



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



<Be used under the machine of RPM=24000(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		
BTC0102	10mm	30	9500~10000	400~600	0.15~0.18	0.3~0.36	3D銑(3D milling)	BTC0102	10mm	75	23000~24000	600~800	0.15~0.18	0.3~0.36	3D銑(3D milling)		
BTC0102	10mm	30	9500~10000	800~1200	0.08~0.11	0.15~0.18	3D銑(3D milling)	BTC0102	10mm	75	23000~24000	1000~1400	0.08~0.11	0.15~0.18	3D銑(3D milling)		
BTC0102	10mm	30	9500~10000	1400~1800	0.03~0.05	0.05~0.08	3D銑(3D milling)	BTC0102	10mm	75	23000~24000	1800~2200	0.03~0.05	0.05~0.08	3D銑(3D milling)		
BTC0152	12mm	45	9500~10000	400~600	0.15~0.18	0.3~0.36	3D銑(3D milling)	BTC0152	12mm	105	22000~23000	600~800	0.15~0.18	0.3~0.36	3D銑(3D milling)		
BTC0152	12mm	45	9500~10000	1000~1400	0.08~0.11	0.15~0.18	3D銑(3D milling)	BTC0152	12mm	105	22000~23000	1400~1800	0.08~0.11	0.15~0.18	3D銑(3D milling)		
BTC0152	12mm	45	9500~10000	1800~2200	0.03~0.05	0.05~0.08	3D銑(3D milling)	BTC0152	12mm	105	22000~23000	2200~2600	0.03~0.05	0.05~0.08	3D銑(3D milling)		
BTC0202	12mm	60	9000~9500	600~1000	0.2~0.25	0.45~0.5	3D銑(3D milling)	BTC0202	12mm	125	20000~22000	800~1200	0.2~0.25	0.45~0.5	3D銑(3D milling)		
BTC0202	12mm	60	9000~9500	1200~1600	0.1~0.13	0.2~0.25	3D銑(3D milling)	BTC0202	12mm	125	20000~22000	1600~2000	0.1~0.13	0.2~0.25	3D銑(3D milling)		
BTC0202	12mm	60	9000~9500	2200~2600	0.04~0.06	0.06~0.1	3D銑(3D milling)	BTC0202	12mm	125	20000~22000	2600~3000	0.04~0.06	0.06~0.1	3D銑(3D milling)		
BTC0302	14mm	85	9000~9500	800~1200	0.25~0.3	0.5~0.6	3D銑(3D milling)	BTC0302	14mm	160	17000~19000	1100~1500	0.25~0.3	0.5~0.6	3D銑(3D milling)		
BTC0302	14mm	85	9000~9500	1500~1900	0.12~0.15	0.23~0.28	3D銑(3D milling)	BTC0302	14mm	160	17000~19000	1800~2200	0.12~0.15	0.23~0.28	3D銑(3D milling)		
BTC0302	14mm	85	9000~9500	2400~2800	0.05~0.07	0.8~0.12	3D銑(3D milling)	BTC0302	14mm	160	17000~19000	2800~3200	0.05~0.07	0.8~0.12	3D銑(3D milling)		
BTC0402	14mm	115	9000~9500	1000~1400	0.3~0.35	0.7~0.8	3D銑(3D milling)	BTC0402	14mm	200	16000~17000	1400~1800	0.3~0.35	0.7~0.8	3D銑(3D milling)		
BTC0402	14mm	115	9000~9500	2000~2400	0.15~0.18	0.3~0.4	3D銑(3D milling)	BTC0402	14mm	200	16000~17000	2600~3000	0.15~0.18	0.3~0.4	3D銑(3D milling)		
BTC0402	14mm	115	9000~9500	2600~3000	0.06~0.08	0.1~0.13	3D銑(3D milling)	BTC0402	14mm	200	16000~17000	3000~3400	0.06~0.08	0.1~0.13	3D銑(3D milling)		
BTC0602	20mm	160	8500~9000	1200~1600	0.5~0.6	1~1.5	3D銑(3D milling)	BTC0602	20mm	285	15000~16000	1600~2000	0.5~0.6	1~1.5	3D銑(3D milling)		
BTC0602	20mm	160	8500~9000	2400~2800	0.2~0.25	0.4~0.5	3D銑(3D milling)	BTC0602	20mm	285	15000~16000	2800~3200	0.2~0.25	0.4~0.5	3D銑(3D milling)		
BTC0602	20mm	170	9000~9500	3000~3400	0.08~0.1	0.12~0.15	3D銑(3D milling)	BTC0602	20mm	285	15000~16000	3400~3800	0.08~0.1	0.12~0.15	3D銑(3D milling)		
BTC0802	25mm	200	8000~8500	1400~1800	0.7~1	2~2.5	3D銑(3D milling)	BTC0802	25mm	330	13000~14000	2000~2400	0.7~1	2~2.5	3D銑(3D milling)		
BTC0802	25mm	200	8000~8500	2600~3000	0.25~0.3	0.5~0.6	3D銑(3D milling)	BTC0802	25mm	330	13000~14000	3600~4000	0.25~0.3	0.5~0.6	3D銑(3D milling)		
BTC0802	25mm	230	9000~9500	3200~3600	0.08~0.13	0.15~0.2	3D銑(3D milling)	BTC0802	25mm	330	13000~14000	4200~4600	0.08~0.13	0.15~0.2	3D銑(3D milling)		
BTC1002	35mm	255	8000~8500	1600~2000	0.8~1.3	2~2.5	3D銑(3D milling)	BTC1002	35mm	315	10000~11000	2000~2400	0.8~1.3	2~2.5	3D銑(3D milling)		
BTC1002	35mm	255	8000~8500	3400~3800	0.3~0.35	0.7~0.8	3D銑(3D milling)	BTC1002	35mm	380	12000~13000	4000~4400	0.3~0.35	0.7~0.8	3D銑(3D milling)		
BTC1002	35mm	285	9000~9500	3000~3400	0.1~0.15	0.18~0.23	3D銑(3D milling)	BTC1002	35mm	380	12000~13000	3800~4200	0.1~0.15	0.18~0.23	3D銑(3D milling)		
BTC1202	40mm	290	7700~8200	1600~2000	1~1.5	2.5~3.5	3D銑(3D milling)	BTC1202	40mm	415	11000~12000	2400~2800	1~1.5	2.5~3.5	3D銑(3D milling)		
BTC1202	40mm	290	7700~8200	2800~3200	0.4~0.45	0.8~1	3D銑(3D milling)	BTC1202	40mm	415	11000~12000	3800~4200	0.4~0.45	0.8~1	3D銑(3D milling)		
BTC1202	40mm	290	7700~8200	3800~4200	0.13~0.16	0.2~0.25	3D銑(3D milling)	BTC1202	40mm	415	11000~12000	4200~4600	0.13~0.16	0.2~0.25	3D銑(3D milling)		

附註 / Note:

建議冷卻方式為濕式。

Suggest to use Wet coolant.

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