

被切削材 Work Material		鋁合金 Aluminum Alloy- Al5052 , Al7075						被切削材 Work Material	
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 ⁻¹)	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 Milling Type	型號 Type NO.	
AEA0052	9mm	30	20000	1400~1800	0.02~0.04	0	面銑(Surface milling)	AEA0052	
AEA0052	9mm	30	20000	1400~1800	0~0.04	1	溝銑(Slotting)	AEA0052	
AEA0052	9mm	30	20000	500~800	0.04~0.07	1	溝銑(Slotting)	AEA0052	
AEA0052	9mm	30	20000	200~400	0.07~0.1	1	溝銑(Slotting)	AEA0052	
AEA0052	9mm	30	20000	1400~1800	1	0.03~0.05	側銑(Side milling)	AEA0052	
AEA0052	9mm	30	20000	1400~1800	1	0~0.04	側銑(Side milling)	AEA0052	
AEA0052	9mm	30	20000	500~800	1	0.04~0.07	側銑(Side milling)	AEA0052	
AEA0052	9mm	30	20000	200~400	1	0.07~0.1	側銑(Side milling)	AEA0052	
AEA0102	9mm	60	20000	1600~2000	0.03~0.06	1	面銑(Surface milling)	AEA0102	
AEA0102	9mm	60	20000	1600~2000	0~0.1	1	溝銑(Slotting)	AEA0102	
AEA0102	9mm	60	20000	1000~1300	0.1~0.2	1	溝銑(Slotting)	AEA0102	
AEA0102	9mm	60	20000	600~900	0.2~0.3	1	溝銑(Slotting)	AEA0102	
AEA0102	9mm	60	20000	1600~2000	3	0.03~0.06	側銑(Side milling)	AEA0102	
AEA0102	9mm	60	20000	1600~2000	2	0~0.1	側銑(Side milling)	AEA0102	
AEA0102	9mm	60	20000	1000~1300	2	0.1~0.2	側銑(Side milling)	AEA0102	
AEA0102	9mm	60	20000	600~900	2	0.2~0.3	側銑(Side milling)	AEA0102	
AEA0152	9mm	75	16000	1600~2000	0.04~0.07	1	面銑(Surface milling)	AEA0152	
AEA0152	9mm	75	16000	2000~2500	0~0.2	2	溝銑(Slotting)	AEA0152	
AEA0152	9mm	75	16000	1300~1600	0.2~0.4	2	溝銑(Slotting)	AEA0152	
AEA0152	9mm	75	16000	600~900	0.4~0.6	2	溝銑(Slotting)	AEA0152	
AEA0152	9mm	75	16000	1600~2000	4	0.04~0.07	側銑(Side milling)	AEA0152	
AEA0152	9mm	75	16000	2000~2500	2	0~0.2	側銑(Side milling)	AEA0152	
AEA0152	9mm	75	16000	1300~1600	2	0.2~0.4	側銑(Side milling)	AEA0152	
AEA0152	9mm	75	16000	600~900	2	0.4~0.6	側銑(Side milling)	AEA0152	
AEA0202	9mm	100	16000	1600~2000	0.05~0.08	2	面銑(Surface milling)	AEA0202	
AEA0202	9mm	100	16000	2500~3000	0~0.2	2	溝銑(Slotting)	AEA0202	
AEA0202	9mm	100	16000	1300~1600	0.2~0.6	2	溝銑(Slotting)	AEA0202	
AEA0202	9mm	100	16000	700~1000	0.6~1	2	溝銑(Slotting)	AEA0202	
AEA0202	9mm	100	16000	1600~2000	5	0.05~0.08	側銑(Side milling)	AEA0202	
AEA0202	9mm	100	16000	2500~3000	2	0~0.2	側銑(Side milling)	AEA0202	
AEA0202	9mm	100	16000	1300~1600	2	0.2~0.6	側銑(Side milling)	AEA0202	
AEA0202	9mm	100	16000	700~1000	2	0.6~1	側銑(Side milling)	AEA0202	
AEA0302	12mm	115	12000	1600~2000	0.05~0.1	3	面銑(Surface milling)	AEA0302	
AEA0302	12mm	115	12000	2500~3000	0~0.4	3	溝銑(Slotting)	AEA0302	
AEA0302	12mm	115	12000	1600~2000	0.4~0.8	3	溝銑(Slotting)	AEA0302	
AEA0302	12mm	115	12000	800~1100	0.8~1.2	3	溝銑(Slotting)	AEA0302	
AEA0302	12mm	115	12000	1600~2000	9	0.05~0.1	側銑(Side milling)	AEA0302	
AEA0302	12mm	115	12000	2500~3000	3	0~0.4	側銑(Side milling)	AEA0302	
AEA0302	12mm	115	12000	1600~2000	3	0.4~0.8	側銑(Side milling)	AEA0302	
AEA0302	12mm	115	12000	900~1200	3	0.8~1.2	側銑(Side milling)	AEA0302	

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AEA0402	15mm	150	12000	1800~2200	0.05~0.12	3	面铣(Surface milling)	AEA0402
AEA0402	15mm	150	12000	2500~3000	0~0.6	4	溝铣(Slotting)	AEA0402
AEA0402	15mm	150	12000	1600~2000	0.6~1.2	4	溝铣(Slotting)	AEA0402
AEA0402	15mm	150	12000	900~1200	1.2~2	4	溝铣(Slotting)	AEA0402
AEA0402	15mm	150	12000	1800~2200	11	0.05~0.12	側铣(Side milling)	AEA0402
AEA0402	15mm	150	12000	2500~3000	4	0~0.6	側铣(Side milling)	AEA0402
AEA0402	15mm	150	12000	1600~2000	4	0.6~1.2	側铣(Side milling)	AEA0402
AEA0402	15mm	150	12000	1000~1300	4	1.2~2	側铣(Side milling)	AEA0402
AEA0502	19mm	155	10000	2000~2400	0.05~0.12	4	面铣(Surface milling)	AEA0502
AEA0502	19mm	155	10000	3000~3500	0~0.7	5	溝铣(Slotting)	AEA0502
AEA0502	19mm	155	10000	1700~2200	0.7~1.5	5	溝铣(Slotting)	AEA0502
AEA0502	19mm	155	10000	900~1300	1.5~3.5	5	溝铣(Slotting)	AEA0502
AEA0502	19mm	155	10000	2000~2400	15	0.05~0.12	側铣(Side milling)	AEA0502
AEA0502	19mm	155	10000	3300~3800	5	0~0.7	側铣(Side milling)	AEA0502
AEA0502	19mm	155	10000	2000~2400	5	0.7~1.5	側铣(Side milling)	AEA0502
AEA0502	19mm	155	10000	1000~1400	5	1.5~3.5	側铣(Side milling)	AEA0502
AEA0602	21mm	190	10000	1800~2200	0.05~0.15	5	面铣(Surface milling)	AEA0602
AEA0602	21mm	190	10000	3500~4000	0~1	6	溝铣(Slotting)	AEA0602
AEA0602	21mm	190	10000	1600~2000	1~3	6	溝铣(Slotting)	AEA0602
AEA0602	21mm	190	10000	1000~1400	3~6	6	溝铣(Slotting)	AEA0602
AEA0602	21mm	190	10000	1800~2200	17	0.05~0.15	側铣(Side milling)	AEA0602
AEA0602	21mm	190	10000	4000~4500	6	0~1	側铣(Side milling)	AEA0602
AEA0602	21mm	190	10000	1800~2200	6	1~3	側铣(Side milling)	AEA0602
AEA0602	21mm	190	10000	1200~1500	6	3~6	側铣(Side milling)	AEA0602
AEA0802	25mm	200	8000	2000~2400	0.05~0.15	6	面铣(Surface milling)	AEA0802
AEA0802	25mm	200	8000	4000~4500	0~1.5	8	溝铣(Slotting)	AEA0802
AEA0802	25mm	200	8000	1700~2200	1.5~4	8	溝铣(Slotting)	AEA0802
AEA0802	25mm	200	8000	1500~2000	4~8	8	溝铣(Slotting)	AEA0802
AEA0802	25mm	200	8000	2000~2400	19	0.05~0.15	側铣(Side milling)	AEA0802
AEA0802	25mm	200	8000	4500~5000	8	0~2	側铣(Side milling)	AEA0802
AEA0802	25mm	200	8000	2000~2500	8	2~4	側铣(Side milling)	AEA0802
AEA0802	25mm	200	8000	1700~2100	8	4~8	側铣(Side milling)	AEA0802
AEA1002	30mm	250	8000	2000~2400	0.05~0.15	8	面铣(Surface milling)	AEA1002
AEA1002	30mm	250	8000	3500~4000	0~2	10	溝铣(Slotting)	AEA1002
AEA1002	30mm	250	8000	2000~2500	2~5	10	溝铣(Slotting)	AEA1002
AEA1002	30mm	250	8000	1600~2000	5~10	10	溝铣(Slotting)	AEA1002
AEA1002	30mm	250	8000	2000~2400	24	0.05~0.15	側铣(Side milling)	AEA1002
AEA1002	30mm	250	8000	4000~4500	10	0~2	側铣(Side milling)	AEA1002
AEA1002	30mm	250	8000	2500~3000	10	2~5	側铣(Side milling)	AEA1002
AEA1002	30mm	250	8000	2000~2400	10	5~10	側铣(Side milling)	AEA1002
AEA1202	35mm	225	6000	1600~2000	0.05~0.15	10	面铣(Surface milling)	AEA1202
AEA1202	35mm	225	6000	2500~3000	0~2	12	溝铣(Slotting)	AEA1202
AEA1202	35mm	225	6000	1500~2000	2~6	12	溝铣(Slotting)	AEA1202
AEA1202	35mm	225	6000	1000~1400	6~12	12	溝铣(Slotting)	AEA1202
AEA1202	35mm	225	6000	1600~2000	29	0.05~0.15	側铣(Side milling)	AEA1202
AEA1202	35mm	225	6000	3000~3500	12	0~2	側铣(Side milling)	AEA1202

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AEA1202	35mm	225	6000	2000~2500	12	2~6	側銑(Side milling)	AEA1202
AEA1202	35mm	225	6000	1100~1500	12	6~12	側銑(Side milling)	附註: 1. AEA本身刀法請 AEA is special

鋁合金 Alloy- Al5052 , Al7075							Aluminum
刀具伸長量 Extension Length	切削速度 Cutting Speed (m/min)	迴轉速度 Speed (min ⁻¹)	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 Milling Type	
9mm	65	40000	1600~2000	0.02~0.04	0	面銑(Surface milling)	
9mm	65	40000	1600~2000	0~0.04	1	溝銑(Slotting)	
9mm	65	40000	700~1000	0.04~0.07	1	溝銑(Slotting)	
9mm	65	40000	300~500	0.07~0.1	1	溝銑(Slotting)	
9mm	65	40000	1600~2000	1	0.03~0.05	側銑(Side milling)	
9mm	65	40000	1600~2000	1	0~0.04	側銑(Side milling)	
9mm	65	40000	700~1000	1	0.04~0.07	側銑(Side milling)	
9mm	65	40000	300~500	1	0.07~0.1	側銑(Side milling)	
9mm	125	40000	2000~2400	0.03~0.06	1	面銑(Surface milling)	
9mm	125	40000	2000~2400	0~0.1	1	溝銑(Slotting)	
9mm	125	40000	1200~1500	0.1~0.2	1	溝銑(Slotting)	
9mm	125	40000	600~900	0.2~0.3	1	溝銑(Slotting)	
9mm	125	40000	2000~2400	3	0.03~0.06	側銑(Side milling)	
9mm	125	40000	2000~2400	2	0~0.1	側銑(Side milling)	
9mm	125	40000	1200~1500	2	0.1~0.2	側銑(Side milling)	
9mm	125	40000	700~1000	2	0.2~0.3	側銑(Side milling)	
9mm	190	40000	2000~2400	0.04~0.07	1	面銑(Surface milling)	
9mm	190	40000	2800~3300	0~0.2	2	溝銑(Slotting)	
9mm	190	40000	1600~1900	0.2~0.4	2	溝銑(Slotting)	
9mm	190	40000	900~1200	0.4~0.6	2	溝銑(Slotting)	
9mm	190	40000	2000~2400	4	0.04~0.07	側銑(Side milling)	
9mm	190	40000	2800~3300	2	0~0.2	側銑(Side milling)	
9mm	190	40000	1700~2000	2	0.2~0.4	側銑(Side milling)	
9mm	190	40000	1000~1300	2	0.4~0.6	側銑(Side milling)	
9mm	250	40000	2000~2400	0.05~0.08	2	面銑(Surface milling)	
9mm	250	40000	3000~3500	0~0.2	2	溝銑(Slotting)	
9mm	250	40000	1600~1900	0.2~0.6	2	溝銑(Slotting)	
9mm	250	40000	1100~1500	0.6~1	2	溝銑(Slotting)	
9mm	250	40000	2000~2400	5	0.05~0.08	側銑(Side milling)	
9mm	250	40000	3200~3700	2	0~0.2	側銑(Side milling)	
9mm	250	40000	1600~1900	2	0.2~0.6	側銑(Side milling)	
9mm	250	40000	1300~1700	2	0.6~1	側銑(Side milling)	
12mm	250	26500	2000~2400	0.05~0.1	3	面銑(Surface milling)	
12mm	250	26500	3400~3800	0~0.4	3	溝銑(Slotting)	
12mm	250	26500	2400~2800	0.4~0.8	3	溝銑(Slotting)	
12mm	250	26500	1200~1600	0.8~1.2	3	溝銑(Slotting)	
12mm	250	26500	2000~2400	9	0.05~0.1	側銑(Side milling)	
12mm	250	26500	3500~4000	3	0~0.4	側銑(Side milling)	
12mm	250	26500	2400~2800	3	0.4~0.8	側銑(Side milling)	
12mm	250	26500	1800~2200	3	0.8~1.2	側銑(Side milling)	

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15mm	250	20000	2000~2400	0.05~0.12	3	面铣(Surface milling)
15mm	250	20000	3000~3500	0~0.6	4	溝铣(Slotting)
15mm	250	20000	2100~2500	0.6~1.2	4	溝铣(Slotting)
15mm	250	20000	1200~1600	1.2~2	4	溝铣(Slotting)
15mm	250	20000	2000~2400	11	0.05~0.12	側铣(Side milling)
15mm	250	20000	3000~3500	4	0~0.6	側铣(Side milling)
15mm	250	20000	2000~2400	4	0.6~1.2	側铣(Side milling)
15mm	250	20000	1400~1800	4	1.2~2	側铣(Side milling)
19mm	250	16000	2000~2400	0.05~0.12	4	面铣(Surface milling)
19mm	250	16000	3500~4000	0~0.7	5	溝铣(Slotting)
19mm	250	16000	2000~2500	0.7~1.5	5	溝铣(Slotting)
19mm	250	16000	1200~1600	1.5~3.5	5	溝铣(Slotting)
19mm	250	16000	2000~2400	15	0.05~0.12	側铣(Side milling)
19mm	250	16000	4200~4800	5	0~0.7	側铣(Side milling)
19mm	250	16000	2400~2800	5	0.7~1.5	側铣(Side milling)
19mm	250	16000	1400~1800	5	1.5~3.5	側铣(Side milling)
21mm	250	13200	1800~2200	0.05~0.15	5	面铣(Surface milling)
21mm	225	12000	4000~4500	0~1	6	溝铣(Slotting)
21mm	225	12000	1800~2200	1~3	6	溝铣(Slotting)
21mm	225	12000	1200~1600	3~6	6	溝铣(Slotting)
21mm	250	13200	1800~2200	17	0.05~0.15	側铣(Side milling)
21mm	225	12000	4500~5000	6	0~1	側铣(Side milling)
21mm	225	12000	2000~2500	6	1~3	側铣(Side milling)
21mm	225	12000	1400~1700	6	3~6	側铣(Side milling)
25mm	300	12000	2000~2400	0.05~0.15	6	面铣(Surface milling)
25mm	300	12000	4500~5000	0~1.5	8	溝铣(Slotting)
25mm	300	12000	2000~2500	1.5~4	8	溝铣(Slotting)
25mm	300	12000	2000~2400	4~8	8	溝铣(Slotting)
25mm	300	12000	2000~2400	19	0.05~0.15	側铣(Side milling)
25mm	300	12000	5000~5500	8	0~2	側铣(Side milling)
25mm	300	12000	2500~3000	8	2~4	側铣(Side milling)
25mm	300	12000	2000~2400	8	4~8	側铣(Side milling)
30mm	300	9500	2000~2400	0.05~0.15	8	面铣(Surface milling)
30mm	300	9500	4000~4500	0~2	10	溝铣(Slotting)
30mm	300	9500	2500~3000	2~5	10	溝铣(Slotting)
30mm	300	9500	2000~2400	5~10	10	溝铣(Slotting)
30mm	300	9500	2000~2400	24	0.05~0.15	側铣(Side milling)
30mm	300	9500	4500~5000	10	0~2	側铣(Side milling)
30mm	300	9500	3000~3500	10	2~5	側铣(Side milling)
30mm	300	9500	2400~2800	10	5~10	側铣(Side milling)
35mm	300	8000	2000~2400	0.05~0.15	10	面铣(Surface milling)
35mm	300	8000	3500~4000	0~2	12	溝铣(Slotting)
35mm	300	8000	2000~2500	2~6	12	溝铣(Slotting)
35mm	300	8000	1600~2000	6~12	12	溝铣(Slotting)
35mm	300	8000	2000~2400	29	0.05~0.15	側铣(Side milling)
35mm	300	8000	4500~5000	12	0~2	側铣(Side milling)

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35mm	300	8000	3000~3500	12	2~6	側銑(Side milling)

設計屬於精銑和粗銑兩用刀具，其效能為AES的65%。
 ly designed for both Finishing and Roughing. It can reach 65% performance of AES.