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 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
HBC0402	35mm	100	8000~8500	1200~1600	0.09~0.18	0.18~0.3	3D銑(3D milling)
HBC0402	35mm	115	9000~9500	1800~2200	0.06~0.08	0.1~0.15	3D銑(3D milling)
HBC0502	35mm	120	7300~7800	1400~1800	0.15~0.22	0.38~0.48	3D銑(3D milling)
HBC0502	35mm	130	8000~8500	2000~2400	0.05~0.1	0.1~0.15	3D銑(3D milling)
HBC0602	35mm	130	6700~7200	1400~1800	0.15~0.25	0.3~0.5	3D銑(3D milling)
HBC0602	35mm	150	7700~8200	2000~2400	0.05~0.1	0.12~0.16	3D銑(3D milling)
IBC0402	50mm	85	6700~7200	1000~1400	0.09~0.18	0.18~0.3	3D銑(3D milling)
IBC0402	50mm	100	8000~8500	1600~2000	0.06~0.08	0.1~0.15	3D銑(3D milling)
IBC0602	50mm	120	6000~6500	1200~1600	0.15~0.25	0.3~0.5	3D銑(3D milling)
IBC0602	50mm	140	7200~7600	1800~2200	0.05~0.1	0.12~0.16	3D銑(3D milling)
IBC0802	50mm	200	8000~8500	2000~2400	0.25~0.3	0.5~0.6	3D銑(3D milling)
IBC0802	50mm	230	9000~9500	3200~3600	0.08~0.13	0.15~0.2	3D銑(3D milling)
IBC1002	60mm	255	8000~8500	3600~4000	0.3~0.35	0.7~0.8	3D銑(3D milling)
IBC1002	60mm	285	9000~9500	3000~3400	0.1~0.15	0.18~0.23	3D銑(3D milling)
IBC1202	60mm	290	7700~8200	3000~3400	0.35~0.4	0.8~1	3D銑(3D milling)
IBC1202	60mm	290	7700~8200	3000~3400	0.13~0.16	0.2~0.25	3D銑(3D milling)
JBC0602	80mm	120	4700~5200	1600~2000	0.1~0.2	0.2~0.4	3D銑(3D milling)
JBC0602	80mm	180	9000~9500	2000~2400	0.05~0.1	0.12~0.16	3D銑(3D milling)
JBC0802	80mm	120	4700~5200	2000~2400	0.25~0.3	0.5~0.6	3D銑(3D milling)
JBC0802	80mm	230	9000~9500	3000~3400	0.08~0.13	0.15~0.2	3D銑(3D milling)
JBC1002	100mm	125	4000~4400	1200~1600	0.1~0.15	0.18~0.23	3D銑(3D milling)
JBC1002	100mm	285	9000~9500	3000~3400	0.1~0.15	0.18~0.23	3D銑(3D milling)
JBC1202	100mm	85	2000~2400	800~1000	0.35~0.4	0.8~1	3D銑(3D milling)
JBC1202	100mm	150	3700~4200	1800~2200	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.