



<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		
AET0052	13mm	15	9500~10000	500~700	0.04~0.06	0.1~0.5	溝銑(Slotting)	AET0052	13mm	30	18000~20000	600~800	0.04~0.06	0.1~0.5	溝銑(Slotting)		
AET0052	13mm	15	9500~10000	300~500	1	0.04~0.06	側銑(Side milling)	AET0052	13mm	30	18000~20000	400~600	1	0.04~0.06	側銑(Side milling)		
AET0102	13mm	30	9500~10000	800~1000	0.05~0.08	0.5~1	溝銑(Slotting)	AET0102	13mm	60	18000~20000	1200~1400	0.05~0.08	0.5~1	溝銑(Slotting)		
AET0102	13mm	30	9500~10000	600~800	2	0.05~0.08	側銑(Side milling)	AET0102	13mm	60	18000~20000	1000~1200	2	0.05~0.08	側銑(Side milling)		
AET0152	13mm	45	9500~10000	1000~1200	0.05~0.08	0.5~1.5	溝銑(Slotting)	AET0152	13mm	85	18000~20000	1400~1600	0.05~0.08	0.5~1.5	溝銑(Slotting)		
AET0152	13mm	45	9500~10000	800~1000	3	0.05~0.08	側銑(Side milling)	AET0152	13mm	85	18000~20000	1200~1400	3	0.05~0.08	側銑(Side milling)		
AET0202	14mm	60	9500~10000	1800~2200	0~0.2	0.5~2	溝銑(Slotting)	AET0202	14mm	110	17000~18000	2200~2600	0~0.2	0.5~2	溝銑(Slotting)		
AET0202	14mm	60	9500~10000	1000~1200	0.05~0.08	0.5~2	溝銑(Slotting)	AET0202	14mm	110	17000~18000	1400~1600	0.05~0.08	0.5~2	溝銑(Slotting)		
AET0202	14mm	60	9500~10000	2000~2400	4	0~0.2	側銑(Side milling)	AET0202	14mm	110	17000~18000	2600~3000	4	0~0.2	側銑(Side milling)		
AET0202	14mm	60	9500~10000	800~1000	4	0.05~0.08	側銑(Side milling)	AET0202	14mm	110	17000~18000	1400~1600	4	0.05~0.08	側銑(Side milling)		
AET0302	14mm	90	9500~10000	2200~2600	0~0.4	1~3	溝銑(Slotting)	AET0302	14mm	160	17000~18000	2600~3000	0~0.4	1~3	溝銑(Slotting)		
AET0302	14mm	90	9500~10000	1000~1400	0.05~0.1	1~3	溝銑(Slotting)	AET0302	14mm	160	17000~18000	1800~2200	0.05~0.1	1~3	溝銑(Slotting)		
AET0302	14mm	90	9500~10000	2600~3000	6	0~0.4	側銑(Side milling)	AET0302	14mm	160	17000~18000	3000~3400	6	0~0.4	側銑(Side milling)		
AET0302	14mm	90	9500~10000	800~1200	6	0.05~0.1	側銑(Side milling)	AET0302	14mm	160	17000~18000	1600~2000	6	0.05~0.1	側銑(Side milling)		
AET0402	16mm	120	9500~10000	2800~3200	0~0.6	2~4	溝銑(Slotting)	AET0402	16mm	200	16000~17000	3400~3800	0~0.6	2~4	溝銑(Slotting)		
AET0402	16mm	120	9500~10000	1200~1600	0.05~0.12	2~4	溝銑(Slotting)	AET0402	16mm	200	16000~17000	2000~2400	0.05~0.12	2~4	溝銑(Slotting)		
AET0402	16mm	120	9500~10000	3000~3400	8	0~0.6	側銑(Side milling)	AET0402	16mm	200	16000~17000	3400~3800	8	0~0.6	側銑(Side milling)		
AET0402	16mm	120	9500~10000	1000~1400	8	0.05~0.12	側銑(Side milling)	AET0402	16mm	200	16000~17000	1600~2000	8	0.05~0.12	側銑(Side milling)		
AET0502	18mm	150	9500~10000	3400~3800	0~0.7	3~5	溝銑(Slotting)	AET0502	18mm	235	15000~16000	4400~4800	0~0.7	3~5	溝銑(Slotting)		
AET0502	18mm	150	9500~10000	1400~1800	0.05~0.15	3~5	溝銑(Slotting)	AET0502	18mm	235	15000~16000	2400~2800	0.05~0.15	3~5	溝銑(Slotting)		
AET0502	18mm	150	9500~10000	3400~3800	10	0~0.7	側銑(Side milling)	AET0502	18mm	235	15000~16000	4400~4800	10	0~0.7	側銑(Side milling)		
AET0502	18mm	150	9500~10000	1000~1400	10	0.05~0.15	側銑(Side milling)	AET0502	18mm	235	15000~16000	1600~2000	10	0.05~0.15	側銑(Side milling)		
AET0602	20mm	170	9000~9500	3400~3800	0~1	4~6	溝銑(Slotting)	AET0602	20mm	285	15000~16000	4400~4800	0~1	4~6	溝銑(Slotting)		
AET0602	20mm	170	9000~9500	1400~1800	0.05~0.15	4~6	溝銑(Slotting)	AET0602	20mm	285	15000~16000	2400~2800	0.05~0.15	4~6	溝銑(Slotting)		
AET0602	20mm	170	9000~9500	3400~3800	12	0~1	側銑(Side milling)	AET0602	20mm	285	15000~16000	4400~4800	12	0~1	側銑(Side milling)		
AET0602	20mm	170	9000~9500	1000~1400	12	0.05~0.15	側銑(Side milling)	AET0602	20mm	285	15000~16000	1600~2000	12	0.05~0.15	側銑(Side milling)		
AET0802	26mm	215	8500~9000	3400~3800	0~1.5	6~8	溝銑(Slotting)	AET0802	26mm	355	14000~15000	4500~5000	0~1.5	6~8	溝銑(Slotting)		
AET0802	26mm	215	8500~9000	1600~2000	0.05~0.15	6~8	溝銑(Slotting)	AET0802	26mm	355	14000~15000	2200~2600	0.05~0.15	6~8	溝銑(Slotting)		
AET0802	26mm	215	8500~9000	3600~4000	16	0~2	側銑(Side milling)	AET0802	26mm	355	14000~15000	5000~5500	16	0~2	側銑(Side milling)		
AET0802	26mm	215	8500~9000	1400~1800	16	0.05~0.15	側銑(Side milling)	AET0802	26mm	355	14000~15000	2000~2400	16	0.05~0.15	側銑(Side milling)		
AET1002	30mm	245	7800~8200	4000~4500	0~2	8~10	溝銑(Slotting)	AET1002	30mm	380	12000~13000	5500~6000	0~2	8~10	溝銑(Slotting)		
AET1002	30mm	245	7800~8200	1400~1800	0.05~0.15	8~10	溝銑(Slotting)	AET1002	30mm	380	12000~13000	2000~2400	0.05~0.15	8~10	溝銑(Slotting)		
AET1002	30mm	245	7800~8200	4000~4500	20	0~2	側銑(Side milling)	AET1002	30mm	380	12000~13000	6000~6500	20	0~2	側銑(Side milling)		
AET1002	30mm	245	7800~8200	1400~1800	20	0.05~0.15	側銑(Side milling)	AET1002	30mm	380	12000~13000	1800~2200	20	0.05~0.15	側銑(Side milling)		
AET1202	36mm	295	7800~8200	4000~4500	0~2	10~12	溝銑(Slotting)	AET1202	36mm	295	7800~8200	4000~4500	0~2	10~12	溝銑(Slotting)		
AET1202	36mm	295	7800~8200	1200~1600	0.05~0.15	10~12	溝銑(Slotting)	AET1202	36mm	295	7800~8200	1200~1600	0.05~0.15	10~12	溝銑(Slotting)		
AET1202	36mm	295	7800~8200	3200~3600	24	0~2	側銑(Side milling)	AET1202	36mm	295	7800~8200	3200~3600	24	0~2	側銑(Side milling)		
AET1202	36mm	295	7800~8200	1200~1600	24	0.05~0.15	側銑(Side milling)	AET1202	36mm	295	7800~8200	1200~1600	24	0.05~0.15	側銑(Side milling)		

附註 / Note:

建議冷卻方式為濕式。

Suggest to use Wet coolant.

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