

# 益詮切削刀具

ECHAINTOOL Cutting Tools



## CHAIN®



台灣精品 2008  
TAIWAN EXCELLENCE



設計優良產品  
GOOD DESIGN PRODUCT



第22屆小巨人獎  
The 22nd Hsing Star Award



第20屆中小企業  
創新交流獎  
The 20th Taiwan Skills  
Interchange Award



仕友精工 中國一級代理  
Sunkyo Agent in China

## 鎢鋼鑽頭系列

CARBIDE END DRILL SERIES



Our web



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# ME20系列

# 鎢鋼鑽頭

識別系統 / 規格圖標指南

Carbide Drill Identification System / Specification Icon Guide



# M E C 2 0600 S 03 D4

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- 1 材質 Grade
- 2 尖端角 Point Angle
- 3 油孔 Oil Hole
- 4 刃數 INO
- 5 加工徑 Processing Shank
- 6 刀口形狀 Insert Shape
- 7 加工倍數 Processing Multiple
- 8 其他 Other

## 1 材質 Grade

記號 Sign	材質 Grade	記號 Sign	材質 Grade
E	E300	P	P550
G	G300	W	W500
M	M500		

## 2 尖端角 Point Angle

記號 Sign	尖端角 Point Angle	記號 Sign	尖端角 Point Angle
A	118	F	142
B	120	G	145
C	130	H	150
D	135	I	180
E	140		

## 5 加工徑 Processing Shank

說明 Explanation
ex: 0220 : 2.2mm 2225 : 22.25mm

## 6 刀口形狀 Insert Shape

記號 Sign	用途說明 Directions For Use
S型	一般通用 General
X型	深孔及較硬材用 For Deep Holes And Harder Materials
XS型	深孔用 For Deep Holes

## 7 倍數 Multiple

加工深度倍數 Processing Depth Multiple	02、04、03、 05、08
深孔倍數 Deep Hole Multiple	10、12、15 20、25、30

## 8 其他 Other

記號 Sign	用途說明 Directions For Use
A	小數點柄徑 Decimal Point Of Shank
DXX	特殊柄徑 Special Shank Diameter
TXX	錐度 Taper
L1XXX	特殊刃長 Special Flute length

圖標 Icon	說明 Explanation
	超微粒子超硬合金 Micro Grain Carbide
	含鈷量12% Cobalt Content 12%
	可被切削材硬度 <55° Working Hardness <55°
	AlTiN 塗層 AlTiN Coating
	材質 Grade M500
	符合DIN6537規範 Comply With DIN6537 Specification
	刃徑公差 Tolerance Of Diameter
	加工深度倍數 Processing Depth Multiple

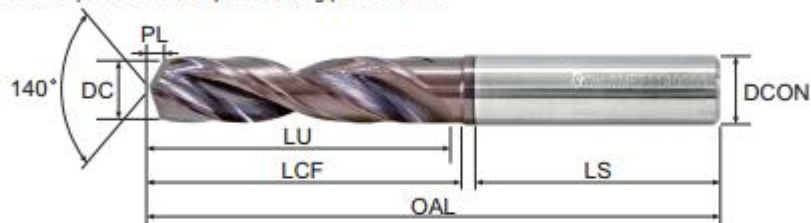


## 鑽鎢鑽頭 Carbide Drill

### ME20 鎢鋼鑽頭 Carbide Drill



- ◆ 圓棒採用含鈷量12%超微粒硬質合金，高剛性、耐磨耗、耐高溫。  
The round bar adopts 12% cobalt content ultra-fine hard alloy, high rigidity, wear resistance, high temperature resistance.
- ◆ 採用全新進口五軸刀具研磨機生產，研磨尺寸精準且穩定。  
Produced by a brand-new imported five-axis cutter grinder with precise and stable grinding size.
- ◆ 獨特雙刃帶設計，提升加工穩定性，延長加工使用時間。  
Unique double-edged belt design improves processing stability and prolongs processing time.
- ◆ 全新Al-TiN鍍鈦塗層，泛用性廣，可適用：合金鋼、不銹鋼、鑄鐵加工。  
The new Al-TiN titanium plating coating has wide versatility and can be applied to: alloy steel, uncast steel, cast iron processing.
- ◆ 鑽尖結構優化設計，提升切削排屑性能。  
Optimized design of drill tip structure to improve cutting performance.



產品型號 Model No	加工徑 DC Processing Shank	槽長 LCF Length Chip Flute	鑽孔深度 LU Usable Length	全長 OAL O.A.L	柄長 LS Shank Length	先端距 PL Point Length	柄徑 DCON Shank Dia
ME20200S03	2	13	9	58	28	0.4	4
ME20200S05	2	18	14	58	28	0.4	4
ME20210S03	2.1	13	9	58	28	0.4	4
ME20210S05	2.1	18	14	58	28	0.4	4
ME20220S03	2.2	13	9	58	28	0.5	4
ME20220S05	2.2	18	14	58	28	0.5	4
ME20230S03	2.3	13	9	58	28	0.4	4
ME20230S05	2.3	18	14	58	28	0.4	4
ME20240S03	2.4	17	12	58	28	0.4	4
ME20240S05	2.4	22	17	58	28	0.4	4
ME20250S03	2.5	17	12	58	28	0.5	4
ME20250S05	2.5	22	17	58	28	0.5	4
ME20255S03	2.55	17	12	58	28	0.5	4
ME20260S03	2.6	17	12	58	28	0.5	4
ME20260S05	2.6	22	17	58	28	0.5	4
ME20270S03	2.7	17	12	58	28	0.5	4
ME20270S05	2.7	22	17	58	28	0.5	4
ME20280S03	2.8	17	12	58	28	0.5	4
ME20280S05	2.8	22	17	58	28	0.5	4
ME20290S03	2.9	17	12	58	28	0.5	4
ME20290S05	2.9	22	17	58	28	0.5	4
ME20300S03D4	3	20	14	62	36	0.5	4
ME20300S03	3	20	14	62	36	0.5	6
ME20300S05D4	3	28	23	66	36	0.5	4

## 鑽鎢鑽頭 Carbide Drill



產品型號 Model No	加工徑 DC Processing Shank	槽長 LCF Length Chip Flute	鑽孔深度 LU Usable Length	全長 OAL O.A.L.	柄長 LS Shank Length	先端距 PL Point Length	柄徑 DCON Shank Dia
ME20300S05	3	28	23	66	36	0.5	6
ME20310S03D4	3.1	20	14	62	36	0.6	4
ME20310S03	3.1	20	14	62	36	0.6	6
ME20310S05D4	3.1	28	23	66	36	0.6	4
ME20310S05	3.1	28	23	66	36	0.6	6
ME20320S03D4	3.2	20	14	62	36	0.6	4
ME20320S03	3.2	20	14	62	36	0.6	6
ME20320S05D4	3.2	28	23	66	36	0.6	4
ME20320S05	3.2	28	23	66	36	0.6	6
ME20325S03D4	3.25	20	14	62	36	0.6	4
ME20325S03	3.25	20	14	62	36	0.6	6
ME20330S03D4	3.3	20	14	62	36	0.6	4
ME20330S03	3.3	20	14	62	36	0.6	6
ME20330S05D4	3.3	28	23	66	36	0.6	4
ME20330S05	3.3	28	23	66	36	0.6	6
ME20340S03D4	3.4	20	14	62	36	0.6	4
ME20340S03	3.4	20	14	62	36	0.6	6
ME20340S05D4	3.4	28	23	66	36	0.6	4
ME20340S05	3.4	28	23	66	36	0.6	6
ME20350S03D4	3.5	20	14	62	36	0.6	4
ME20350S03	3.5	20	14	62	36	0.6	6
ME20350S05D4	3.5	28	23	66	36	0.6	4
ME20350S05	3.5	28	23	66	36	0.6	6
ME20360S03D4	3.6	20	14	62	36	0.7	4
ME20360S03	3.6	20	14	62	36	0.7	6
ME20360S05D4	3.6	28	23	66	36	0.7	4
ME20360S05	3.6	28	23	66	36	0.7	6
ME20370S03D4	3.7	20	14	62	36	0.7	4
ME20370S03	3.7	20	14	62	36	0.7	6
ME20370S05D4	3.7	28	23	66	36	0.7	4
ME20370S05	3.7	28	23	66	36	0.7	6

## 鑽鎢鑽頭 Carbide Drill



產品型號 Model No	加工徑 DC Processing Shank	槽長 LCF Length Chip Flute	鑽孔深度 LU Usable Length	全長 OAL O.A.L.	柄長 LS Shank Length	先端距 PL Point Length	柄徑 DCON Shank Dia
ME20380S03D4	3.8	24	17	62	36	0.7	4
ME20380S03	3.8	24	17	62	36	0.7	6
ME20380S05D4	3.8	36	29	74	36	0.7	4
ME20380S05	3.8	36	29	74	36	0.7	6
ME20390S03D4	3.9	24	17	66	36	0.7	4
ME20390S03	3.9	24	17	66	36	0.7	6
ME20390S05D4	3.9	36	29	74	36	0.7	4
ME20390S05	3.9	36	29	74	36	0.7	6
ME20400S03D4	4	24	17	66	36	0.7	4
ME20400S03	4	24	17	66	36	0.7	6
ME20400S05D4	4	36	29	74	36	0.7	4
ME20400S05	4	36	29	74	36	0.7	6
ME20410S03	4.1	24	17	66	36	0.7	6
ME20410S05	4.1	36	29	74	36	0.7	6
ME20420S03	4.2	24	17	66	36	0.8	6
ME20420S05	4.2	36	29	74	36	0.8	6
ME20430S03	4.3	24	17	66	36	0.8	6
ME20430S05	4.3	36	29	74	36	0.8	6
ME20440S03	4.4	24	17	66	36	0.8	6
ME20440S05	4.4	36	29	74	36	0.8	6
ME20450S03	4.5	24	17	66	36	0.8	6
ME20450S05	4.5	36	29	74	36	0.8	6
ME20460S03	4.6	24	17	66	36	0.8	6
ME20460S05	4.6	36	29	74	36	0.8	6
ME20470S03	4.7	24	17	66	36	0.9	6
ME20470S05	4.7	36	29	74	36	0.9	6
ME20480S03	4.8	28	20	66	36	0.9	6
ME20480S05	4.8	44	35	82	36	0.9	6
ME20490S03	4.9	28	20	66	36	0.9	6
ME20490S05	4.9	44	35	82	36	0.9	6
ME20500S03	5	28	20	66	36	0.9	6

## 鑽鎢鑽頭 Carbide Drill



產品型號 Model No	加工徑 DC Processing Shank	槽長 LCF Length Chip Flute	鑽孔深度 LU Usable Length	全長 OAL O.A.L	柄長 LS Shank Length	先端距 PL Point Length	柄徑 DCON Shank Dia
ME20500S05	5	44	35	82	36	0.9	6
ME20510S03	5.1	28	20	66	36	0.9	6
ME20510S05	5.1	44	35	82	36	0.9	6
ME20520S03	5.2	28	20	66	36	0.9	6
ME20520S05	5.2	44	35	82	36	0.9	6
ME20530S03	5.3	28	20	66	36	1	6
ME20530S05	5.3	44	35	82	36	1	6
ME20540S03	5.4	28	20	66	36	1	6
ME20540S05	5.4	44	35	82	36	1	6
ME20550S03	5.5	28	20	66	36	1	6
ME20550S05	5.5	44	35	82	36	1	6
ME20560S03	5.6	28	20	66	36	1	6
ME20560S05	5.6	44	35	82	36	1	6
ME20570S03	5.7	28	20	66	36	1	6
ME20570S05	5.7	44	35	82	36	1	6
ME20580S03	5.8	28	20	66	36	1.1	6
ME20580S05	5.8	44	35	82	36	1.1	6
ME20590S03	5.9	28	20	66	36	1.1	6
ME20590S05	5.9	44	35	82	36	1.1	6
ME20600S03	6	28	20	66	36	1.1	6
ME20600S05	6	44	35	82	36	1.1	6
ME20610S03	6.1	34	24	79	36	1.1	8
ME20610S05	6.1	53	43	91	36	1.1	8
ME20620S03	6.2	34	24	79	36	1.1	8
ME20620S05	6.2	53	43	91	36	1.1	8
ME20630S03	6.3	34	24	79	36	1.1	8
ME20630S05	6.3	53	43	91	36	1.1	8
ME20640S03	6.4	34	24	79	36	1.2	8
ME20640S05	6.4	53	43	91	36	1.2	8
ME20650S03	6.5	34	24	79	36	1.2	8
ME20650S05	6.5	53	43	91	36	1.2	8

## 鑽鎢鑽頭 Carbide Drill



產品型號 Model No	加工徑 DC Processing Shank	槽長 LCF Length Chip Flute	鑽孔深度 LU Usable Length	全長 OAL O.A.L	柄長 LS Shank Length	先端距 PL Point Length	柄徑 DCON Shank Dia
ME20660S03	6.6	34	24	79	36	1.2	8
ME20660S05	6.6	53	43	91	36	1.2	8
ME20670S03	6.7	34	24	79	36	1.2	8
ME20670S05	6.7	53	43	91	36	1.2	8
ME20680S03	6.8	34	24	79	36	1.2	8
ME20680S05	6.8	53	43	91	36	1.2	8
ME20690S03	6.9	34	24	79	36	1.3	8
ME20690S05	6.9	53	43	91	36	1.3	8
ME20700S03	7	34	24	79	36	1.3	8
ME20700S05	7	53	43	91	36	1.3	8
ME20710S03	7.1	41	29	79	36	1.3	8
ME20710S05	7.1	53	43	91	36	1.3	8
ME20720S03	7.2	41	29	79	36	1.3	8
ME20720S05	7.2	53	43	91	36	1.3	8
ME20730S03	7.3	41	29	79	36	1.3	8
ME20730S05	7.3	53	43	91	36	1.3	8
ME20740S03	7.4	41	29	79	36	1.3	8
ME20740S05	7.4	53	43	91	36	1.3	8
ME20750S03	7.5	41	29	79	36	1.4	8
ME20750S05	7.5	53	43	91	36	1.4	8
ME20760S03	7.6	41	29	79	36	1.4	8
ME20760S05	7.6	53	43	91	36	1.4	8
ME20770S03	7.7	41	29	79	36	1.4	8
ME20770S05	7.7	53	43	91	36	1.4	8
ME20780S03	7.8	41	29	79	36	1.4	8
ME20780S05	7.8	53	43	91	36	1.4	8
ME20790S03	7.9	41	29	79	36	1.4	8
ME20790S05	7.9	53	43	91	36	1.4	8
ME20800S03	8	41	29	79	36	1.5	8
ME20800S05	8	53	43	91	36	1.5	8
ME20810S03	8.1	47	35	89	40	1.5	10

## 鑽鎢鑽頭 Carbide Drill



產品型號 Model No	加工徑 DC Processing Shank	槽長 LCF Length Chip Flute	鑽孔深度 LU Usable Length	全長 OAL O.A.L	柄長 LS Shank Length	先端距 PL Point Length	柄徑 DCON Shank Dia
ME20810S05	8.1	61	49	103	40	1.5	10
ME20820S03	8.2	47	35	89	40	1.5	10
ME20820S05	8.2	61	49	103	40	1.5	10
ME20830S03	8.3	47	35	89	40	1.5	10
ME20830S05	8.3	61	49	103	40	1.5	10
ME20840S03	8.4	47	35	89	40	1.5	10
ME20840S05	8.4	61	49	103	40	1.5	10
ME20850S03	8.5	47	35	89	40	1.5	10
ME20850S05	8.5	61	49	103	40	1.5	10
ME20860S03	8.6	47	35	89	40	1.6	10
ME20860S05	8.6	61	49	103	40	1.6	10
ME20870S03	8.7	47	35	89	40	1.6	10
ME20870S05	8.7	61	49	103	40	1.6	10
ME20880S03	8.8	47	35	89	40	1.6	10
ME20880S05	8.8	61	49	103	40	1.6	10
ME20890S03	8.9	47	35	89	40	1.6	10
ME20890S05	8.9	61	49	103	40	1.6	10
ME20900S03	9	47	35	89	40	1.6	10
ME20900S05	9	61	49	103	40	1.6	10
ME20910S03	9.1	47	35	89	40	1.7	10
ME20910S05	9.1	61	49	103	40	1.7	10
ME20920S03	9.2	47	35	89	40	1.7	10
ME20920S05	9.2	61	49	103	40	1.7	10
ME20930S03	9.3	47	35	89	40	1.7	10
ME20930S05	9.3	61	49	103	40	1.7	10
ME20940S03	9.4	47	35	89	40	1.7	10
ME20940S05	9.4	61	49	103	40	1.7	10
ME20950S03	9.5	47	35	89	40	1.7	10
ME20950S05	9.5	61	49	103	40	1.7	10
ME20960S03	9.6	47	35	89	40	1.7	10
ME20960S05	9.6	61	49	103	40	1.7	10



## 鑽鎢鑽頭 Carbide Drill



產品型號 Model No	加工徑 DC Processing Shank	槽長 LCF Length Chip Flute	鑽孔深度 LU Usable Length	全長 OAL O.A.L.	柄長 LS Shank Length	先端距 PL Point Length	柄徑 DCON Shank Dia
ME20970S03	9.7	47	35	89	40	1.8	10
ME20970S05	9.7	61	49	103	40	1.8	10
ME20980S03	9.8	47	35	89	40	1.8	10
ME20980S05	9.8	61	49	103	40	1.8	10
ME20990S03	9.9	47	35	89	40	1.8	10
ME20990S05	9.9	61	49	103	40	1.8	10
ME21000S03	10	47	35	89	40	1.8	10
ME21000S05	10	61	49	103	40	1.8	10
ME21010S03	10.1	55	40	102	45	1.8	12
ME21010S05	10.1	71	56	118	45	1.8	12
ME21020S03	10.2	55	40	102	45	1.9	12
ME21020S05	10.2	71	56	118	45	1.9	12
ME21030S03	10.3	55	40	102	45	1.9	12
ME21030S05	10.3	71	56	118	45	1.9	12
ME21040S03	10.4	55	40	102	45	1.9	12
ME21040S05	10.4	71	56	118	45	1.9	12
ME21050S03	10.5	55	40	102	45	1.9	12
ME21050S05	10.5	71	56	118	45	1.9	12
ME21060S03	10.6	55	40	102	45	1.9	12
ME21060S05	10.6	71	56	118	45	1.9	12
ME21070S03	10.7	55	40	102	45	1.9	12
ME21070S05	10.7	71	56	118	45	1.9	12
ME21080S03	10.8	55	40	102	45	2	12
ME21080S05	10.8	71	56	118	45	2	12
ME21090S03	10.9	55	40	102	45	2	12
ME21090S05	10.9	71	56	118	45	2	12
ME21100S03	11	55	40	102	45	2	12
ME21100S05	11	71	56	118	45	2	12
ME21110S03	11.1	55	40	102	45	2	12
ME21110S05	11.1	71	56	118	45	2	12
ME21120S03	11.2	55	40	102	45	2	12

## 鑽鎢鑽頭 Carbide Drill



產品型號 Model No	加工徑 DC Processing Shank	槽長 LCF Length Chip Flute	鑽孔深度 LU Usable Length	全長 OAL O.A.L.	柄長 LS Shank Length	先端距 PL Point Length	柄徑 DCON Shank Dia
ME21120S05	11.2	71	56	118	45	2	12
ME21130S03	11.3	55	40	102	45	2.1	12
ME21130S05	11.3	71	56	118	45	2.1	12
ME21140S03	11.4	55	40	102	45	2.1	12
ME21140S05	11.4	71	56	118	45	2.1	12
ME21150S03	11.5	55	40	102	45	2.1	12
ME21150S05	11.5	71	56	118	45	2.1	12
ME21160S03	11.6	55	40	102	45	2.1	12
ME21160S05	11.6	71	56	118	45	2.1	12
ME21170S03	11.7	55	40	102	45	2.1	12
ME21170S05	11.7	71	55	118	45	2.1	12
ME21180S03	11.8	55	40	102	45	2.1	12
ME21180S05	11.8	71	56	118	45	2.1	12
ME21190S03	11.9	55	40	102	45	2.2	12
ME21190S05	11.9	71	56	118	45	2.2	12
ME21200S03	12	55	40	102	45	2.2	12
ME21200S05	12	71	56	118	45	2.2	12
ME21210S03	12.1	60	43	107	45	2.2	14
ME21210S05	12.1	77	60	124	45	2.2	14
ME21220S03	12.2	60	43	107	45	2.2	14
ME21220S05	12.2	77	60	124	45	2.2	14
ME21230S03	12.3	60	43	107	45	2.2	14
ME21230S05	12.3	77	60	124	45	2.2	14
ME21250S03	12.5	60	43	107	45	2.3	14
ME21250S05	12.5	77	60	124	45	2.3	14
ME21270S03	12.7	60	43	107	45	2.3	14
ME21270S05	12.7	77	60	124	45	2.3	14
ME21280S03	12.8	60	43	107	45	2.3	14
ME21280S05	12.8	77	60	124	45	2.3	14
ME21290S03	12.9	60	43	107	45	2.3	14
ME21290S05	12.9	77	60	124	45	2.3	14

## 鑽鎢鑽頭 Carbide Drill



產品型號 Model No	加工徑 DC Processing Shank	槽長 LCF Length Chip Flute	鑽孔深度 LU Usable Length	全長 OAL O.A.L.	柄長 LS Shank Length	先端距 PL Point Length	柄徑 DCON Shank Dia
ME21300S03	13	60	43	107	45	2.4	14
ME21300S05	13	77	60	124	45	2.4	14
ME21310S03	13.1	60	43	107	45	2.4	14
ME21310S05	13.1	77	60	124	45	2.4	14
ME21350S03	13.5	60	43	107	45	2.5	14
ME21350S05	13.5	77	60	124	45	2.5	14
ME21380S03	13.8	60	43	107	45	2.5	14
ME21380S05	13.8	77	60	124	45	2.5	14
ME21400S03	14	65	45	115	45	2.5	14
ME21400S05	14	83	63	133	45	2.5	14
ME21430S03	14.3	65	45	115	48	2.6	16
ME21430S05	14.3	83	63	133	48	2.6	16
ME21450S03	14.5	65	45	115	48	2.6	16
ME21450S05	14.5	83	63	133	48	2.6	16
ME21480S03	14.8	65	45	115	48	2.7	16
ME21480S05	14.8	83	63	133	48	2.7	16
ME21500S03	15	65	45	115	48	2.7	16
ME21500S05	15	83	63	133	48	2.7	16
ME21510S03	15.1	65	45	115	48	2.7	16
ME21510S05	15.1	83	63	133	48	2.7	16
ME21550S03	15.5	65	45	115	48	2.8	16
ME21550S05	15.5	83	63	133	48	2.8	16
ME21580S03	15.8	65	45	115	48	2.9	16
ME21580S05	15.8	83	63	133	48	2.9	16
ME21600S03	16	65	45	115	48	2.9	16
ME21600S05	16	83	63	133	48	2.9	16
ME21650S03	16.5	73	51	123	48	3	18
ME21650S05	16.5	93	71	143	48	3	18
ME21680S03	16.8	73	51	123	48	3.1	18
ME21680S05	16.8	93	71	143	48	3.1	18
ME21700S03	17	73	51	123	48	3.1	18

# 鑽鎢鑽頭 Carbide Drill



產品型號 Model No	加工徑 DC Processing Shank	槽長 LCF Length Chip Flute	鑽孔深度 LU Usable Length	全長 OAL O.A.L.	柄長 LS Shank Length	先端距 PL Point Length	柄徑 DCON Shank Dia
ME21700S05	17	93	71	143	48	3.1	18
ME21750S03	17.5	73	51	123	48	3.2	18
ME21750S05	17.5	93	71	143	48	3.2	18
ME21780S03	17.8	73	51	123	48	3.2	18
ME21780S05	17.8	93	71	143	48	3.2	18
ME21790S03	17.9	73	51	123	48	3.3	18
ME21790S05	17.9	93	71	143	48	3.3	18
ME21800S03	18	73	51	123	48	3.3	18
ME21800S05	18	93	71	143	48	3.3	18
ME21830S03	18.3	79	55	131	50	3.3	20
ME21830S05	18.3	101	77	153	50	3.3	20
ME21850S03	18.5	79	55	131	50	3.4	20
ME21850S05	18.5	101	77	153	50	3.4	20
ME21880S03	18.8	79	55	131	50	3.4	20
ME21880S05	18.8	101	77	153	50	3.4	20
ME21900S03	19	79	55	131	50	3.5	20
ME21900S05	19	101	77	153	50	3.5	20
ME21950S03	19.5	79	55	131	50	3.5	20
ME21950S05	19.5	101	77	153	50	3.5	20
ME21980S03	19.8	79	55	131	50	3.6	20
ME21980S05	19.8	101	77	153	50	3.6	20
ME22000S03	20	79	55	131	50	3.6	20
ME22000S05	20	101	77	153	50	3.6	20

## 鎢鋼鑽頭切削參數 The Cutting Data For Carbide Drill Series

被加工材質：合金鋼、不鏽鋼、鑄鐵  
Material: Alloy Steel, Stainless steel, Iron cast

直徑 (mm) Shank	2	3	4	5	6	7	8	9	10	11	12	14	16	20
<b>P</b> 進給速度 Vf (mm/min)	0.06	0.08	0.1	0.14	0.15	0.16	0.18	0.2	0.2	0.2	0.2	0.2	0.2	0.2
<b>K</b> 轉速 f (min)	6300	4200	3200	2600	2100	1800	1600	1400	1300	1150	1100	900	800	650
<b>M</b> 進給速度 Vf (mm/min)	0.04	0.07	0.07	0.1	0.1	0.12	0.14	0.14	0.14	0.18	0.18	0.18	0.18	0.18
轉速 f (min)	4800	3200	2400	1900	1600	1400	1200	1100	950	870	800	680	600	480