



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
DC0203	14mm	60	9500~10000	600~1000	0.05~0.1	2	溝銑(Slotting)
DC0203	14mm	60	9500~10000	1000~1400	0,2	2	溝銑(Slotting)
DC0203	14mm	60	9500~10000	600~1000	2	0.05~0.1	側銑(Side milling)
DC0203	14mm	60	9500~10000	1200~1600	2	0,4	側銑(Side milling)
DC0203	14mm	60	9500~10000	400~800	4	0.05~0.1	側銑(Side milling)
DC0203	14mm	60	9500~10000	700~1100	4	0,2	側銑(Side milling)
DC0303	16mm	90	9500~10000	700~1100	0.05~0.1	3	溝銑(Slotting)
DC0303	16mm	90	9500~10000	1200~1600	0,3	3	溝銑(Slotting)
DC0303	16mm	90	9500~10000	700~1100	3	0.05~0.1	側銑(Side milling)
DC0303	16mm	90	9500~10000	1400~1800	3	0,4	側銑(Side milling)
DC0303	16mm	90	9500~10000	400~800	6	0.05~0.1	側銑(Side milling)
DC0303	16mm	90	9500~10000	800~1200	6	0,3	側銑(Side milling)
DC0403	16mm	120	9500~10000	800~1200	0.05~0.1	4	溝銑(Slotting)
DC0403	16mm	120	9500~10000	1200~1600	0,4	4	溝銑(Slotting)
DC0403	16mm	120	9500~10000	800~1200	4	0.05~0.1	側銑(Side milling)
DC0403	16mm	120	9500~10000	1400~1800	4	0,4	側銑(Side milling)
DC0403	16mm	120	9500~10000	400~800	8	0.05~0.1	側銑(Side milling)
DC0403	16mm	120	9500~10000	800~1200	8	0,4	側銑(Side milling)
DC0503	16mm	155	9500~10000	800~1200	0.05~0.15	5	溝銑(Slotting)
DC0503	16mm	155	9500~10000	1400~1800	0,4	5	溝銑(Slotting)
DC0503	16mm	155	9500~10000	800~1200	5	0.05~0.15	側銑(Side milling)
DC0503	16mm	155	9500~10000	1600~2000	5	0,4	側銑(Side milling)
DC0503	16mm	155	9500~10000	400~800	10	0.05~0.15	側銑(Side milling)
DC0503	16mm	155	9500~10000	1000~1400	10	0,4	側銑(Side milling)
DC0603	20mm	175	9000~9500	800~1200	0.05~0.15	6	溝銑(Slotting)
DC0603	20mm	185	9500~10000	1600~2000	0,5	6	溝銑(Slotting)
DC0603	20mm	175	9000~9500	800~1200	6	0.05~0.15	側銑(Side milling)
DC0603	20mm	185	9500~10000	1800~2200	6	0,5	側銑(Side milling)
DC0603	20mm	175	9000~9500	600~800	12	0.05~0.15	側銑(Side milling)
DC0603	20mm	185	9500~10000	1200~1600	12	0,5	側銑(Side milling)
DC0803	25mm	230	8800~9300	1000~1400	0.05~0.15	8	溝銑(Slotting)
DC0803	25mm	230	8800~9300	1800~2200	0,5	8	溝銑(Slotting)
DC0803	25mm	230	8800~9300	1000~1400	8	0.05~0.15	側銑(Side milling)
DC0803	25mm	230	8800~9300	2000~2400	8	0,5	側銑(Side milling)
DC0803	25mm	230	9500~10000	800~1200	8	1	側銑(Side milling)
DC0803	25mm	245	8800~9300	800~1200	16	0.05~0.15	側銑(Side milling)
DC0803	25mm	230	8800~9300	1400~1800	16	0,5	側銑(Side milling)
DC1003	30mm	285	8800~9300	1000~1400	0.05~0.15	10	溝銑(Slotting)
DC1003	30mm	285	8800~9300	2000~2400	0,5	10	溝銑(Slotting)
DC1003	30mm	285	8800~9300	1000~1400	10	0.05~0.15	側銑(Side milling)
DC1003	30mm	285	8800~9300	1600~2000	10	0,5~1	側銑(Side milling)
DC1003	30mm	285	8800~9300	1000~1400	10	1,5~2	側銑(Side milling)
DC1003	30mm	285	8800~9300	800~1200	20	0.05~0.15	側銑(Side milling)
DC1003	30mm	285	8800~9300	600~1000	20	0,5~1	側銑(Side milling)
DC1203	35mm	275	7000~7500	800~1200	0.05~0.15	12	溝銑(Slotting)
DC1203	35mm	275	7000~7500	1600~2000	0,5	12	溝銑(Slotting)
DC1203	35mm	275	7000~7500	1000~1400	12	0.05~0.15	側銑(Side milling)
DC1203	35mm	275	7000~7500	1600~2000	12	0,5	側銑(Side milling)
DC1203	35mm	275	7000~7500	1200~1600	12	1~1,5	側銑(Side milling)
DC1203	35mm	275	7000~7500	800~1200	24	0.05~0.15	側銑(Side milling)
DC1203	35mm	275	7000~7500	800~1200	24	1~1,5	側銑(Side milling)
DC1603	55mm	265	5000~5500	600~1000	0.05~0.15	16	溝銑(Slotting)
DC1603	55mm	265	5000~5500	1000~1400	0,5	16	溝銑(Slotting)
DC1603	55mm	265	5000~5500	600~1000	16	0.05~0.15	側銑(Side milling)
DC1603	55mm	265	5000~5500	1000~1400	16	0,5	側銑(Side milling)
DC1603	55mm	265	5000~5500	400~800	32	0.05~0.15	側銑(Side milling)
DC1603	55mm	265	5000~5500	300~700	32	0,5	側銑(Side milling)