

被切削材 Work Material	鋁合金 : Aluminum Alloy 5052 / 6061 / 7075						
型號 Type NO.	刀具伸長量 Extension Length	切削速度 (m/min) Cutting Speed	迴轉速度 Speed (min ⁻¹)	進給速度 Feed (mm/min)	加工深度(Aa) Cut of depth	加工寬度(Ap) Cut of width	加工方式 Milling Type
DC0202	9mm	60	9000~9500	900~1300	0.05~0.08	1.5~2	溝銑(Slotting)
DC0202	9mm	60	9000~9500	1300~1700	0.1~0.2	2	溝銑(Slotting)
DC0202	9mm	60	9000~9500	800~1100	0.4~0.6	2	溝銑(Slotting)
DC0202	9mm	60	9000~9500	1000~1400	2~4	0.05~0.08	側銑(Side milling)
DC0202	9mm	60	9000~9500	1500~1900	2~4	0.2~0.3	側銑(Side milling)
DC0302	12mm	85	8500~9000	900~1300	0.05~0.1	2.5~3	溝銑(Slotting)
DC0302	12mm	85	8500~9000	1300~1700	0.2~0.4	3	溝銑(Slotting)
DC0302	12mm	85	8500~9000	800~1100	0.4~0.8	3	溝銑(Slotting)
DC0302	12mm	85	8500~9000	1000~1400	3~6	0.05~0.1	側銑(Side milling)
DC0302	12mm	85	8500~9000	1500~1900	3~6	0.4~0.6	側銑(Side milling)
DC0402	15mm	110	8500~9000	900~1300	0.05~0.12	3~4	溝銑(Slotting)
DC0402	15mm	110	8500~9000	1300~1700	0.3~0.6	4	溝銑(Slotting)
DC0402	15mm	110	8500~9000	800~1100	0.6~1.2	4	溝銑(Slotting)
DC0402	15mm	110	8500~9000	1000~1400	4~8	0.05~0.12	側銑(Side milling)
DC0402	15mm	110	8500~9000	1500~1900	4~8	0.5~0.7	側銑(Side milling)
DC0502	19mm	140	8500~9000	1100~1500	0.05~0.12	4~5	溝銑(Slotting)
DC0502	19mm	140	8500~9000	2000~2400	0.4~0.7	5	溝銑(Slotting)
DC0502	19mm	140	8500~9000	1100~1500	0.7~1.5	5	溝銑(Slotting)
DC0502	19mm	140	8500~9000	1000~1400	5~10	0.05~0.12	側銑(Side milling)
DC0502	19mm	140	8500~9000	1500~1900	5~10	0.7~1	側銑(Side milling)
DC0602	21mm	165	8500~9000	1200~1600	0.05~0.15	5~6	溝銑(Slotting)
DC0602	21mm	165	8500~9000	2000~2400	0.5~1	6	溝銑(Slotting)
DC0602	21mm	165	8500~9000	1000~1400	1~2	6	溝銑(Slotting)
DC0602	21mm	165	8500~9000	1000~1400	6~12	0.05~0.15	側銑(Side milling)
DC0602	21mm	165	8500~9000	1800~2200	6~12	0.8~1.2	側銑(Side milling)
DC0802	25mm	200	7800~8300	1200~1600	0.05~0.15	6~8	溝銑(Slotting)
DC0802	25mm	200	7800~8300	2000~2400	1~1.5	8	溝銑(Slotting)
DC0802	25mm	200	7800~8300	1000~1400	2~3	8	溝銑(Slotting)
DC0802	25mm	200	7800~8300	1000~1400	8~16	0.05~0.15	側銑(Side milling)
DC0802	25mm	200	7800~8300	1800~2200	8~16	1~1.5	側銑(Side milling)
DC1002	30mm	250	7800~8300	1200~1600	0.05~0.15	8~10	溝銑(Slotting)
DC1002	30mm	250	7800~8300	2000~2400	1~1.5	10	溝銑(Slotting)
DC1002	30mm	250	7800~8300	1000~1400	2~3	10	溝銑(Slotting)
DC1002	30mm	250	7800~8300	1000~1400	10~20	0.05~0.15	側銑(Side milling)
DC1002	30mm	250	7800~8300	1800~2200	10~20	1~1.5	側銑(Side milling)
DC1202	35mm	225	5800~6300	1200~1600	0.05~0.15	10~12	溝銑(Slotting)
DC1202	35mm	225	5800~6300	2000~2400	1~1.5	12	溝銑(Slotting)
DC1202	35mm	225	5800~6300	1000~1400	2~3	12	溝銑(Slotting)
DC1202	35mm	225	5800~6300	1000~1400	12~24	0.05~0.15	側銑(Side milling)
DC1202	35mm	225	5800~6300	1800~2200	12~24	1~1.5	側銑(Side milling)
DC1602	55mm	225	4200~4700	800~1200	0.05~0.15	14~16	溝銑(Slotting)
DC1602	55mm	225	4200~4700	1400~1800	1~1.5	14~16	溝銑(Slotting)
DC1602	55mm	225	4200~4700	800~1200	2~3	14~16	溝銑(Slotting)
DC1602	55mm	225	4200~4700	700~1100	16~32	0.05~0.15	側銑(Side milling)
DC1602	55mm	225	4200~4700	1400~1800	16~32	1~1.5	側銑(Side milling)
DC2002	65mm	225	3300~3800	700~1100	0.05~0.15	18~20	溝銑(Slotting)
DC2002	65mm	225	3300~3800	1200~1600	1~1.5	18~20	溝銑(Slotting)
DC2002	65mm	225	3300~3800	800~1200	2~3	18~20	溝銑(Slotting)
DC2002	65mm	225	3300~3800	700~1100	20~40	0.05~0.15	側銑(Side milling)
DC2002	65mm	225	3300~3800	1200~1600	20~40	1.5~2	側銑(Side milling)