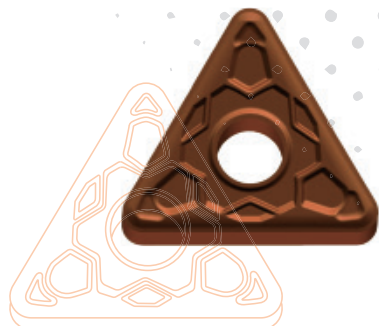
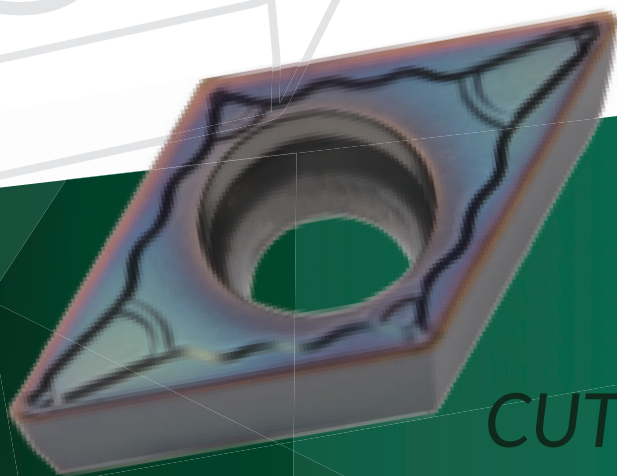




Turning Inserts

車削刀片

No. 240306002



CUTTING EDGE SOLUTION

與時俱進 先端製造

Keep Up With The Times & Proactive Advanced Manufacturing

正河源股份有限公司創立於西元1992年，經營方針致力於CNC加工中心機週邊工具及切削刀具，近年因應切削市場需求公司投入更多資源建立完善營運環境及先端製造設備，為機械加工業者提供更優質的產品品質及加工效率提升。在研發方向著重於未來智能化製造相關週邊工具及切削刀具，人力資源投入方面結合科技大學共同培育未來切削領域專業人才，在資源投入方面包括8250平方米現代辦公大樓及自動化製造廠區，歐洲日本生產設備及檢驗設備等。因應未來科技發展高溫合金及非鐵金屬材料應用於各產業，正河源經營團隊展現Cutting Edge Solution 快速解決客加工需求的專業與服務熱忱，持續研發生產高效能切削刀具為機械加工業者提供最佳服務。

Proactive Advanced Manufacturing

Chain Headway was founded in 1992 to develop and produce cutting tools and accessories for CNC machining centers. Our company has developed over the years to provide a stable production environment with advanced R&D and manufacturing capabilities.

This is designed to provide cutting edge products and more efficient materials processing solutions for various types of industries. Our investment in R&D helps us to deliver the latest materials processing solutions for intelligent manufacturing to our customers.

- We are partnered with the University of Science & Technology developing a group of future Cutting professionals.
- We have a new 8250 square meter production facility which combines our office buildings with automated production facilities.
- Our production and inspection equipment is sourced from Japan and Europe to maintain the best possible quality and efficiency.

Industry processing challenges are constantly evolving with the development of high temperature alloys and composite materials. Our management team is proactively addressing these evolving materials processing requirements to rapidly develop & provide customers with the latest material processing solutions and the best possible customer service.



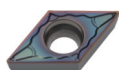
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VN NEGATIVE RAKE ANGLE INSERT	



WN 負角刀片	09
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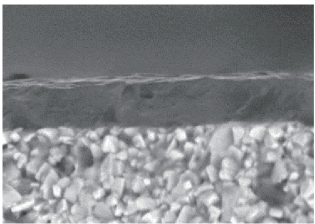
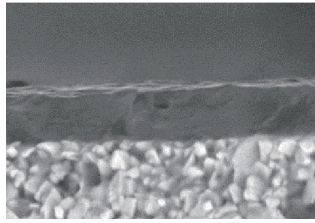
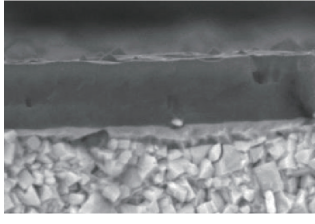


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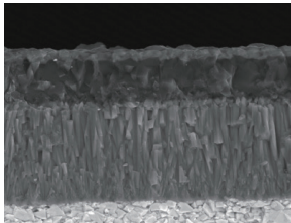
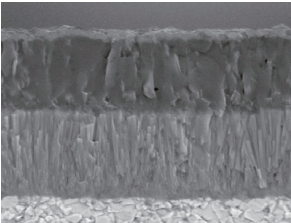
PVD 塗層介紹

PVD (PHYSICAL VAPOR DEPOSITION) COATING INTRODUCTION

材質 Grade	塗層類型 Coating Type	顏色 Color	加工特點 Feature	截面照片 Profile
RM385	PVD AlTiSiN	藍金色 Blue-gold	• 抗高溫氧化，塗層硬度高，耐磨損 • 適用於不銹鋼材料 • Resistant to high-temperature oxidation, with high hardness and wear resistance. • Ideal for stainless steel materials.	
RM380	PVD AlTiSiN	鐵灰色 Iron grey	• 具有良好的耐磨及抗崩性能，通用性高 • 適用於不銹鋼材料 • Excellent wear resistance, anti-catastrophic performance, and high versatility. • Ideal for stainless materials.	
RM388	PVD AlTiN	灰黑色 Gray-black	• 含鈷量較高材質耐衝擊 • 適用於不銹鋼斷續切削 • Material with a higher cobalt content is impact-resistant. • Ideal for stainless steel interrupted cutting.	

CVD 塗層介紹

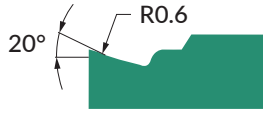
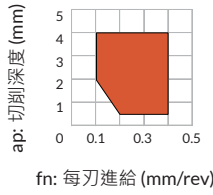
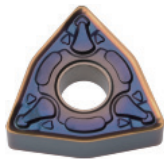
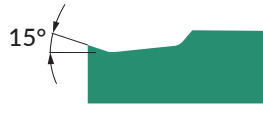
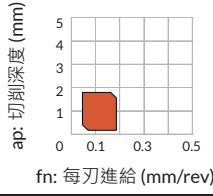
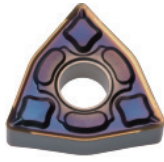
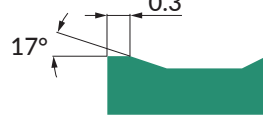
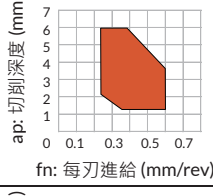
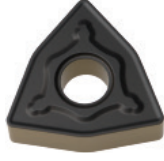
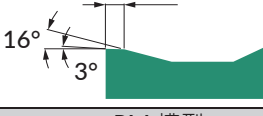
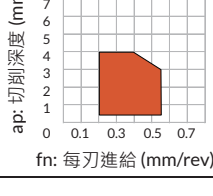
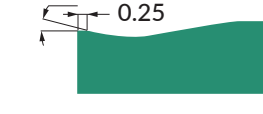
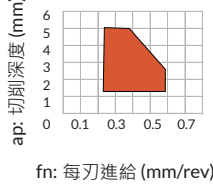
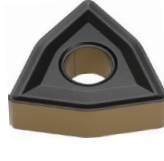
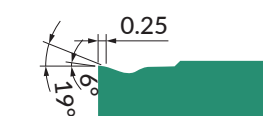
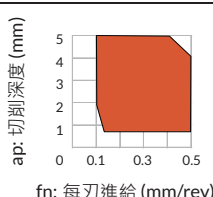
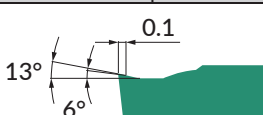
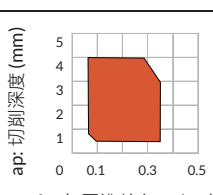
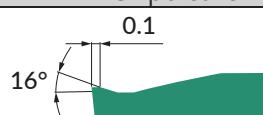
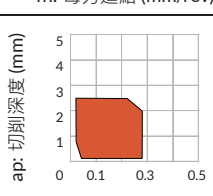
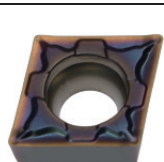
CVD (CHEMICAL VAPOR DEPOSITION) COATING INTRODUCTION

材質 Grade	塗層類型 Coating Type	顏色 Color	加工特點 Feature	截面照片 Profile
RM485	CVD MT-TiCN +Al ₂ O ₃	金色 Gold	• 高強度表面處理工藝，顯著提高加工通用性 • 適用於鋼件材質的半精加工及粗加工 • High-strength surface treatment significantly enhances machining versatility. • Ideal for semi-finishing and roughing of steel materials.	
RM285	CVD MT-TiCN +Al ₂ O ₃	雙色 Gold & Grey	• 具有較好的抗崩性和耐磨性，確保高速切削工況下具有良好的刀具壽命 • 通用性好，適用於各種鑄鐵材料的中 - 重載切削加工 • Ensures extended tool life with excellent impact resistance and wear resistance during high-speed cutting. • Ideal for medium to heavy cutting of various cast iron materials.	

• 長度單位 Unit of Length (mm)

車削用刀片槽型一覽表

TYPES OF TURNING INSERT CHIPBREAKERS

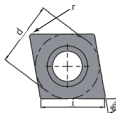
MM 槽型 MM Chipbreaker				不銹鋼精 - 半精加工槽型 - MM - 前角圓弧設計，提高鋒利度，降低切削力 - 梯形斷屑槽結構，在不同切深與進給下，提高斷屑能力 - 心形斷屑槽設計，在大切深的加工參數下，利於切屑捲曲斷屑 Stainless steel materials - for finishing/semi-finishing - MM - Rounded edge design enhances sharpness and reduces cutting forces. - Trapezoidal chipbreaker enhances chip-breaking in varying cutting depths and feeds. - Heart-shaped chipbreaker facilitates chip curling in deep cutting.
MF 槽型 MF Chipbreaker				不銹鋼精加工槽型 - MF - 前角角度漸變設計，既減少切削阻力，又提高刀片剛性 - 曲線刀與加高斷屑設計，利於切屑側向捲曲，強化斷屑效果 Stainless steel materials - for finishing - MF - The rake angle's gradual design reduces cutting resistance and enhances insert rigidity. - Curved edge and elevated chipbreaker enhance lateral chip curling, strengthening chip breaking.
KR 槽型 KR Chipbreaker				鑄鐵重切削槽型 - KR - 寬刀口 (Land) 設計，確保大切深和高進給量切削下刀片強度 - 獨特槽型設計，降低切削阻力，提升切削性能；刀尖强度高，適合鑄鐵重切削 Cast iron materials - for heaving cutting - KR - Wide land design ensures insert strength in deep and high-feed cutting. - Unique chipbreaker design reduces cutting resistance, ideal for heavy cast iron machining with high edge strength.
KM 槽型 KM Chipbreaker				鑄鐵中切削槽型 - KM - 雙前角設計，增強切削鋒利性及刀尖穩定性 - 大容屑槽，切削過程中排屑流暢 Cast iron materials - for medium cutting - KM - Double rake angle design enhances sharpness and stability. - Large chip breaker ensures smooth chip evacuation during machining.
PM 槽型 PM Chipbreaker				鋼材中切削槽型 - PM - 小前角大刃寬，保證更大切削刃強度 - 通用性優異的全周斷屑槽 - 適宜的斷屑槽角度，降低切削磨損，提高小切深加工下斷屑能力 Steel materials - for medium cutting - PM - Small rake angle, wide edge design ensures strong cutting strength. - Excellent all-around chip breaker for versatility. - Optimal chipbreaker angle reduces wear, enhances chipbreaking in small-depth cutting.
DM 槽型 DM Chipbreaker				鋼材半精加工槽型 - DM - 雙前角設計，確保切削鋒利及刃口強度需求 - 寬刀口設計，提升高強度鋼件加工與切削刃口強度 - 漸變斷屑設計，提高小切深加工下斷屑能力 Steel materials - for semi-finishing - DM - Dual rake angles ensure sharp cutting and strength. - Wide edge enhances strength for high-strength steel parts. - Gradient chipbreaker enhances chipbreaking in small-depth cutting.
MR 槽型 MR Chipbreaker				正角粗 - 半精加工通用槽型 - MR - 雙前角設計，保證切削刃口強度 - 大容屑槽，排屑流暢 Positive angle - for semi-finishing - MR - Dual rake angle design ensures cutting edge strength. - Large chipbreaker ensures smooth chip evacuation.
MF 槽型 MF Chipbreaker				正角精加工槽型 - MF - 刀尖容屑槽設計，降低切削阻力，減少副切削刃的干擾 - 曲線刀設計，加強薄屑的捲曲，提升精加工中斷屑效果 Positive angle - for finishing - MF - Tip chip groove reduces resistance and interference from secondary edges. - Curved edge design enhances thin chip curling, improving chip breaking in finishing.

• 長度單位 Unit of Length (mm)

CC 正角刀片

CC POSITIVE ANGLE INSERT

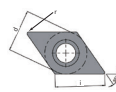
○ 一般切削 General Cutting
■ 斷續切削 Interrupted Cutting

形狀 Shape	規格 Spec.	鍍層硬質合金 Layer coated carbide alloy					尺寸 (mm)				圖形 Drawing
		CVD	PVD			CVD	Size				
		RM485	RM380	RM385	RM388	RM285	d	i	s	r	
	CCMT060204-MF			M			6.35	6.4	2.38	0.4	 
	CCMT060208-MF			M			6.35	6.4	2.38	0.8	
	CCMT09T304-MF			M			9.525	9.7	3.97	0.4	
	CCMT060204-MR		M		M		6.35	6.4	2.38	0.4	
	CCMT060208-MR		M		M		6.35	6.4	2.38	0.8	
	CCMT09T304-MR		M		M		6.35	6.4	2.38	0.4	
	CCMT09T308-MR		M		M		9.525	9.7	3.97	0.8	
	CCMT060204-KR					K	6.35	6.4	2.38	0.4	
	CCMT060208-KR					K	6.35	6.4	2.38	0.8	
	CCMT09T304-KR					K	9.525	9.7	3.97	0.4	
	CCMT09T308-KR					K	9.525	9.7	3.97	0.8	

DC 刀片

DC POSITIVE ANGLE INSERT

○ 一般切削 General Cutting
■ 斷續切削 Interrupted Cutting

形狀 Shape	規格 Spec.	鍍層硬質合金 Layer coated carbide alloy					尺寸 (mm)				圖形 Drawing
		CVD	PVD			CVD	Size				
		RM485	RM380	RM385	RM388	RM285	d	i	s	r	
	DCMT070204-MF			Ⓜ			6.35	7.8	2.38	0.4	 
	DCMT070208-MF			Ⓜ			6.35	7.8	2.38	0.8	
	DCMT070204-MR		Ⓜ		Ⓜ		6.35	7.8	2.38	0.4	
	DCMT070208-MR		Ⓜ		Ⓜ		6.35	7.8	2.38	0.8	
	DCMT11T304-MR		Ⓜ		Ⓜ		9.525	11.6	3.97	0.4	
	DCMT11T308-MR		Ⓜ		Ⓜ		9.525	11.6	3.97	0.8	

TC 刀片

TC POSITIVE ANGLE INSERT

○ 一般切削 General Cutting
■ 斷續切削 Interrupted Cutting

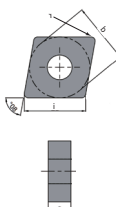
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		CVD	PVD			CVD	Size				
		RM485	RM380	RM385	RM388	RM285	d	i	s	r	
	TCMT110204-MF			Ⓜ			9.525	11	3.97	0.4	 
	TCMT110208-MF			Ⓜ			9.525	11	3.97	0.8	
	TCMT110204-MR		Ⓜ		Ⓜ		9.525	11	3.97	0.4	
	TCMT110208-MR		Ⓜ		Ⓜ		9.525	11	3.97	0.8	

• 長度單位 Unit of Length (mm)

CN 負角刀片

CN NEGATIVE RAKE ANGLE INSERT

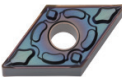
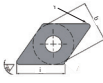
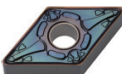
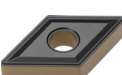
○ 一般切削 General Cutting
■ 斷續切削 Interrupted Cutting

形狀 Shape	規格 Spec.	鍍層硬質合金 Layer coated carbide alloy					尺寸 (mm)				圖形 Drawing
		CVD	PVD			CVD	Size				
		RM485	RM380	RM385	RM388	RM285	d	i	s	r	
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	CNMG120408-MF			M			12.7	12.9	4.76	0.8	
	CNMG120412-MF			M			12.7	12.9	4.76	1.2	
	CNMG120404-MM			M	M		12.7	12.9	4.76	0.4	
	CNMG120408-MM			M	M		12.7	12.9	4.76	0.8	
	CNMG120412-MM			M	M		12.7	12.9	4.76	1.2	
	CNMG120404-DM	P					12.7	12.9	4.76	0.4	
	CNMG120408-DM	P					12.7	12.9	4.76	0.8	
	CNMG120412-DM	P					12.7	12.9	4.76	1.2	
	CNMG120404-PM	P					12.7	12.9	4.76	0.4	
	CNMG120408-PM	P					12.7	12.9	4.76	0.8	
	CNMG120412-PM	P					12.7	12.9	4.76	1.2	
	CNMG120404-KM					K	12.7	12.9	4.76	0.4	
	CNMG120408-KM					K	12.7	12.9	4.76	0.8	
	CNMG120412-KM					K	12.7	12.9	4.76	1.2	
	CNMG120408-KR					K	12.7	12.9	4.76	0.8	
	CNMG120412-KR					K	12.7	12.9	4.76	1.2	

DN 負角刀片

DN NEGATIVE RAKE ANGLE INSERT

○ 一般切削 General Cutting
■ 斷續切削 Interrupted Cutting

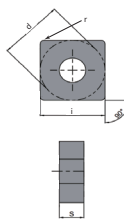
形狀 Shape	規格 Spec.	鍍層硬質合金 Layer coated carbide alloy					尺寸 (mm)				圖形 Drawing
		CVD	PVD			CVD	Size				
		RM485	RM380	RM385	RM388	RM285	d	i	s	r	
	DNMG150404-MF			M			12.7	15.5	4.76	0.4	 
	DNMG150408-MF			M			12.7	15.5	4.76	0.8	
	DNMG150412-MF			M			12.7	15.5	4.76	1.2	
	DNMG150404-MM			M	M		12.7	15.5	4.76	0.4	
	DNMG150408-MM			M	M		12.7	15.5	4.76	0.8	
	DNMG150412-MM			M	M		12.7	15.5	4.76	1.2	
	DNMG150404-DM	P					12.7	15.5	4.76	0.4	
	DNMG150408-DM	P					12.7	15.5	4.76	0.8	
	DNMG150412-DM	P					12.7	15.5	4.76	1.2	
	DNMG150404-PM	P					12.7	15.5	4.76	0.4	
	DNMG150408-PM	P					12.7	15.5	4.76	0.8	
	DNMG150412-PM	P					12.7	15.5	4.76	1.2	
	DNMG150404-KM					K	12.7	15.5	4.76	0.4	
	DNMG150408-KM					K	12.7	15.5	4.76	0.8	
	DNMG150412-KM					K	12.7	15.5	4.76	1.2	
	DNMG150408-KR					K	12.7	15.5	4.76	0.8	
	DNMG150412-KR					K	12.7	15.5	4.76	1.2	

• 長度單位 Unit of Length (mm)

SN 負角刀片

SN NEGATIVE RAKE ANGLE INSERT

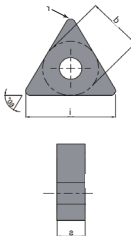
○ 一般切削 General Cutting
■ 斷續切削 Interrupted Cutting

形狀 Shape	規格 Spec.	鍍層硬質合金 Layer coated carbide alloy					尺寸 (mm)				圖形 Drawing
		CVD	PVD			CVD	Size				
		RM485	RM380	RM385	RM388	RM285	d	i	s	r	
	SNMG120404-MF			M			12.7	12.7	4.76	0.4	
	SNMG120408-MF			M			12.7	12.7	4.76	0.8	
	SNMG120412-MF			M			12.7	12.7	4.76	1.2	
	SNMG120404-MM			M	M		12.7	12.7	4.76	0.4	
	SNMG120408-MM			M	M		12.7	12.7	4.76	0.8	
	SNMG120412-MM			M	M		12.7	12.7	4.76	1.2	
	SNMG120404-DM	P					12.7	12.7	4.76	0.4	
	SNMG120408-DM	P					12.7	12.7	4.76	0.8	
	SNMG120412-DM	P					12.7	12.7	4.76	1.2	
	SNMG120404-PM	P					12.7	12.7	4.76	0.4	
	SNMG120408-PM	P					12.7	12.7	4.76	0.8	
	SNMG120412-PM	P					12.7	12.7	4.76	1.2	
	SNMG120404-KM					K	12.7	12.7	4.76	0.4	
	SNMG120408-KM					K	12.7	12.7	4.76	0.8	
	SNMG120412-KM					K	12.7	12.7	4.76	1.2	
	SNMG120408-KR					K	12.7	12.7	4.76	0.8	
	SNMG120412-KR					K	12.7	12.7	4.76	1.2	

TN 負角刀片

TN NEGATIVE RAKE ANGLE INSERT

○ 一般切削 General Cutting
■ 斷續切削 Interrupted Cutting

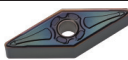
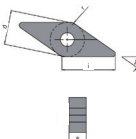
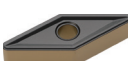
形狀 Shape	規格 Spec.	鍍層硬質合金 Layer coated carbide alloy					尺寸 (mm)				圖形 Drawing
		CVD	PVD			CVD	Size				
		RM485	RM380	RM385	RM388	RM285	d	i	s	r	
	TNMG160404-MF			M			9.525	16.5	4.76	0.4	
	TNMG160408-MF			M			9.525	16.5	4.76	0.8	
	TNMG160412-MF			M			9.525	16.5	4.76	1.2	
	TNMG160404-MM			M	M		9.525	16.5	4.76	0.4	
	TNMG160408-MM			M	M		9.525	16.5	4.76	0.8	
	TNMG160412-MM			M	M		9.525	16.5	4.76	1.2	
	TNMG160404-DM	P					9.525	16.5	4.76	0.4	
	TNMG160408-DM	P					9.525	16.5	4.76	0.8	
	TNMG160412-DM	P					9.525	16.5	4.76	1.2	
	TNMG160404-PM	P					9.525	16.5	4.76	0.4	
	TNMG160408-PM	P					9.525	16.5	4.76	0.8	
	TNMG160412-PM	P					9.525	16.5	4.76	1.2	
	TNMG160404-KM					K	9.525	16.5	4.76	0.4	
	TNMG160408-KM					K	9.525	16.5	4.76	0.8	
	TNMG160412-KM					K	9.525	16.5	4.76	1.2	
	TNMG160408-KR					K	9.525	16.5	4.76	0.8	
	TNMG160412-KR					K	9.525	16.5	4.76	1.2	

• 長度單位 Unit of Length (mm)

VN 負角刀片

VN NEGATIVE RAKE ANGLE INSERT

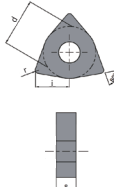
○ 一般切削 General Cutting
■ 斷續切削 Interrupted Cutting

形狀 Shape	規格 Spec.	鍍層硬質合金 Layer coated carbide alloy					尺寸 (mm)				圖形 Drawing
		CVD	PVD			CVD	Size				
		RM485	RM380	RM385	RM388	RM285	d	i	s	r	
	VNMG160404-MM			M	M		9.525	16.6	4.76	0.4	
	VNMG160408-MM			M	M		9.525	16.6	4.76	0.8	
	VNMG160404-DM	P					9.525	16.6	4.76	0.4	
	VNMG160408-DM	P					9.525	16.6	4.76	0.8	
	VNMG160412-DM	P					9.525	16.6	4.76	1.2	
	VNMG160404-PM	P					9.525	16.6	4.76	0.4	
	VNMG160408-PM	P					9.525	16.6	4.76	0.8	
	VNMG160412-PM	P					9.525	16.6	4.76	1.2	
	VNMG160404-KM					K	9.525	16.6	4.76	0.4	
	VNMG160408-KM					K	9.525	16.6	4.76	0.8	
	VNMG160404-KR					K	9.525	16.6	4.76	0.4	
	VNMG160408-KR					K	9.525	16.6	4.76	0.8	
	VNMG160412-KR					K	9.525	16.6	4.76	1.2	

WN 負角刀片

WN NEGATIVE RAKE ANGLE INSERT

○ 一般切削 General Cutting
■ 斷續切削 Interrupted Cutting

形狀 Shape	規格 Spec.	鍍層硬質合金 Layer coated carbide alloy					尺寸 (mm)				圖形 Drawing
		CVD	PVD			CVD	Size				
		RM485	RM380	RM385	RM388	RM285	d	i	s	r	
	WNMG080404-MF			M			12.7	8.7	4.76	0.4	
	WNMG080408-MF			M			12.7	8.7	4.76	0.8	
	WNMG080412-MF			M			12.7	8.7	4.76	1.2	
	WNMG080404-MM			M	M		12.7	8.7	4.76	0.4	
	WNMG080408-MM			M	M		12.7	8.7	4.76	0.8	
	WNMG080412-MM			M	M		12.7	8.7	4.76	1.2	
	WNMG080404-DM	P					12.7	8.7	4.76	0.4	
	WNMG080408-DM	P					12.7	8.7	4.76	0.8	
	WNMG080412-DM	P					12.7	8.7	4.76	1.2	
	WNMG080404-PM	P					12.7	8.7	4.76	0.4	
	WNMG080408-PM	P					12.7	8.7	4.76	0.8	
	WNMG080412-PM	P					12.7	8.7	4.76	1.2	
	WNMG080404-KM					K	12.7	8.7	4.76	0.4	
	WNMG080408-KM					K	12.7	8.7	4.76	0.8	
	WNMG080412-KM					K	12.7	8.7	4.76	1.2	
	WNMG080408-KR					K	12.7	8.7	4.76	0.8	
	WNMG080412-KR					K	12.7	8.7	4.76	1.2	

• 長度單位 Unit of Length (mm)

車削加工推薦切削參數 (負角)

RECOMMENDED CUTTING PARAMETERS FOR TURNING (NEGATIVE)

ISO	工件材料 Material	硬度範圍 Hardness	加工類型 Processing Type	切削狀態 Cutting Condition	斷屑槽 Chip Breaker	材質 Grade	切削參數 Cutting Parameters		
							切削速度 vc (m/min)	每刃進給 fz (mm/rev)	切削深度 ap (mm)
P	軟鋼 Mild Steel	≤ 180HB	半精加工 Semi-finishing	連續 - 斷續 Continuous-Interrupted	DM	RM485	180-320	0.2-0.5	1.0-5.0
	碳鋼、合金鋼 Carbon Steel、Alloy Steel	≤ 180-280HB	半精加工 Semi-finishing	連續 - 斷續 Continuous-Interrupted	DM	RM485	110-240	0.2-0.5	1.0-5.0
		≤ 280-350HB	半精加工 Semi-finishing	連續 - 斷續 Continuous-Interrupted	DM	RM485	110-240	0.2-0.5	1.0-5.0
	軟鋼 Mild Steel	≤ 180HB	中切削 Medium	連續 - 斷續 Continuous-Interrupted	PM	RM485	180-320	0.25-0.6	1.0-5.0
	碳鋼、合金鋼 Carbon Steel、Alloy Steel	≤ 180-280HB	中切削 Medium	連續 - 斷續 Continuous-Interrupted	PM	RM485	110-240	0.25-0.6	1.0-5.0
		≤ 280-350HB	中切削 Medium	連續 - 斷續 Continuous-Interrupted	PM	RM485	110-240	0.25-0.6	1.0-5.0
M	不鏽鋼 304、316 等 Stainless Steel 304、316	≤ 300HB	精加工 Finishing	連續 - 斷續 Continuous-Interrupted	MF	RM385	110-240	0.05-0.2	0.2-1.6
			半精加工 Semi-finishing	連續 - 斷續 Continuous-Interrupted	MM	RM385	110-240	0.1-0.35	0.5-3.5
				斷續 Interrupted	MM	RM388	100-230	0.1-0.35	0.5-3.5
K	灰口鑄鐵 Gray Iron	≤ 250HB	半精加工 Semi-finishing	連續 Continuous	KM	RM285	230-500	0.20-0.55	1.00-4.00
				斷續 Interrupted			220-480		
			粗加工 Roughing	連續 Continuous	KR	RM285	220-480	0.25-0.60	1.50-6.00
				斷續 Interrupted			210-450		
	球墨鑄鐵 Ductile Iron	≤ 300HB	半精加工 Semi-finishing	連續 Continuous	KM	RM285	180-380	0.20-0.55	1.00-4.00
				斷續 Interrupted			160-350		
			粗加工 Roughing	連續 Continuous	KR	RM285	180-360	0.25-0.60	1.50-6.00
				斷續 Interrupted			160-340		

• 長度單位 Unit of Length (mm)

車削加工推薦切削參數（正角）

RECOMMENDED CUTTING PARAMETERS FOR TURNING (POSITIVE)

ISO	工件材料 Material	硬度範圍 Hardness	加工類型 Processing Type	切削狀態 Cutting Condition	斷屑槽 Chip Breaker	材質 Grade	切削參數 Cutting Parameters		
							切削速度 v_c (m/min)	每刃進給 f_z (mm/rev)	切削深度 a_p (mm)
M	不鏽鋼 201、304、316 等 Stainless Steel 201、304、316	$\leq 300\text{HB}$	精加工 Finishing	連續 - 斷續 Continuous-Interrupted	MF	RM385	80-160	0.07-0.25	0.4-2.0
			粗加工 Roughing	連續 - 斷續 Continuous-Interrupted	MR	RM380	60-150	0.06-0.28	0.3-3.0
				斷續 Interrupted	MR	RM388	55-140	0.06-0.28	0.3-3.0
K	灰口鑄鐵 Gray Iron	$\leq 250\text{HB}$	粗加工 Roughing	連續 Continuous	KR	RM285	180-360	0.06-0.28	0.3-3.0
				斷續 Interrupted			160-340		
	球墨鑄鐵 Ductile Iron	$\leq 300\text{HB}$	粗加工 Roughing	連續 Continuous	KR	RM285	160-330	0.06-0.28	0.3-3.0
				斷續 Interrupted			140-310		



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