



被切削材 Work Material		鋁合金 : Aluminum Alloy 5052 / 6061 / 7075							被切削材 Work Material		鋁合金 : Aluminum Alloy 5052 / 6061 / 7075						
型號 Type NO.	刀具伸長量 Extension Length	切削速度 Cutting Speed (m/min)	迴轉速度 Speed (min <sup>-1</sup> )	進給速度 Feed (mm/min)	加工深度(Aa) Depth of Cut	加工寬度(Ap) Width of Cut	加工方式 Type	Milling	型號 Type NO.	刀具伸長量 Extension Length	切削速度 Cutting Speed (m/min)	迴轉速度 Speed (min <sup>-1</sup> )	進給速度 Feed (mm/min)	加工深度(Aa) Depth of Cut	加工寬度(Ap) Width of Cut	加工方式 Type	Milling
X-BTC0802	30	200	8000~8500	1400~1800	0.7~1	2~2.5	3D銑(3D milling)		X-BTC0802	30	330	13000~14000	2000~2400	0.7~1	2~2.5	3D銑(3D milling)	
X-BTC0802	30	200	8000~8500	2600~3000	0.25~0.3	0.5~0.6	3D銑(3D milling)		X-BTC0802	30	330	13000~14000	3600~4000	0.25~0.3	0.5~0.6	3D銑(3D milling)	
X-BTC0802	30	230	9000~9500	3200~3600	0.08~0.13	0.15~0.2	3D銑(3D milling)		X-BTC0802	30	330	13000~14000	4200~4600	0.08~0.13	0.15~0.2	3D銑(3D milling)	
X-BTC0802	50	200	8000~8500	2000~2400	0.25~0.3	0.5~0.6	3D銑(3D milling)		X-BTC0802	50	305	12000~13000	2400~2800	0.25~0.3	0.5~0.6	3D銑(3D milling)	
X-BTC0802	50	230	9000~9500	3200~3600	0.08~0.13	0.15~0.2	3D銑(3D milling)		X-BTC0802	50	305	12000~13000	4200~4600	0.08~0.13	0.15~0.2	3D銑(3D milling)	
X-BTC0802	70	120	4700~5200	2000~2400	0.25~0.3	0.5~0.6	3D銑(3D milling)		X-BTC0802	70	120	4700~5200	2000~2400	0.25~0.3	0.5~0.6	3D銑(3D milling)	
X-BTC0802	70	230	9000~9500	3000~3400	0.08~0.13	0.15~0.2	3D銑(3D milling)		X-BTC0802	70	305	12000~13000	3400~3800	0.08~0.13	0.15~0.2	3D銑(3D milling)	
X-BTC1002	40	255	8000~8500	1800~2200	0.8~1.3	2~2.5	3D銑(3D milling)		X-BTC1002	40	315	10000~11000	2000~2400	0.8~1.3	2~2.5	3D銑(3D milling)	
X-BTC1002	40	255	8000~8500	3600~4000	0.3~0.35	0.7~0.8	3D銑(3D milling)		X-BTC1002	40	380	12000~13000	4000~4400	0.3~0.35	0.7~0.8	3D銑(3D milling)	
X-BTC1002	40	285	9000~9500	3000~3400	0.1~0.15	0.15~0.23	3D銑(3D milling)		X-BTC1002	40	380	12000~13000	3800~4200	0.1~0.15	0.18~0.23	3D銑(3D milling)	
X-BTC1002	60	255	8000~8500	3600~4000	0.3~0.35	0.7~0.8	3D銑(3D milling)		X-BTC1002	60	255	8000~8500	3600~4000	0.3~0.35	0.7~0.8	3D銑(3D milling)	
X-BTC1002	60	285	9000~9500	3000~3400	0.1~0.15	0.18~0.23	3D銑(3D milling)		X-BTC1002	60	345	11000~12000	3800~4200	0.1~0.15	0.18~0.23	3D銑(3D milling)	
X-BTC1002	100	125	4000~4400	1200~1600	0.1~0.15	0.18~0.23	3D銑(3D milling)		X-BTC1002	100	125	4000~4400	1200~1600	0.1~0.15	0.18~0.23	3D銑(3D milling)	
X-BTC1002	100	285	9000~9500	3000~3400	0.1~0.15	0.18~0.23	3D銑(3D milling)		X-BTC1002	100	285	9000~9500	3000~3400	0.1~0.15	0.18~0.23	3D銑(3D milling)	
X-BTC1202	40	290	7700~8200	1600~2000	1~1.5	2.5~3.5	3D銑(3D milling)		X-BTC1202	40	415	11000~12000	2400~2800	1~1.5	2.5~3.5	3D銑(3D milling)	
X-BTC1202	40	290	7700~8200	3000~3400	0.35~0.4	0.8~1	3D銑(3D milling)		X-BTC1202	40	415	11000~12000	3800~4200	0.35~0.4	0.8~1	3D銑(3D milling)	
X-BTC1202	40	290	7700~8200	3800~4200	0.13~0.16	0.2~0.25	3D銑(3D milling)		X-BTC1202	40	415	11000~12000	4200~4600	0.13~0.16	0.2~0.25	3D銑(3D milling)	
X-BTC1202	60	290	7700~8200	3000~3400	0.35~0.4	0.8~1	3D銑(3D milling)		X-BTC1202	60	290	7700~8200	3000~3400	0.35~0.4	0.8~1	3D銑(3D milling)	
X-BTC1202	60	290	7700~8200	3000~3400	0.13~0.16	0.2~0.25	3D銑(3D milling)		X-BTC1202	60	380	10000~11000	3800~4200	0.13~0.16	0.2~0.25	3D銑(3D milling)	
X-BTC1202	100	85	2000~2400	800~1000	0.35~0.4	0.8~1	3D銑(3D milling)		X-BTC1202	100	85	2000~2400	800~1000	0.35~0.4	0.8~1	3D銑(3D milling)	
X-BTC1202	100	150	3700~4200	1800~2200	0.13~0.16	0.2~0.25	3D銑(3D milling)		X-BTC1202	100	150	3700~4200	1800~2200	0.13~0.16	0.2~0.25	3D銑(3D milling)	
X-BTC1602	60	390	7700~8200	2200~2600	1~2	3~4	3D銑(3D milling)		X-BTC1602	60	480	9500~10500	3000~3400	1~2	3~4	3D銑(3D milling)	
X-BTC1602	60	390	7700~8200	3800~4200	0.4~0.45	0.9~1.3	3D銑(3D milling)		X-BTC1602	60	480	9500~10500	4500~5500	0.4~0.45	0.9~1.3	3D銑(3D milling)	
X-BTC1602	60	390	7700~8200	3200~3600	0.15~0.18	0.22~0.27	3D銑(3D milling)		X-BTC1602	60	480	9500~10500	3600~4000	0.15~0.18	0.22~0.27	3D銑(3D milling)	
X-BTC1602	100	285	5600~6200	1800~2200	0.4~0.45	0.9~1.3	3D銑(3D milling)		X-BTC1602	100	285	5600~6200	1800~2200	0.4~0.45	0.9~1.3	3D銑(3D milling)	
X-BTC1602	100	335	6600~7200	3200~3600	0.15~0.18	0.22~0.27	3D銑(3D milling)		X-BTC1602	100	335	6600~7200	3200~3600	0.15~0.18	0.22~0.27	3D銑(3D milling)	
X-BTC1602	140	100	2000~2400	600~800	0.4~0.45	0.9~1.3	3D銑(3D milling)		X-BTC1602	140	100	2000~2400	600~800	0.4~0.45	0.9~1.3	3D銑(3D milling)	
X-BTC1602	140	215	4200~4600	2200~2600	0.15~0.18	0.22~0.27	3D銑(3D milling)		X-BTC1602	140	215	4200~4600	2200~2600	0.15~0.18	0.22~0.27	3D銑(3D milling)	
X-BTC2002	80	475	7500~8200	1000~1400	1~2	3~4	3D銑(3D milling)		X-BTC2002	80	475	7500~8200	1000~1400	1~2	3~4	3D銑(3D milling)	
X-BTC2002	80	505	7500~8500	2200~2600	0.55~0.65	1.2~1.7	3D銑(3D milling)		X-BTC2002	80	505	7500~8500	2200~2600	0.55~0.65	1.2~1.7	3D銑(3D milling)	
X-BTC2002	80	505	7500~8500	3200~3600	0.15~0.25	0.3~0.4	3D銑(3D milling)		X-BTC2002	80	505	7500~8500	3200~3600	0.15~0.25	0.3~0.4	3D銑(3D milling)	
X-BTC2002	130	475	7500~8500	2000~2400	0.55~0.65	1.2~1.7	3D銑(3D milling)		X-BTC2002	130	475	7500~8500	2000~2400	0.55~0.65	1.2~1.7	3D銑(3D milling)	
X-BTC2002	130	475	7500~8500	2800~3200	0.15~0.25	0.3~0.4	3D銑(3D milling)		X-BTC2002	130	475	7500~8500	2800~3200	0.15~0.25	0.3~0.4	3D銑(3D milling)	
X-BTC2002	180	125	2000~2500	500~800	0.55~0.65	1.2~1.7	3D銑(3D milling)		X-BTC2002	180	125	2000~2500	500~800	0.55~0.65	1.2~1.7	3D銑(3D milling)	
X-BTC2002	180	255	3800~4600	2200~2600	0.15~0.25	0.3~0.4	3D銑(3D milling)		X-BTC2002	180	255	3800~4600	2200~2600	0.15~0.25	0.3~0.4	3D銑(3D milling)	
X-BTC2502	90	400	4800~5300	800~1200	1~2	3~4	3D銑(3D milling)		X-BTC2502	90	400	4800~5300	800~1200	1~2	3~4	3D銑(3D milling)	
X-BTC2502	90	400	4800~5300	2000~2400	0.55~0.65	1.2~1.7	3D銑(3D milling)		X-BTC2502	90	400	4800~5300	2000~2400	0.55~0.65	1.2~1.7	3D銑(3D milling)	
X-BTC2502	90	400	4800~5300	2600~3000	0.15~0.25	0.3~0.4	3D銑(3D milling)		X-BTC2502	90	400	4800~5300	2600~3000	0.15~0.25	0.3~0.4	3D銑(3D milling)	
X-BTC2502	150	350	4400~4800	1600~2000	0.55~0.65	1.2~1.7	3D銑(3D milling)		X-BTC2502	150	350	4400~4800	1600~2000	0.55~0.65	1.2~1.7	3D銑(3D milling)	
X-BTC2502	150	350	4400~4800	2000~2400	0.15~0.25	0.3~0.4	3D銑(3D milling)		X-BTC2502	150	350	4400~4800	2000~2400	0.15~0.25	0.3~0.4	3D銑(3D milling)	
X-BTC2502	200	250	2800~3200	1600~2000	0.15~0.25	0.3~0.4	3D銑(3D milling)		X-BTC2502	200	250	2800~3200	1600~2000	0.15~0.25	0.3~0.4	3D銑(3D milling)	
X-BTC3202	100	400	3700~4200	800~1200	1~2	3~4	3D銑(3D milling)		X-BTC3202	100	400	3700~4200	800~1200	1~2	3~4	3D銑(3D milling)	
X-BTC3202	100	400	3700~4200	1600~2000	0.55~0.65	1.2~1.7	3D銑(3D milling)		X-BTC3202	100	400	3700~4200	1600~2000	0.55~0.65	1.2~1.7	3D銑(3D milling)	
X-BTC3202	100	400	3700~4200	2000~2400	0.15~0.25	0.3~0.4	3D銑(3D milling)		X-BTC3202	100	400	3700~4200	2000~2400	0.15~0.25	0.3~0.4	3D銑(3D milling)	
X-BTC3202	170	350	3200~3700	1200~1600	0.55~0.65	1.2~1.7	3D銑(3D milling)		X-BTC3202	170	350	3200~3700	1200~1600	0.55~0.65	1.2~1.7	3D銑(3D milling)	
X-BTC3202	170	350	3200~3700	1600~2000	0.15~0.25	0.3~0.4	3D銑(3D milling)		X-BTC3202	170	350	3200~3700	1600~2000	0.15~0.25	0.3~0.4	3D銑(3D milling)	
X-BTC3202	220	250	2200~2700	1200~1600	0.15~0.25	0.3~0.4	3D銑(3D milling)		X-BTC3202	220	250	2200~2700	1200~1600	0.15~0.25	0.3~0.4	3D銑(3D milling)	

附註 / Note:

以上冷卻方式皆為濕式。

Suggest to use Wet coolant.

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