



&lt;Be used under the machine

被切削材 Work Material	鋁合金 : Aluminum Alloy 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
AET0203	14mm	60	9500~10000	2200~2600	0~0.2	0.5~2
AET0203	14mm	60	9500~10000	1200~1600	0.05~0.08	0.5~2
AET0203	14mm	60	9500~10000	2400~2800	4	0~0.2
AET0203	14mm	60	9500~10000	1200~1600	4	0.05~0.08
AET0303	16mm	90	9500~10000	2800~3200	0~0.4	1~3
AET0303	16mm	90	9500~10000	1600~2000	0.05~0.1	1~3
AET0303	16mm	90	9500~10000	3000~3400	6	0~0.4
AET0303	16mm	90	9500~10000	1400~1800	6	0.05~0.1
AET0403	18mm	115	9000~9500	3400~3800	0~0.6	2~4
AET0403	18mm	115	9000~9500	1600~2000	0.05~0.12	2~4
AET0403	18mm	115	9000~9500	3400~3800	8	0~0.6
AET0403	18mm	115	9000~9500	1400~1800	8	0.05~0.12
AET0503	20mm	125	7800~8300	3800~4200	0~0.7	3~5
AET0503	20mm	125	7800~8300	1600~2000	0.05~0.15	3~5
AET0503	20mm	125	7800~8300	3800~4200	10	0~0.7
AET0503	20mm	125	7800~8300	1200~1600	10	0.05~0.15
AET0603	22mm	150	7800~8200	4200~4600	0~0.9	4~6
AET0603	22mm	150	7800~8200	1600~2000	0.05~0.15	4~6
AET0603	22mm	150	7800~8200	4200~4600	12	0~0.9
AET0603	22mm	150	7800~8200	1600~2000	12	0.05~0.15
AET0803	26mm	175	7000~7500	3000~3400	0~1.5	6~8
AET0803	26mm	215	8500~9000	1800~2200	0.05~0.15	6~8
AET0803	26mm	215	8500~9000	1600~2000	16	0~1
AET0803	26mm	215	8500~9000	1600~2000	16	0.05~0.15
AET1003	30mm	245	7800~8200	4500~5000	0~2	8~10
AET1003	30mm	245	7800~8200	1600~2000	0.05~0.15	8~10
AET1003	30mm	245	7800~8200	4000~4500	20	0~2
AET1003	30mm	245	7800~8200	1600~2000	20	0.05~0.15
AET1203	36mm	295	7800~8200	5000~5500	0~2	10~12
AET1203	36mm	295	7800~8200	1600~2000	0.05~0.15	10~12
AET1203	36mm	295	7800~8200	4500~5000	24	0~2
AET1203	36mm	295	7800~8200	1600~2000	24	2
AET1603	55mm	325	6400~6800	4400~4800	0~2	14~16
AET1603	55mm	325	6400~6800	1400~1800	0.05~0.2	14~16

AET1603	55mm	325	6400~6800	4600~5000	32	0~2
AET1603	55mm	325	6400~6800	1400~1800	32	0.05~0.2
附註 / Note:						
建議冷卻方式為濕式。						
Suggest to use Wet coolant.						



> of RPM=10000(mm<sup>-1</sup>)<

<Be used

5052 / 6061 /		被切削材 Work Material		鋁合金 : Aluminum Alloy 6061 / 7075		
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 <sup>-1</sup> )	進給速度 Feed (mm/min)	加工深度(Aa) Depth of Cut
溝銑(Slotting)	AET0203	14mm	115	18000~20000	3400~3800	0~0.2
溝銑(Slotting)	AET0203	14mm	115	18000~20000	1800~2200	0.05~0.08
側銑(Side milling)	AET0203	14mm	115	18000~20000	3400~3800	4
側銑(Side milling)	AET0203	14mm	115	18000~20000	1800~2200	4
溝銑(Slotting)	AET0303	16mm	160	17000~18000	3800~4200	0~0.4
溝銑(Slotting)	AET0303	16mm	160	17000~18000	2400~2800	0.05~0.1
側銑(Side milling)	AET0303	16mm	160	17000~18000	3800~4200	6
側銑(Side milling)	AET0303	16mm	160	17000~18000	2000~2400	6
溝銑(Slotting)	AET0403	18mm	165	13000~14000	4200~4600	0~0.6
溝銑(Slotting)	AET0403	18mm	165	13000~14000	2400~2800	0.05~0.12
側銑(Side milling)	AET0403	18mm	165	13000~14000	4200~4600	8
側銑(Side milling)	AET0403	18mm	165	13000~14000	2000~2400	8
溝銑(Slotting)	AET0503	20mm	175	11000~12000	5000~5400	0~0.7
溝銑(Slotting)	AET0503	20mm	175	11000~12000	2600~3000	0.05~0.15
側銑(Side milling)	AET0503	20mm	175	11000~12000	5000~5400	10
側銑(Side milling)	AET0503	20mm	175	11000~12000	1800~2200	10
溝銑(Slotting)	AET0603	22mm	255	13000~14000	6000~6500	0~0.9
溝銑(Slotting)	AET0603	22mm	255	13000~14000	2400~2800	0.05~0.15
側銑(Side milling)	AET0603	22mm	255	13000~14000	6500~7500	12
側銑(Side milling)	AET0603	22mm	255	13000~14000	2200~2600	12
溝銑(Slotting)	AET0803	26mm	280	11000~12000	4000~4500	0~1
溝銑(Slotting)	AET0803	26mm	355	14000~15000	2400~2800	0.05~0.15
側銑(Side milling)	AET0803	26mm	355	14000~15000	2800~3200	16
側銑(Side milling)	AET0803	26mm	355	14000~15000	2200~2600	16
溝銑(Slotting)	AET1003	30mm	360	11000~12000	5500~6000	0~2
溝銑(Slotting)	AET1003	30mm	360	11000~12000	2400~2800	0.05~0.15
側銑(Side milling)	AET1003	30mm	360	11000~12000	5500~6000	20
側銑(Side milling)	AET1003	30mm	360	11000~12000	2200~2600	20
溝銑(Slotting)	AET1203	36mm	295	7800~8200	5000~5500	0~2
溝銑(Slotting)	AET1203	36mm	295	7800~8200	1600~2000	0.05~0.15
側銑(Side milling)	AET1203	36mm	295	7800~8200	4500~5000	24
側銑(Side milling)	AET1203	36mm	295	7800~8200	1600~2000	24
溝銑(Slotting)	AET1603	55mm	325	6400~6800	4400~4800	0~2
溝銑(Slotting)	AET1603	55mm	325	6400~6800	1400~1800	0.05~0.2

側銑(Side milling)	AET1603	55mm	325	6400~6800	4600~5000	32
側銑(Side milling)	AET1603	55mm	325	6400~6800	1400~1800	32
	附註 / Note:					
	建議冷卻方式為濕式。					
	Suggest to use Wet coolant.					

under the machine of RPM=20000(min<sup>-1</sup>)>

5052 /

加工寬度(Ap) Width of Cut	加工方式 Milling Type
0.5~2	溝銑(Slotting)
0.5~2	溝銑(Slotting)
0~0.2	側銑(Side milling)
0.05~0.08	側銑(Side milling)
1~3	溝銑(Slotting)
1~3	溝銑(Slotting)
0~0.4	側銑(Side milling)
0.05~0.1	側銑(Side milling)
2~4	溝銑(Slotting)
2~4	溝銑(Slotting)
0~0.6	側銑(Side milling)
0.05~0.12	側銑(Side milling)
3~5	溝銑(Slotting)
3~5	溝銑(Slotting)
0~0.7	側銑(Side milling)
0.05~0.15	側銑(Side milling)
4~6	溝銑(Slotting)
4~6	溝銑(Slotting)
0~0.9	側銑(Side milling)
0.05~0.15	側銑(Side milling)
6~8	溝銑(Slotting)
6~8	溝銑(Slotting)
0~1	側銑(Side milling)
0.05~0.15	側銑(Side milling)
8~10	溝銑(Slotting)
8~10	溝銑(Slotting)
0~2	側銑(Side milling)
0.05~0.15	側銑(Side milling)
10~12	溝銑(Slotting)
10~12	溝銑(Slotting)
0~2	側銑(Side milling)
2	側銑(Side milling)
14~16	溝銑(Slotting)
14~16	溝銑(Slotting)

0~2	側銑(Side milling)
0.05~0.2	側銑(Side milling)