



<Be used under the machine of RPM=10000(min⁻¹)>



<Be used under the machine of RPM=20000(min⁻¹)>

被切削材 Work Material	鋁合金 : Aluminum Alloy 7075								5052 / 6061 /	被切削材 Work Material	鋁合金 : Aluminum Alloy 6061 / 7075								5052 /
	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.	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	
AES0203	14mm	60	9500~10000	2600~3000	0-0.2	0.5~2	溝銑(Slotting)	AES0203	14mm	115	18000~20000	4400~4800	0-0.2	0.5~2	溝銑(Slotting)				
AES0203	14mm	60	9500~10000	1800~2200	0.3~0.6	0.5~2	溝銑(Slotting)	AES0203	14mm	115	18000~20000	3400~3800	0.3~0.6	0.5~2	溝銑(Slotting)				
AES0203	14mm	60	9500~10000	1000~1300	0.7~1	0.5~2	溝銑(Slotting)	AES0203	14mm	115	18000~20000	2400~2800	0.7~1	0.5~2	溝銑(Slotting)				
AES0203	14mm	60	9500~10000	1800~2200	0.05~0.08	0.5~2	溝銑(Slotting)	AES0203	14mm	115	18000~20000	2400~2800	0.05~0.08	0.5~2	溝銑(Slotting)				
AES0203	14mm	60	9500~10000	2800~3200	4	0~0.2	側銑(Side milling)	AES0203	14mm	115	18000~20000	4000~4400	4	0~0.2	側銑(Side milling)				
AES0203	14mm	60	9500~10000	1800~2200	4	0.3~0.6	側銑(Side milling)	AES0203	14mm	115	18000~20000	3000~3400	4	0.3~0.6	側銑(Side milling)				
AES0203	14mm	60	9500~10000	1000~1400	4	0.7~1	側銑(Side milling)	AES0203	14mm	115	18000~20000	2000~2400	4	0.7~1	側銑(Side milling)				
AES0203	14mm	60	9500~10000	1200~1600	4	0.05~0.08	側銑(Side milling)	AES0203	14mm	115	18000~20000	2400~2800	4	0.05~0.08	側銑(Side milling)				
AES0303	16mm	90	9500~10000	3000~3500	0~0.4	1~3	溝銑(Slotting)	AES0303	16mm	160	17000~18000	4400~4800	0~0.4	1~3	溝銑(Slotting)				
AES0303	16mm	90	9500~10000	2200~2700	0.5~0.8	1~3	溝銑(Slotting)	AES0303	16mm	160	17000~18000	3400~3800	0.5~0.8	1~3	溝銑(Slotting)				
AES0303	16mm	90	9500~10000	1200~1600	0.9~1.2	1~3	溝銑(Slotting)	AES0303	16mm	160	17000~18000	2400~2800	0.9~1.2	1~3	溝銑(Slotting)				
AES0303	16mm	90	9500~10000	1500~2000	0.05~0.1	1~3	溝銑(Slotting)	AES0303	16mm	160	17000~18000	2400~2800	0.05~0.1	1~3	溝銑(Slotting)				
AES0303	16mm	90	9500~10000	3000~3500	6	0~0.4	側銑(Side milling)	AES0303	16mm	160	17000~18000	4000~4400	6	0~0.4	側銑(Side milling)				
AES0303	16mm	90	9500~10000	2200~2700	6	0.5~0.8	側銑(Side milling)	AES0303	16mm	160	17000~18000	3000~3400	6	0.5~0.8	側銑(Side milling)				
AES0303	16mm	90	9500~10000	1200~1600	6	0.9~1.2	側銑(Side milling)	AES0303	16mm	160	17000~18000	2000~2400	6	0.9~1.2	側銑(Side milling)				
AES0303	16mm	90	9500~10000	1400~1800	6	0.05~0.1	側銑(Side milling)	AES0303	16mm	160	17000~18000	2400~2800	6	0.05~0.1	側銑(Side milling)				
AES0403	16mm	120	9500~10000	4000~4500	0~0.6	2~4	溝銑(Slotting)	AES0403	16mm	175	14000~15000	4800~5300	0~0.6	2~4	溝銑(Slotting)				
AES0403	16mm	120	9500~10000	2500~3000	0.7~1.2	2~4	溝銑(Slotting)	AES0403	16mm	150	12000~13000	3200~3700	0.7~1.2	2~4	溝銑(Slotting)				
AES0403	16mm	120	9500~10000	1500~2000	1.3~2	2~4	溝銑(Slotting)	AES0403	16mm	150	12000~13000	2200~2700	1.3~2	2~4	溝銑(Slotting)				
AES0403	16mm	120	9500~10000	1500~2000	0.05~0.12	2~4	溝銑(Slotting)	AES0403	16mm	200	16000~17000	3000~3500	0.05~0.12	2~4	溝銑(Slotting)				
AES0403	16mm	120	9500~10000	4000~4500	8	0~0.6	側銑(Side milling)	AES0403	16mm	175	14000~15000	4800~5300	8	0~0.6	側銑(Side milling)				
AES0403	16mm	120	9500~10000	2500~3000	8	0.7~1.2	側銑(Side milling)	AES0403	16mm	150	12000~13000	3200~3700	8	0.7~1.2	側銑(Side milling)				
AES0403	16mm	120	9500~10000	1500~2000	8	1.3~2	側銑(Side milling)	AES0403	16mm	150	12000~13000	2200~2700	8	1.3~2	側銑(Side milling)				
AES0403	16mm	120	9500~10000	1400~1800	8	0.05~0.12	側銑(Side milling)	AES0403	16mm	150	12000~13000	1600~2000	8	0.05~0.12	側銑(Side milling)				
AES0503	16mm	150	9500~10000	4500~5000	0~0.7	3~5	溝銑(Slotting)	AES0503	16mm	235	15000~16000	5500~6000	0~0.7	3~5	溝銑(Slotting)				
AES0503	16mm	150	9500~10000	2500~3000	0.8~1.5	3~5	溝銑(Slotting)	AES0503	16mm	190	12000~13000	3500~4000	0.8~1.5	3~5	溝銑(Slotting)				
AES0503	16mm	150	9500~10000	1500~2000	1.6~3.5	3~5	溝銑(Slotting)	AES0503	16mm	190	12000~13000	2500~3000	1.6~3.5	3~5	溝銑(Slotting)				
AES0503	16mm	150	9500~10000	1800~2200	0.05~0.15	3~5	溝銑(Slotting)	AES0503	16mm	235	15000~16000	3000~3500	0.05~0.15	3~5	溝銑(Slotting)				
AES0503	16mm	150	9500~10000	4500~5000	10	0~0.7	側銑(Side milling)	AES0503	16mm	205	13000~14000	5500~6000	10	0~0.7	側銑(Side milling)				
AES0503	16mm	150	9500~10000	3000~3500	10	0.8~1.5	側銑(Side milling)	AES0503	16mm	190	12000~13000	3500~4000	10	0.8~1.5	側銑(Side milling)				
AES0503	16mm	150	9500~10000	1500~2000	10	1.6~3.5	側銑(Side milling)	AES0503	16mm	190	12000~13000	2500~3000	10	1.6~3.5	側銑(Side milling)				
AES0503	16mm	150	9500~10000	1600~2000	10	0.05~0.15	側銑(Side milling)	AES0503	16mm	205	13000~14000	2200~2600	10	0.05~0.15	側銑(Side milling)				
AES0603	20mm	170	9000~9500	5000~5500	0~1	4~6	溝銑(Slotting)	AES0603	20mm	305	16000~17000	6500~7500	0~1	4~6	溝銑(Slotting)				
AES0603	20mm	170	9000~9500	3800~4300	2~3	4~6	溝銑(Slotting)	AES0603	20mm	285	15000~16000	5000~5500	2~3	4~6	溝銑(Slotting)				
AES0603	20mm	170	9000~9500	3000~3500	3.5~6	4~6	溝銑(Slotting)	AES0603	20mm	285	15000~16000	3800~4300	3.5~6	4~6	溝銑(Slotting)				
AES0603	20mm	170	9000~9500	1800~2200	0.05~0.15	4~6	溝銑(Slotting)	AES0603	20mm	305	16000~17000	3000~3500	0.05~0.15	4~6	溝銑(Slotting)				
AES0603	20mm	170	9000~9500	5000~5500	12	0~1	側銑(Side milling)	AES0603	20mm	305	16000~17000	6500~7500	12	0~1	側銑(Side milling)				
AES0603	20mm	170	9000~9500	3800~4300	12	2~3	側銑(Side milling)	AES0603	20mm	285	15000~16000	4500~5000	12	2~3	側銑(Side milling)				
AES0603	20mm	170	9000~9500	2400~2800	12	3.5~6	側銑(Side milling)	AES0603	20mm	285	15000~16000	3000~3500	12	3.5~6	側銑(Side milling)				
AES0603	20mm	170	9000~9500	1800~2200	12	0.05~0.15	側銑(Side milling)	AES0603	20mm	305	16000~17000	2800~3200	12	0.05~0.15	側銑(Side milling)				
AES0803	25mm	215	8500~9000	5000~5500	0~1.5	6~8	溝銑(Slotting)	AES0803	25mm	355	14000~15000	6000~6500	0~1.5	6~8	溝銑(Slotting)				
AES0803	25mm	215	8500~9000	3500~4000	2~4	6~8	溝銑(Slotting)	AES0803	25mm	355	14000~15000	4500~5000	2~4	6~8	溝銑(Slotting)				
AES0803	25mm	215	8500~9000	2500~3000	5~8	6~8	溝銑(Slotting)	AES0803	25mm	355	14000~15000	3000~3500	5~8	6~8	溝銑(Slotting)				
AES0803	25mm	215	8500~9000	1800~2300	0.05~0.15	6~8	溝銑(Slotting)	AES0803	25mm	355	14000~15000	2600~3000	0.05~0.15	6~8	溝銑(Slotting)				
AES0803	25mm	215	8500~9000	5000~5500	16	0~2	側銑(Side milling)	AES0803	25mm	330	13000~14000	6500~7500	16	0~2	側銑(Side milling)				
AES0803	25mm	215	8500~9000	4000~4500	16	2.5~4	側銑(Side milling)	AES0803	25mm	330	13000~14000	5000~5500	16	2.5~4	側銑(Side milling)				
AES0803	25mm	215	8500~9000	2500~3000	16	5~8	側銑(Side milling)	AES0803	25mm	330	13000~14000	3000~3500	16	5~8	側銑(Side milling)				
AES0803	25mm	215	8500~9000	1800~2300	16	0.05~0.15	側銑(Side milling)	AES0803	25mm	305	12000~13000	2400~2800	16	0.05~0.15	側銑(Side milling)				
AES1003	30mm	245	7800~8200	5500~6000	0~2	8~10	溝銑(Slotting)	AES1003	30mm	380	12000~13000	6500~7000	0~2	8~10	溝銑(Slotting)				
AES1003	30mm	245	7800~8200	3000~3500	3~5	8~10	溝銑(Slotting)	AES1003	30mm	315	10000~11000	3500~4000	3~5	8~10	溝銑(Slotting)				
AES1003	30mm	245	7800~8200	2000~2500	6~10	8~10	溝銑(Slotting)	AES1003	30mm	315	10000~11000	3000~3500	6~10	8~10	溝銑(Slotting)				
AES1003	30mm	245	7800~8200	2000~2400	0.05~0.15	8~10	溝銑(Slotting)	AES1003	30mm	380	12000~13000	3000~3500	0.05~0.15	8~10	溝銑(Slotting)				
AES1003	30mm	245	7800~8200	5500~6000	20	0~2	側銑(Side milling)	AES1003	30mm	380	12000~13000	7000~8000	20	0~2	側銑(Side milling)				
AES1003	30mm	245	7800~8200	2800~3300	20	3~5	側銑(Side milling)	AES1003	30mm	315	10000~11000	3500~4000	20	3~5	側銑(Side milling)				
AES1003	30mm	245	7800~8200	1200~1600	20	6~10	側銑(Side milling)	AES1003	30mm	315	10000~11000	2000~2500	20	6~10	側銑(Side milling)				
AES1003	30mm	245	7800~8200	1400~1800	20	0.05~0.15	側銑(Side milling)	AES1003	30mm	380	12000~13000	2800~3200	20	0.05~0.15	側銑(Side milling)				
AES1203	35mm	295	7800~8200	6000~6500	0~2	10~12	溝銑(Slotting)	AES1203	35mm	295	7800~8200	6000~6500	0~2	10~12	溝銑(Slotting)				
AES1203	35mm	295	7800~8200	3500~4000	3~6	10~12	溝銑(Slotting)	AES1203	35mm	295	7800~8200	3500~4000	3~6	10~12	溝銑(Slotting)				
AES1203	35mm	295	7800~8200	2800~3300	7~12	10~12	溝銑(Slotting)	AES1203	35mm	295	7800~8200	2800~3300	7~12	10~12	溝銑(Slotting)				
AES1203	35mm	295	7800~8200	2000~2400	0.05~0.15	10~12	溝銑(Slotting)	AES1203	35mm	295	7800~8200	2000~2400	0.05~0.15	10~12	溝銑(Slotting)				
AES1203	35mm	295	7800~8200	5500~6000	24	0~2	側銑(Side milling)	AES1203	35mm	295	7800~8200	5500~6000	24	0~2	側銑(Side milling)				
AES1203	35mm	295	7800~8200	3500~4000	24	3~6	側銑(Side milling)	AES1203	35mm	295	7800~8200	3500~4000	24	3~6	側銑(Side milling)				
AES1203	35mm	295	7800~8200	2800~3300	24	7~12	側銑(Side milling)	AES1203	35mm	295	7800~8200	2800~3300	24	7~12	側銑(Side milling)				
AES1203	35mm	295	7800~8200	2000~2400	24	0.05~0.15	側銑(Side milling)	AES1203	35mm	295	7800~8200	2000~2400	24	0.05~0.15	側銑(Side milling)				
AES1603	55mm	325	6200~6700	3500~4000	0~2	14~16	溝銑(Slotting)	AES1603	55mm	325	6200~6700	3500~4000	0~2	14~16	溝銑(Slotting)				
AES1603	55mm	325	6200~6700	2500~3000	3~6	14~16	溝銑(Slotting)	AES1603	55mm	325	6200~6700	2500~3000	3~6	14~16	溝銑(Slotting)				
AES1603	55mm	325	6200~6700	1700~2200	7~12	14~16	溝銑(Slotting)	AES1603	55mm	325	6200~6700	1700~2200	7~12	14~16	溝銑(Slotting)				
AES1603	55mm	325	6200~6700	1400~1800	0.05~0.2	14~16	溝銑(Slotting)	AES1603	55mm	325	6200~6700								