

被切削材 Work Material		鋁合金 - A15052 , A17075						Aluminum Alloy		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.		
AEA0203	9mm	125	16000~20000	1600~2000	0.05~0.08	2	面銑(Surface milling)	AEA0203		
AEA0203	9mm	125	16000~20000	2600~3000	0~0.2	2	溝銑(Slotting)	AEA0203		
AEA0203	9mm	125	16000~20000	1400~1800	0.2~0.6	2	溝銑(Slotting)	AEA0203		
AEA0203	9mm	125	16000~20000	1100~1500	0.6~1	2	溝銑(Slotting)	AEA0203		
AEA0203	9mm	125	16000~20000	1600~2000	5	0.05~0.08	側銑(Side milling)	AEA0203		
AEA0203	9mm	125	16000~20000	2600~3000	2	0~0.2	側銑(Side milling)	AEA0203		
AEA0203	9mm	125	16000~20000	1400~1800	2	0.2~0.6	側銑(Side milling)	AEA0203		
AEA0203	9mm	125	16000~20000	1100~1500	2	0.6~1	側銑(Side milling)	AEA0203		
AEA0303	12mm	125	13500	1600~2000	0.05~0.1	3	面銑(Surface milling)	AEA0303		
AEA0303	12mm	125	13500	2200~2600	0~0.4	3	溝銑(Slotting)	AEA0303		
AEA0303	12mm	125	13500	1800~2200	0.4~0.8	3	溝銑(Slotting)	AEA0303		
AEA0303	12mm	125	13500	1200~1600	0.8~1.2	3	溝銑(Slotting)	AEA0303		
AEA0303	12mm	125	13500	1600~2000	9	0.05~0.1	側銑(Side milling)	AEA0303		
AEA0303	12mm	125	13500	2200~2600	3	0~0.4	側銑(Side milling)	AEA0303		
AEA0303	12mm	125	13500	1800~2200	3	0.4~0.8	側銑(Side milling)	AEA0303		
AEA0303	12mm	125	13500	1200~1600	3	0.8~1.2	側銑(Side milling)	AEA0303		
AEA0403	15mm	125	10000	1600~2000	0.05~0.12	3	面銑(Surface milling)	AEA0403		
AEA0403	15mm	125	10000	2700~3200	0~0.6	4	溝銑(Slotting)	AEA0403		
AEA0403	15mm	125	10000	2100~2500	0.6~1.2	4	溝銑(Slotting)	AEA0403		
AEA0403	15mm	125	10000	1300~1700	1.2~2	4	溝銑(Slotting)	AEA0403		
AEA0403	15mm	125	10000	1600~2000	11	0.05~0.12	側銑(Side milling)	AEA0403		
AEA0403	15mm	125	10000	2700~3200	4	0~0.6	側銑(Side milling)	AEA0403		
AEA0403	15mm	125	10000	2100~2500	4	0.6~1.2	側銑(Side milling)	AEA0403		
AEA0403	15mm	125	10000	1300~1700	4	1.2~2	側銑(Side milling)	AEA0403		
AEA0503	19mm	125	8000	1600~2000	0.05~0.12	4	面銑(Surface milling)	AEA0503		
AEA0503	19mm	125	8000	3500~4000	0~0.7	5	溝銑(Slotting)	AEA0503		
AEA0503	19mm	125	8000	2000~2500	0.7~1.5	5	溝銑(Slotting)	AEA0503		
AEA0503	19mm	125	8000	1200~1700	1.5~3.5	5	溝銑(Slotting)	AEA0503		
AEA0503	19mm	125	8000	1600~2000	15	0.05~0.12	側銑(Side milling)	AEA0503		
AEA0503	19mm	125	8000	3500~4000	5	0~0.7	側銑(Side milling)	AEA0503		
AEA0503	19mm	125	8000	2000~2500	5	0.7~1.5	側銑(Side milling)	AEA0503		
AEA0503	19mm	125	8000	1200~1700	5	1.5~3.5	側銑(Side milling)	AEA0503		
AEA0603	21mm	150	8000	1800~2200	0.05~0.15	5	面銑(Surface milling)	AEA0603		
AEA0603	21mm	150	8000	3500~4000	0~1	6	溝銑(Slotting)	AEA0603		
AEA0603	21mm	150	8000	1700~2200	1~3	6	溝銑(Slotting)	AEA0603		
AEA0603	21mm	150	8000	1200~1700	3~6	6	溝銑(Slotting)	AEA0603		
AEA0603	21mm	150	8000	1800~2200	17	0.05~0.15	側銑(Side milling)	AEA0603		
AEA0603	21mm	150	8000	2500~3000	6	0~1	側銑(Side milling)	AEA0603		
AEA0603	21mm	150	8000	1800~2300	6	1~3	側銑(Side milling)	AEA0603		
AEA0603	21mm	150	8000	1200~1700	6	3~6	側銑(Side milling)	AEA0603		

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AEA0803	25mm	200	8000	1800~2200	0.05~0.15	6	面铣(Surface milling)	AEA0803
AEA0803	25mm	200	8000	5000~5500	0~1.5	8	溝铣(Slotting)	AEA0803
AEA0803	25mm	200	8000	3000~3500	1.5~4	8	溝铣(Slotting)	AEA0803
AEA0803	25mm	200	8000	2400~2800	4~8	8	溝铣(Slotting)	AEA0803
AEA0803	25mm	200	8000	1800~2200	19	0.05~0.15	側铣(Side milling)	AEA0803
AEA0803	25mm	200	8000	4800~5300	8	0~2	側铣(Side milling)	AEA0803
AEA0803	25mm	200	8000	3000~3500	8	2~4	側铣(Side milling)	AEA0803
AEA0803	25mm	200	8000	2400~2800	8	4~8	側铣(Side milling)	AEA0803
AEA1003	30mm	250	8000	1800~2200	0.05~0.15	8	面铣(Surface milling)	AEA1003
AEA1003	30mm	250	8000	5000~5500	0~2	10	溝铣(Slotting)	AEA1003
AEA1003	30mm	250	8000	3500~4000	2~5	10	溝铣(Slotting)	AEA1003
AEA1003	30mm	250	8000	2000~2400	5~10	10	溝铣(Slotting)	AEA1003
AEA1003	30mm	250	8000	1800~2200	24	0.05~0.15	側铣(Side milling)	AEA1003
AEA1003	30mm	250	8000	5000~5500	10	0~2	側铣(Side milling)	AEA1003
AEA1003	30mm	250	8000	3500~4000	10	2~5	側铣(Side milling)	AEA1003
AEA1003	30mm	250	8000	2000~2400	10	5~10	側铣(Side milling)	AEA1003
AEA1203	35mm	300	8000	2000~2400	0.05~0.15	10	面铣(Surface milling)	AEA1203
AEA1203	35mm	300	8000	4500~5000	0~2	12	溝铣(Slotting)	AEA1203
AEA1203	35mm	300	8000	3000~3500	2~6	12	溝铣(Slotting)	AEA1203
AEA1203	35mm	300	8000	2000~2400	6~12	12	溝铣(Slotting)	AEA1203
AEA1203	35mm	300	8000	2000~2400	29	0.05~0.15	側铣(Side milling)	AEA1203
AEA1203	35mm	300	8000	4500~5000	12	0~2	側铣(Side milling)	AEA1203
AEA1203	35mm	300	8000	3500~4000	12	2~6	側铣(Side milling)	AEA1203
AEA1203	35mm	300	8000	2000~2400	12	6~12	側铣(Side milling)	AEA1203
AEA1603	50mm	330	6600	1700~2100	0.05~0.2	14	面铣(Surface milling)	AEA1603
AEA1603	50mm	330	6600	3500~4000	0~2	16	溝铣(Slotting)	AEA1603
AEA1603	50mm	330	6600	2600~3200	2~6	16	溝铣(Slotting)	AEA1603
AEA1603	50mm	330	6600	2000~2400	6~12	16	溝铣(Slotting)	AEA1603
AEA1603	50mm	330	6600	1700~2100	39	0.05~0.2	側铣(Side milling)	AEA1603
AEA1603	50mm	330	6600	3500~4000	16	0~2	側铣(Side milling)	AEA1603
AEA1603	50mm	330	6600	2600~3200	16	2~6	側铣(Side milling)	AEA1603
AEA1603	50mm	330	6600	2000~2400	16	6~12	側铣(Side milling)	AEA1603
							附註:	
							1. AEA本身刀法請	
							AEA is special	

鋁合金 - A15052 , A17075							Aluminum Alloy
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	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	1700~2000	0.2~0.6	2	溝銑(Slotting)	
9mm	250	40000	1300~1700	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	2600~3000	0~0.4	3	溝銑(Slotting)	
12mm	250	26500	2000~2400	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	3400~3900	3	0~0.4	側銑(Side milling)	
12mm	250	26500	1800~2100	3	0.4~0.8	側銑(Side milling)	
12mm	250	26500	1300~1700	3	0.8~1.2	側銑(Side milling)	
15mm	250	20000	2000~2400	0.05~0.12	3	面銑(Surface milling)	
15mm	250	20000	3000~3500	0~0.6	4	溝銑(Slotting)	
15mm	250	20000	2100~2500	0.6~1.2	4	溝銑(Slotting)	
15mm	250	20000	1400~1800	1.2~2	4	溝銑(Slotting)	
15mm	250	20000	2000~2400	11	0.05~0.12	側銑(Side milling)	
15mm	250	20000	3000~3500	4	0~0.6	側銑(Side milling)	
15mm	250	20000	2100~2500	4	0.6~1.2	側銑(Side milling)	
15mm	250	20000	1400~1800	4	1.2~2	側銑(Side milling)	
19mm	250	16000	2000~2400	0.05~0.12	4	面銑(Surface milling)	
19mm	250	16000	4000~4500	0~0.7	5	溝銑(Slotting)	
19mm	250	16000	2400~2800	0.7~1.5	5	溝銑(Slotting)	
19mm	250	16000	1400~1800	1.5~3.5	5	溝銑(Slotting)	
19mm	250	16000	2000~2400	15	0.05~0.12	側銑(Side milling)	
19mm	250	16000	4200~4800	5	0~0.7	側銑(Side milling)	
19mm	250	16000	2400~2800	5	0.7~1.5	側銑(Side milling)	
19mm	250	16000	1400~1800	5	1.5~3.5	側銑(Side milling)	
21mm	250	13200	2000~2400	0.05~0.15	5	面銑(Surface milling)	
21mm	225	12000	4000~4500	0~1	6	溝銑(Slotting)	
21mm	225	12000	2500~3000	1~3	6	溝銑(Slotting)	
21mm	200	10500	1600~2000	3~6	6	溝銑(Slotting)	
21mm	250	13200	2000~2400	17	0.05~0.15	側銑(Side milling)	
21mm	225	12000	3500~4000	6	0~1	側銑(Side milling)	
21mm	225	12000	2000~2500	6	1~3	側銑(Side milling)	
21mm	200	10500	1600~2000	6	3~6	側銑(Side milling)	

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25mm	300	12000	2000~2400	0.05~0.15	6	面铣(Surface milling)
25mm	225	9000	5500~6000	0~1.5	8	溝铣(Slotting)
25mm	225	9000	3500~4000	1.5~4	8	溝铣(Slotting)
25mm	200	8000	2400~2800	4~8	8	溝铣(Slotting)
25mm	300	12000	2000~2400	19	0.05~0.15	側铣(Side milling)
25mm	225	9000	5200~5700	8	0~2	側铣(Side milling)
25mm	225	9000	3500~4000	8	2~4	側铣(Side milling)
25mm	200	8000	2400~2800	8	4~8	側铣(Side milling)
30mm	300	9500	2000~2400	0.05~0.15	8	面铣(Surface milling)
30mm	250	8000	5000~5500	0~2	10	溝铣(Slotting)
30mm	250	8000	3500~4000	2~5	10	溝铣(Slotting)
30mm	250	8000	2000~2400	5~10	10	溝铣(Slotting)
30mm	300	9500	2000~2400	24	0.05~0.15	側铣(Side milling)
30mm	250	8000	5000~5500	10	0~2	側铣(Side milling)
30mm	250	8000	3500~4000	10	2~5	側铣(Side milling)
30mm	250	8000	2000~2400	10	5~10	側铣(Side milling)
35mm	300	8000	2000~2400	0.05~0.15	10	面铣(Surface milling)
35mm	300	8000	4500~5000	0~2	12	溝铣(Slotting)
35mm	300	8000	3000~3500	2~6	12	溝铣(Slotting)
35mm	300	8000	2000~2400	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)
35mm	300	8000	3500~4000	12	2~6	側铣(Side milling)
35mm	300	8000	2000~2400	12	6~12	側铣(Side milling)
50mm	300	6000	1700~2100	0.05~0.2	14	面铣(Surface milling)
50mm	300	6000	3500~4000	0~2	16	溝铣(Slotting)
50mm	300	6000	2600~3200	2~6	16	溝铣(Slotting)
50mm	300	6000	2000~2400	6~12	16	溝铣(Slotting)
50mm	300	6000	1700~2100	39	0.05~0.2	側铣(Side milling)
50mm	300	6000	3500~4000	16	0~2	側铣(Side milling)
50mm	300	6000	2600~3200	16	2~6	側铣(Side milling)
50mm	300	6000	2000~2400	16	6~12	側铣(Side milling)

設計屬於精銑和粗銑兩用刀具，其效能為AES的70%。

ly designed for both Finishing and Roughing. It can reach 70% performance of AES.
