05~0.06	0.8	SLOTTING
META0082	10	21000~23000	800~1000	0.04~0.05	0.8	SLOTTING
META0092	10	21000~23000	650~850	0.05~0.06	0.9	SLOTTING
META0092	10	21000~23000	850~1050	0.04~0.05	0.9	SLOTTING
META0102	10	19000~21000	700~900	0.05~0.06	1	SLOTTING
META0102	10	19000~21000	900~1100	0.04~0.05	1	SLOTTING
META0122	10	19000~21000	700~900	0.06~0.08	1.2	SLOTTING
META0122	10	19000~21000	900~1100	0.04~0.05	1.2	SLOTTING
META0142	10	18000~20000	700~900	0.07~0.09	1.4	SLOTTING
META0142	10	18000~20000	900~1100	0.04~0.05	1.4	SLOTTING
META0152	10	18000~20000	750~950	0.08~0.1	1.5	SLOTTING
META0152	10	18000~20000	950~1150	0.05~0.06	1.5	SLOTTING
META0162	10	17000~19000	800~1000	0.09~0.11	1.6	SLOTTING
META0162	10	17000~19000	1000~1200	0.05~0.07	1.6	SLOTTING
META0182	10	15000~17000	900~1000	0.1~0.12	1.8	SLOTTING
META0182	10	15000~17000	1100~1200	0.06~0.08	1.8	SLOTTING
META0202	11	15000~17000	900~1100	0.1~0.12	2	SLOTTING
META0202	11	15000~17000	1100~1300	0.06~0.08	2	SLOTTING
META0252	13	14000~16000	1300~1500	0.12~0.14	2.5	SLOTTING
META0252	13	14000~16000	1500~1700	0.07~0.12	2.5	SLOTTING
META0302	14	14000~16000	1500~1700	0.14~0.16	3	SLOTTING
META0302	14	14000~16000	1700~1900	0.08~0.13	3	SLOTTING

META MILLING CONDITIONS

DHF ITALIA

Work Material	*Prehardened Steels :* **NAK80, 1.2083** (HRc38)
Coolant Type	Wet coolant

Type No.	Extension Length (mm)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_p) Width of Cut	Milling Type
META0022	10	17000~18000	150~200	0.005~0.01	0.2	SLOTTING
META0022	10	17000~18000	150~200	0.005~0.01	0.2	SLOTTING
META0032	10	17000~18000	200~300	0.01~0.015	0.3	SLOTTING
META0032	10	17000~18000	300~400	0.005~0.01	0.3	SLOTTING
META0042	10	17000~18000	300~400	0.02~0.03	0.4	SLOTTING
META0042	10	17000~18000	400~500	0.01~0.02	0.4	SLOTTING
META0052	10	17000~18000	400~600	0.03~0.04	0.5	SLOTTING
META0052	10	17000~18000	700~800	0.01~0.02	0.5	SLOTTING
META0062	10	16000~17000	400~600	0.04~0.05	0.6	SLOTTING
META0062	10	16000~17000	700~800	0.03~0.04	0.6	SLOTTING
META0072	10	16000~17000	500~700	0.04~0.05	0.7	SLOTTING
META0072	10	16000~17000	700~900	0.03~0.04	0.7	SLOTTING
META0082	10	16000~17000	500~700	0.05~0.06	0.8	SLOTTING
META0082	10	16000~17000	700~900	0.04~0.05	0.8	SLOTTING
META0092	10	16000~17000	550~750	0.05~0.06	0.9	SLOTTING
META0092	10	16000~17000	750~950	0.04~0.05	0.9	SLOTTING
META0102	10	16000~17000	600~800	0.05~0.06	1	SLOTTING
META0102	10	16000~17000	800~1000	0.04~0.05	1	SLOTTING
META0122	10	15000~16000	600~800	0.06~0.08	1.2	SLOTTING
META0122	10	15000~16000	800~1000	0.04~0.05	1.2	SLOTTING
META0142	10	15000~16000	600~800	0.07~0.09	1.4	SLOTTING
META0142	10	15000~16000	800~1000	0.04~0.05	1.4	SLOTTING
META0152	10	15000~16000	650~850	0.08~0.1	1.5	SLOTTING
META0152	10	15000~16000	850~1050	0.05~0.06	1.5	SLOTTING
META0162	10	15000~16000	700~900	0.09~0.11	1.6	SLOTTING
META0162	10	15000~16000	900~1100	0.05~0.07	1.6	SLOTTING
META0182	10	14000~15000	800~900	0.1~0.12	1.8	SLOTTING
META0182	10	14000~15000	1000~1100	0.06~0.08	1.8	SLOTTING
META0202	11	14000~15000	800~1000	0.1~0.12	2	SLOTTING
META0202	11	14000~15000	1000~1200	0.06~0.08	2	SLOTTING
META0252	13	11000~12000	1200~1400	0.12~0.14	2.5	SLOTTING
META0252	13	11000~12000	1400~1600	0.07~0.12	2.5	SLOTTING
META0302	14	10000~11000	1400~1600	0.14~0.16	3	SLOTTING
META0302	14	10000~11000	1600~1800	0.08~0.13	3	SLOTTING

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UNBX 2 Flute MILLING CONDITIONS

DHF ITALIA

Work Material	*Prehardened Steels :* **NAK80, 1.2083** (HRc38)
Coolant Type	MQL coolant

Type No.	Extension Length (mm)	Cutting Speed (m/min)	Speed (min^{-1})	Feed (mm/min)	(Aa) Depth of Cut	(Ap) Width of Cut	Milling Type
UNBX0201	12	15	24000~26000	250~400	0.008~0.012	0.2	SLOTTING
UNBX0201	12	15	24000~26000	400~550	0.008~0.012	0.01~0.03	3D MILLING
UNBX0202	13	15	24000~26000	200~350	0.006~0.01	0.2	SLOTTING
UNBX0202	13	15	24000~26000	350~500	0.006~0.01	0.01~0.02	3D MILLING
UNBX0301	13	25	22000~24000	400~600	0.015~0.02	0.3	SLOTTING
UNBX0301	13	25	22000~24000	600~700	0.015~0.02	0.02~0.04	3D MILLING
UNBX0302	14	25	22000~24000	350~550	0.015~0.02	0.3	SLOTTING
UNBX0302	14	25	22000~24000	500~600	0.015~0.02	0.02~0.04	3D MILLING
UNBX0303	15	25	22000~24000	200~400	0.01~0.015	0.3	SLOTTING
UNBX0303	15	25	22000~24000	300~500	0.01~0.015	0.02~0.03	3D MILLING
UNBX0402	14	30	22000~24000	400~600	0.015~0.025	0.4	SLOTTING
UNBX0402	14	30	22000~24000	500~700	0.015~0.025	0.03~0.05	3D MILLING
UNBX0403	15	30	22000~24000	300~500	0.01~0.015	0.4	SLOTTING
UNBX0403	15	30	22000~24000	400~600	0.01~0.015	0.02~0.03	3D MILLING
UNBX0404	16	30	22000~24000	200~400	0.008~0.012	0.4	SLOTTING
UNBX0404	16	30	22000~24000	300~500	0.008~0.012	0.015~0.03	3D MILLING
UNBX0502	15	35	20000~22000	500~700	0.02~0.03	0.5	SLOTTING
UNBX0502	15	35	20000~22000	650~850	0.02~0.03	0.04~0.06	3D MILLING
UNBX0504	17	35	20000~22000	350~550	0.015~0.02	0.5	SLOTTING
UNBX0504	17	35	20000~22000	500~700	0.015~0.02	0.02~0.05	3D MILLING
UNBX0506	19	35	20000~22000	300~500	0.01~0.015	0.5	SLOTTING
UNBX0506	19	35	20000~22000	450~650	0.01~0.015	0.02~0.05	3D MILLING
UNBX0602	16	40	20000~22000	700~900	0.025~0.035	0.6	SLOTTING
UNBX0602	16	40	20000~22000	800~1000	0.025~0.035	0.05~0.08	3D MILLING
UNBX0604	18	40	20000~22000	400~600	0.02~0.03	0.6	SLOTTING
UNBX0604	18	40	20000~22000	600~800	0.015~0.03	0.03~0.06	3D MILLING
UNBX0606	20	40	20000~22000	300~500	0.015~0.025	0.6	SLOTTING
UNBX0606	20	40	20000~22000	450~650	0.015~0.03	0.03~0.06	3D MILLING
UMBX0804	15	50	18000~20000	800~1000	0.02~0.04	0.8	SLOTTING
UMBX0804	15	50	18000~20000	900~1100	0.04~0.06	0.1~0.15	3D MILLING
UMBX0804	15	50	18000~20000	1300~1500	0.02~0.04	0.04~0.08	3D MILLING
UNBX0806	17	50	18000~20000	700~900	0.02~0.04	0.8	SLOTTING
UNBX0806	17	50	18000~20000	800~1000	0.04~0.06	0.1~0.15	3D MILLING
UNBX0806	17	50	18000~20000	1100~1300	0.02~0.04	0.04~0.08	3D MILLING
UNBX0808	19	50	18000~20000	600~800	0.02~0.04	0.8	SLOTTING
UNBX0808	19	50	18000~20000	700~900	0.04~0.06	0.1~0.15	3D MILLING
UNBX0808	19	50	18000~20000	1100~1300	0.01~0.03	0.04~0.08	3D MILLING
UNBX1004	11	55	17000~18000	800~1000	0.02~0.04	1	SLOTTING
UNBX1004	11	55	17000~18000	900~1100	0.05~0.07	0.1~0.15	3D MILLING
UNBX1004	11	55	17000~18000	1300~1500	0.02~0.04	0.04~0.08	3D MILLING
UNBX1006	13	55	17000~18000	700~900	0.02~0.04	1	SLOTTING
UNBX1006	13	55	17000~18000	800~1000	0.05~0.07	0.1~0.15	3D MILLING
UNBX1006	13	55	17000~18000	1300~1500	0.02~0.04	0.04~0.08	3D MILLING
UNBX1008	15	55	17000~18000	600~800	0.02~0.04	1	SLOTTING
UNBX1008	15	55	17000~18000	700~900	0.05~0.07	0.1~0.15	3D MILLING
UNBX1008	15	55	17000~18000	1200~1400	0.02~0.04	0.04~0.08	3D MILLING
UNBX1010	17	55	17000~18000	500~700	0.02~0.04	1	SLOTTING
UNBX1010	17	55	17000~18000	700~900	0.05~0.07	0.1~0.15	3D MILLING
UNBX1010	17	55	17000~18000	1000~1200	0.02~0.04	0.04~0.08	3D MILLING
UNBX1012	19	55	17000~18000	400~600	0.02~0.04	1	SLOTTING
UNBX1012	19	55	17000~18000	500~700	0.05~0.07	0.1~0.15	3D MILLING
UNBX1012	19	55	17000~18000	800~1000	0.02~0.04	0.04~0.08	3D MILLING

Type No.	Extension Length (mm)	Cutting Speed (m/min)	Speed (min^{-1})	Feed (mm/min)	(Aa) Depth of Cut	(A_P) Width of Cut	Milling Type
UNBX1208	15	65	17000~18000	600~800	0.02~0.04	1.2	SLOTTING
UNBX1208	15	65	17000~18000	700~900	0.05~0.07	0.1~0.15	3D MILLING
UNBX1208	15	65	17000~18000	1200~1400	0.02~0.04	0.04~0.09	3D MILLING
UNBX1212	19	65	17000~18000	500~700	0.02~0.04	1.2	SLOTTING
UNBX1212	19	65	17000~18000	700~900	0.05~0.07	0.1~0.15	3D MILLING
UNBX1212	19	65	17000~18000	1000~1200	0.02~0.04	0.04~0.09	3D MILLING
UNBX1506	13	70	16000~17000	1100~1300	0.08~0.1	1.5	SLOTTING
UNBX1506	13	70	16000~17000	1300~1700	0.01~0.04	1.5	SLOTTING
UNBX1506	13	70	16000~17000	1500~1700	0.12~0.14	0.24~0.28	3D MILLING
UNBX1506	13	70	16000~17000	2100~2600	0.02~0.045	0.04~0.09	3D MILLING
UNBX1508	14	70	16000~17000	1100~1300	0.08~0.1	1.5	SLOTTING
UNBX1508	14	70	16000~17000	1300~1700	0.01~0.04	1.5	SLOTTING
UNBX1508	14	70	16000~17000	1500~1700	0.12~0.14	0.24~0.28	3D MILLING
UNBX1508	14	70	16000~17000	2100~2600	0.02~0.045	0.04~0.09	3D MILLING
UNBX1510	16	70	16000~17000	900~1100	0.08~0.1	1.5	SLOTTING
UNBX1510	16	70	16000~17000	1200~1600	0.01~0.04	1.5	SLOTTING
UNBX1510	16	70	16000~17000	1400~1600	0.1~0.12	0.2~0.24	3D MILLING
UNBX1510	16	70	16000~17000	2000~2400	0.02~0.04	0.04~0.08	3D MILLING
UNBX1512	18	70	16000~17000	700~900	0.06~0.08	1.5	SLOTTING
UNBX1512	18	70	16000~17000	1000~1400	0.01~0.04	1.5	SLOTTING
UNBX1512	18	70	16000~17000	1300~1500	0.1~0.12	0.2~0.24	3D MILLING
UNBX1512	18	70	16000~17000	1800~2200	0.02~0.04	0.04~0.08	3D MILLING
UNBX1516	22	70	16000~17000	600~800	0.04~0.06	1.5	SLOTTING
UNBX1516	22	70	16000~17000	900~1100	0.01~0.03	1.5	SLOTTING
UNBX1516	22	70	16000~17000	1100~1300	0.08~0.1	0.16~0.2	3D MILLING
UNBX1516	22	70	16000~17000	1700~2100	0.015~0.04	0.03~0.08	3D MILLING
UNBX1520	26	70	16000~17000	300~500	0.04~0.06	1.5	SLOTTING
UNBX1520	26	70	16000~17000	600~1000	0.01~0.03	1.5	SLOTTING
UNBX1520	26	70	16000~17000	900~1100	0.06~0.08	0.12~0.16	3D MILLING
UNBX1520	26	70	16000~17000	1300~1700	0.015~0.03	0.03~0.06	3D MILLING
UNBX1608	14	85	16000~17000	1100~1300	0.08~0.1	1.6	SLOTTING
UNBX1608	14	85	16000~17000	1300~1700	0.01~0.04	1.6	SLOTTING
UNBX1608	14	85	16000~17000	1500~1700	0.12~0.14	0.24~0.28	3D MILLING
UNBX1608	14	85	16000~17000	2100~2600	0.02~0.045	0.04~0.09	3D MILLING
UNBX1612	16	85	16000~17000	700~900	0.06~0.08	1.6	SLOTTING
UNBX1612	16	85	16000~17000	1000~1400	0.01~0.04	1.6	SLOTTING
UNBX1612	16	85	16000~17000	1300~1500	0.1~0.12	0.2~0.24	3D MILLING
UNBX1612	16	85	16000~17000	1800~2200	0.02~0.04	0.04~0.08	3D MILLING
UNBX1616	20	85	16000~17000	600~800	0.04~0.06	1.6	SLOTTING
UNBX1616	20	85	16000~17000	900~1100	0.01~0.03	1.6	SLOTTING
UNBX1616	20	85	16000~17000	1100~1300	0.08~0.1	0.16~0.2	3D MILLING
UNBX1616	20	85	16000~17000	1700~2100	0.015~0.04	0.03~0.08	3D MILLING
UNBX2008	14	100	15000~16000	1900~2100	0.12~0.14	2	SLOTTING
UNBX2008	14	100	15000~16000	2400~2800	0.02~0.07	2	SLOTTING
UNBX2008	14	100	15000~16000	2000~2400	0.16~0.18	0.32~0.36	3D MILLING
UNBX2008	14	100	15000~16000	3000~3400	0.02~0.05	0.04~0.1	3D MILLING
UNBX2010	16	100	15000~16000	1800~2000	0.12~0.14	2	SLOTTING
UNBX2010	16	100	15000~16000	2300~2700	0.02~0.07	2	SLOTTING
UNBX2010	16	100	15000~16000	1900~2300	0.16~0.18	0.32~0.36	3D MILLING
UNBX2010	16	100	15000~16000	3000~3400	0.02~0.05	0.04~0.1	3D MILLING
UNBX2012	18	100	15000~16000	1700~1900	0.1~0.12	2	SLOTTING
UNBX2012	18	100	15000~16000	2100~2500	0.015~0.05	2	SLOTTING
UNBX2012	18	100	15000~16000	1900~2300	0.14~0.16	0.28~0.32	3D MILLING
UNBX2012	18	100	15000~16000	2600~3000	0.015~0.05	0.03~0.1	3D MILLING
UNBX2016	22	100	15000~16000	1400~1600	0.1~0.12	2	SLOTTING
UNBX2016	22	100	15000~16000	1800~2200	0.015~0.05	2	SLOTTING
UNBX2016	22	100	15000~16000	1700~1900	0.12~0.14	0.24~0.28	3D MILLING
UNBX2016	22	100	15000~16000	2200~2600	0.015~0.05	0.03~0.1	3D MILLING

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Type No.	Extension Length (mm)	Cutting Speed (m/min)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_P) Width of Cut	Milling Type
UNBX2020	26	100	15000~16000	1300~1500	0.08~0.1	2	SLOTTING
UNBX2020	26	100	15000~16000	1700~2100	0.015~0.05	2	SLOTTING
UNBX2020	26	100	15000~16000	1400~1600	0.1~0.12	0.2~0.24	3D MILLING
UNBX2020	26	100	15000~16000	2000~2400	0.015~0.05	0.03~0.1	3D MILLING
UNBX3008	16	140	14000~15000	2000~2300	0.16~0.18	3	SLOTTING
UNBX3008	16	140	14000~15000	2400~2800	0.03~0.1	3	SLOTTING
UNBX3008	16	140	14000~15000	2800~3200	0.2~0.22	0.4~0.44	3D MILLING
UNBX3008	16	140	14000~15000	3200~3600	0.03~0.1	0.06~0.2	3D MILLING
UNBX3010	18	140	14000~15000	2000~2300	0.16~0.18	3	SLOTTING
UNBX3010	18	140	14000~15000	2400~2800	0.03~0.1	3	SLOTTING
UNBX3010	18	140	14000~15000	2800~3000	0.2~0.22	0.4~0.44	3D MILLING
UNBX3010	18	140	14000~15000	3200~3600	0.03~0.1	0.06~0.2	3D MILLING
UNBX3012	20	140	14000~15000	1800~2100	0.14~0.16	3	SLOTTING
UNBX3012	20	140	14000~15000	2200~2600	0.03~0.08	3	SLOTTING
UNBX3012	20	140	14000~15000	2600~2800	0.18~0.2	0.36~0.4	3D MILLING
UNBX3012	20	140	14000~15000	3000~3400	0.03~0.08	0.06~0.16	3D MILLING
UNBX3016	24	140	14000~15000	1700~1900	0.13~0.15	3	SLOTTING
UNBX3016	24	140	14000~15000	1900~2300	0.03~0.08	3	SLOTTING
UNBX3016	24	140	14000~15000	2000~2200	0.16~0.18	0.32~0.36	3D MILLING
UNBX3016	24	140	14000~15000	2600~3000	0.03~0.08	0.06~0.16	3D MILLING
UNBX3020	28	140	14000~15000	1500~1700	0.1~0.12	3	SLOTTING
UNBX3020	28	140	14000~15000	1800~2100	0.02~0.06	3	SLOTTING
UNBX3020	28	140	14000~15000	1800~2100	0.14~0.16	0.28~0.32	3D MILLING
UNBX3020	28	140	14000~15000	2300~2700	0.02~0.06	0.04~0.12	3D MILLING
UNBX3025	33	140	14000~15000	1100~1300	0.08~0.1	3	SLOTTING
UNBX3025	33	140	14000~15000	1500~1900	0.015~0.04	3	SLOTTING
UNBX3025	33	140	14000~15000	1500~1800	0.1~0.12	0.2~0.24	3D MILLING
UNBX3025	33	140	14000~15000	2000~2400	0.015~0.04	0.03~0.08	3D MILLING
UNBX4010	20	160	12000~13000	2000~2400	0.24~0.26	4	SLOTTING
UNBX4010	20	160	12000~13000	3000~3400	0.04~0.1	4	SLOTTING
UNBX4010	20	160	12000~13000	2100~2600	0.26~0.28	0.52~0.56	3D MILLING
UNBX4010	20	160	12000~13000	3200~3400	0.04~0.12	0.08~0.24	3D MILLING
UNBX4015	25	160	12000~13000	2000~2400	0.22~0.24	4	SLOTTING
UNBX4015	25	160	12000~13000	3000~3400	0.03~0.08	4	SLOTTING
UNBX4015	25	160	12000~13000	2100~2600	0.24~0.26	0.48~0.52	3D MILLING
UNBX4015	25	160	12000~13000	3200~3400	0.04~0.1	0.08~0.2	3D MILLING
UNBX4020	30	160	12000~13000	1800~2200	0.21~0.23	4	SLOTTING
UNBX4020	30	160	12000~13000	2800~3200	0.03~0.08	4	SLOTTING
UNBX4020	30	160	12000~13000	2100~2300	0.23~0.25	0.46~0.5	3D MILLING
UNBX4020	30	160	12000~13000	3200~3500	0.04~0.1	0.08~0.2	3D MILLING
UNBX4025	35	160	12000~13000	1600~2000	0.19~0.21	4	SLOTTING
UNBX4025	35	160	12000~13000	2400~2600	0.04~0.08	4	SLOTTING
UNBX4025	35	160	12000~13000	1900~2100	0.21~0.23	0.42~0.46	3D MILLING
UNBX4025	35	160	12000~13000	2600~3000	0.04~0.1	0.08~0.2	3D MILLING
UNBX4030	40	160	12000~13000	1500~1700	0.16~0.18	4	SLOTTING
UNBX4030	40	160	12000~13000	1800~2200	0.03~0.07	4	SLOTTING
UNBX4030	40	160	12000~13000	1600~1800	0.18~0.2	0.36~0.4	3D MILLING
UNBX4030	40	160	12000~13000	2200~2500	0.04~0.07	0.08~0.14	3D MILLING

UNBX 2 Flute MILLING CONDITIONS

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Work Material	*Hardened Steels :* **SKD61/STAVAX/1.2083/17-4PH** (HRc52)
Coolant Type	MQL coolant

Type No.	Extension Length (mm)	Cutting Speed (m/min)	Speed (min^{-1})	Feed (mm/min)	(Aa) Depth of Cut	(A_P) Width of Cut	Milling Type
UNBX0201	12	15	18000~20000	150~300	0.005~0.008	0.2	SLOTTING
UNBX0201	12	15	18000~20000	150~300	0.005~0.008	0.01~0.016	3D MILLING
UNBX0202	13	15	18000~20000	150~300	0.005~0.008	0.2	SLOTTING
UNBX0202	13	15	18000~20000	150~300	0.005~0.008	0.01~0.016	3D MILLING
UNBX0301	13	20	18000~20000	150~300	0.005~0.008	0.3	SLOTTING
UNBX0301	13	20	18000~20000	150~300	0.005~0.01	0.01~0.02	3D MILLING
UNBX0302	14	20	18000~20000	150~300	0.005~0.008	0.3	SLOTTING
UNBX0302	14	20	18000~20000	150~300	0.005~0.01	0.01~0.02	3D MILLING
UNBX0303	15	20	18000~20000	150~300	0.005~0.008	0.3	SLOTTING
UNBX0303	15	20	18000~20000	150~300	0.005~0.01	0.01~0.02	3D MILLING
UNBX0402	14	25	18000~20000	150~300	0.005~0.01	0.4	SLOTTING
UNBX0402	14	25	18000~20000	200~400	0.005~0.013	0.01~0.026	3D MILLING
UNBX0403	15	25	18000~20000	150~300	0.005~0.01	0.4	SLOTTING
UNBX0403	15	25	18000~20000	200~400	0.005~0.013	0.01~0.026	3D MILLING
UNBX0404	16	25	18000~20000	150~300	0.005~0.01	0.4	SLOTTING
UNBX0404	16	25	18000~20000	200~400	0.005~0.013	0.01~0.026	3D MILLING
UNBX0502	15	35	18000~20000	200~400	0.005~0.013	0.5	SLOTTING
UNBX0502	15	35	18000~20000	200~400	0.008~0.015	0.016~0.03	3D MILLING
UNBX0504	17	35	18000~20000	200~400	0.005~0.013	0.5	SLOTTING
UNBX0504	17	35	18000~20000	200~400	0.008~0.015	0.016~0.03	3D MILLING
UNBX0506	19	35	18000~20000	150~300	0.005~0.013	0.5	SLOTTING
UNBX0506	19	35	18000~20000	200~400	0.005~0.013	0.01~0.026	3D MILLING
UNBX0602	16	40	18000~20000	200~400	0.005~0.013	0.6	SLOTTING
UNBX0602	16	40	18000~20000	200~400	0.008~0.015	0.016~0.03	3D MILLING
UNBX0604	18	40	18000~20000	200~400	0.005~0.013	0.6	SLOTTING
UNBX0604	18	40	18000~20000	200~400	0.008~0.015	0.016~0.03	3D MILLING
UNBX0606	20	40	18000~20000	150~300	0.005~0.013	0.6	SLOTTING
UNBX0606	20	40	18000~20000	200~400	0.005~0.013	0.01~0.026	3D MILLING
UMBX0804	15	45	16000~18000	300~500	0.01~0.02	0.8	SLOTTING
UMBX0804	15	45	16000~18000	300~500	0.015~0.025	0.03~0.05	3D MILLING
UMBX0804	15	45	16000~18000	500~700	0.008~0.015	0.016~0.03	3D MILLING
UNBX0806	17	45	16000~18000	300~500	0.01~0.02	0.8	SLOTTING
UNBX0806	17	45	16000~18000	300~500	0.015~0.025	0.03~0.05	3D MILLING
UNBX0806	17	45	16000~18000	500~700	0.005~0.015	0.01~0.03	3D MILLING
UNBX0808	19	45	16000~18000	200~400	0.01~0.02	0.8	SLOTTING
UNBX0808	19	45	16000~18000	200~400	0.015~0.025	0.03~0.05	3D MILLING
UNBX0808	19	45	16000~18000	400~600	0.005~0.015	0.01~0.03	3D MILLING
UNBX1004	11	50	15000~16000	400~600	0.015~0.035	1	SLOTTING
UNBX1004	11	50	15000~16000	400~600	0.03~0.05	0.06~0.1	3D MILLING
UNBX1004	11	50	15000~16000	600~800	0.01~0.03	0.02~0.06	3D MILLING
UNBX1006	13	50	15000~16000	400~600	0.015~0.035	1	SLOTTING
UNBX1006	13	50	15000~16000	400~600	0.03~0.05	0.06~0.1	3D MILLING
UNBX1006	13	50	15000~16000	600~800	0.01~0.03	0.02~0.06	3D MILLING
UNBX1008	15	50	15000~16000	300~500	0.01~0.03	1	SLOTTING
UNBX1008	15	50	15000~16000	300~500	0.03~0.05	0.06~0.1	3D MILLING
UNBX1008	15	50	15000~16000	600~800	0.01~0.02	0.02~0.04	3D MILLING
UNBX1010	17	50	15000~16000	300~500	0.01~0.03	1	SLOTTING
UNBX1010	17	50	15000~16000	300~500	0.03~0.05	0.06~0.1	3D MILLING
UNBX1010	17	50	15000~16000	600~800	0.01~0.02	0.02~0.04	3D MILLING
UNBX1012	19	50	15000~16000	300~500	0.01~0.03	1	SLOTTING
UNBX1012	19	50	15000~16000	300~500	0.03~0.05	0.06~0.1	3D MILLING
UNBX1012	19	50	15000~16000	600~800	0.01~0.02	0.02~0.04	3D MILLING

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Type No.	Extension Length (mm)	Cutting Speed (m/min)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_P) Width of Cut	Milling Type
UNBX1208	15	60	15000~16000	400~600	0.02~0.04	1.2	SLOTTING
UNBX1208	15	60	15000~16000	400~600	0.04~0.06	0.08~0.12	3D MILLING
UNBX1208	15	60	15000~16000	800~1000	0.01~0.025	0.02~0.05	3D MILLING
UNBX1212	19	60	15000~16000	400~600	0.02~0.04	1.2	SLOTTING
UNBX1212	19	60	15000~16000	400~600	0.04~0.06	0.08~0.12	3D MILLING
UNBX1212	19	60	15000~16000	800~1000	0.01~0.025	0.02~0.05	3D MILLING
UNBX1506	13	70	14000~15000	400~600	0.04~0.06	1.5	SLOTTING
UNBX1506	13	70	14000~15000	700~900	0.01~0.03	1.5	SLOTTING
UNBX1506	13	70	14000~15000	400~600	0.05~0.07	0.1~0.14	3D MILLING
UNBX1506	13	70	14000~15000	800~1000	0.015~0.035	0.03~0.07	3D MILLING
UNBX1508	14	70	14000~15000	400~600	0.04~0.06	1.5	SLOTTING
UNBX1508	14	70	14000~15000	700~900	0.01~0.03	1.5	SLOTTING
UNBX1508	14	70	14000~15000	400~600	0.05~0.07	0.1~0.14	3D MILLING
UNBX1508	14	70	14000~15000	800~1000	0.015~0.035	0.03~0.07	3D MILLING
UNBX1510	16	70	14000~15000	400~600	0.03~0.05	1.5	SLOTTING
UNBX1510	16	70	14000~15000	600~800	0.01~0.03	1.5	SLOTTING
UNBX1510	16	70	14000~15000	400~600	0.04~0.06	0.08~0.12	3D MILLING
UNBX1510	16	70	14000~15000	700~900	0.015~0.035	0.03~0.07	3D MILLING
UNBX1512	18	70	14000~15000	300~500	0.03~0.05	1.5	SLOTTING
UNBX1512	18	70	14000~15000	500~700	0.01~0.03	1.5	SLOTTING
UNBX1512	18	70	14000~15000	400~600	0.04~0.06	0.08~0.12	3D MILLING
UNBX1512	18	70	14000~15000	600~800	0.015~0.035	0.03~0.07	3D MILLING
UNBX1516	22	70	14000~15000	300~500	0.02~0.04	1.5	SLOTTING
UNBX1516	22	70	14000~15000	500~600	0.008~0.02	1.5	SLOTTING
UNBX1516	22	70	14000~15000	300~500	0.03~0.05	0.06~0.1	3D MILLING
UNBX1516	22	70	14000~15000	600~800	0.01~0.025	0.02~0.05	3D MILLING
UNBX1520	26	70	14000~15000	200~400	0.02~0.04	1.5	SLOTTING
UNBX1520	26	70	14000~15000	400~600	0.008~0.02	1.5	SLOTTING
UNBX1520	26	70	14000~15000	200~400	0.02~0.04	0.04~0.08	3D MILLING
UNBX1520	26	70	14000~15000	400~600	0.008~0.02	0.016~0.04	3D MILLING
UNBX1608	14	75	14000~15000	500~700	0.04~0.06	1.6	SLOTTING
UNBX1608	14	75	14000~15000	800~1000	0.01~0.03	1.6	SLOTTING
UNBX1608	14	75	14000~15000	500~700	0.05~0.07	0.1~0.14	3D MILLING
UNBX1608	14	75	14000~15000	800~1000	0.015~0.035	0.03~0.07	3D MILLING
UNBX1612	16	75	14000~15000	400~600	0.03~0.05	1.6	SLOTTING
UNBX1612	16	75	14000~15000	600~800	0.01~0.03	1.6	SLOTTING
UNBX1612	16	75	14000~15000	500~700	0.04~0.06	0.08~0.12	3D MILLING
UNBX1612	16	75	14000~15000	800~1000	0.015~0.03	0.03~0.06	3D MILLING
UNBX1616	20	75	14000~15000	300~500	0.02~0.04	1.6	SLOTTING
UNBX1616	20	75	14000~15000	500~700	0.008~0.02	1.6	SLOTTING
UNBX1616	20	75	14000~15000	400~600	0.03~0.05	0.06~0.1	3D MILLING
UNBX1616	20	75	14000~15000	600~800	0.01~0.03	0.02~0.06	3D MILLING
UNBX2008	14	85	12000~13000	500~700	0.05~0.07	2	SLOTTING
UNBX2008	14	85	12000~13000	800~1000	0.01~0.03	2	SLOTTING
UNBX2008	14	85	12000~13000	500~700	0.07~0.09	0.14~0.18	3D MILLING
UNBX2008	14	85	12000~13000	1100~1300	0.015~0.035	0.03~0.07	3D MILLING
UNBX2010	16	85	12000~13000	400~600	0.04~0.06	2	SLOTTING
UNBX2010	16	85	12000~13000	800~1000	0.01~0.03	2	SLOTTING
UNBX2010	16	85	12000~13000	400~600	0.06~0.08	0.12~0.16	3D MILLING
UNBX2010	16	85	12000~13000	1000~1200	0.015~0.035	0.03~0.07	3D MILLING
UNBX2012	18	85	12000~13000	400~600	0.04~0.06	2	SLOTTING
UNBX2012	18	85	12000~13000	800~1000	0.01~0.03	2	SLOTTING
UNBX2012	18	85	12000~13000	400~600	0.06~0.08	0.12~0.16	3D MILLING
UNBX2012	18	85	12000~13000	1000~1200	0.015~0.035	0.03~0.07	3D MILLING
UNBX2016	22	85	12000~13000	300~500	0.03~0.05	2	SLOTTING
UNBX2016	22	85	12000~13000	600~800	0.01~0.025	2	SLOTTING
UNBX2016	22	85	12000~13000	400~600	0.04~0.06	0.08~0.12	3D MILLING
UNBX2016	22	85	12000~13000	800~1000	0.015~0.03	0.03~0.06	3D MILLING

Type No.	Extension Length (mm)	Cutting Speed (m/min)	Speed (min^{-1})	Feed (mm/min)	(Aa) Depth of Cut	(A_P) Width of Cut	Milling Type
UNBX2020	26	85	12000~13000	200~400	0.03~0.05	2	SLOTTING
UNBX2020	26	85	12000~13000	400~600	0.01~0.025	2	SLOTTING
UNBX2020	26	85	12000~13000	400~600	0.03~0.05	0.06~0.1	3D MILLING
UNBX2020	26	85	12000~13000	600~800	0.015~0.03	0.03~0.06	3D MILLING
UNBX3008	16	105	10000~11000	700~900	0.08~0.1	3	SLOTTING
UNBX3008	16	105	10000~11000	1200~1600	0.02~0.05	3	SLOTTING
UNBX3008	16	105	10000~11000	800~1000	0.12~0.14	0.24~0.28	3D MILLING
UNBX3008	16	105	10000~11000	1400~1800	0.03~0.07	0.06~0.14	3D MILLING
UNBX3010	18	105	10000~11000	600~800	0.08~0.1	3	SLOTTING
UNBX3010	18	105	10000~11000	1100~1500	0.02~0.05	3	SLOTTING
UNBX3010	18	105	10000~11000	700~900	0.12~0.14	0.24~0.28	3D MILLING
UNBX3010	18	105	10000~11000	1300~1700	0.03~0.07	0.06~0.14	3D MILLING
UNBX3012	20	105	10000~11000	500~700	0.07~0.09	3	SLOTTING
UNBX3012	20	105	10000~11000	1000~1400	0.02~0.05	3	SLOTTING
UNBX3012	20	105	10000~11000	700~900	0.1~0.12	0.2~0.24	3D MILLING
UNBX3012	20	105	10000~11000	1200~1600	0.03~0.06	0.06~0.12	3D MILLING
UNBX3016	24	105	10000~11000	400~600	0.06~0.08	3	SLOTTING
UNBX3016	24	105	10000~11000	800~1200	0.015~0.035	3	SLOTTING
UNBX3016	24	105	10000~11000	600~800	0.1~0.12	0.2~0.24	3D MILLING
UNBX3016	24	105	10000~11000	1000~1400	0.02~0.05	0.04~0.1	3D MILLING
UNBX3020	28	105	10000~11000	300~500	0.04~0.06	3	SLOTTING
UNBX3020	28	105	10000~11000	700~900	0.01~0.03	3	SLOTTING
UNBX3020	28	105	10000~11000	400~600	0.07~0.09	0.14~0.18	3D MILLING
UNBX3020	28	105	10000~11000	900~1300	0.015~0.035	0.03~0.07	3D MILLING
UNBX3025	33	105	10000~11000	200~400	0.04~0.06	3	SLOTTING
UNBX3025	33	105	10000~11000	600~800	0.01~0.03	3	SLOTTING
UNBX3025	33	105	10000~11000	400~600	0.06~0.08	0.12~0.16	3D MILLING
UNBX3025	33	105	10000~11000	800~1200	0.015~0.035	0.03~0.07	3D MILLING
UNBX4010	20	115	8000~9000	800~1000	0.1~0.12	4	SLOTTING
UNBX4010	20	115	8000~9000	1400~1800	0.03~0.07	4	SLOTTING
UNBX4010	20	115	8000~9000	1000~1200	0.14~0.16	0.28~0.32	3D MILLING
UNBX4010	20	115	8000~9000	1600~2000	0.04~0.09	0.08~0.18	3D MILLING
UNBX4015	25	115	8000~9000	600~800	0.08~0.1	4	SLOTTING
UNBX4015	25	115	8000~9000	1200~1600	0.025~0.06	4	SLOTTING
UNBX4015	25	115	8000~9000	1000~1200	0.1~0.12	0.2~0.24	3D MILLING
UNBX4015	25	115	8000~9000	1600~2000	0.03~0.06	0.06~0.12	3D MILLING
UNBX4020	30	115	8000~9000	600~800	0.06~0.08	4	SLOTTING
UNBX4020	30	115	8000~9000	1000~1400	0.025~0.05	4	SLOTTING
UNBX4020	30	115	8000~9000	1000~1200	0.08~0.1	0.16~0.2	3D MILLING
UNBX4020	30	115	8000~9000	1600~2000	0.025~0.05	0.05~0.1	3D MILLING
UNBX4025	35	115	8000~9000	500~700	0.05~0.07	4	SLOTTING
UNBX4025	35	115	8000~9000	800~1200	0.015~0.035	4	SLOTTING
UNBX4025	35	115	8000~9000	800~1000	0.06~0.08	0.12~0.16	3D MILLING
UNBX4025	35	115	8000~9000	1200~1600	0.025~0.05	0.05~0.1	3D MILLING
UNBX4030	40	115	8000~9000	400~600	0.04~0.06	4	SLOTTING
UNBX4030	40	115	8000~9000	700~1100	0.015~0.035	4	SLOTTING
UNBX4030	40	115	8000~9000	600~800	0.05~0.07	0.1~0.14	3D MILLING
UNBX4030	40	115	8000~9000	1000~1400	0.015~0.04	0.03~0.08	3D MILLING

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UNBX 2 Flute MILLING CONDITIONS

DHF ITALIA

Work Material	*Hardened Steels :* **SKD11 /1.2379/D2** (HRc62)
Coolant Type	MQL coolant

Type No.	Extension Length (mm)	Cutting Speed (m/min)	Speed (min^{-1})	Feed (mm/min)	(Aa) Depth of Cut	(Ap) Width of Cut	Milling Type
UNBX0201	12	15	16000~18000	100~200	0.003~0.006	0.2	SLOTTING
UNBX0201	12	15	16000~18000	100~200	0.005~0.008	0.01~0.016	3D MILLING
UNBX0202	13	15	16000~18000	100~200	0.003~0.006	0.2	SLOTTING
UNBX0202	13	15	16000~18000	100~200	0.005~0.008	0.01~0.016	3D MILLING
UNBX0301	13	15	15000~16000	100~200	0.003~0.006	0.3	SLOTTING
UNBX0301	13	15	15000~16000	100~200	0.005~0.01	0.01~0.02	3D MILLING
UNBX0302	14	15	15000~16000	100~200	0.003~0.006	0.3	SLOTTING
UNBX0302	14	15	15000~16000	100~200	0.005~0.01	0.01~0.02	3D MILLING
UNBX0303	15	15	15000~16000	100~200	0.003~0.006	0.3	SLOTTING
UNBX0303	15	15	15000~16000	100~200	0.005~0.01	0.01~0.02	3D MILLING
UNBX0402	14	20	15000~16000	100~200	0.005~0.008	0.4	SLOTTING
UNBX0402	14	20	15000~16000	150~300	0.005~0.01	0.01~0.02	3D MILLING
UNBX0403	15	20	15000~16000	100~200	0.005~0.008	0.4	SLOTTING
UNBX0403	15	20	15000~16000	150~300	0.005~0.01	0.01~0.02	3D MILLING
UNBX0404	16	20	15000~16000	100~200	0.005~0.008	0.4	SLOTTING
UNBX0404	16	20	15000~16000	100~200	0.005~0.01	0.01~0.02	3D MILLING
UNBX0502	15	25	15000~16000	150~300	0.005~0.01	0.5	SLOTTING
UNBX0502	15	25	15000~16000	150~300	0.005~0.01	0.01~0.02	3D MILLING
UNBX0504	17	25	15000~16000	100~200	0.005~0.01	0.5	SLOTTING
UNBX0504	17	25	15000~16000	100~200	0.005~0.01	0.01~0.02	3D MILLING
UNBX0506	19	25	15000~16000	100~200	0.005~0.01	0.5	SLOTTING
UNBX0506	19	25	15000~16000	100~200	0.005~0.01	0.01~0.02	3D MILLING
UNBX0602	16	30	14000~15000	150~300	0.005~0.01	0.6	SLOTTING
UNBX0602	16	30	14000~15000	150~300	0.005~0.01	0.01~0.02	3D MILLING
UNBX0604	18	30	14000~15000	100~200	0.005~0.01	0.6	SLOTTING
UNBX0604	18	30	14000~15000	100~200	0.005~0.01	0.01~0.02	3D MILLING
UNBX0606	20	30	14000~15000	100~200	0.005~0.01	0.6	SLOTTING
UNBX0606	20	30	14000~15000	100~200	0.005~0.01	0.01~0.02	3D MILLING
UMBX0804	15	40	14000~15000	200~400	0.01~0.02	0.8	SLOTTING
UMBX0804	15	40	14000~15000	200~400	0.008~0.015	0.016~0.03	3D MILLING
UMBX0804	15	40	14000~15000	200~400	0.008~0.015	0.016~0.03	3D MILLING
UNBX0806	17	40	14000~15000	150~300	0.01~0.02	0.8	SLOTTING
UNBX0806	17	40	14000~15000	150~300	0.005~0.015	0.01~0.03	3D MILLING
UNBX0806	17	40	14000~15000	150~300	0.005~0.015	0.01~0.03	3D MILLING
UNBX0808	19	40	14000~15000	150~300	0.01~0.02	0.8	SLOTTING
UNBX0808	19	40	14000~15000	150~300	0.005~0.015	0.01~0.03	3D MILLING
UNBX0808	19	40	14000~15000	150~300	0.005~0.015	0.01~0.03	3D MILLING
UNBX1004	11	45	13000~14000	200~400	0.01~0.02	1	SLOTTING
UNBX1004	11	45	13000~14000	300~500	0.02~0.04	0.04~0.08	3D MILLING
UNBX1004	11	45	13000~14000	500~700	0.008~0.015	0.016~0.03	3D MILLING
UNBX1006	13	45	13000~14000	200~400	0.01~0.02	1	SLOTTING
UNBX1006	13	45	13000~14000	300~500	0.02~0.04	0.04~0.08	3D MILLING
UNBX1006	13	45	13000~14000	500~700	0.008~0.015	0.016~0.03	3D MILLING
UNBX1008	15	45	13000~14000	200~400	0.01~0.02	1	SLOTTING
UNBX1008	15	45	13000~14000	200~400	0.02~0.04	0.04~0.08	3D MILLING
UNBX1008	15	45	13000~14000	500~700	0.008~0.015	0.016~0.03	3D MILLING
UNBX1010	17	45	13000~14000	200~400	0.01~0.02	1	SLOTTING
UNBX1010	17	45	13000~14000	200~400	0.02~0.04	0.04~0.08	3D MILLING
UNBX1010	17	45	13000~14000	500~700	0.008~0.015	0.016~0.03	3D MILLING
UNBX1012	19	45	13000~14000	150~300	0.01~0.02	1	SLOTTING
UNBX1012	19	45	13000~14000	150~300	0.015~0.025	0.03~0.05	3D MILLING
UNBX1012	19	45	13000~14000	300~400	0.008~0.015	0.016~0.03	3D MILLING

Type No.	Extension Length (mm)	Cutting Speed (m/min)	Speed (min^{-1})	Feed (mm/min)	(Aa) Depth of Cut	(A_P) Width of Cut	Milling Type
UNBX1208	15	50	12000~13000	200~400	0.02~0.04	1.2	SLOTTING
UNBX1208	15	50	12000~13000	300~500	0.02~0.04	0.04~0.08	3D MILLING
UNBX1208	15	50	12000~13000	500~700	0.01~0.02	0.02~0.04	3D MILLING
UNBX1212	19	50	12000~13000	200~400	0.01~0.03	1.2	SLOTTING
UNBX1212	19	50	12000~13000	200~400	0.008~0.015	0.016~0.03	3D MILLING
UNBX1212	19	50	12000~13000	200~400	0.008~0.015	0.016~0.03	3D MILLING
UNBX1506	13	60	11000~12000	400~600	0.03~0.05	1.5	SLOTTING
UNBX1506	13	60	11000~12000	600~800	0.01~0.03	1.5	SLOTTING
UNBX1506	13	60	11000~12000	400~600	0.04~0.06	0.08~0.12	3D MILLING
UNBX1506	13	60	11000~12000	700~900	0.01~0.03	0.02~0.06	3D MILLING
UNBX1508	14	60	11000~12000	300~500	0.03~0.05	1.5	SLOTTING
UNBX1508	14	60	11000~12000	500~700	0.01~0.03	1.5	SLOTTING
UNBX1508	14	60	11000~12000	400~600	0.04~0.06	0.08~0.12	3D MILLING
UNBX1508	14	60	11000~12000	700~900	0.01~0.03	0.02~0.06	3D MILLING
UNBX1510	16	60	11000~12000	300~500	0.02~0.04	1.5	SLOTTING
UNBX1510	16	60	11000~12000	500~700	0.01~0.02	1.5	SLOTTING
UNBX1510	16	60	11000~12000	300~500	0.03~0.05	0.06~0.1	3D MILLING
UNBX1510	16	60	11000~12000	500~700	0.01~0.025	0.02~0.05	3D MILLING
UNBX1512	18	60	11000~12000	300~500	0.02~0.04	1.5	SLOTTING
UNBX1512	18	60	11000~12000	500~700	0.01~0.02	1.5	SLOTTING
UNBX1512	18	60	11000~12000	300~500	0.03~0.05	0.06~0.1	3D MILLING
UNBX1512	18	60	11000~12000	500~700	0.01~0.025	0.02~0.05	3D MILLING
UNBX1516	22	60	11000~12000	200~400	0.01~0.02	1.5	SLOTTING
UNBX1516	22	60	11000~12000	200~400	0.01~0.02	1.5	SLOTTING
UNBX1516	22	60	11000~12000	300~500	0.02~0.04	0.04~0.08	3D MILLING
UNBX1516	22	60	11000~12000	500~700	0.01~0.02	0.02~0.04	3D MILLING
UNBX1520	26	60	11000~12000	150~300	0.01~0.02	1.5	SLOTTING
UNBX1520	26	60	11000~12000	150~300	0.01~0.02	1.5	SLOTTING
UNBX1520	26	60	11000~12000	150~300	0.02~0.04	0.04~0.08	3D MILLING
UNBX1520	26	60	11000~12000	300~500	0.008~0.015	0.016~0.03	3D MILLING
UNBX1608	14	60	11000~12000	300~500	0.03~0.05	1.6	SLOTTING
UNBX1608	14	60	11000~12000	500~700	0.01~0.03	1.6	SLOTTING
UNBX1608	14	60	11000~12000	400~600	0.04~0.06	0.08~0.12	3D MILLING
UNBX1608	14	60	11000~12000	700~900	0.015~0.03	0.03~0.06	3D MILLING
UNBX1612	16	60	11000~12000	200~400	0.02~0.04	1.6	SLOTTING
UNBX1612	16	60	11000~12000	400~600	0.01~0.02	1.6	SLOTTING
UNBX1612	16	60	11000~12000	300~500	0.03~0.05	0.06~0.1	3D MILLING
UNBX1612	16	60	11000~12000	500~700	0.01~0.03	0.02~0.06	3D MILLING
UNBX1616	20	60	11000~12000	200~400	0.01~0.02	1.6	SLOTTING
UNBX1616	20	60	11000~12000	200~400	0.01~0.02	1.6	SLOTTING
UNBX1616	20	60	11000~12000	200~400	0.01~0.03	0.02~0.06	3D MILLING
UNBX1616	20	60	11000~12000	200~400	0.01~0.03	0.02~0.06	3D MILLING
UNBX2008	14	70	10000~11000	400~600	0.04~0.06	2	SLOTTING
UNBX2008	14	70	10000~11000	700~900	0.01~0.03	2	SLOTTING
UNBX2008	14	70	10000~11000	400~600	0.05~0.07	0.1~0.14	3D MILLING
UNBX2008	14	70	10000~11000	800~1000	0.015~0.035	0.03~0.07	3D MILLING
UNBX2010	16	70	10000~11000	300~500	0.03~0.05	2	SLOTTING
UNBX2010	16	70	10000~11000	500~700	0.01~0.03	2	SLOTTING
UNBX2010	16	70	10000~11000	400~600	0.04~0.06	0.08~0.12	3D MILLING
UNBX2010	16	70	10000~11000	800~1000	0.01~0.03	0.02~0.06	3D MILLING
UNBX2012	18	70	10000~11000	300~500	0.03~0.05	2	SLOTTING
UNBX2012	18	70	10000~11000	500~700	0.01~0.03	2	SLOTTING
UNBX2012	18	70	10000~11000	400~600	0.04~0.06	0.08~0.12	3D MILLING
UNBX2012	18	70	10000~11000	800~1000	0.01~0.03	0.02~0.06	3D MILLING
UNBX2016	22	70	10000~11000	200~400	0.02~0.04	2	SLOTTING
UNBX2016	22	70	10000~11000	400~600	0.01~0.02	2	SLOTTING
UNBX2016	22	70	10000~11000	300~500	0.03~0.05	0.09~0.1	3D MILLING
UNBX2016	22	70	10000~11000	500~700	0.01~0.03	0.02~0.06	3D MILLING

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Type No.	Extension Length (mm)	Cutting Speed (m/min)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_P) Width of Cut	Milling Type
UNBX2020	26	70	10000~11000	200~400	0.01~0.02	2	SLOTTING
UNBX2020	26	70	10000~11000	200~400	0.01~0.02	2	SLOTTING
UNBX2020	26	70	10000~11000	200~400	0.01~0.03	0.02~0.06	3D MILLING
UNBX2020	26	70	10000~11000	200~400	0.01~0.03	0.02~0.06	3D MILLING
UNBX3008	16	85	8000~9000	600~800	0.06~0.08	3	SLOTTING
UNBX3008	16	85	8000~9000	1000~1200	0.02~0.04	3	SLOTTING
UNBX3008	16	85	8000~9000	600~800	0.09~0.11	0.18~0.22	3D MILLING
UNBX3008	16	85	8000~9000	1000~1400	0.03~0.065	0.06~0.13	3D MILLING
UNBX3010	18	85	8000~9000	500~700	0.06~0.08	3	SLOTTING
UNBX3010	18	85	8000~9000	800~1000	0.02~0.04	3	SLOTTING
UNBX3010	18	85	8000~9000	500~700	0.09~0.11	0.18~0.22	3D MILLING
UNBX3010	18	85	8000~9000	900~1300	0.03~0.065	0.06~0.13	3D MILLING
UNBX3012	20	85	8000~9000	500~700	0.05~0.07	3	SLOTTING
UNBX3012	20	85	8000~9000	800~1000	0.02~0.04	3	SLOTTING
UNBX3012	20	85	8000~9000	500~700	0.08~0.1	0.16~0.2	3D MILLING
UNBX3012	20	85	8000~9000	900~1300	0.02~0.06	0.04~0.12	3D MILLING
UNBX3016	24	85	8000~9000	400~600	0.05~0.07	3	SLOTTING
UNBX3016	24	85	8000~9000	700~1100	0.015~0.035	3	SLOTTING
UNBX3016	24	85	8000~9000	400~600	0.08~0.1	0.16~0.2	3D MILLING
UNBX3016	24	85	8000~9000	800~1200	0.02~0.05	0.04~0.1	3D MILLING
UNBX3020	28	85	8000~9000	300~500	0.03~0.05	3	SLOTTING
UNBX3020	28	85	8000~9000	500~700	0.01~0.03	3	SLOTTING
UNBX3020	28	85	8000~9000	400~600	0.06~0.08	0.12~0.16	3D MILLING
UNBX3020	28	85	8000~9000	800~1000	0.015~0.035	0.03~0.07	3D MILLING
UNBX3025	33	85	8000~9000	200~400	0.02~0.04	3	SLOTTING
UNBX3025	33	85	8000~9000	400~600	0.008~0.02	3	SLOTTING
UNBX3025	33	85	8000~9000	300~500	0.04~0.06	0.08~0.12	3D MILLING
UNBX3025	33	85	8000~9000	700~900	0.01~0.025	0.02~0.05	3D MILLING
UNBX4010	20	100	6000~8000	600~800	0.07~0.09	4	SLOTTING
UNBX4010	20	100	6000~8000	1000~1400	0.03~0.05	4	SLOTTING
UNBX4010	20	100	6000~8000	800~1000	0.11~0.13	0.22~0.26	3D MILLING
UNBX4010	20	100	6000~8000	1400~1800	0.035~0.07	0.07~0.14	3D MILLING
UNBX4015	25	100	6000~8000	400~600	0.06~0.08	4	SLOTTING
UNBX4015	25	100	6000~8000	800~1000	0.025~0.05	4	SLOTTING
UNBX4015	25	100	6000~8000	600~800	0.07~0.09	0.14~0.18	3D MILLING
UNBX4015	25	100	6000~8000	1200~1600	0.03~0.06	0.06~0.12	3D MILLING
UNBX4020	30	100	6000~8000	400~600	0.05~0.07	4	SLOTTING
UNBX4020	30	100	6000~8000	800~1000	0.015~0.03	4	SLOTTING
UNBX4020	30	100	6000~8000	600~800	0.06~0.08	0.12~0.16	3D MILLING
UNBX4020	30	100	6000~8000	1200~1600	0.025~0.05	0.05~0.1	3D MILLING
UNBX4025	35	100	6000~8000	300~500	0.04~0.06	4	SLOTTING
UNBX4025	35	100	6000~8000	700~900	0.015~0.03	4	SLOTTING
UNBX4025	35	100	6000~8000	500~700	0.05~0.07	0.1~0.14	3D MILLING
UNBX4025	35	100	6000~8000	900~1100	0.015~0.03	0.03~0.06	3D MILLING
UNBX4030	40	100	6000~8000	200~400	0.04~0.06	4	SLOTTING
UNBX4030	40	100	6000~8000	500~700	0.015~0.03	4	SLOTTING
UNBX4030	40	100	6000~8000	400~600	0.04~0.06	0.08~0.12	3D MILLING
UNBX4030	40	100	6000~8000	800~1000	0.01~0.03	0.02~0.06	3D MILLING

UNBX 4 Flute MILLING CONDITIONS

DHF ITALIA

Work Material	*Hardened Steels :* **SKD61/STAVAX/1.2083/17-4PH** (HRc52)
Coolant Type	MQL coolant

型號 Type No.	Extension Length (mm)	Cutting Speed (m/min)	Speed (min^{-1})	Feed (mm/min)	(Aa) Depth of Cut	(Ap) Width of Cut	Milling Type
UNBX100404	11	60	17000~18000	600~800	0.015~0.035	1	SLOTTING
UNBX100404	11	60	17000~18000	900~1100	0.02~0.04	0.04~0.08	3D MILLING
UNBX100604	13	60	17000~18000	500~700	0.015~0.035	1	SLOTTING
UNBX100604	13	60	17000~18000	800~1000	0.02~0.04	0.04~0.08	3D MILLING
UNBX100804	15	60	17000~18000	400~600	0.015~0.035	1	SLOTTING
UNBX100804	15	60	17000~18000	700~900	0.02~0.04	0.04~0.08	3D MILLING
UNBX101004	17	60	17000~18000	300~500	0.01~0.025	1	SLOTTING
UNBX101004	17	60	17000~18000	600~800	0.02~0.03	0.04~0.06	3D MILLING
UNBX101204	19	60	17000~18000	300~500	0.01~0.025	1	SLOTTING
UNBX101204	19	60	17000~18000	600~800	0.01~0.025	0.02~0.05	3D MILLING
UNBX150604	13	80	16000~17000	600~800	0.02~0.04	1.5	SLOTTING
UNBX150604	13	80	16000~17000	900~1100	0.03~0.05	0.06~0.1	3D MILLING
UNBX150804	15	80	16000~17000	500~700	0.02~0.04	1.5	SLOTTING
UNBX150804	15	80	16000~17000	800~1000	0.03~0.05	0.06~0.1	3D MILLING
UNBX151004	17	80	16000~17000	400~600	0.015~0.035	1.5	SLOTTING
UNBX151004	17	80	16000~17000	700~900	0.02~0.04	0.04~0.08	3D MILLING
UNBX151204	19	80	16000~17000	300~500	0.015~0.035	1.5	SLOTTING
UNBX151204	19	80	16000~17000	600~800	0.02~0.04	0.04~0.08	3D MILLING
UNBX151604	23	80	16000~17000	200~400	0.015~0.035	1.5	SLOTTING
UNBX151604	23	80	16000~17000	500~700	0.02~0.04	0.04~0.08	3D MILLING
UNBX200804	14	100	15000~16000	600~800	0.03~0.06	2	SLOTTING
UNBX200804	14	100	15000~16000	1000~1400	0.03~0.06	0.06~0.12	3D MILLING
UNBX201004	16	100	15000~16000	600~800	0.03~0.06	2	SLOTTING
UNBX201004	16	100	15000~16000	1000~1200	0.03~0.06	0.06~0.12	3D MILLING
UNBX201204	18	100	15000~16000	500~700	0.03~0.06	2	SLOTTING
UNBX201204	18	100	15000~16000	900~1100	0.03~0.06	0.06~0.12	3D MILLING
UNBX201604	22	100	15000~16000	500~700	0.02~0.05	2	SLOTTING
UNBX201604	22	100	15000~16000	900~1100	0.02~0.04	0.04~0.08	3D MILLING
UNBX202004	26	100	15000~16000	400~600	0.02~0.05	2	SLOTTING
UNBX202004	26	100	15000~16000	700~900	0.02~0.04	0.04~0.08	3D MILLING
UNBX300804	19	145	14000~15000	900~1100	0.04~0.08	3	SLOTTING
UNBX300804	19	145	14000~15000	1400~1800	0.04~0.08	0.08~0.16	3D MILLING
UNBX301004	21	145	14000~15000	900~1100	0.04~0.08	3	SLOTTING
UNBX301004	21	145	14000~15000	1400~1800	0.04~0.08	0.08~0.16	3D MILLING
UNBX301204	23	145	14000~15000	800~1000	0.04~0.08	3	SLOTTING
UNBX301204	23	145	14000~15000	1300~1700	0.04~0.08	0.08~0.16	3D MILLING
UNBX301604	27	145	14000~15000	700~900	0.03~0.06	3	SLOTTING
UNBX301604	27	145	14000~15000	1200~1600	0.03~0.07	0.06~0.14	3D MILLING
UNBX302004	31	145	14000~15000	700~900	0.02~0.05	3	SLOTTING
UNBX302004	31	145	14000~15000	1200~1600	0.02~0.06	0.04~0.12	3D MILLING
UNBX302504	36	145	14000~15000	600~800	0.01~0.03	3	SLOTTING
UNBX302504	36	145	14000~15000	1100~1500	0.02~0.05	0.04~0.1	3D MILLING
UNBX401004	26	165	11000~13000	1100~1500	0.04~0.08	4	SLOTTING
UNBX401004	26	165	11000~13000	1600~2000	0.04~0.09	0.08~0.18	3D MILLING
UNBX401204	28	165	11000~13000	1100~1500	0.04~0.08	4	SLOTTING
UNBX401204	28	165	11000~13000	1600~2000	0.04~0.09	0.08~0.18	3D MILLING
UNBX401604	32	165	11000~13000	1000~1400	0.03~0.06	4	SLOTTING
UNBX401604	32	165	11000~13000	1600~2000	0.03~0.08	0.06~0.16	3D MILLING
UNBX402004	36	165	11000~13000	1000~1200	0.03~0.06	4	SLOTTING
UNBX402004	36	165	11000~13000	1400~1800	0.02~0.05	0.04~0.1	3D MILLING
UNBX402504	41	165	11000~13000	800~1000	0.03~0.06	4	SLOTTING
UNBX402504	41	165	11000~13000	1200~1600	0.02~0.05	0.04~0.1	3D MILLING

UNBX 4 Flute MILLING CONDITIONS

DHF ITALIA

Work Material	*Hardened Steels :* **SKD11 /1.2379/D2** (HRc62)
Coolant Type	MQL coolant

Type No.	Extension Length (mm)	Cutting Speed (m/min)	Speed (min^{-1})	Feed (mm/min)	(Aa) Depth of Cut	(Ap) Width of Cut	Milling Type
UNBX100404	11	50	15000~16000	400~600	0.01~0.025	1	SLOTTING
UNBX100404	11	50	15000~16000	700~900	0.01~0.03	0.02~0.06	3D MILLING
UNBX100604	13	50	15000~16000	400~600	0.01~0.025	1	SLOTTING
UNBX100604	13	50	15000~16000	700~900	0.01~0.03	0.02~0.06	3D MILLING
UNBX100804	15	50	15000~16000	300~500	0.01~0.025	1	SLOTTING
UNBX100804	15	50	15000~16000	600~800	0.01~0.03	0.02~0.06	3D MILLING
UNBX101004	17	50	15000~16000	200~400	0.01~0.02	1	SLOTTING
UNBX101004	17	50	15000~16000	400~600	0.008~0.015	0.016~0.03	3D MILLING
UNBX101204	19	50	15000~16000	200~400	0.01~0.02	1	SLOTTING
UNBX101204	19	50	15000~16000	400~600	0.008~0.015	0.016~0.03	3D MILLING
UNBX150604	13	65	13000~14000	500~700	0.01~0.03	1.5	SLOTTING
UNBX150604	13	65	13000~14000	800~1000	0.02~0.04	0.04~0.08	3D MILLING
UNBX150804	15	65	13000~14000	400~600	0.01~0.03	1.5	SLOTTING
UNBX150804	15	65	13000~14000	700~900	0.02~0.04	0.04~0.08	3D MILLING
UNBX151004	17	65	13000~14000	300~500	0.01~0.02	1.5	SLOTTING
UNBX151004	17	65	13000~14000	600~800	0.02~0.03	0.04~0.06	3D MILLING
UNBX151204	19	65	13000~14000	300~500	0.01~0.02	1.5	SLOTTING
UNBX151204	19	65	13000~14000	600~800	0.02~0.03	0.04~0.06	3D MILLING
UNBX151604	23	65	13000~14000	200~400	0.01~0.02	1.5	SLOTTING
UNBX151604	23	65	13000~14000	500~700	0.01~0.02	0.02~0.04	3D MILLING
UNBX200804	14	85	12000~13000	500~700	0.02~0.05	2	SLOTTING
UNBX200804	14	85	12000~13000	700~1100	0.02~0.05	0.04~0.1	3D MILLING
UNBX201004	16	85	12000~13000	500~700	0.02~0.05	2	SLOTTING
UNBX201004	16	85	12000~13000	700~1100	0.02~0.05	0.04~0.1	3D MILLING
UNBX201204	18	85	12000~13000	400~600	0.02~0.04	2	SLOTTING
UNBX201204	18	85	12000~13000	600~1000	0.02~0.05	0.04~0.1	3D MILLING
UNBX201604	22	85	12000~13000	300~500	0.01~0.03	2	SLOTTING
UNBX201604	22	85	12000~13000	500~900	0.01~0.04	0.02~0.08	3D MILLING
UNBX202004	26	85	12000~13000	200~400	0.01~0.02	2	SLOTTING
UNBX202004	26	85	12000~13000	400~800	0.01~0.03	0.02~0.06	3D MILLING
UNBX300804	19	115	10000~12000	800~1000	0.03~0.06	3	SLOTTING
UNBX300804	19	115	10000~12000	1300~1700	0.03~0.07	0.06~0.14	3D MILLING
UNBX301004	21	115	10000~12000	800~1000	0.03~0.06	3	SLOTTING
UNBX301004	21	115	10000~12000	1300~1700	0.03~0.07	0.06~0.14	3D MILLING
UNBX301204	23	115	10000~12000	700~900	0.03~0.06	3	SLOTTING
UNBX301204	23	115	10000~12000	1200~1600	0.03~0.07	0.06~0.14	3D MILLING
UNBX301604	27	115	10000~12000	600~800	0.02~0.05	3	SLOTTING
UNBX301604	27	115	10000~12000	1000~1400	0.02~0.05	0.04~0.1	3D MILLING
UNBX302004	31	115	10000~12000	500~700	0.02~0.04	3	SLOTTING
UNBX302004	31	115	10000~12000	1000~1400	0.02~0.04	0.04~0.08	3D MILLING
UNBX302504	36	115	10000~12000	400~600	0.02~0.04	3	SLOTTING
UNBX302504	36	115	10000~12000	600~1000	0.02~0.04	0.04~0.08	3D MILLING
UNBX401004	26	115	7000~9000	800~1200	0.03~0.07	4	SLOTTING
UNBX401004	26	115	7000~9000	1200~1600	0.04~0.08	0.08~0.16	3D MILLING
UNBX401204	28	115	7000~9000	800~1200	0.03~0.07	4	SLOTTING
UNBX401204	28	115	7000~9000	1200~1600	0.04~0.08	0.08~0.16	3D MILLING
UNBX401604	32	115	7000~9000	600~1000	0.02~0.06	4	SLOTTING
UNBX401604	32	115	7000~9000	1000~1400	0.03~0.07	0.06~0.14	3D MILLING
UNBX402004	36	115	7000~9000	600~800	0.02~0.05	4	SLOTTING
UNBX402004	36	115	7000~9000	800~1200	0.02~0.06	0.04~0.12	3D MILLING
UNBX402504	41	115	7000~9000	500~700	0.02~0.05	4	SLOTTING
UNBX402504	41	115	7000~9000	600~1000	0.02~0.06	0.04~0.12	3D MILLING

LNB MILLING CONDITIONS

DHF ITALIA

Work Material	*Stainless Steels :* **SUS316/1.4401, SUS304/1.4301** (HRc30)					
Coolant Type	Wet coolant					
Type No.	Extension Length (mm)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_p) Width of Cut	Milling Type
LNB1006	18	13000~14000	600~800	0.04~0.06	1	SLOTTING
LNB1006	18	13000~14000	800~1000	0.01~0.03	1	SLOTTING
LNB1006	18	14000~15000	800~1000	0.05~0.07	0.1~0.14	3D MILLING
LNB1006	18	14000~15000	1200~1600	0.01~0.03	0.02~0.06	3D MILLING
LNB1008	20	13000~14000	600~800	0.04~0.05	1	SLOTTING
LNB1008	20	13000~14000	800~1000	0.01~0.03	1	SLOTTING
LNB1008	20	14000~15000	800~1000	0.04~0.06	0.08~0.12	3D MILLING
LNB1008	20	14000~15000	1200~1600	0.01~0.03	0.02~0.06	3D MILLING
LNB1010	22	13000~14000	400~600	0.04~0.05	1	SLOTTING
LNB1010	22	13000~14000	600~800	0.01~0.03	1	SLOTTING
LNB1010	22	14000~15000	600~800	0.04~0.06	0.08~0.12	3D MILLING
LNB1010	22	14000~15000	1000~1200	0.01~0.03	0.02~0.06	3D MILLING
LNB1012	24	13000~14000	350~550	0.02~0.04	1	SLOTTING
LNB1012	24	13000~14000	550~750	0.01~0.02	1	SLOTTING
LNB1012	24	14000~15000	550~750	0.04~0.06	0.08~0.12	3D MILLING
LNB1012	24	14000~15000	750~950	0.01~0.025	0.02~0.05	3D MILLING
LNB1508	16	12000~13000	1000~1200	0.04~0.06	1.5	SLOTTING
LNB1508	16	12000~13000	1200~1400	0.01~0.035	1.5	SLOTTING
LNB1508	16	13000~14000	1400~1600	0.06~0.08	0.12~0.16	3D MILLING
LNB1508	16	13000~14000	1600~2000	0.01~0.045	0.02~0.09	3D MILLING
LNB1510	18	12000~13000	800~1000	0.04~0.06	1.5	SLOTTING
LNB1510	18	12000~13000	1000~1200	0.01~0.03	1.5	SLOTTING
LNB1510	18	13000~14000	1200~1400	0.06~0.08	0.12~0.16	3D MILLING
LNB1510	18	13000~14000	1400~1800	0.01~0.04	0.02~0.08	3D MILLING
LNB1512	20	12000~13000	800~1000	0.04~0.06	1.5	SLOTTING
LNB1512	20	12000~13000	1000~1200	0.01~0.03	1.5	SLOTTING
LNB1512	20	13000~14000	1200~1400	0.06~0.08	0.12~0.16	3D MILLING
LNB1512	20	13000~14000	1400~1800	0.01~0.035	0.02~0.07	3D MILLING
LNB1516	24	12000~13000	600~800	0.03~0.05	1.5	SLOTTING
LNB1516	24	12000~13000	800~1000	0.01~0.02	1.5	SLOTTING
LNB1516	24	13000~14000	1000~1200	0.04~0.06	0.08~0.12	3D MILLING
LNB1516	24	13000~14000	1200~1600	0.01~0.03	0.02~0.06	3D MILLING
LNB1520	28	12000~13000	400~600	0.02~0.04	1.5	SLOTTING
LNB1520	28	12000~13000	600~800	0.01~0.015	1.5	SLOTTING
LNB1520	28	13000~14000	800~1000	0.04~0.05	0.08~0.1	3D MILLING
LNB1520	28	13000~14000	1000~1200	0.01~0.025	0.02~0.05	3D MILLING
LNB2008	16	11000~12000	1000~1200	0.06~0.08	2	SLOTTING
LNB2008	16	11000~12000	1200~1600	0.015~0.04	2	SLOTTING
LNB2008	16	12000~13000	1400~1600	0.1~0.12	0.2~0.24	3D MILLING
LNB2008	16	12000~13000	2000~2400	0.01~0.04	0.02~0.08	3D MILLING
LNB2010	18	11000~12000	800~1000	0.06~0.08	2	SLOTTING
LNB2010	18	11000~12000	1200~1400	0.01~0.03	2	SLOTTING
LNB2010	18	12000~13000	1200~1400	0.08~0.1	0.16~0.2	3D MILLING
LNB2010	18	12000~13000	1800~2000	0.01~0.035	0.02~0.07	3D MILLING
LNB2012	20	11000~12000	800~1000	0.05~0.07	2	SLOTTING
LNB2012	20	11000~12000	1200~1400	0.01~0.025	2	SLOTTING
LNB2012	20	12000~13000	800~1000	0.08~0.1	0.16~0.2	3D MILLING
LNB2012	20	12000~13000	1600~2000	0.01~0.035	0.02~0.07	3D MILLING
LNB2016	24	11000~12000	600~800	0.03~0.05	2	SLOTTING
LNB2016	24	11000~12000	1000~1200	0.01~0.02	2	SLOTTING
LNB2016	24	12000~13000	800~1000	0.06~0.08	0.12~0.16	3D MILLING
LNB2016	24	12000~13000	1400~1600	0.01~0.035	0.02~0.07	3D MILLING

Type No.	Extension Length (mm)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_p) Width of Cut	Milling Type
LNB2020	26	11000~12000	600~800	0.02~0.04	2	SLOTTING
LNB2020	26	11000~12000	800~1000	0.01~0.02	2	SLOTTING
LNB2020	26	12000~13000	800~1000	0.06~0.08	0.12~0.16	3D MILLING
LNB2020	26	12000~13000	1200~1400	0.01~0.035	0.02~0.07	3D MILLING
LNB3008	18	10000~11000	1200~1400	0.1~0.12	3	SLOTTING
LNB3008	18	10000~11000	1600~1800	0.015~0.05	3	SLOTTING
LNB3008	18	11000~12000	1800~2000	0.1~0.12	0.2~0.24	3D MILLING
LNB3008	18	11000~12000	2200~2400	0.025~0.06	0.05~0.12	3D MILLING
LNB3010	20	10000~11000	1000~1200	0.08~0.1	3	SLOTTING
LNB3010	20	10000~11000	1600~1800	0.015~0.045	3	SLOTTING
LNB3010	20	11000~12000	1600~1800	0.1~0.12	0.2~0.24	3D MILLING
LNB3010	20	11000~12000	2000~2400	0.025~0.06	0.05~0.12	3D MILLING
LNB3012	22	10000~11000	1000~1200	0.08~0.1	3	SLOTTING
LNB3012	22	10000~11000	1600~1800	0.015~0.045	3	SLOTTING
LNB3012	22	11000~12000	1600~1800	0.1~0.12	0.2~0.24	3D MILLING
LNB3012	22	11000~12000	2000~2400	0.025~0.06	0.05~0.12	3D MILLING
LNB3016	26	10000~11000	800~1000	0.06~0.08	3	SLOTTING
LNB3016	26	10000~11000	1200~1400	0.01~0.04	3	SLOTTING
LNB3016	26	11000~12000	1000~1200	0.08~0.1	0.16~0.2	3D MILLING
LNB3016	26	11000~12000	1400~1800	0.02~0.05	0.04~0.1	3D MILLING
LNB3020	30	10000~11000	600~800	0.04~0.06	3	SLOTTING
LNB3020	30	10000~11000	800~1000	0.01~0.04	3	SLOTTING
LNB3020	30	11000~12000	800~1000	0.06~0.08	0.12~0.16	3D MILLING
LNB3020	30	11000~12000	1200~1600	0.015~0.04	0.03~0.08	3D MILLING
LNB3025	35	10000~11000	400~600	0.04~0.06	3	SLOTTING
LNB3025	35	10000~11000	700~900	0.01~0.03	3	SLOTTING
LNB3025	35	11000~12000	600~800	0.04~0.06	0.08~0.12	3D MILLING
LNB3025	35	11000~12000	1000~1400	0.015~0.03	0.03~0.06	3D MILLING
LNB4012	23	9000~10000	1400~1600	0.1~0.12	4	SLOTTING
LNB4012	23	9000~10000	1600~2000	0.025~0.06	4	SLOTTING
LNB4012	23	10000~11000	1600~2000	0.12~0.14	0.24~0.28	3D MILLING
LNB4012	23	10000~11000	2400~2600	0.03~0.07	0.06~0.14	3D MILLING
LNB4016	27	9000~10000	1000~1200	0.08~0.1	4	SLOTTING
LNB4016	27	9000~10000	1400~1600	0.025~0.05	4	SLOTTING
LNB4016	27	10000~11000	1400~1600	0.12~0.14	0.24~0.28	3D MILLING
LNB4016	27	10000~11000	1600~2000	0.03~0.07	0.06~0.14	3D MILLING
LNB4020	31	9000~10000	1000~1200	0.08~0.1	4	SLOTTING
LNB4020	31	9000~10000	1200~1500	0.025~0.05	4	SLOTTING
LNB4020	31	10000~11000	1200~1400	0.1~0.12	0.2~0.24	3D MILLING
LNB4020	31	10000~11000	1600~2000	0.03~0.07	0.06~0.14	3D MILLING
LNB4025	36	9000~10000	800~1000	0.06~0.08	4	SLOTTING
LNB4025	36	9000~10000	1200~1500	0.02~0.045	4	SLOTTING
LNB4025	36	10000~11000	1200~1400	0.08~0.1	0.16~0.2	3D MILLING
LNB4025	36	10000~11000	1600~2000	0.025~0.06	0.05~0.12	3D MILLING
LNB4030	40	9000~10000	800~1000	0.04~0.06	4	SLOTTING
LNB4030	40	9000~10000	1200~1500	0.015~0.03	4	SLOTTING
LNB4030	40	10000~11000	1200~1400	0.06~0.08	0.12~0.16	3D MILLING
LNB4030	40	10000~11000	1600~2000	0.015~0.05	0.03~0.1	3D MILLING

LNB MILLING CONDITIONS

DHF ITALIA

Work Material	*Plastic Mould Steels* : **P3/P5/P20/1.2311** (HRc32)					
Coolant Type	Wet coolant					
Type No.	Extension Length (mm)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_p) Width of Cut	Milling Type
LNB1006	18	17000~18000	700~900	0.04~0.06	1	SLOTTING
LNB1006	18	17000~18000	1000~1400	0.01~0.03	1	SLOTTING
LNB1006	18	17000~18000	1000~1200	0.05~0.07	0.1~0.14	3D MILLING
LNB1006	18	17000~18000	1400~1600	0.01~0.03	0.02~0.06	3D MILLING
LNB1008	20	17000~18000	600~800	0.04~0.05	1	SLOTTING
LNB1008	20	17000~18000	900~1100	0.01~0.03	1	SLOTTING
LNB1008	20	17000~18000	1000~1200	0.05~0.07	0.1~0.14	3D MILLING
LNB1008	20	17000~18000	1400~1600	0.01~0.03	0.02~0.06	3D MILLING
LNB1010	22	17000~18000	500~700	0.04~0.05	1	SLOTTING
LNB1010	22	17000~18000	900~1100	0.01~0.03	1	SLOTTING
LNB1010	22	17000~18000	800~1000	0.04~0.06	0.08~0.12	3D MILLING
LNB1010	22	17000~18000	1200~1400	0.01~0.03	0.02~0.06	3D MILLING
LNB1012	24	17000~18000	400~600	0.02~0.04	1	SLOTTING
LNB1012	24	17000~18000	600~800	0.01~0.02	1	SLOTTING
LNB1012	24	17000~18000	600~800	0.04~0.06	0.08~0.12	3D MILLING
LNB1012	24	17000~18000	800~1000	0.01~0.03	0.02~0.06	3D MILLING
LNB1508	16	16000~17000	1000~1400	0.08~0.1	1.5	SLOTTING
LNB1508	16	16000~17000	1600~2000	0.01~0.04	1.5	SLOTTING
LNB1508	16	16000~17000	1600~1800	0.12~0.14	0.24~0.28	3D MILLING
LNB1508	16	16000~17000	2200~2600	0.02~0.045	0.04~0.09	3D MILLING
LNB1510	18	16000~17000	800~1200	0.08~0.1	1.5	SLOTTING
LNB1510	18	16000~17000	1400~1800	0.01~0.04	1.5	SLOTTING
LNB1510	18	16000~17000	1400~1600	0.1~0.12	0.2~0.24	3D MILLING
LNB1510	18	16000~17000	2000~2400	0.02~0.04	0.04~0.08	3D MILLING
LNB1512	20	16000~17000	600~1000	0.06~0.08	1.5	SLOTTING
LNB1512	20	16000~17000	1200~1600	0.01~0.04	1.5	SLOTTING
LNB1512	20	16000~17000	1400~1600	0.1~0.12	0.2~0.24	3D MILLING
LNB1512	20	16000~17000	2000~2400	0.02~0.04	0.04~0.08	3D MILLING
LNB1516	24	16000~17000	500~800	0.04~0.06	1.5	SLOTTING
LNB1516	24	16000~17000	1000~1200	0.01~0.03	1.5	SLOTTING
LNB1516	24	16000~17000	1200~1400	0.08~0.1	0.16~0.2	3D MILLING
LNB1516	24	16000~17000	1800~2200	0.015~0.04	0.03~0.08	3D MILLING
LNB1520	28	16000~17000	400~600	0.04~0.06	1.5	SLOTTING
LNB1520	28	16000~17000	600~1000	0.01~0.03	1.5	SLOTTING
LNB1520	28	16000~17000	1000~1200	0.06~0.08	0.12~0.16	3D MILLING
LNB1520	28	16000~17000	1400~1800	0.015~0.03	0.03~0.06	3D MILLING
LNB2008	16	15000~16000	1800~2200	0.12~0.14	2	SLOTTING
LNB2008	16	15000~16000	2400~2800	0.02~0.07	2	SLOTTING
LNB2008	16	15000~16000	2400~2600	0.16~0.18	0.32~0.36	3D MILLING
LNB2008	16	15000~16000	3000~3400	0.02~0.05	0.04~0.1	3D MILLING
LNB2010	18	15000~16000	1800~2200	0.12~0.14	2	SLOTTING
LNB2010	18	15000~16000	2400~2800	0.02~0.07	2	SLOTTING
LNB2010	18	15000~16000	2400~2600	0.16~0.18	0.32~0.36	3D MILLING
LNB2010	18	15000~16000	3000~3400	0.02~0.05	0.04~0.1	3D MILLING
LNB2012	20	15000~16000	1600~2000	0.1~0.12	2	SLOTTING
LNB2012	20	15000~16000	2200~2600	0.015~0.05	2	SLOTTING
LNB2012	20	15000~16000	2200~2400	0.14~0.16	0.28~0.32	3D MILLING
LNB2012	20	15000~16000	2600~3000	0.015~0.05	0.03~0.1	3D MILLING
LNB2016	24	15000~16000	1400~1800	0.1~0.12	2	SLOTTING
LNB2016	24	15000~16000	2000~2400	0.015~0.05	2	SLOTTING
LNB2016	24	15000~16000	1800~2000	0.12~0.14	0.24~0.28	3D MILLING
LNB2016	24	15000~16000	2400~2800	0.015~0.05	0.03~0.1	3D MILLING

Type No.	Extension Length (mm)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_p) Width of Cut	Milling Type
LNB2020	26	15000~16000	1200~1600	0.08~0.1	2	SLOTTING
LNB2020	26	15000~16000	1800~2200	0.015~0.05	2	SLOTTING
LNB2020	26	15000~16000	1600~1800	0.1~0.12	0.2~0.24	3D MILLING
LNB2020	26	15000~16000	2200~2600	0.015~0.05	0.03~0.1	3D MILLING
LNB3008	18	14000~15000	2000~2400	0.16~0.18	3	SLOTTING
LNB3008	18	14000~15000	2600~3000	0.03~0.1	3	SLOTTING
LNB3008	18	14000~15000	3000~3200	0.2~0.22	0.4~0.44	3D MILLING
LNB3008	18	14000~15000	3400~3800	0.03~0.1	0.06~0.2	3D MILLING
LNB3010	20	14000~15000	2000~2400	0.16~0.18	3	SLOTTING
LNB3010	20	14000~15000	2400~2800	0.03~0.1	3	SLOTTING
LNB3010	20	14000~15000	2800~3000	0.2~0.22	0.4~0.44	3D MILLING
LNB3010	20	14000~15000	3200~3600	0.03~0.1	0.06~0.2	3D MILLING
LNB3012	22	14000~15000	1800~2200	0.14~0.16	3	SLOTTING
LNB3012	22	14000~15000	2200~2600	0.03~0.08	3	SLOTTING
LNB3012	22	14000~15000	2600~2800	0.18~0.2	0.36~0.4	3D MILLING
LNB3012	22	14000~15000	3000~3400	0.03~0.08	0.06~0.16	3D MILLING
LNB3016	26	14000~15000	1600~2000	0.13~0.15	3	SLOTTING
LNB3016	26	14000~15000	2000~2400	0.03~0.08	3	SLOTTING
LNB3016	26	14000~15000	2200~2400	0.16~0.18	0.32~0.36	3D MILLING
LNB3016	26	14000~15000	2800~3200	0.03~0.08	0.06~0.16	3D MILLING
LNB3020	30	14000~15000	1400~1800	0.1~0.12	3	SLOTTING
LNB3020	30	14000~15000	2000~2400	0.02~0.06	3	SLOTTING
LNB3020	30	14000~15000	2000~2200	0.14~0.16	0.28~0.32	3D MILLING
LNB3020	30	14000~15000	2400~2800	0.02~0.06	0.04~0.12	3D MILLING
LNB3025	35	14000~15000	1000~1400	0.08~0.1	3	SLOTTING
LNB3025	35	14000~15000	1600~2000	0.015~0.04	3	SLOTTING
LNB3025	35	14000~15000	1600~2000	0.1~0.12	0.2~0.24	3D MILLING
LNB3025	35	14000~15000	2200~2600	0.015~0.04	0.03~0.08	3D MILLING
LNB4012	23	12000~13000	2400~2800	0.24~0.26	4	SLOTTING
LNB4012	23	12000~13000	3500~3700	0.04~0.1	4	SLOTTING
LNB4012	23	12000~13000	2400~2800	0.26~0.28	0.52~0.56	3D MILLING
LNB4012	23	12000~13000	3500~3800	0.04~0.12	0.08~0.24	3D MILLING
LNB4016	27	12000~13000	2200~2600	0.22~0.24	4	SLOTTING
LNB4016	27	12000~13000	3300~3600	0.03~0.08	4	SLOTTING
LNB4016	27	12000~13000	2400~2800	0.24~0.26	0.48~0.52	3D MILLING
LNB4016	27	12000~13000	3500~3800	0.04~0.1	0.08~0.2	3D MILLING
LNB4020	31	12000~13000	2000~2400	0.21~0.23	4	SLOTTING
LNB4020	31	12000~13000	3200~3500	0.03~0.08	4	SLOTTING
LNB4020	31	12000~13000	2300~2500	0.23~0.25	0.46~0.5	3D MILLING
LNB4020	31	12000~13000	3400~3700	0.04~0.1	0.08~0.2	3D MILLING
LNB4025	36	12000~13000	1800~2200	0.19~0.21	4	SLOTTING
LNB4025	36	12000~13000	2600~2800	0.04~0.08	4	SLOTTING
LNB4025	36	12000~13000	2100~2300	0.21~0.23	0.42~0.46	3D MILLING
LNB4025	36	12000~13000	2800~3200	0.04~0.1	0.08~0.2	3D MILLING
LNB4030	40	12000~13000	1600~1800	0.16~0.18	4	SLOTTING
LNB4030	40	12000~13000	2000~2400	0.03~0.07	4	SLOTTING
LNB4030	40	12000~13000	1800~2000	0.18~0.2	0.36~0.4	3D MILLING
LNB4030	40	12000~13000	2500~2800	0.04~0.07	0.08~0.14	3D MILLING

LNB MILLING CONDITIONS

DHF ITALIA

Work Material	*Prehardened Steels* : **NAK80, 1.2083** (HRc38)					
Coolant Type	Wet coolant					
Type No.	Extension Length (mm)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_p) Width of Cut	Milling Type
LNB1006	18	17000~18000	700~900	0.04~0.06	1	SLOTTING
LNB1006	18	17000~18000	900~1300	0.01~0.03	1	SLOTTING
LNB1006	18	17000~18000	900~1100	0.05~0.07	0.1~0.14	3D MILLING
LNB1006	18	17000~18000	1300~1500	0.01~0.03	0.02~0.06	3D MILLING
LNB1008	20	17000~18000	500~700	0.04~0.05	1	SLOTTING
LNB1008	20	17000~18000	800~1000	0.01~0.03	1	SLOTTING
LNB1008	20	17000~18000	900~1100	0.05~0.07	0.1~0.14	3D MILLING
LNB1008	20	17000~18000	1300~1500	0.01~0.03	0.02~0.06	3D MILLING
LNB1010	22	17000~18000	500~700	0.04~0.05	1	SLOTTING
LNB1010	22	17000~18000	800~1000	0.01~0.03	1	SLOTTING
LNB1010	22	17000~18000	700~900	0.04~0.06	0.08~0.12	3D MILLING
LNB1010	22	17000~18000	1100~1300	0.01~0.03	0.02~0.06	3D MILLING
LNB1012	24	17000~18000	400~500	0.02~0.04	1	SLOTTING
LNB1012	24	17000~18000	600~700	0.01~0.02	1	SLOTTING
LNB1012	24	17000~18000	500~700	0.04~0.06	0.08~0.12	3D MILLING
LNB1012	24	17000~18000	800~900	0.01~0.03	0.02~0.06	3D MILLING
LNB1508	16	16000~17000	1100~1300	0.08~0.1	1.5	SLOTTING
LNB1508	16	16000~17000	1300~1700	0.01~0.04	1.5	SLOTTING
LNB1508	16	16000~17000	1500~1700	0.12~0.14	0.24~0.28	3D MILLING
LNB1508	16	16000~17000	2100~2600	0.02~0.045	0.04~0.09	3D MILLING
LNB1510	18	16000~17000	900~1100	0.08~0.1	1.5	SLOTTING
LNB1510	18	16000~17000	1200~1600	0.01~0.04	1.5	SLOTTING
LNB1510	18	16000~17000	1400~1600	0.1~0.12	0.2~0.24	3D MILLING
LNB1510	18	16000~17000	2000~2400	0.02~0.04	0.04~0.08	3D MILLING
LNB1512	20	16000~17000	700~900	0.06~0.08	1.5	SLOTTING
LNB1512	20	16000~17000	1000~1400	0.01~0.04	1.5	SLOTTING
LNB1512	20	16000~17000	1300~1500	0.1~0.12	0.2~0.24	3D MILLING
LNB1512	20	16000~17000	1800~2200	0.02~0.04	0.04~0.08	3D MILLING
LNB1516	24	16000~17000	600~800	0.04~0.06	1.5	SLOTTING
LNB1516	24	16000~17000	900~1100	0.01~0.03	1.5	SLOTTING
LNB1516	24	16000~17000	1100~1300	0.08~0.1	0.16~0.2	3D MILLING
LNB1516	24	16000~17000	1700~2100	0.015~0.04	0.03~0.08	3D MILLING
LNB1520	28	16000~17000	300~500	0.04~0.06	1.5	SLOTTING
LNB1520	28	16000~17000	600~1000	0.01~0.03	1.5	SLOTTING
LNB1520	28	16000~17000	900~1100	0.06~0.08	0.12~0.16	3D MILLING
LNB1520	28	16000~17000	1300~1700	0.015~0.03	0.03~0.06	3D MILLING
LNB2008	16	15000~16000	1900~2100	0.12~0.14	2	SLOTTING
LNB2008	16	15000~16000	2400~2800	0.02~0.07	2	SLOTTING
LNB2008	16	15000~16000	2000~2400	0.16~0.18	0.32~0.36	3D MILLING
LNB2008	16	15000~16000	3000~3400	0.02~0.05	0.04~0.1	3D MILLING
LNB2010	18	15000~16000	1800~2000	0.12~0.14	2	SLOTTING
LNB2010	18	15000~16000	2300~2700	0.02~0.07	2	SLOTTING
LNB2010	18	15000~16000	1900~2300	0.16~0.18	0.32~0.36	3D MILLING
LNB2010	18	15000~16000	3000~3400	0.02~0.05	0.04~0.1	3D MILLING
LNB2012	20	15000~16000	1700~1900	0.1~0.12	2	SLOTTING
LNB2012	20	15000~16000	2100~2500	0.02~0.05	2	SLOTTING
LNB2012	20	15000~16000	1900~2300	0.14~0.16	0.28~0.32	3D MILLING
LNB2012	20	15000~16000	2600~3000	0.02~0.05	0.03~0.1	3D MILLING
LNB2016	24	15000~16000	1400~1600	0.1~0.12	2	SLOTTING
LNB2016	24	15000~16000	1800~2200	0.02~0.05	2	SLOTTING
LNB2016	24	15000~16000	1700~1900	0.12~0.14	0.24~0.28	3D MILLING
LNB2016	24	15000~16000	2200~2600	0.02~0.05	0.03~0.1	3D MILLING

Type No.	Extension Length (mm)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_p) Width of Cut	Milling Type
LNB2020	26	15000~16000	1300~1500	0.08~0.1	2	SLOTTING
LNB2020	26	15000~16000	1700~2100	0.02~0.05	2	SLOTTING
LNB2020	26	15000~16000	1400~1600	0.1~0.12	0.2~0.24	3D MILLING
LNB2020	26	15000~16000	2000~2400	0.02~0.05	0.03~0.1	3D MILLING
LNB3008	18	14000~15000	1800~2200	0.16~0.18	3	SLOTTING
LNB3008	18	14000~15000	2400~2800	0.03~0.1	3	SLOTTING
LNB3008	18	14000~15000	2800~3200	0.2~0.22	0.4~0.44	3D MILLING
LNB3008	18	14000~15000	3200~3600	0.03~0.1	0.06~0.2	3D MILLING
LNB3010	20	14000~15000	1800~2200	0.16~0.18	3	SLOTTING
LNB3010	20	14000~15000	2400~2800	0.03~0.1	3	SLOTTING
LNB3010	20	14000~15000	2800~3000	0.2~0.22	0.4~0.44	3D MILLING
LNB3010	20	14000~15000	3200~3600	0.03~0.1	0.06~0.2	3D MILLING
LNB3012	22	14000~15000	1600~2000	0.14~0.16	3	SLOTTING
LNB3012	22	14000~15000	2200~2600	0.03~0.08	3	SLOTTING
LNB3012	22	14000~15000	2600~2800	0.18~0.2	0.36~0.4	3D MILLING
LNB3012	22	14000~15000	3000~3400	0.03~0.08	0.06~0.16	3D MILLING
LNB3016	26	14000~15000	1400~1800	0.13~0.15	3	SLOTTING
LNB3016	26	14000~15000	1800~2200	0.03~0.08	3	SLOTTING
LNB3016	26	14000~15000	2000~2200	0.16~0.18	0.32~0.36	3D MILLING
LNB3016	26	14000~15000	2600~3000	0.03~0.08	0.06~0.16	3D MILLING
LNB3020	30	14000~15000	1200~1600	0.1~0.12	3	SLOTTING
LNB3020	30	14000~15000	1800~2100	0.02~0.06	3	SLOTTING
LNB3020	30	14000~15000	1800~2100	0.14~0.16	0.28~0.32	3D MILLING
LNB3020	30	14000~15000	2300~2700	0.02~0.06	0.04~0.12	3D MILLING
LNB3025	35	14000~15000	1000~1400	0.08~0.1	3	SLOTTING
LNB3025	35	14000~15000	1500~1900	0.015~0.04	3	SLOTTING
LNB3025	35	14000~15000	1500~1800	0.1~0.12	0.2~0.24	3D MILLING
LNB3025	35	14000~15000	2000~2400	0.015~0.04	0.03~0.08	3D MILLING
LNB4012	23	12000~13000	2200~2600	0.24~0.26	4	SLOTTING
LNB4012	23	12000~13000	3200~3400	0.04~0.1	4	SLOTTING
LNB4012	23	12000~13000	2100~2600	0.26~0.28	0.52~0.56	3D MILLING
LNB4012	23	12000~13000	3200~3400	0.04~0.12	0.08~0.24	3D MILLING
LNB4016	27	12000~13000	2200~2600	0.22~0.24	4	SLOTTING
LNB4016	27	12000~13000	3200~3400	0.03~0.08	4	SLOTTING
LNB4016	27	12000~13000	2100~2600	0.24~0.26	0.48~0.52	3D MILLING
LNB4016	27	12000~13000	3200~3400	0.04~0.1	0.08~0.2	3D MILLING
LNB4020	31	12000~13000	1800~2200	0.21~0.23	4	SLOTTING
LNB4020	31	12000~13000	3000~3300	0.03~0.08	4	SLOTTING
LNB4020	31	12000~13000	2100~2300	0.23~0.25	0.46~0.5	3D MILLING
LNB4020	31	12000~13000	3200~3500	0.04~0.1	0.08~0.2	3D MILLING
LNB4025	36	12000~13000	1600~2000	0.19~0.21	4	SLOTTING
LNB4025	36	12000~13000	2400~2600	0.04~0.08	4	SLOTTING
LNB4025	36	12000~13000	1900~2100	0.21~0.23	0.42~0.46	3D MILLING
LNB4025	36	12000~13000	2600~3000	0.04~0.1	0.08~0.2	3D MILLING
LNB4030	40	12000~13000	1300~1700	0.16~0.18	4	SLOTTING
LNB4030	40	12000~13000	1800~2200	0.03~0.07	4	SLOTTING
LNB4030	40	12000~13000	1600~1800	0.18~0.2	0.36~0.4	3D MILLING
LNB4030	40	12000~13000	2200~2500	0.04~0.07	0.08~0.14	3D MILLING

UNB MILLING CONDITIONS

DHF ITALIA

Work Material	*Hardened Steels :* **SKD61/STAVAX/1.2083/17-4PH** (HRc52)
Coolant Type	Dry coolant

Type No.	Extension Length (mm)	Cutting Speed (m/min)	Speed (min^{-1})	Feed (mm/min)	(Aa) Depth of Cut	(A_P) Width of Cut	Milling Type
UNB0502	15	35	18000~20000	200~400	0.005~0.013	0.5	SLOTTING
UNB0502	15	35	18000~20000	200~400	0.008~0.015	0.016~0.03	3D MILLING
UNB0504	17	35	18000~20000	200~400	0.005~0.013	0.5	SLOTTING
UNB0504	17	35	18000~20000	200~400	0.008~0.015	0.016~0.03	3D MILLING
UNB0506	19	35	18000~20000	150~300	0.005~0.013	0.5	SLOTTING
UNB0506	19	35	18000~20000	200~400	0.005~0.013	0.01~0.026	3D MILLING
UNB0604	18	40	18000~20000	200~400	0.005~0.013	0.6	SLOTTING
UNB0604	18	40	18000~20000	200~400	0.008~0.015	0.016~0.03	3D MILLING
UNB0606	20	40	18000~20000	150~300	0.005~0.013	0.6	SLOTTING
UNB0606	20	40	18000~20000	200~400	0.005~0.013	0.01~0.026	3D MILLING
UNB0806	17	45	16000~18000	300~500	0.01~0.02	0.8	SLOTTING
UNB0806	17	45	16000~18000	300~500	0.015~0.025	0.03~0.05	3D MILLING
UNB0806	17	45	16000~18000	500~700	0.005~0.015	0.01~0.03	3D MILLING
UNB0808	19	45	16000~18000	200~400	0.01~0.02	0.8	SLOTTING
UNB0808	19	45	16000~18000	200~400	0.015~0.025	0.03~0.05	3D MILLING
UNB0808	19	45	16000~18000	400~600	0.005~0.015	0.01~0.03	3D MILLING
UNB1006	13	50	15000~16000	400~600	0.015~0.035	1	SLOTTING
UNB1006	13	50	15000~16000	400~600	0.03~0.05	0.06~0.1	3D MILLING
UNB1006	13	50	15000~16000	600~800	0.01~0.03	0.02~0.06	3D MILLING
UNB1008	15	50	15000~16000	300~500	0.01~0.03	1	SLOTTING
UNB1008	15	50	15000~16000	300~500	0.03~0.05	0.06~0.1	3D MILLING
UNB1008	15	50	15000~16000	600~800	0.01~0.02	0.02~0.04	3D MILLING
UNB1010	17	50	15000~16000	300~500	0.01~0.03	1	SLOTTING
UNB1010	17	50	15000~16000	300~500	0.03~0.05	0.06~0.1	3D MILLING
UNB1010	17	50	15000~16000	600~800	0.01~0.02	0.02~0.04	3D MILLING
UNB1012	19	50	15000~16000	300~500	0.01~0.03	1	SLOTTING
UNB1012	19	50	15000~16000	300~500	0.03~0.05	0.06~0.1	3D MILLING
UNB1012	19	50	15000~16000	600~800	0.01~0.02	0.02~0.04	3D MILLING
UNB1208	15	60	15000~16000	400~600	0.02~0.04	1.2	SLOTTING
UNB1208	15	60	15000~16000	400~600	0.04~0.06	0.08~0.12	3D MILLING
UNB1208	15	60	15000~16000	800~100	0.01~0.025	0.02~0.05	3D MILLING
UNB1212	19	60	15000~16000	400~600	0.02~0.04	1.2	SLOTTING
UNB1212	19	60	15000~16000	400~600	0.04~0.06	0.08~0.12	3D MILLING
UNB1212	19	60	15000~16000	800~100	0.01~0.025	0.02~0.05	3D MILLING
UNB1508	14	70	14000~15000	400~600	0.04~0.06	1.5	SLOTTING
UNB1508	14	70	14000~15000	700~900	0.01~0.03	1.5	SLOTTING
UNB1508	14	70	14000~15000	400~600	0.05~0.07	0.1~0.14	3D MILLING
UNB1508	14	70	14000~15000	800~1000	0.015~0.035	0.03~0.07	3D MILLING
UNB1510	16	70	14000~15000	400~600	0.03~0.05	1.5	SLOTTING
UNB1510	16	70	14000~15000	600~800	0.01~0.03	1.5	SLOTTING
UNB1510	16	70	14000~15000	400~600	0.04~0.06	0.08~0.12	3D MILLING
UNB1510	16	70	14000~15000	700~900	0.015~0.035	0.03~0.07	3D MILLING
UNB1512	18	70	14000~15000	300~500	0.03~0.05	1.5	SLOTTING
UNB1512	18	70	14000~15000	500~700	0.01~0.03	1.5	SLOTTING
UNB1512	18	70	14000~15000	400~600	0.04~0.06	0.08~0.12	3D MILLING
UNB1512	18	70	14000~15000	600~800	0.015~0.035	0.03~0.07	3D MILLING
UNB1516	22	70	14000~15000	300~500	0.02~0.04	1.5	SLOTTING
UNB1516	22	70	14000~15000	500~600	0.008~0.02	1.5	SLOTTING
UNB1516	22	70	14000~15000	300~500	0.03~0.05	0.06~0.1	3D MILLING
UNB1516	22	70	14000~15000	600~800	0.01~0.025	0.02~0.05	3D MILLING
UNB1520	26	70	14000~15000	200~400	0.02~0.04	1.5	SLOTTING
UNB1520	26	70	14000~15000	400~600	0.008~0.02	1.5	SLOTTING
UNB1520	26	70	14000~15000	200~400	0.02~0.04	0.04~0.08	3D MILLING
UNB1520	26	70	14000~15000	400~600	0.008~0.02	0.016~0.04	3D MILLING
UNB1608	14	75	14000~15000	500~700	0.04~0.06	1.6	SLOTTING
UNB1608	14	75	14000~15000	800~1000	0.01~0.03	1.6	SLOTTING
UNB1608	14	75	14000~15000	500~700	0.05~0.07	0.1~0.14	3D MILLING
UNB1608	14	75	14000~15000	800~1000	0.015~0.035	0.03~0.07	3D MILLING

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Type No.	Extension Length (mm)	Cutting Speed (m/min)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_P) Width of Cut	Milling Type
UNB1612	16	75	14000~15000	400~600	0.03~0.05	1.6	SLOTTING
UNB1612	16	75	14000~15000	600~800	0.01~0.03	1.6	SLOTTING
UNB1612	16	75	14000~15000	500~700	0.04~0.06	0.08~0.12	3D MILLING
UNB1612	16	75	14000~15000	800~1000	0.015~0.03	0.03~0.06	3D MILLING
UNB1616	20	75	14000~15000	300~500	0.02~0.04	1.6	SLOTTING
UNB1616	20	75	14000~15000	500~700	0.008~0.02	1.6	SLOTTING
UNB1616	20	75	14000~15000	400~600	0.03~0.05	0.06~0.1	3D MILLING
UNB1616	20	75	14000~15000	600~800	0.01~0.03	0.02~0.06	3D MILLING
UNB2008	14	85	12000~13000	500~700	0.05~0.07	2	SLOTTING
UNB2008	14	85	12000~13000	800~1000	0.01~0.03	2	SLOTTING
UNB2008	14	85	12000~13000	500~700	0.07~0.09	0.14~0.18	3D MILLING
UNB2008	14	85	12000~13000	1100~1300	0.015~0.035	0.03~0.07	3D MILLING
UNB2010	16	85	12000~13000	400~600	0.04~0.06	2	SLOTTING
UNB2010	16	85	12000~13000	800~1000	0.01~0.03	2	SLOTTING
UNB2010	16	85	12000~13000	400~600	0.06~0.08	0.12~0.16	3D MILLING
UNB2010	16	85	12000~13000	1000~1200	0.015~0.035	0.03~0.07	3D MILLING
UNB2012	18	85	12000~13000	400~600	0.04~0.06	2	SLOTTING
UNB2012	18	85	12000~13000	800~1000	0.01~0.03	2	SLOTTING
UNB2012	18	85	12000~13000	400~600	0.06~0.08	0.12~0.16	3D MILLING
UNB2012	18	85	12000~13000	1000~1200	0.015~0.035	0.03~0.07	3D MILLING
UNB2016	22	85	12000~13000	300~500	0.03~0.05	2	SLOTTING
UNB2016	22	85	12000~13000	600~800	0.01~0.025	2	SLOTTING
UNB2016	22	85	12000~13000	400~600	0.04~0.06	0.08~0.12	3D MILLING
UNB2016	22	85	12000~13000	800~1000	0.015~0.03	0.03~0.06	3D MILLING
UNB2020	26	85	12000~13000	200~400	0.03~0.05	2	SLOTTING
UNB2020	26	85	12000~13000	400~600	0.01~0.025	2	SLOTTING
UNB2020	26	85	12000~13000	400~600	0.03~0.05	0.06~0.1	3D MILLING
UNB2020	26	85	12000~13000	600~800	0.015~0.03	0.03~0.06	3D MILLING
UNB3008	16	105	10000~11000	700~900	0.08~0.1	3	SLOTTING
UNB3008	16	105	10000~11000	1200~1600	0.02~0.05	3	SLOTTING
UNB3008	16	105	10000~11000	800~1000	0.12~0.14	0.24~0.28	3D MILLING
UNB3008	16	105	10000~11000	1400~1800	0.03~0.07	0.06~0.14	3D MILLING
UNB3010	18	105	10000~11000	600~800	0.08~0.1	3	SLOTTING
UNB3010	18	105	10000~11000	1100~1500	0.02~0.05	3	SLOTTING
UNB3010	18	105	10000~11000	700~900	0.12~0.14	0.24~0.28	3D MILLING
UNB3010	18	105	10000~11000	1300~1700	0.03~0.07	0.06~0.14	3D MILLING
UNB3016	20	105	10000~11000	400~600	0.06~0.08	3	SLOTTING
UNB3016	20	105	10000~11000	800~1200	0.015~0.035	3	SLOTTING
UNB3016	20	105	10000~11000	600~800	0.1~0.12	0.2~0.24	3D MILLING
UNB3016	20	105	10000~11000	1000~1400	0.02~0.05	0.04~0.1	3D MILLING
UNB3020	24	105	10000~11000	300~500	0.04~0.06	3	SLOTTING
UNB3020	24	105	10000~11000	700~900	0.01~0.03	3	SLOTTING
UNB3020	24	105	10000~11000	400~600	0.07~0.09	0.14~0.18	3D MILLING
UNB3020	24	105	10000~11000	900~1300	0.015~0.035	0.03~0.07	3D MILLING
UNB3025	28	105	10000~11000	200~400	0.04~0.06	3	SLOTTING
UNB3025	28	105	10000~11000	600~800	0.01~0.03	3	SLOTTING
UNB3025	28	105	10000~11000	400~600	0.06~0.08	0.12~0.16	3D MILLING
UNB3025	28	105	10000~11000	800~1200	0.015~0.035	0.03~0.07	3D MILLING
UNB4010	20	115	8000~9000	800~1000	0.1~0.12	4	SLOTTING
UNB4010	20	115	8000~9000	1400~1800	0.03~0.07	4	SLOTTING
UNB4010	20	115	8000~9000	1000~1200	0.14~0.16	0.28~0.32	3D MILLING
UNB4010	20	115	8000~9000	1600~2000	0.04~0.09	0.08~0.18	3D MILLING
UNB4015	25	115	8000~9000	600~800	0.08~0.1	4	SLOTTING
UNB4015	25	115	8000~9000	1200~1600	0.025~0.06	4	SLOTTING
UNB4015	25	115	8000~9000	1000~1200	0.1~0.12	0.2~0.24	3D MILLING
UNB4015	25	115	8000~9000	1600~2000	0.03~0.06	0.06~0.12	3D MILLING
UNB4020	30	115	8000~9000	600~800	0.06~0.08	4	SLOTTING
UNB4020	30	115	8000~9000	1000~1400	0.025~0.05	4	SLOTTING
UNB4020	30	115	8000~9000	1000~1200	0.08~0.1	0.16~0.2	3D MILLING
UNB4020	30	115	8000~9000	1600~2000	0.025~0.05	0.05~0.1	3D MILLING
UNB4025	35	115	8000~9000	500~700	0.05~0.07	4	SLOTTING
UNB4025	35	115	8000~9000	800~1200	0.015~0.035	4	SLOTTING
UNB4025	35	115	8000~9000	800~1000	0.06~0.08	0.12~0.16	3D MILLING
UNB4025	35	115	8000~9000	1200~1600	0.025~0.05	0.05~0.1	3D MILLING
UNB4030	40	115	8000~9000	400~600	0.04~0.06	4	SLOTTING
UNB4030	40	115	8000~9000	700~1100	0.015~0.035	4	SLOTTING
UNB4030	40	115	8000~9000	600~800	0.05~0.07	0.1~0.14	3D MILLING
UNB4030	40	115	8000~9000	1000~1400	0.015~0.04	0.03~0.08	3D MILLING

UXE MILLING CONDITIONS

DHF ITALIA

Work Material	*Hardened Steels :* **SKD61/STAVAX/1.2083/17-4PH** (HRc52)
Coolant Type	MQL coolant

Type No.	Extension Length (mm)	Cutting Speed (m/min)	Speed (min^{-1})	Feed (mm/min)	(Aa) Depth of Cut	(A_P) Width of Cut	Milling Type
UXE100401	18	55	15000~17000	400~600	0.04~0.06	1	SLOTTING
UXE100401	18	55	15000~17000	800~1200	0.01~0.025	1	SLOTTING
UXE100601	20	55	15000~17000	400~600	0.03~0.05	1	SLOTTING
UXE100601	20	55	15000~17000	800~1200	0.008~0.02	1	SLOTTING
UXE100801	22	55	15000~17000	300~500	0.03~0.05	1	SLOTTING
UXE100801	22	55	15000~17000	600~800	0.008~0.02	1	SLOTTING
UXE101001	24	55	15000~17000	300~500	0.02~0.04	1	SLOTTING
UXE101001	24	55	15000~17000	500~700	0.008~0.02	1	SLOTTING
UXE101201	26	55	15000~17000	200~400	0.02~0.04	1	SLOTTING
UXE101201	26	55	15000~17000	400~600	0.008~0.02	1	SLOTTING
UXE100402	18	55	15000~17000	500~700	0.04~0.06	1	SLOTTING
UXE100402	18	55	15000~17000	900~1300	0.01~0.025	1	SLOTTING
UXE100602	20	55	15000~17000	500~700	0.03~0.05	1	SLOTTING
UXE100602	20	55	15000~17000	900~1300	0.008~0.02	1	SLOTTING
UXE100802	22	55	15000~17000	400~600	0.03~0.05	1	SLOTTING
UXE100802	22	55	15000~17000	700~900	0.008~0.02	1	SLOTTING
UXE101002	24	55	15000~17000	400~600	0.02~0.04	1	SLOTTING
UXE101002	24	55	15000~17000	700~900	0.008~0.02	1	SLOTTING
UXE101202	26	55	15000~17000	300~500	0.02~0.04	1	SLOTTING
UXE101202	26	55	15000~17000	500~700	0.008~0.02	1	SLOTTING
UXE150401	18	70	13000~15000	400~600	0.06~0.08	1.5	SLOTTING
UXE150401	18	70	13000~15000	800~1200	0.02~0.04	1.5	SLOTTING
UXE150601	20	70	13000~15000	400~600	0.05~0.07	1.5	SLOTTING
UXE150601	20	70	13000~15000	800~1200	0.015~0.035	1.5	SLOTTING
UXE150801	22	70	13000~15000	300~500	0.05~0.07	1.5	SLOTTING
UXE150801	22	70	13000~15000	600~800	0.015~0.035	1.5	SLOTTING
UXE151001	24	70	13000~15000	300~500	0.04~0.06	1.5	SLOTTING
UXE151001	24	70	13000~15000	500~700	0.01~0.025	1.5	SLOTTING
UXE151201	26	70	13000~15000	200~400	0.04~0.06	1.5	SLOTTING
UXE151201	26	70	13000~15000	400~600	0.01~0.025	1.5	SLOTTING
UXE150402	18	70	13000~15000	500~700	0.06~0.08	1.5	SLOTTING
UXE150402	18	70	13000~15000	900~1300	0.02~0.04	1.5	SLOTTING
UXE150602	20	70	13000~15000	500~700	0.05~0.07	1.5	SLOTTING
UXE150602	20	70	13000~15000	900~1300	0.015~0.035	1.5	SLOTTING
UXE150802	22	70	13000~15000	400~600	0.05~0.07	1.5	SLOTTING
UXE150802	22	70	13000~15000	700~900	0.015~0.035	1.5	SLOTTING
UXE151002	24	70	13000~15000	400~600	0.04~0.06	1.5	SLOTTING
UXE151002	24	70	13000~15000	700~900	0.01~0.025	1.5	SLOTTING
UXE151202	26	70	13000~15000	300~500	0.04~0.06	1.5	SLOTTING
UXE151202	26	70	13000~15000	500~700	0.01~0.025	1.5	SLOTTING
UXE200801	18	85	11000~13000	500~700	0.1~0.12	2	SLOTTING
UXE200801	18	85	11000~13000	1000~1400	0.02~0.06	2	SLOTTING
UXE201001	20	85	11000~13000	400~600	0.09~0.11	2	SLOTTING
UXE201001	20	85	11000~13000	1000~1400	0.02~0.06	2	SLOTTING
UXE201201	22	85	11000~13000	400~600	0.08~0.1	2	SLOTTING
UXE201201	22	85	11000~13000	1000~1400	0.02~0.06	2	SLOTTING
UXE201601	26	85	11000~13000	400~600	0.06~0.08	2	SLOTTING
UXE201601	26	85	11000~13000	1000~1400	0.02~0.04	2	SLOTTING

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Type No.	Extension Length (mm)	Cutting Speed (m/min)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_P) Width of Cut	Milling Type
UXE202001	30	85	11000~13000	300~500	0.05~0.07	2	SLOTTING
UXE202001	30	85	11000~13000	800~1200	0.015~0.035	2	SLOTTING
UXE200802	18	85	11000~13000	600~800	0.1~0.12	2	SLOTTING
UXE200802	18	85	11000~13000	1200~1600	0.02~0.06	2	SLOTTING
UXE201002	20	85	11000~13000	500~700	0.09~0.11	2	SLOTTING
UXE201002	20	85	11000~13000	1100~1500	0.02~0.06	2	SLOTTING
UXE201202	22	85	11000~13000	500~700	0.08~0.1	2	SLOTTING
UXE201202	22	85	11000~13000	1100~1500	0.02~0.06	2	SLOTTING
UXE201602	26	85	11000~13000	500~700	0.06~0.08	2	SLOTTING
UXE201602	26	85	11000~13000	1100~1500	0.02~0.04	2	SLOTTING
UXE202002	30	85	11000~13000	400~600	0.05~0.07	2	SLOTTING
UXE202002	30	85	11000~13000	900~1300	0.015~0.035	2	SLOTTING
UXE300802	18	105	9000~11000	500~700	0.12~0.14	3	SLOTTING
UXE300802	18	105	9000~11000	1100~1500	0.03~0.08	3	SLOTTING
UXE301002	20	105	9000~11000	400~600	0.12~0.14	3	SLOTTING
UXE301002	20	105	9000~11000	1000~1400	0.03~0.08	3	SLOTTING
UXE301202	22	105	9000~11000	400~600	0.12~0.14	3	SLOTTING
UXE301202	22	105	9000~11000	1000~1400	0.03~0.08	3	SLOTTING
UXE301602	26	105	9000~11000	400~600	0.08~0.1	3	SLOTTING
UXE301602	26	105	9000~11000	1000~1400	0.02~0.06	3	SLOTTING
UXE302002	30	105	9000~11000	300~500	0.06~0.08	3	SLOTTING
UXE302002	30	105	9000~11000	700~900	0.01~0.035	3	SLOTTING
UXE300803	18	105	9000~11000	600~800	0.12~0.14	3	SLOTTING
UXE300803	18	105	9000~11000	1200~1600	0.03~0.08	3	SLOTTING
UXE301003	20	105	9000~11000	500~700	0.12~0.14	3	SLOTTING
UXE301003	20	105	9000~11000	1100~1500	0.03~0.08	3	SLOTTING
UXE301203	22	105	9000~11000	500~700	0.12~0.14	3	SLOTTING
UXE301203	22	105	9000~11000	1100~1500	0.03~0.08	3	SLOTTING
UXE301603	26	105	9000~11000	500~700	0.08~0.1	3	SLOTTING
UXE301603	26	105	9000~11000	1100~1500	0.02~0.06	3	SLOTTING
UXE302003	30	105	9000~11000	400~600	0.06~0.08	3	SLOTTING
UXE302003	30	105	9000~11000	800~1000	0.01~0.035	3	SLOTTING
UXE401002	20	115	7000~9000	700~900	0.13~0.15	4	SLOTTING
UXE401002	20	115	7000~9000	1300~1700	0.03~0.08	4	SLOTTING
UXE401202	22	115	7000~9000	700~900	0.12~0.14	4	SLOTTING
UXE401202	22	115	7000~9000	1300~1700	0.03~0.08	4	SLOTTING
UXE401602	26	115	7000~9000	600~800	0.08~0.1	4	SLOTTING
UXE401602	26	115	7000~9000	1200~1600	0.02~0.06	4	SLOTTING
UXE402002	30	115	7000~9000	500~700	0.06~0.08	4	SLOTTING
UXE402002	30	115	7000~9000	900~1100	0.015~0.04	4	SLOTTING
UXE401003	20	115	7000~9000	800~1000	0.14~0.16	4	SLOTTING
UXE401003	20	115	7000~9000	1400~1800	0.04~0.09	4	SLOTTING
UXE401203	22	115	7000~9000	800~1000	0.13~0.15	4	SLOTTING
UXE401203	22	115	7000~9000	1400~1800	0.04~0.09	4	SLOTTING
UXE401603	26	115	7000~9000	700~900	0.09~0.11	4	SLOTTING
UXE401603	26	115	7000~9000	1300~1700	0.03~0.08	4	SLOTTING
UXE402003	30	115	7000~9000	600~800	0.07~0.09	4	SLOTTING
UXE402003	30	115	7000~9000	1000~1200	0.02~0.05	4	SLOTTING

UXE MILLING CONDITIONS

DHF ITALIA

Work Material	*Hardened Steels :* **SKD11 /1.2379/D2** (HRc62)
Coolant Type	MQL coolant

Type No.	Extension Length (mm)	Cutting Speed (m/min)	Speed (min^{-1})	Feed (mm/min)	(Aa) Depth of Cut	(A_P) Width of Cut	Milling Type
UXE100401	18	40	11000~13000	400~600	0.01~0.03	1	SLOTTING
UXE100401	18	40	11000~13000	400~600	0.01~0.03	1	SLOTTING
UXE100601	20	40	11000~13000	400~600	0.01~0.03	1	SLOTTING
UXE100601	20	40	11000~13000	400~600	0.01~0.03	1	SLOTTING
UXE100801	22	40	11000~13000	300~500	0.01~0.03	1	SLOTTING
UXE100801	22	40	11000~13000	300~500	0.01~0.03	1	SLOTTING
UXE101001	24	40	11000~13000	300~500	0.01~0.03	1	SLOTTING
UXE101001	24	40	11000~13000	300~500	0.01~0.03	1	SLOTTING
UXE101201	26	40	11000~13000	200~400	0.01~0.025	1	SLOTTING
UXE101201	26	40	11000~13000	200~400	0.01~0.025	1	SLOTTING
UXE100402	18	40	11000~13000	400~600	0.01~0.03	1	SLOTTING
UXE100402	18	40	11000~13000	400~600	0.01~0.03	1	SLOTTING
UXE100602	20	40	11000~13000	400~600	0.01~0.03	1	SLOTTING
UXE100602	20	40	11000~13000	400~600	0.01~0.03	1	SLOTTING
UXE100802	22	40	11000~13000	300~500	0.01~0.03	1	SLOTTING
UXE100802	22	40	11000~13000	300~500	0.01~0.03	1	SLOTTING
UXE101002	24	40	11000~13000	300~500	0.01~0.03	1	SLOTTING
UXE101002	24	40	11000~13000	300~500	0.01~0.03	1	SLOTTING
UXE101202	26	40	11000~13000	200~400	0.01~0.025	1	SLOTTING
UXE101202	26	40	11000~13000	200~400	0.01~0.025	1	SLOTTING
UXE150401	18	55	9000~11000	400~600	0.02~0.04	1.5	SLOTTING
UXE150401	18	55	9000~11000	400~600	0.02~0.04	1.5	SLOTTING
UXE150601	20	55	9000~11000	400~600	0.02~0.04	1.5	SLOTTING
UXE150601	20	55	9000~11000	400~600	0.02~0.04	1.5	SLOTTING
UXE150801	22	55	9000~11000	400~600	0.02~0.04	1.5	SLOTTING
UXE150801	22	55	9000~11000	400~600	0.02~0.04	1.5	SLOTTING
UXE151001	24	55	9000~11000	300~500	0.01~0.025	1.5	SLOTTING
UXE151001	24	55	9000~11000	300~500	0.01~0.025	1.5	SLOTTING
UXE151201	26	55	9000~11000	300~500	0.01~0.025	1.5	SLOTTING
UXE151201	26	55	9000~11000	300~500	0.01~0.025	1.5	SLOTTING
UXE150402	18	55	9000~11000	400~600	0.02~0.04	1.5	SLOTTING
UXE150402	18	55	9000~11000	400~600	0.02~0.04	1.5	SLOTTING
UXE150602	20	55	9000~11000	400~600	0.02~0.04	1.5	SLOTTING
UXE150602	20	55	9000~11000	400~600	0.02~0.04	1.5	SLOTTING
UXE150802	22	55	9000~11000	400~600	0.02~0.04	1.5	SLOTTING
UXE150802	22	55	9000~11000	400~600	0.02~0.04	1.5	SLOTTING
UXE151002	24	55	9000~11000	300~500	0.01~0.025	1.5	SLOTTING
UXE151002	24	55	9000~11000	300~500	0.01~0.025	1.5	SLOTTING
UXE151202	26	55	9000~11000	300~500	0.01~0.025	1.5	SLOTTING
UXE151202	26	55	9000~11000	300~500	0.01~0.025	1.5	SLOTTING
UXE200801	18	60	7000~9000	500~700	0.04~0.06	2	SLOTTING
UXE200801	18	60	7000~9000	800~1000	0.01~0.025	2	SLOTTING
UXE201001	20	60	7000~9000	400~600	0.03~0.05	2	SLOTTING
UXE201001	20	60	7000~9000	800~1000	0.008~0.02	2	SLOTTING
UXE201201	22	60	7000~9000	400~600	0.03~0.05	2	SLOTTING
UXE201201	22	60	7000~9000	800~1000	0.008~0.02	2	SLOTTING
UXE201601	26	60	7000~9000	400~600	0.02~0.04	2	SLOTTING
UXE201601	26	60	7000~9000	800~1000	0.008~0.015	2	SLOTTING

Type No.	Extension Length (mm)	Cutting Speed (m/min)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_P) Width of Cut	Milling Type
UXE202001	30	60	7000~9000	300~500	0.02~0.04	2	SLOTTING
UXE202001	30	60	7000~9000	600~800	0.008~0.013	2	SLOTTING
UXE200802	18	60	7000~9000	500~700	0.04~0.06	2	SLOTTING
UXE200802	18	60	7000~9000	800~1000	0.01~0.025	2	SLOTTING
UXE201002	20	60	7000~9000	400~600	0.03~0.05	2	SLOTTING
UXE201002	20	60	7000~9000	800~1000	0.008~0.02	2	SLOTTING
UXE201202	22	60	7000~9000	400~600	0.03~0.05	2	SLOTTING
UXE201202	22	60	7000~9000	800~1000	0.008~0.02	2	SLOTTING
UXE201602	26	60	7000~9000	400~600	0.02~0.04	2	SLOTTING
UXE201602	26	60	7000~9000	800~1000	0.008~0.015	2	SLOTTING
UXE202002	30	60	7000~9000	300~500	0.02~0.04	2	SLOTTING
UXE202002	30	60	7000~9000	600~800	0.008~0.013	2	SLOTTING
UXE300802	18	65	5000~7000	500~700	0.05~0.07	3	SLOTTING
UXE300802	18	65	5000~7000	900~1100	0.01~0.03	3	SLOTTING
UXE301002	20	65	5000~7000	400~600	0.05~0.07	3	SLOTTING
UXE301002	20	65	5000~7000	800~1000	0.01~0.03	3	SLOTTING
UXE301202	22	65	5000~7000	400~600	0.05~0.07	3	SLOTTING
UXE301202	22	65	5000~7000	800~1000	0.01~0.03	3	SLOTTING
UXE301602	26	65	5000~7000	400~600	0.03~0.05	3	SLOTTING
UXE301602	26	65	5000~7000	400~600	0.03~0.05	3	SLOTTING
UXE302002	30	65	5000~7000	300~500	0.02~0.04	3	SLOTTING
UXE302002	30	65	5000~7000	300~500	0.02~0.04	3	SLOTTING
UXE300803	18	65	5000~7000	600~800	0.05~0.07	3	SLOTTING
UXE300803	18	65	5000~7000	1000~1200	0.01~0.03	3	SLOTTING
UXE301003	20	65	5000~7000	500~700	0.05~0.07	3	SLOTTING
UXE301003	20	65	5000~7000	900~1100	0.01~0.03	3	SLOTTING
UXE301203	22	65	5000~7000	500~700	0.05~0.07	3	SLOTTING
UXE301203	22	65	5000~7000	900~1100	0.01~0.03	3	SLOTTING
UXE301603	26	65	5000~7000	500~700	0.03~0.05	3	SLOTTING
UXE301603	26	65	5000~7000	500~700	0.03~0.05	3	SLOTTING
UXE302003	30	65	5000~7000	400~600	0.02~0.04	3	SLOTTING
UXE302003	30	65	5000~7000	400~600	0.02~0.04	3	SLOTTING
UXE401002	20	65	4000~5000	700~900	0.08~0.1	4	SLOTTING
UXE401002	20	65	4000~5000	1100~1300	0.02~0.04	4	SLOTTING
UXE401202	22	65	4000~5000	700~900	0.06~0.08	4	SLOTTING
UXE401202	22	65	4000~5000	1000~1200	0.02~0.04	4	SLOTTING
UXE401602	26	65	4000~5000	600~800	0.05~0.07	4	SLOTTING
UXE401602	26	65	4000~5000	900~1100	0.01~0.03	4	SLOTTING
UXE402002	30	65	4000~5000	500~700	0.04~0.06	4	SLOTTING
UXE402002	30	65	4000~5000	800~1000	0.01~0.03	4	SLOTTING
UXE401003	20	65	4000~5000	800~1000	0.08~0.1	4	SLOTTING
UXE401003	20	65	4000~5000	1200~1400	0.02~0.04	4	SLOTTING
UXE401203	22	65	4000~5000	800~1000	0.06~0.08	4	SLOTTING
UXE401203	22	65	4000~5000	1100~1300	0.02~0.04	4	SLOTTING
UXE401603	26	65	4000~5000	700~900	0.05~0.07	4	SLOTTING
UXE401603	26	65	4000~5000	1000~1200	0.01~0.03	4	SLOTTING
UXE402003	30	65	4000~5000	600~800	0.04~0.06	4	SLOTTING
UXE402003	30	65	4000~5000	900~1100	0.01~0.03	4	SLOTTING

UNE MILLING CONDITIONS

DHF ITALIA

Work Material	*Prehardened Steels* : **NAK80, 1.2083** (HRc38)
Coolant Type	Wet coolant

Type No.	Extension Length (mm)	Cutting Speed (m/min)	Speed (min^{-1})	Feed (mm/min)	(Aa) Depth of Cut	(A_P) Width of Cut	Milling Type
UNE1004	16	60	17000~18000	300~500	0.04~0.06	1	SLOTTING
UNE1004	16	60	17000~18000	700~900	0.01~0.025	1	SLOTTING
UNE1006	18	60	17000~18000	300~500	0.03~0.05	1	SLOTTING
UNE1006	18	60	17000~18000	700~900	0.008~0.015	1	SLOTTING
UNE1008	20	60	17000~18000	200~400	0.03~0.05	1	SLOTTING
UNE1008	20	60	17000~18000	600~800	0.008~0.015	1	SLOTTING
UNE1010	22	60	17000~18000	200~400	0.02~0.04	1	SLOTTING
UNE1010	22	60	17000~18000	500~700	0.008~0.015	1	SLOTTING
UNE1012	24	60	17000~18000	200~400	0.01~0.03	1	SLOTTING
UNE1012	24	60	17000~18000	200~400	0.01~0.03	1	SLOTTING
UNE1504	16	80	16000~17000	400~600	0.06~0.08	1.5	SLOTTING
UNE1504	16	80	16000~17000	800~1000	0.015~0.035	1.5	SLOTTING
UNE1508	18	80	16000~17000	400~600	0.04~0.06	1.5	SLOTTING
UNE1508	18	80	16000~17000	800~1000	0.01~0.025	1.5	SLOTTING
UNE1510	20	80	16000~17000	300~500	0.04~0.06	1.5	SLOTTING
UNE1510	20	80	16000~17000	700~900	0.01~0.025	1.5	SLOTTING
UNE1512	22	80	16000~17000	300~500	0.03~0.05	1.5	SLOTTING
UNE1512	22	80	16000~17000	700~900	0.008~0.015	1.5	SLOTTING
UNE2008	20	100	14000~16000	500~700	0.05~0.07	2	SLOTTING
UNE2008	20	100	14000~16000	900~1100	0.02~0.04	2	SLOTTING
UNE2010	22	100	14000~16000	500~700	0.04~0.06	2	SLOTTING
UNE2010	22	100	14000~16000	900~1100	0.01~0.03	2	SLOTTING
UNE2012	24	100	14000~16000	400~600	0.04~0.06	2	SLOTTING
UNE2012	24	100	14000~16000	800~1000	0.01~0.03	2	SLOTTING
UNE2016	28	100	14000~16000	300~500	0.03~0.05	2	SLOTTING
UNE2016	28	100	14000~16000	600~800	0.008~0.02	2	SLOTTING
UNE3008	15	125	11000~13000	600~800	0.12~0.14	3	SLOTTING
UNE3008	15	125	11000~13000	1200~1600	0.04~0.08	3	SLOTTING
UNE3012	19	125	11000~13000	600~800	0.1~0.12	3	SLOTTING
UNE3012	19	125	11000~13000	1200~1600	0.03~0.07	3	SLOTTING
UNE3016	23	125	11000~13000	600~800	0.08~0.1	3	SLOTTING
UNE3016	23	125	11000~13000	1000~1400	0.02~0.05	3	SLOTTING
UNE3020	27	125	11000~13000	500~700	0.06~0.08	3	SLOTTING
UNE3020	27	125	11000~13000	900~1100	0.02~0.04	3	SLOTTING
UNE4010	17	140	9000~11000	800~1000	0.12~0.14	4	SLOTTING
UNE4010	17	140	9000~11000	1400~1800	0.04~0.08	4	SLOTTING
UNE4016	23	140	9000~11000	600~800	0.1~0.12	4	SLOTTING
UNE4016	23	140	9000~11000	1200~1600	0.03~0.07	4	SLOTTING
UNE4020	27	140	9000~11000	600~800	0.06~0.08	4	SLOTTING
UNE4020	27	140	9000~11000	1200~1600	0.02~0.04	4	SLOTTING

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UNE MILLING CONDITIONS

DHF ITALIA

Work Material	*Hardened Steels :* **SKD61/STAVAX/1.2083/17-4PH** (HRc52)
Coolant Type	Dry coolant

Type No.	Extension Length (mm)	Cutting Speed (m/min)	Speed (min^{-1})	Feed (mm/min)	(Aa) Depth of Cut	(Ap) Width of Cut	Milling Type
UNE1004	16	50	14000~15000	300~500	0.03~0.05	1	SLOTTING
UNE1004	16	50	14000~15000	500~700	0.01~0.03	1	SLOTTING
UNE1006	18	50	14000~15000	300~500	0.02~0.04	1	SLOTTING
UNE1006	18	50	14000~15000	300~500	0.02~0.04	1	SLOTTING
UNE1008	20	50	14000~15000	200~400	0.01~0.03	1	SLOTTING
UNE1008	20	50	14000~15000	200~400	0.01~0.03	1	SLOTTING
UNE1010	22	50	14000~15000	200~400	0.01~0.03	1	SLOTTING
UNE1010	22	50	14000~15000	200~400	0.01~0.03	1	SLOTTING
UNE1012	24	50	14000~15000	200~400	0.008~0.015	1	SLOTTING
UNE1012	24	50	14000~15000	200~400	0.008~0.015	1	SLOTTING
UNE1504	16	65	13000~14000	300~500	0.04~0.06	1.5	SLOTTING
UNE1504	16	65	13000~14000	600~800	0.015~0.03	1.5	SLOTTING
UNE1508	18	65	13000~14000	300~500	0.03~0.05	1.5	SLOTTING
UNE1508	18	65	13000~14000	600~800	0.01~0.02	1.5	SLOTTING
UNE1510	20	65	13000~14000	300~500	0.03~0.05	1.5	SLOTTING
UNE1510	20	65	13000~14000	600~800	0.01~0.02	1.5	SLOTTING
UNE1512	22	65	13000~14000	200~400	0.02~0.04	1.5	SLOTTING
UNE1512	22	65	13000~14000	200~400	0.02~0.04	1.5	SLOTTING
UNE2008	20	85	12000~13000	400~600	0.03~0.05	2	SLOTTING
UNE2008	20	85	12000~13000	700~900	0.01~0.02	2	SLOTTING
UNE2010	22	85	12000~13000	300~500	0.03~0.05	2	SLOTTING
UNE2010	22	85	12000~13000	600~800	0.01~0.02	2	SLOTTING
UNE2012	24	85	12000~13000	300~500	0.02~0.04	2	SLOTTING
UNE2012	24	85	12000~13000	300~500	0.02~0.04	2	SLOTTING
UNE2016	28	85	12000~13000	200~400	0.02~0.04	2	SLOTTING
UNE2016	28	85	12000~13000	200~400	0.02~0.04	2	SLOTTING
UNE3008	15	105	11000~12000	500~700	0.06~0.08	3	SLOTTING
UNE3008	15	105	11000~12000	900~1100	0.02~0.04	3	SLOTTING
UNE3012	19	105	11000~12000	400~600	0.06~0.08	3	SLOTTING
UNE3012	19	105	11000~12000	800~1000	0.02~0.04	3	SLOTTING
UNE3016	23	105	11000~12000	400~600	0.04~0.06	3	SLOTTING
UNE3016	23	105	11000~12000	800~1000	0.01~0.025	3	SLOTTING
UNE3020	27	105	11000~12000	300~500	0.03~0.05	3	SLOTTING
UNE3020	27	105	11000~12000	600~800	0.01~0.02	3	SLOTTING
UNE4010	17	115	7000~9000	500~700	0.06~0.08	4	SLOTTING
UNE4010	17	115	7000~9000	900~1100	0.02~0.04	4	SLOTTING
UNE4016	23	115	7000~9000	400~600	0.04~0.06	4	SLOTTING
UNE4016	23	115	7000~9000	800~1000	0.01~0.03	4	SLOTTING
UNE4020	27	115	7000~9000	400~600	0.03~0.05	4	SLOTTING
UNE4020	27	115	7000~9000	600~800	0.01~0.03	4	SLOTTING

UNER MILLING CONDITIONS

DHF ITALIA

Work Material	*Prehardened Steels* : **NAK80, 1.2083** (HRc38)
Coolant Type	Wet coolant

Type No.	Extension Length (mm)	Cutting Speed (m/min)	Speed (min^{-1})	Feed (mm/min)	(Aa) Depth of Cut	(A_P) Width of Cut	Milling Type
UNER1006	13	60	17000~18000	300~500	0.03~0.05	1	SLOTTING
UNER1006	13	60	17000~18000	700~900	0.008~0.015	1	SLOTTING
UNER1008	15	60	17000~18000	200~400	0.03~0.05	1	SLOTTING
UNER1008	15	60	17000~18000	600~800	0.008~0.015	1	SLOTTING
UNER1010	17	60	17000~18000	200~400	0.02~0.04	1	SLOTTING
UNER1010	17	60	17000~18000	500~700	0.008~0.015	1	SLOTTING
UNER1012	19	60	17000~18000	200~400	0.01~0.03	1	SLOTTING
UNER1012	19	60	17000~18000	200~400	0.01~0.03	1	SLOTTING
UNER1508	17	80	16000~17000	400~600	0.04~0.06	1.5	SLOTTING
UNER1508	17	80	16000~17000	800~1000	0.01~0.025	1.5	SLOTTING
UNER1510	19	80	16000~17000	300~500	0.04~0.06	1.5	SLOTTING
UNER1510	19	80	16000~17000	700~900	0.01~0.025	1.5	SLOTTING
UNER1512	21	80	16000~17000	300~500	0.03~0.05	1.5	SLOTTING
UNER1512	21	80	16000~17000	700~900	0.008~0.015	1.5	SLOTTING
UNER1516	25	80	16000~17000	200~400	0.02~0.04	1.5	SLOTTING
UNER1516	25	80	16000~17000	500~700	0.008~0.015	1.5	SLOTTING
UNER2008	20	100	14000~16000	500~700	0.05~0.07	2	SLOTTING
UNER2008	20	100	14000~16000	900~1100	0.02~0.04	2	SLOTTING
UNER2010	22	100	14000~16000	500~700	0.04~0.06	2	SLOTTING
UNER2010	22	100	14000~16000	900~1100	0.01~0.03	2	SLOTTING
UNER2012	24	100	14000~16000	400~600	0.04~0.06	2	SLOTTING
UNER2012	24	100	14000~16000	800~1000	0.01~0.03	2	SLOTTING
UNER2016	28	100	14000~16000	300~500	0.03~0.05	2	SLOTTING
UNER2016	28	100	14000~16000	600~800	0.008~0.02	2	SLOTTING
UNER2020	32	100	14000~16000	300~500	0.02~0.04	2	SLOTTING
UNER2020	32	100	14000~16000	500~700	0.008~0.02	2	SLOTTING
UNER2510	20	110	13000~14000	600~800	0.06~0.08	2.5	SLOTTING
UNER2510	20	110	13000~14000	1100~1400	0.02~0.05	2.5	SLOTTING
UNER2512	22	110	13000~14000	500~700	0.06~0.08	2.5	SLOTTING
UNER2512	22	110	13000~14000	1000~1300	0.02~0.05	2.5	SLOTTING
UNER2516	26	110	13000~14000	400~600	0.04~0.06	2.5	SLOTTING
UNER2516	26	110	13000~14000	800~1000	0.01~0.025	2.5	SLOTTING
UNER2520	30	110	13000~14000	300~500	0.03~0.05	2.5	SLOTTING
UNER2520	30	110	13000~14000	600~800	0.01~0.02	2.5	SLOTTING
UNER3010	18	125	11000~13000	700~900	0.1~0.12	3	SLOTTING
UNER3010	18	125	11000~13000	1300~1700	0.03~0.07	3	SLOTTING
UNER3012	20	125	11000~13000	600~800	0.1~0.12	3	SLOTTING
UNER3012	20	125	11000~13000	1200~1600	0.03~0.07	3	SLOTTING
UNER3016	24	125	11000~13000	600~800	0.08~0.1	3	SLOTTING
UNER3016	24	125	11000~13000	1000~1400	0.02~0.05	3	SLOTTING
UNER3020	28	125	11000~13000	500~700	0.06~0.08	3	SLOTTING
UNER3020	28	125	11000~13000	900~1100	0.02~0.04	3	SLOTTING
UNER3025	33	125	11000~13000	400~600	0.05~0.07	3	SLOTTING
UNER3025	33	125	11000~13000	800~1000	0.01~0.03	3	SLOTTING

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UNER MILLING CONDITIONS

DHF ITALIA

Work Material	*Hardened Steels :* **SKD61/STAVAX/1.2083/17-4PH** (HRc52)
Coolant Type	Dry coolant

Type No.	Extension Length (mm)	Cutting Speed (m/min)	Speed (min^{-1})	Feed (mm/min)	(Aa) Depth of Cut	(Ap) Width of Cut	Milling Type
UNER1006	13	50	14000~15000	300~500	0.02~0.04	1	SLOTTING
UNER1006	13	50	14000~15000	300~500	0.02~0.04	1	SLOTTING
UNER1008	15	50	14000~15000	200~400	0.01~0.03	1	SLOTTING
UNER1008	15	50	14000~15000	200~400	0.01~0.03	1	SLOTTING
UNER1010	17	50	14000~15000	200~400	0.01~0.03	1	SLOTTING
UNER1010	17	50	14000~15000	200~400	0.01~0.03	1	SLOTTING
UNER1012	19	50	14000~15000	200~400	0.008~0.015	1	SLOTTING
UNER1012	19	50	14000~15000	200~400	0.008~0.015	1	SLOTTING
UNER1508	17	65	13000~14000	300~500	0.03~0.05	1.5	SLOTTING
UNER1508	17	65	13000~14000	600~800	0.01~0.02	1.5	SLOTTING
UNER1510	19	65	13000~14000	300~500	0.03~0.05	1.5	SLOTTING
UNER1510	19	65	13000~14000	600~800	0.01~0.02	1.5	SLOTTING
UNER1512	21	65	13000~14000	200~400	0.02~0.04	1.5	SLOTTING
UNER1512	21	65	13000~14000	200~400	0.02~0.04	1.5	SLOTTING
UNER1516	25	65	13000~14000	200~400	0.01~0.03	1.5	SLOTTING
UNER1516	25	65	13000~14000	200~400	0.01~0.03	1.5	SLOTTING
UNER2008	20	85	12000~13000	400~600	0.03~0.05	2	SLOTTING
UNER2008	20	85	12000~13000	700~900	0.01~0.02	2	SLOTTING
UNER2010	22	85	12000~13000	300~500	0.03~0.05	2	SLOTTING
UNER2010	22	85	12000~13000	600~800	0.01~0.02	2	SLOTTING
UNER2012	24	85	12000~13000	300~500	0.02~0.04	2	SLOTTING
UNER2012	24	85	12000~13000	300~500	0.02~0.04	2	SLOTTING
UNER2016	28	85	12000~13000	200~400	0.02~0.04	2	SLOTTING
UNER2016	28	85	12000~13000	200~400	0.02~0.04	2	SLOTTING
UNER2020	32	85	12000~13000	200~400	0.01~0.03	2	SLOTTING
UNER2020	32	85	12000~13000	200~400	0.01~0.03	2	SLOTTING
UNER2510	20	95	11000~12000	400~600	0.04~0.06	2.5	SLOTTING
UNER2510	20	95	11000~12000	600~800	0.02~0.04	2.5	SLOTTING
UNER2512	22	95	11000~12000	400~600	0.03~0.05	2.5	SLOTTING
UNER2512	22	95	11000~12000	600~800	0.01~0.02	2.5	SLOTTING
UNER2516	26	95	11000~12000	300~500	0.02~0.04	2.5	SLOTTING
UNER2516	26	95	11000~12000	300~500	0.02~0.04	2.5	SLOTTING
UNER2520	30	95	11000~12000	200~400	0.01~0.03	2.5	SLOTTING
UNER2520	30	95	11000~12000	200~400	0.01~0.03	2.5	SLOTTING
UNER3010	18	105	11000~12000	500~700	0.06~0.08	3	SLOTTING
UNER3010	18	105	11000~12000	900~1100	0.02~0.04	3	SLOTTING
UNER3012	20	105	11000~12000	400~600	0.06~0.08	3	SLOTTING
UNER3012	20	105	11000~12000	800~1000	0.02~0.04	3	SLOTTING
UNER3016	24	105	11000~12000	400~600	0.04~0.06	3	SLOTTING
UNER3016	24	105	11000~12000	800~1000	0.01~0.025	3	SLOTTING
UNER3020	28	105	11000~12000	300~500	0.03~0.05	3	SLOTTING
UNER3020	28	105	11000~12000	600~800	0.01~0.02	3	SLOTTING
UNER3025	33	105	11000~12000	200~400	0.02~0.04	3	SLOTTING
UNER3025	33	105	11000~12000	200~400	0.02~0.04	3	SLOTTING

UDE MILLING CONDITIONS

DHF ITALIA

Work Material	*Hardened Steels :* **SKD61/STAVAX/1.2083/17-4PH** (HRc52)
Coolant Type	MQL coolant

Type No.	Extension Length (mm)	Cutting Speed (m/min)	Speed (min^{-1})	Feed (mm/min)	(Aa) Depth of Cut	(A_P) Width of Cut	Milling Type
UDE0201	10	15	18000~20000	100~150	0.003~0.006	0.2	SLOTTING
UDE0201	10	15	18000~20000	100~150	0.003~0.006	0.2	SLOTTING
UDE0202	11	15	18000~20000	100~150	0.003~0.006	0.2	SLOTTING
UDE0202	11	15	18000~20000	100~150	0.003~0.006	0.2	SLOTTING
UDE0301	10	20	18000~20000	100~150	0.005~0.008	0.3	SLOTTING
UDE0301	10	20	18000~20000	100~150	0.005~0.008	0.3	SLOTTING
UDE0302	12	20	18000~20000	100~150	0.005~0.008	0.3	SLOTTING
UDE0302	12	20	18000~20000	100~150	0.005~0.008	0.3	SLOTTING
UDE0303	13	20	18000~20000	100~150	0.005~0.008	0.3	SLOTTING
UDE0303	13	20	18000~20000	100~150	0.005~0.008	0.3	SLOTTING
UDE0402	12	25	18000~20000	100~200	0.008~0.012	0.4	SLOTTING
UDE0402	12	25	18000~20000	100~200	0.008~0.012	0.4	SLOTTING
UDE0403	13	25	18000~20000	100~200	0.008~0.012	0.4	SLOTTING
UDE0403	13	25	18000~20000	100~200	0.008~0.012	0.4	SLOTTING
UDE0404	14	25	18000~20000	100~200	0.008~0.012	0.4	SLOTTING
UDE0404	14	25	18000~20000	100~200	0.008~0.012	0.4	SLOTTING
UDE0502	11	30	17000~18000	150~250	0.008~0.015	0.5	SLOTTING
UDE0502	11	30	17000~18000	150~250	0.008~0.015	0.5	SLOTTING
UDE0504	13	30	17000~18000	100~200	0.008~0.015	0.5	SLOTTING
UDE0504	13	30	17000~18000	100~200	0.008~0.015	0.5	SLOTTING
UDE0506	15	30	17000~18000	100~200	0.008~0.015	0.5	SLOTTING
UDE0506	15	30	17000~18000	100~200	0.008~0.015	0.5	SLOTTING
UDE0602	11	35	17000~18000	200~300	0.01~0.018	0.6	SLOTTING
UDE0602	11	35	17000~18000	200~300	0.01~0.018	0.6	SLOTTING
UDE0604	13	35	17000~18000	150~250	0.008~0.015	0.6	SLOTTING
UDE0604	13	35	17000~18000	150~250	0.008~0.015	0.6	SLOTTING
UDE0606	15	35	17000~18000	150~250	0.008~0.015	0.6	SLOTTING
UDE0606	15	35	17000~18000	150~250	0.008~0.015	0.6	SLOTTING
UDE0702	11	40	17000~18000	200~300	0.01~0.02	0.7	SLOTTING
UDE0702	11	40	17000~18000	200~300	0.01~0.02	0.7	SLOTTING
UDE0704	13	40	17000~18000	150~250	0.01~0.02	0.7	SLOTTING
UDE0704	13	40	17000~18000	150~250	0.01~0.02	0.7	SLOTTING
UDE0706	15	40	17000~18000	150~250	0.01~0.02	0.7	SLOTTING
UDE0706	15	40	17000~18000	150~250	0.01~0.02	0.7	SLOTTING
UDE0802	12	45	16000~17000	250~350	0.015~0.025	0.8	SLOTTING
UDE0802	12	45	16000~17000	250~350	0.015~0.025	0.8	SLOTTING
UDE0804	14	45	16000~17000	250~350	0.015~0.025	0.8	SLOTTING
UDE0804	14	45	16000~17000	250~350	0.015~0.025	0.8	SLOTTING
UDE0806	16	45	16000~17000	200~300	0.015~0.025	0.8	SLOTTING
UDE0806	16	45	16000~17000	200~300	0.015~0.025	0.8	SLOTTING
UDE0808	18	45	16000~17000	150~250	0.01~0.02	0.8	SLOTTING
UDE0808	18	45	16000~17000	150~250	0.01~0.02	0.8	SLOTTING
UDE1006	13	55	16000~17000	300~500	0.03~0.05	1	SLOTTING
UDE1006	13	55	16000~17000	600~800	0.008~0.02	1	SLOTTING
UDE1008	15	55	16000~17000	300~500	0.03~0.05	1	SLOTTING
UDE1008	15	55	16000~17000	600~800	0.008~0.02	1	SLOTTING

Type No.	Extension Length (mm)	Cutting Speed (m/min)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_P) Width of Cut	Milling Type
UDE1010	17	55	16000~17000	300~500	0.03~0.05	1	SLOTTING
UDE1010	17	55	16000~17000	600~800	0.008~0.02	1	SLOTTING
UDE1012	19	55	16000~17000	200~400	0.02~0.04	1	SLOTTING
UDE1012	19	55	16000~17000	400~600	0.008~0.02	1	SLOTTING
UDE1206	13	65	16000~17000	400~600	0.04~0.06	1.2	SLOTTING
UDE1206	13	65	16000~17000	700~900	0.01~0.025	1.2	SLOTTING
UDE1208	15	65	16000~17000	400~600	0.03~0.05	1.2	SLOTTING
UDE1208	15	65	16000~17000	700~900	0.01~0.025	1.2	SLOTTING
UDE1210	17	65	16000~17000	300~500	0.03~0.05	1.2	SLOTTING
UDE1210	17	65	16000~17000	600~800	0.008~0.02	1.2	SLOTTING
UDE1508	15	75	15000~16000	500~700	0.05~0.07	1.5	SLOTTING
UDE1508	15	75	15000~16000	800~1000	0.01~0.03	1.5	SLOTTING
UDE1510	17	75	15000~16000	500~700	0.05~0.07	1.5	SLOTTING
UDE1510	17	75	15000~16000	800~1000	0.01~0.03	1.5	SLOTTING
UDE1512	19	75	15000~16000	400~600	0.04~0.06	1.5	SLOTTING
UDE1512	19	75	15000~16000	700~900	0.01~0.025	1.5	SLOTTING
UDE1516	23	75	15000~16000	300~500	0.03~0.05	1.5	SLOTTING
UDE1516	23	75	15000~16000	600~800	0.008~0.02	1.5	SLOTTING
UDE2008	15	95	13000~15000	600~800	0.06~0.08	2	SLOTTING
UDE2008	15	95	13000~15000	1000~1400	0.015~0.04	2	SLOTTING
UDE2010	17	95	13000~15000	600~800	0.06~0.08	2	SLOTTING
UDE2010	17	95	13000~15000	1000~1400	0.015~0.04	2	SLOTTING
UDE2012	19	95	13000~15000	500~700	0.05~0.07	2	SLOTTING
UDE2012	19	95	13000~15000	800~1000	0.01~0.03	2	SLOTTING
UDE2016	23	95	13000~15000	400~600	0.04~0.06	2	SLOTTING
UDE2016	23	95	13000~15000	800~1000	0.008~0.02	2	SLOTTING
UDE2020	27	95	13000~15000	300~500	0.04~0.06	2	SLOTTING
UDE2020	27	95	13000~15000	700~900	0.008~0.02	2	SLOTTING
UDE2510	17	120	13000~15000	600~800	0.08~0.1	2.5	SLOTTING
UDE2510	17	120	13000~15000	1200~1600	0.03~0.05	2.5	SLOTTING
UDE2512	19	120	13000~15000	400~600	0.08~0.1	2.5	SLOTTING
UDE2512	19	120	13000~15000	1000~1400	0.03~0.05	2.5	SLOTTING
UDE2516	23	120	13000~15000	400~600	0.07~0.09	2.5	SLOTTING
UDE2516	23	120	13000~15000	1000~1400	0.02~0.04	2.5	SLOTTING
UDE2520	27	120	13000~15000	400~600	0.05~0.07	2.5	SLOTTING
UDE2520	27	120	13000~15000	800~1200	0.015~0.035	2.5	SLOTTING
UDE3010	17	125	11000~13000	800~1000	0.1~0.12	3	SLOTTING
UDE3010	17	125	11000~13000	1300~1700	0.04~0.07	3	SLOTTING
UDE3012	19	125	11000~13000	600~800	0.08~0.1	3	SLOTTING
UDE3012	19	125	11000~13000	1100~1500	0.03~0.06	3	SLOTTING
UDE3016	23	125	11000~13000	500~700	0.07~0.09	3	SLOTTING
UDE3016	23	125	11000~13000	1000~1400	0.02~0.05	3	SLOTTING
UDE3020	27	125	11000~13000	400~600	0.06~0.08	3	SLOTTING
UDE3020	27	125	11000~13000	1000~1400	0.015~0.035	3	SLOTTING
UDE3025	32	125	11000~13000	400~600	0.05~0.07	3	SLOTTING
UDE3025	32	125	11000~13000	1000~1400	0.015~0.035	3	SLOTTING

LNE MILLING CONDITIONS

DHF ITALIA

Work Material	*Stainless Steels :* **SUS316/1.4401, SUS304/1.4301** (HRc30)					
Coolant Type	Wet coolant					
Type No.	Extension Length (mm)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_p) Width of Cut	Milling Type
LNE0502	11	16000~18000	200~300	0.015~0.02	0.5	SLOTTING
LNE0502	11	16000~18000	300~500	0.005~0.015	0.5	SLOTTING
LNE0504	13	16000~18000	150~300	0.015~0.02	0.5	SLOTTING
LNE0504	13	16000~18000	300~500	0.005~0.015	0.5	SLOTTING
LNE0506	15	16000~18000	150~300	0.01~0.015	0.5	SLOTTING
LNE0506	15	16000~18000	300~500	0.005~0.01	0.5	SLOTTING
LNE1006	15	16000~18000	200~300	0.02~0.04	1	SLOTTING
LNE1006	15	16000~18000	300~500	0.005~0.015	1	SLOTTING
LNE1008	17	16000~18000	200~300	0.02~0.04	1	SLOTTING
LNE1008	17	16000~18000	300~500	0.005~0.015	1	SLOTTING
LNE1010	19	16000~18000	200~300	0.02~0.03	1	SLOTTING
LNE1010	19	16000~18000	300~500	0.005~0.015	1	SLOTTING
LNE1012	20	16000~18000	200~300	0.015~0.02	1	SLOTTING
LNE1012	20	16000~18000	300~500	0.005~0.015	1	SLOTTING
LNE1508	15	13000~15000	400~600	0.04~0.06	1.5	SLOTTING
LNE1508	15	13000~15000	700~900	0.01~0.03	1.5	SLOTTING
LNE1510	17	13000~15000	400~600	0.04~0.06	1.5	SLOTTING
LNE1510	17	13000~15000	700~900	0.01~0.03	1.5	SLOTTING
LNE1512	19	13000~15000	400~600	0.04~0.05	1.5	SLOTTING
LNE1512	19	13000~15000	700~900	0.01~0.03	1.5	SLOTTING
LNE1516	21	13000~15000	300~500	0.03~0.05	1.5	SLOTTING
LNE1516	21	13000~15000	600~800	0.01~0.025	1.5	SLOTTING
LNE2008	15	12000~14000	600~800	0.06~0.08	2	SLOTTING
LNE2008	15	12000~14000	800~1200	0.015~0.045	2	SLOTTING
LNE2010	17	12000~14000	400~600	0.04~0.06	2	SLOTTING
LNE2010	17	12000~14000	800~1200	0.015~0.03	2	SLOTTING
LNE2012	19	12000~14000	400~600	0.04~0.06	2	SLOTTING
LNE2012	19	12000~14000	700~1000	0.01~0.03	2	SLOTTING
LNE2016	23	12000~14000	400~600	0.03~0.04	2	SLOTTING
LNE2016	23	12000~14000	700~1000	0.01~0.02	2	SLOTTING
LNE2020	26	12000~14000	400~600	0.03~0.04	2	SLOTTING
LNE2020	26	12000~14000	700~1000	0.01~0.02	2	SLOTTING
LNE2510	17	12000~14000	800~1000	0.08~0.1	2.5	SLOTTING
LNE2510	17	12000~14000	1000~1400	0.025~0.06	2.5	SLOTTING
LNE2512	19	12000~14000	800~1000	0.07~0.09	2.5	SLOTTING
LNE2512	19	12000~14000	1000~1400	0.025~0.06	2.5	SLOTTING
LNE2516	23	12000~14000	700~900	0.05~0.07	2.5	SLOTTING
LNE2516	23	12000~14000	900~1200	0.01~0.035	2.5	SLOTTING
LNE2520	26	12000~14000	400~600	0.03~0.05	2.5	SLOTTING
LNE2520	26	12000~14000	800~1000	0.01~0.025	2.5	SLOTTING
LNE3010	20	11000~13000	800~1000	0.06~0.08	3	SLOTTING
LNE3010	20	11000~13000	1200~1400	0.015~0.04	3	SLOTTING
LNE3012	22	11000~13000	600~800	0.06~0.08	3	SLOTTING
LNE3012	22	11000~13000	1200~1400	0.015~0.04	3	SLOTTING
LNE3016	26	11000~13000	400~600	0.06~0.08	3	SLOTTING
LNE3016	26	11000~13000	1000~1200	0.015~0.04	3	SLOTTING
LNE3020	30	11000~13000	400~600	0.04~0.06	3	SLOTTING
LNE3020	30	11000~13000	800~1200	0.01~0.03	3	SLOTTING
LNE3025	34	11000~13000	400~600	0.02~0.04	3	SLOTTING
LNE3025	34	11000~13000	600~800	0.01~0.015	3	SLOTTING

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LNE MILLING CONDITIONS

DHF ITALIA

Work Material	*Plastic Mould Steels* : **P3/P5/P20/1.2311** (HRc32)				
Coolant Type	Wet coolant				
Type No.	Extension Length (mm)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_p) Width of Cut	Milling Type
LNE0502	11	16000~18000	200~400	0.015~0.02	0.5	SLOTTING
LNE0502	11	16000~18000	400~600	0.005~0.015	0.5	SLOTTING
LNE0504	13	16000~18000	150~300	0.015~0.02	0.5	SLOTTING
LNE0504	13	16000~18000	300~500	0.005~0.015	0.5	SLOTTING
LNE0506	15	16000~18000	150~300	0.01~0.015	0.5	SLOTTING
LNE0506	15	16000~18000	300~500	0.005~0.01	0.5	SLOTTING
LNE1006	15	16000~18000	400~600	0.03~0.05	1	SLOTTING
LNE1006	15	16000~18000	600~800	0.01~0.025	1	SLOTTING
LNE1008	17	16000~18000	400~600	0.03~0.05	1	SLOTTING
LNE1008	17	16000~18000	600~800	0.01~0.025	1	SLOTTING
LNE1010	19	16000~18000	300~500	0.02~0.03	1	SLOTTING
LNE1010	19	16000~18000	500~700	0.005~0.015	1	SLOTTING
LNE1012	20	16000~18000	300~500	0.02~0.03	1	SLOTTING
LNE1012	20	16000~18000	500~700	0.005~0.015	1	SLOTTING
LNE1508	15	15000~17000	800~1000	0.06~0.08	1.5	SLOTTING
LNE1508	15	15000~17000	1200~1400	0.02~0.05	1.5	SLOTTING
LNE1510	17	15000~17000	800~1000	0.05~0.07	1.5	SLOTTING
LNE1510	17	15000~17000	1000~1200	0.015~0.04	1.5	SLOTTING
LNE1512	19	15000~17000	700~900	0.04~0.06	1.5	SLOTTING
LNE1512	19	15000~17000	1000~1200	0.015~0.03	1.5	SLOTTING
LNE1516	21	15000~17000	600~800	0.04~0.06	1.5	SLOTTING
LNE1516	21	15000~17000	900~1100	0.015~0.03	1.5	SLOTTING
LNE2008	15	14000~16000	1200~1400	0.1~0.12	2	SLOTTING
LNE2008	15	14000~16000	1600~1800	0.03~0.07	2	SLOTTING
LNE2010	17	14000~16000	1200~1400	0.08~0.1	2	SLOTTING
LNE2010	17	14000~16000	1600~1800	0.025~0.05	2	SLOTTING
LNE2012	19	14000~16000	1200~1400	0.06~0.08	2	SLOTTING
LNE2012	19	14000~16000	1600~1800	0.02~0.04	2	SLOTTING
LNE2016	23	14000~16000	800~1000	0.04~0.05	2	SLOTTING
LNE2016	23	14000~16000	1200~1400	0.015~0.03	2	SLOTTING
LNE2020	26	14000~16000	600~800	0.03~0.05	2	SLOTTING
LNE2020	26	14000~16000	1000~1200	0.01~0.025	2	SLOTTING
LNE2510	17	13000~15000	1400~1600	0.1~0.12	2.5	SLOTTING
LNE2510	17	13000~15000	1800~2000	0.03~0.06	2.5	SLOTTING
LNE2512	19	13000~15000	1400~1600	0.08~0.1	2.5	SLOTTING
LNE2512	19	13000~15000	1800~2000	0.03~0.06	2.5	SLOTTING
LNE2516	23	13000~15000	1200~1400	0.06~0.08	2.5	SLOTTING
LNE2516	23	13000~15000	1500~1700	0.025~0.05	2.5	SLOTTING
LNE2520	26	13000~15000	800~1000	0.04~0.06	2.5	SLOTTING
LNE2520	26	13000~15000	1200~1400	0.015~0.03	2.5	SLOTTING
LNE3010	20	12000~14000	1800~2000	0.12~0.14	3	SLOTTING
LNE3010	20	12000~14000	2100~2300	0.035~0.08	3	SLOTTING
LNE3012	22	12000~14000	1800~2000	0.1~0.12	3	SLOTTING
LNE3012	22	12000~14000	2100~2300	0.03~0.07	3	SLOTTING
LNE3016	26	12000~14000	1600~1800	0.08~0.1	3	SLOTTING
LNE3016	26	12000~14000	1900~2100	0.02~0.045	3	SLOTTING
LNE3020	30	12000~14000	1200~1400	0.06~0.08	3	SLOTTING
LNE3020	30	12000~14000	1500~1700	0.015~0.035	3	SLOTTING
LNE3025	34	12000~14000	800~1000	0.04~0.06	3	SLOTTING
LNE3025	34	12000~14000	1200~1400	0.015~0.03	3	SLOTTING

LNE MILLING CONDITIONS

DHF ITALIA

Work Material	*Prehardened Steels* : **NAK80, 1.2083** (HRc38)					
Coolant Type	Wet coolant					
Type No.	Extension Length (mm)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_p) Width of Cut	Milling Type
LNE0502	11	16000~18000	200~300	0.015~0.02	0.5	SLOTTING
LNE0502	11	16000~18000	400~500	0.005~0.015	0.5	SLOTTING
LNE0504	13	16000~18000	150~250	0.015~0.02	0.5	SLOTTING
LNE0504	13	16000~18000	300~400	0.005~0.015	0.5	SLOTTING
LNE0506	15	16000~18000	150~220	0.01~0.015	0.5	SLOTTING
LNE0506	15	16000~18000	250~350	0.005~0.01	0.5	SLOTTING
LNE1006	15	16000~18000	400~500	0.03~0.05	1	SLOTTING
LNE1006	15	16000~18000	600~700	0.01~0.025	1	SLOTTING
LNE1008	17	16000~18000	350~450	0.03~0.05	1	SLOTTING
LNE1008	17	16000~18000	550~650	0.01~0.025	1	SLOTTING
LNE1010	19	16000~18000	300~400	0.02~0.03	1	SLOTTING
LNE1010	19	16000~18000	500~600	0.005~0.015	1	SLOTTING
LNE1012	20	16000~18000	300~400	0.02~0.03	1	SLOTTING
LNE1012	20	16000~18000	500~600	0.005~0.015	1	SLOTTING
LNE1508	15	15000~17000	700~900	0.06~0.08	1.5	SLOTTING
LNE1508	15	15000~17000	1100~1300	0.02~0.05	1.5	SLOTTING
LNE1510	17	15000~17000	700~900	0.05~0.07	1.5	SLOTTING
LNE1510	17	15000~17000	900~1100	0.015~0.04	1.5	SLOTTING
LNE1512	19	15000~17000	600~800	0.04~0.06	1.5	SLOTTING
LNE1512	19	15000~17000	900~1100	0.015~0.03	1.5	SLOTTING
LNE1516	21	15000~17000	500~700	0.04~0.06	1.5	SLOTTING
LNE1516	21	15000~17000	800~1000	0.015~0.03	1.5	SLOTTING
LNE2008	15	14000~16000	1100~1300	0.1~0.12	2	SLOTTING
LNE2008	15	14000~16000	1500~1700	0.03~0.07	2	SLOTTING
LNE2010	17	14000~16000	1100~1300	0.08~0.1	2	SLOTTING
LNE2010	17	14000~16000	1500~1700	0.025~0.05	2	SLOTTING
LNE2012	19	14000~16000	1100~1300	0.06~0.08	2	SLOTTING
LNE2012	19	14000~16000	1500~1700	0.02~0.04	2	SLOTTING
LNE2016	23	14000~16000	700~900	0.04~0.05	2	SLOTTING
LNE2016	23	14000~16000	1100~1300	0.015~0.03	2	SLOTTING
LNE2020	26	14000~16000	500~700	0.03~0.05	2	SLOTTING
LNE2020	26	14000~16000	1000~1200	0.01~0.025	2	SLOTTING
LNE2510	17	13000~15000	1300~1500	0.1~0.12	2.5	SLOTTING
LNE2510	17	13000~15000	1700~1900	0.03~0.06	2.5	SLOTTING
LNE2512	19	13000~15000	1300~1500	0.08~0.1	2.5	SLOTTING
LNE2512	19	13000~15000	1700~1900	0.03~0.06	2.5	SLOTTING
LNE2516	23	13000~15000	1100~1300	0.06~0.08	2.5	SLOTTING
LNE2516	23	13000~15000	1400~1600	0.025~0.05	2.5	SLOTTING
LNE2520	26	13000~15000	700~900	0.04~0.06	2.5	SLOTTING
LNE2520	26	13000~15000	1100~1300	0.015~0.03	2.5	SLOTTING
LNE3010	20	12000~14000	1700~1900	0.12~0.14	3	SLOTTING
LNE3010	20	12000~14000	2000~2200	0.035~0.08	3	SLOTTING
LNE3012	22	12000~14000	1700~1900	0.1~0.12	3	SLOTTING
LNE3012	22	12000~14000	2000~2200	0.03~0.07	3	SLOTTING
LNE3016	26	12000~14000	1400~1600	0.08~0.1	3	SLOTTING
LNE3016	26	12000~14000	1800~2000	0.02~0.045	3	SLOTTING
LNE3020	30	12000~14000	1000~1200	0.06~0.08	3	SLOTTING
LNE3020	30	12000~14000	1300~1500	0.015~0.035	3	SLOTTING
LNE3025	34	12000~14000	700~900	0.04~0.06	3	SLOTTING
LNE3025	34	12000~14000	1100~1300	0.015~0.03	3	SLOTTING

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LNH MILLING CONDITIONS

DHF ITALIA

Work Material	*Stainless Steels :* **SUS316/1.4401, SUS304/1.4301** (HRc30)				
Coolant Type	Wet coolant				
Type No.	Extension Length (mm)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_p) Width of Cut	Milling Type
LNH1006	15	16000~18000	200~300	0.02~0.04	1	SLOTTING
LNH1006	15	16000~18000	300~500	0.01~0.015	1	SLOTTING
LNH1008	17	16000~18000	200~300	0.02~0.04	1	SLOTTING
LNH1008	17	16000~18000	300~500	0.01~0.015	1	SLOTTING
LNH1010	19	16000~18000	200~300	0.02~0.03	1	SLOTTING
LNH1010	19	16000~18000	300~500	0.005~0.015	1	SLOTTING
LNH1012	20	16000~18000	200~300	0.015~0.02	1	SLOTTING
LNH1012	20	16000~18000	300~500	0.005~0.015	1	SLOTTING
LNH1508	15	13000~15000	400~600	0.04~0.06	1.5	SLOTTING
LNH1508	15	13000~15000	700~900	0.01~0.03	1.5	SLOTTING
LNH1510	17	13000~15000	400~600	0.04~0.06	1.5	SLOTTING
LNH1510	17	13000~15000	700~900	0.01~0.03	1.5	SLOTTING
LNH1512	19	13000~15000	400~600	0.04~0.05	1.5	SLOTTING
LNH1512	19	13000~15000	700~900	0.01~0.03	1.5	SLOTTING
LNH1516	21	13000~15000	300~500	0.03~0.05	1.5	SLOTTING
LNH1516	21	13000~15000	600~800	0.01~0.025	1.5	SLOTTING
LNH2008	15	12000~14000	600~800	0.06~0.08	2	SLOTTING
LNH2008	15	12000~14000	800~1200	0.015~0.045	2	SLOTTING
LNH2010	17	12000~14000	400~600	0.04~0.06	2	SLOTTING
LNH2010	17	12000~14000	800~1200	0.015~0.03	2	SLOTTING
LNH2012	19	12000~14000	400~600	0.04~0.06	2	SLOTTING
LNH2012	19	12000~14000	700~1100	0.01~0.03	2	SLOTTING
LNH2016	23	12000~14000	400~600	0.03~0.04	2	SLOTTING
LNH2016	23	12000~14000	700~900	0.01~0.02	2	SLOTTING
LNH2020	26	12000~14000	400~600	0.03~0.04	2	SLOTTING
LNH2020	26	12000~14000	600~800	0.01~0.02	2	SLOTTING
LNH2510	17	12000~14000	800~1000	0.08~0.1	2.5	SLOTTING
LNH2510	17	12000~14000	1000~1400	0.025~0.05	2.5	SLOTTING
LNH2512	19	12000~14000	600~800	0.06~0.08	2.5	SLOTTING
LNH2512	19	12000~14000	1000~1400	0.025~0.05	2.5	SLOTTING
LNH2516	23	12000~14000	500~700	0.06~0.08	2.5	SLOTTING
LNH2516	23	12000~14000	900~1200	0.02~0.05	2.5	SLOTTING
LNH2520	26	12000~14000	400~600	0.04~0.06	2.5	SLOTTING
LNH2520	26	12000~14000	800~1000	0.015~0.03	2.5	SLOTTING
LNH3010	20	11000~13000	1000~1200	0.08~0.1	3	SLOTTING
LNH3010	20	11000~13000	1400~1800	0.02~0.06	3	SLOTTING
LNH3012	22	11000~13000	800~1000	0.07~0.09	3	SLOTTING
LNH3012	22	11000~13000	1200~1600	0.02~0.05	3	SLOTTING
LNH3016	26	11000~13000	600~800	0.06~0.08	3	SLOTTING
LNH3016	26	11000~13000	1000~1400	0.015~0.045	3	SLOTTING
LNH3020	30	11000~13000	500~700	0.05~0.07	3	SLOTTING
LNH3020	30	11000~13000	800~1200	0.01~0.035	3	SLOTTING
LNH3025	34	11000~13000	400~600	0.04~0.06	3	SLOTTING
LNH3025	34	11000~13000	600~800	0.01~0.025	3	SLOTTING

LNH MILLING CONDITIONS

DHF ITALIA

Work Material	*Plastic Mould Steels* : **P3/P5/P20/1.2311** (HRc32)					
Coolant Type	Wet coolant					
Type No.	Extension Length (mm)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_p) Width of Cut	Milling Type
LNH1006	15	16000~18000	400~600	0.03~0.05	1	SLOTTING
LNH1006	15	16000~18000	600~800	0.01~0.025	1	SLOTTING
LNH1008	17	16000~18000	400~600	0.03~0.05	1	SLOTTING
LNH1008	17	16000~18000	600~800	0.01~0.025	1	SLOTTING
LNH1010	19	16000~18000	300~500	0.02~0.03	1	SLOTTING
LNH1010	19	16000~18000	500~700	0.005~0.015	1	SLOTTING
LNH1012	20	16000~18000	300~500	0.02~0.03	1	SLOTTING
LNH1012	20	16000~18000	500~700	0.005~0.015	1	SLOTTING
LNH1508	15	15000~17000	800~1000	0.06~0.08	1.5	SLOTTING
LNH1508	15	15000~17000	1200~1400	0.02~0.05	1.5	SLOTTING
LNH1510	17	15000~17000	800~1000	0.05~0.07	1.5	SLOTTING
LNH1510	17	15000~17000	1000~1200	0.015~0.04	1.5	SLOTTING
LNH1512	19	15000~17000	700~900	0.04~0.06	1.5	SLOTTING
LNH1512	19	15000~17000	1000~1200	0.015~0.03	1.5	SLOTTING
LNH1516	21	15000~17000	600~800	0.04~0.06	1.5	SLOTTING
LNH1516	21	15000~17000	900~1100	0.015~0.03	1.5	SLOTTING
LNH2008	15	14000~16000	1200~1400	0.1~0.12	2	SLOTTING
LNH2008	15	14000~16000	1600~1800	0.03~0.07	2	SLOTTING
LNH2010	17	14000~16000	1200~1400	0.08~0.1	2	SLOTTING
LNH2010	17	14000~16000	1600~1800	0.025~0.05	2	SLOTTING
LNH2012	19	14000~16000	1200~1400	0.06~0.08	2	SLOTTING
LNH2012	19	14000~16000	1600~1800	0.02~0.04	2	SLOTTING
LNH2016	23	14000~16000	800~1000	0.04~0.05	2	SLOTTING
LNH2016	23	14000~16000	1200~1400	0.015~0.04	2	SLOTTING
LNH2020	26	14000~16000	600~800	0.04~0.05	2	SLOTTING
LNH2020	26	14000~16000	1000~1200	0.01~0.03	2	SLOTTING
LNH2510	17	13000~15000	1400~1600	0.11~0.13	2.5	SLOTTING
LNH2510	17	13000~15000	1800~2000	0.025~0.06	2.5	SLOTTING
LNH2512	19	13000~15000	1400~1600	0.1~0.12	2.5	SLOTTING
LNH2512	19	13000~15000	1800~2000	0.025~0.06	2.5	SLOTTING
LNH2516	23	13000~15000	1200~1400	0.06~0.08	2.5	SLOTTING
LNH2516	23	13000~15000	1500~1700	0.02~0.05	2.5	SLOTTING
LNH2520	26	13000~15000	800~1000	0.04~0.06	2.5	SLOTTING
LNH2520	26	13000~15000	1200~1400	0.015~0.03	2.5	SLOTTING
LNH3010	20	12000~14000	1800~2000	0.12~0.14	3	SLOTTING
LNH3010	20	12000~14000	2100~2300	0.035~0.1	3	SLOTTING
LNH3012	22	12000~14000	1800~2000	0.11~0.13	3	SLOTTING
LNH3012	22	12000~14000	2100~2300	0.03~0.09	3	SLOTTING
LNH3016	26	12000~14000	1600~1800	0.1~0.12	3	SLOTTING
LNH3016	26	12000~14000	1900~2100	0.03~0.07	3	SLOTTING
LNH3020	30	12000~14000	1200~1400	0.08~0.1	3	SLOTTING
LNH3020	30	12000~14000	1500~1700	0.02~0.06	3	SLOTTING
LNH3025	34	12000~14000	800~1000	0.06~0.08	3	SLOTTING
LNH3025	34	12000~14000	1200~1400	0.02~0.05	3	SLOTTING

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LNH MILLING CONDITIONS

DHF ITALIA

Work Material	*Prehardened Steels* : **NAK80, 1.2083** (HRc38)				
Coolant Type	Wet coolant				
Type No.	Extension Length (mm)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_p) Width of Cut	Milling Type
LNH1006	15	16000~18000	350~550	0.03~0.05	1	SLOTTING
LNH1006	15	16000~18000	550~750	0.01~0.025	1	SLOTTING
LNH1008	17	16000~18000	350~550	0.03~0.05	1	SLOTTING
LNH1008	17	16000~18000	550~750	0.01~0.025	1	SLOTTING
LNH1010	19	16000~18000	300~500	0.02~0.03	1	SLOTTING
LNH1010	19	16000~18000	500~700	0.005~0.015	1	SLOTTING
LNH1012	20	16000~18000	300~400	0.02~0.03	1	SLOTTING
LNH1012	20	16000~18000	500~600	0.005~0.015	1	SLOTTING
LNH1508	15	15000~17000	700~900	0.06~0.08	1.5	SLOTTING
LNH1508	15	15000~17000	1100~1300	0.02~0.05	1.5	SLOTTING
LNH1510	17	15000~17000	700~900	0.05~0.07	1.5	SLOTTING
LNH1510	17	15000~17000	1000~1200	0.015~0.04	1.5	SLOTTING
LNH1512	19	15000~17000	600~800	0.04~0.06	1.5	SLOTTING
LNH1512	19	15000~17000	900~1100	0.015~0.03	1.5	SLOTTING
LNH1516	21	15000~17000	500~700	0.04~0.06	1.5	SLOTTING
LNH1516	21	15000~17000	800~1000	0.015~0.03	1.5	SLOTTING
LNH2008	15	14000~16000	1100~1300	0.1~0.12	2	SLOTTING
LNH2008	15	14000~16000	1500~1700	0.03~0.07	2	SLOTTING
LNH2010	17	14000~16000	1100~1300	0.08~0.1	2	SLOTTING
LNH2010	17	14000~16000	1500~1700	0.025~0.05	2	SLOTTING
LNH2012	19	14000~16000	1000~1200	0.06~0.08	2	SLOTTING
LNH2012	19	14000~16000	1400~1600	0.02~0.04	2	SLOTTING
LNH2016	23	14000~16000	700~900	0.04~0.05	2	SLOTTING
LNH2016	23	14000~16000	1100~1300	0.015~0.04	2	SLOTTING
LNH2020	26	14000~16000	500~700	0.04~0.05	2	SLOTTING
LNH2020	26	14000~16000	900~1100	0.01~0.03	2	SLOTTING
LNH2510	17	13000~15000	1300~1500	0.11~0.13	2.5	SLOTTING
LNH2510	17	13000~15000	1700~1900	0.025~0.06	2.5	SLOTTING
LNH2512	19	13000~15000	1300~1500	0.1~0.12	2.5	SLOTTING
LNH2512	19	13000~15000	1700~1900	0.025~0.06	2.5	SLOTTING
LNH2516	23	13000~15000	1100~1300	0.06~0.08	2.5	SLOTTING
LNH2516	23	13000~15000	1400~1600	0.02~0.05	2.5	SLOTTING
LNH2520	26	13000~15000	700~900	0.04~0.06	2.5	SLOTTING
LNH2520	26	13000~15000	1100~1300	0.015~0.03	2.5	SLOTTING
LNH3010	20	12000~14000	1600~1800	0.12~0.14	3	SLOTTING
LNH3010	20	12000~14000	2000~2200	0.035~0.1	3	SLOTTING
LNH3012	22	12000~14000	1600~1800	0.11~0.13	3	SLOTTING
LNH3012	22	12000~14000	2000~2200	0.03~0.09	3	SLOTTING
LNH3016	26	12000~14000	1500~1700	0.1~0.12	3	SLOTTING
LNH3016	26	12000~14000	1800~2000	0.03~0.07	3	SLOTTING
LNH3020	30	12000~14000	1100~1300	0.08~0.1	3	SLOTTING
LNH3020	30	12000~14000	1500~1700	0.02~0.06	3	SLOTTING
LNH3025	34	12000~14000	700~900	0.06~0.08	3	SLOTTING
LNH3025	34	12000~14000	1200~1400	0.02~0.05	3	SLOTTING

LNX MILLING CONDITIONS

DHF ITALIA

Work Material	*Stainless Steels :* **SUS316/1.4401, SUS304/1.4301** (HRc30)
Coolant Type	Wet coolant

Type No.	Extension Length (mm)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_p) Width of Cut	Milling Type
LNX1006	15	16000~18000	200~300	0.02~0.04	1	SLOTTING
LNX1006	15	16000~18000	300~500	0.005~0.015	1	SLOTTING
LNX1008	17	16000~18000	200~300	0.02~0.04	1	SLOTTING
LNX1008	17	16000~18000	300~500	0.01~0.015	1	SLOTTING
LNX1010	19	16000~18000	200~300	0.02~0.03	1	SLOTTING
LNX1010	19	16000~18000	300~500	0.005~0.015	1	SLOTTING
LNX1012	20	16000~18000	200~300	0.015~0.02	1	SLOTTING
LNX1012	20	16000~18000	300~500	0.005~0.015	1	SLOTTING
LNX1508	15	13000~15000	500~700	0.04~0.06	1.5	SLOTTING
LNX1508	15	13000~15000	700~900	0.01~0.03	1.5	SLOTTING
LNX1510	17	13000~15000	500~700	0.04~0.06	1.5	SLOTTING
LNX1510	17	13000~15000	700~900	0.01~0.03	1.5	SLOTTING
LNX1512	19	13000~15000	400~600	0.04~0.05	1.5	SLOTTING
LNX1512	19	13000~15000	600~800	0.01~0.03	1.5	SLOTTING
LNX1516	21	13000~15000	300~500	0.03~0.05	1.5	SLOTTING
LNX1516	21	13000~15000	500~600	0.01~0.03	1.5	SLOTTING
LNX2008	15	12000~14000	600~800	0.06~0.08	2	SLOTTING
LNX2008	15	12000~14000	800~1000	0.03~0.06	2	SLOTTING
LNX2010	17	12000~14000	600~800	0.05~0.07	2	SLOTTING
LNX2010	17	12000~14000	800~1000	0.03~0.05	2	SLOTTING
LNX2012	19	12000~14000	500~700	0.05~0.06	2	SLOTTING
LNX2012	19	12000~14000	700~900	0.03~0.05	2	SLOTTING
LNX2016	23	12000~14000	400~600	0.04~0.05	2	SLOTTING
LNX2016	23	12000~14000	600~800	0.01~0.03	2	SLOTTING
LNX2020	26	12000~14000	400~600	0.03~0.04	2	SLOTTING
LNX2020	26	12000~14000	600~800	0.01~0.03	2	SLOTTING
LNX2510	17	12000~14000	800~1000	0.08~0.1	2.5	SLOTTING
LNX2510	17	12000~14000	1000~1200	0.05~0.08	2.5	SLOTTING
LNX2512	19	12000~14000	800~1000	0.08~0.1	2.5	SLOTTING
LNX2512	19	12000~14000	1000~1200	0.05~0.08	2.5	SLOTTING
LNX2516	23	12000~14000	700~900	0.06~0.08	2.5	SLOTTING
LNX2516	23	12000~14000	900~1100	0.025~0.05	2.5	SLOTTING
LNX2520	26	12000~14000	600~800	0.04~0.06	2.5	SLOTTING
LNX2520	26	12000~14000	800~1000	0.015~0.03	2.5	SLOTTING
LNX3010	20	11000~13000	1000~1200	0.1~0.12	3	SLOTTING
LNX3010	20	11000~13000	1200~1400	0.06~0.1	3	SLOTTING
LNX3012	22	11000~13000	1000~1200	0.09~0.11	3	SLOTTING
LNX3012	22	11000~13000	1200~1400	0.05~0.09	3	SLOTTING
LNX3016	26	11000~13000	800~1000	0.07~0.09	3	SLOTTING
LNX3016	26	11000~13000	1000~1200	0.04~0.08	3	SLOTTING
LNX3020	30	11000~13000	600~800	0.05~0.07	3	SLOTTING
LNX3020	30	11000~13000	800~1000	0.03~0.06	3	SLOTTING
LNX3025	34	11000~13000	600~800	0.04~0.06	3	SLOTTING
LNX3025	34	11000~13000	700~900	0.02~0.04	3	SLOTTING

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LNX MILLING CONDITIONS

DHF ITALIA

Work Material	*Plastic Mould Steels* : **P3/P5/P20/1.2311** (HRc32)				
Coolant Type	Wet coolant				
Type No.	Extension Length (mm)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_p) Width of Cut	Milling Type
LNX1006	15	16000~18000	400~600	0.03~0.05	1	SLOTTING
LNX1006	15	16000~18000	600~800	0.01~0.03	1	SLOTTING
LNX1008	17	16000~18000	400~600	0.03~0.05	1	SLOTTING
LNX1008	17	16000~18000	600~800	0.01~0.03	1	SLOTTING
LNX1010	19	16000~18000	300~500	0.02~0.03	1	SLOTTING
LNX1010	19	16000~18000	500~700	0.01~0.02	1	SLOTTING
LNX1012	20	16000~18000	300~500	0.02~0.03	1	SLOTTING
LNX1012	20	16000~18000	500~700	0.01~0.02	1	SLOTTING
LNX1508	15	15000~17000	800~1000	0.06~0.08	1.5	SLOTTING
LNX1508	15	15000~17000	1000~1200	0.025~0.05	1.5	SLOTTING
LNX1510	17	15000~17000	800~1000	0.05~0.07	1.5	SLOTTING
LNX1510	17	15000~17000	1000~1200	0.02~0.05	1.5	SLOTTING
LNX1512	19	15000~17000	700~900	0.04~0.06	1.5	SLOTTING
LNX1512	19	15000~17000	900~1100	0.02~0.04	1.5	SLOTTING
LNX1516	21	15000~17000	600~800	0.04~0.06	1.5	SLOTTING
LNX1516	21	15000~17000	800~1000	0.02~0.04	1.5	SLOTTING
LNX2008	15	14000~16000	1200~1400	0.1~0.12	2	SLOTTING
LNX2008	15	14000~16000	1400~1600	0.04~0.08	2	SLOTTING
LNX2010	17	14000~16000	1200~1400	0.08~0.1	2	SLOTTING
LNX2010	17	14000~16000	1400~1600	0.03~0.07	2	SLOTTING
LNX2012	19	14000~16000	1100~1300	0.06~0.08	2	SLOTTING
LNX2012	19	14000~16000	1300~1500	0.02~0.05	2	SLOTTING
LNX2016	23	14000~16000	1000~1200	0.04~0.05	2	SLOTTING
LNX2016	23	14000~16000	1200~1400	0.015~0.04	2	SLOTTING
LNX2020	26	14000~16000	800~1000	0.04~0.05	2	SLOTTING
LNX2020	26	14000~16000	1000~1200	0.01~0.03	2	SLOTTING
LNX2510	17	13000~15000	1400~1600	0.1~0.12	2.5	SLOTTING
LNX2510	17	13000~15000	1600~1800	0.06~0.08	2.5	SLOTTING
LNX2512	19	13000~15000	1400~1600	0.1~0.12	2.5	SLOTTING
LNX2512	19	13000~15000	1600~1800	0.06~0.08	2.5	SLOTTING
LNX2516	23	13000~15000	1200~1400	0.06~0.08	2.5	SLOTTING
LNX2516	23	13000~15000	1400~1600	0.04~0.06	2.5	SLOTTING
LNX2520	26	13000~15000	800~1000	0.04~0.06	2.5	SLOTTING
LNX2520	26	13000~15000	1200~1400	0.02~0.04	2.5	SLOTTING
LNX3010	20	12000~14000	1800~2000	0.12~0.14	3	SLOTTING
LNX3010	20	12000~14000	2000~2200	0.07~0.12	3	SLOTTING
LNX3012	22	12000~14000	1800~2000	0.12~0.14	3	SLOTTING
LNX3012	22	12000~14000	2000~2200	0.07~0.1	3	SLOTTING
LNX3016	26	12000~14000	1600~1800	0.1~0.12	3	SLOTTING
LNX3016	26	12000~14000	1800~2000	0.05~0.1	3	SLOTTING
LNX3020	30	12000~14000	1200~1400	0.08~0.1	3	SLOTTING
LNX3020	30	12000~14000	1400~1600	0.05~0.08	3	SLOTTING
LNX3025	34	12000~14000	800~1000	0.06~0.08	3	SLOTTING
LNX3025	34	12000~14000	1000~1200	0.03~0.06	3	SLOTTING

LNX MILLING CONDITIONS

DHF ITALIA

Work Material	*Prehardened Steels* : **NAK80, 1.2083** (HRc38)					
Coolant Type	Wet coolant					
Type No.	Extension Length (mm)	Speed (min^{-1})	Feed (mm/min)	(A_a) Depth of Cut	(A_p) Width of Cut	Milling Type
LNX1006	15	16000~18000	400~550	0.03~0.05	1	溝銑 SLOTTING
LNX1006	15	16000~18000	600~800	0.01~0.03	1	溝銑 SLOTTING
LNX1008	17	16000~18000	400~500	0.03~0.05	1	溝銑 SLOTTING
LNX1008	17	16000~18000	600~800	0.01~0.03	1	溝銑 SLOTTING
LNX1010	19	16000~18000	300~450	0.02~0.03	1	溝銑 SLOTTING
LNX1010	19	16000~18000	500~700	0.01~0.02	1	溝銑 SLOTTING
LNX1012	20	16000~18000	300~400	0.02~0.03	1	溝銑 SLOTTING
LNX1012	20	16000~18000	500~700	0.01~0.02	1	溝銑 SLOTTING
LNX1508	15	15000~17000	800~950	0.06~0.08	1.5	溝銑 SLOTTING
LNX1508	15	15000~17000	1000~1200	0.025~0.05	1.5	溝銑 SLOTTING
LNX1510	17	15000~17000	800~900	0.05~0.07	1.5	溝銑 SLOTTING
LNX1510	17	15000~17000	1000~1200	0.02~0.05	1.5	溝銑 SLOTTING
LNX1512	19	15000~17000	700~800	0.04~0.06	1.5	溝銑 SLOTTING
LNX1512	19	15000~17000	900~1100	0.02~0.04	1.5	溝銑 SLOTTING
LNX1516	21	15000~17000	600~700	0.04~0.06	1.5	溝銑 SLOTTING
LNX1516	21	15000~17000	800~1000	0.02~0.04	1.5	溝銑 SLOTTING
LNX2008	15	14000~16000	1200~1300	0.1~0.12	2	溝銑 SLOTTING
LNX2008	15	14000~16000	1400~1600	0.04~0.08	2	溝銑 SLOTTING
LNX2010	17	14000~16000	1100~1300	0.08~0.1	2	溝銑 SLOTTING
LNX2010	17	14000~16000	1400~1600	0.03~0.07	2	溝銑 SLOTTING
LNX2012	19	14000~16000	1000~1200	0.06~0.08	2	溝銑 SLOTTING
LNX2012	19	14000~16000	1300~1500	0.02~0.05	2	溝銑 SLOTTING
LNX2016	23	14000~16000	900~1100	0.04~0.05	2	溝銑 SLOTTING
LNX2016	23	14000~16000	1200~1400	0.015~0.04	2	溝銑 SLOTTING
LNX2020	26	14000~16000	700~900	0.04~0.05	2	溝銑 SLOTTING
LNX2020	26	14000~16000	1000~1200	0.01~0.03	2	溝銑 SLOTTING
LNX2510	17	13000~15000	1300~1500	0.1~0.12	2.5	溝銑 SLOTTING
LNX2510	17	13000~15000	1600~1800	0.06~0.08	2.5	溝銑 SLOTTING
LNX2512	19	13000~15000	1300~1500	0.1~0.12	2.5	溝銑 SLOTTING
LNX2512	19	13000~15000	1600~1800	0.06~0.08	2.5	溝銑 SLOTTING
LNX2516	23	13000~15000	1200~1300	0.06~0.08	2.5	溝銑 SLOTTING
LNX2516	23	13000~15000	1400~1600	0.04~0.06	2.5	溝銑 SLOTTING
LNX2520	26	13000~15000	800~1000	0.04~0.06	2.5	溝銑 SLOTTING
LNX2520	26	13000~15000	1200~1400	0.02~0.04	2.5	溝銑 SLOTTING
LNX3010	20	12000~14000	1700~1900	0.12~0.14	3	溝銑 SLOTTING
LNX3010	20	12000~14000	2000~2200	0.07~0.12	3	溝銑 SLOTTING
LNX3012	22	12000~14000	1700~1900	0.12~0.14	3	溝銑 SLOTTING
LNX3012	22	12000~14000	2000~2200	0.07~0.1	3	溝銑 SLOTTING
LNX3016	26	12000~14000	1600~1800	0.1~0.12	3	溝銑 SLOTTING
LNX3016	26	12000~14000	1800~2000	0.05~0.1	3	溝銑 SLOTTING
LNX3020	30	12000~14000	1100~1300	0.08~0.1	3	溝銑 SLOTTING
LNX3020	30	12000~14000	1400~1600	0.05~0.08	3	溝銑 SLOTTING
LNX3025	34	12000~14000	700~900	0.06~0.08	3	溝銑 SLOTTING
LNX3025	34	12000~14000	900~1100	0.03~0.06	3	溝銑 SLOTTING

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REPLY

		(HRC)
	☐ ☐	
	☐ UG ☐ CIMATRON ☐ Power-Mill ☐ Pro-E ☐ Work NC ☐ Master CAM	
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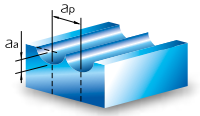

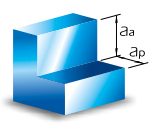

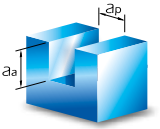

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