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AEW 彩虹立銑刀

1. 抗震好，穩定性佳。
2. 獨特的斷屑設計，不易黏屑，排屑順暢。
3. 高進給、大切深，縮短加工時間。
4. 切深在1D以上，削鐵如泥。

1. Low vibration and high stability.
2. Special design features smooth chip removal and low stickiness.
3. High Feed and large Depth of cutting; shorten milling times.
4. Depth of cutting is over 1D, and the endmill is very easy to cut.

AES 高效能鋁用立銑刀

1. 獨特的刀刃設計，表面光潔度佳。
2. 獨特的溝槽設計，粗、精銑適用。
3. 高進給、大切深。

1. Unique flute design enables the optimum surface finishing.
2. Special grooving concept is suitable for Roughing and Finishing millings.
3. High Feed and large Depth of cutting.

鋁合金側銑加工表面光潔度實例
Demonstration for side milling with optimum surface finishing on Aluminum alloy

AES

AET-3T

AEA-3T

AET-2T

AEA-2T

DHF Design . Honesty . Future

目錄
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品名 Product	AER	AESR	AEA-2T	AEA-3T
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品名 Product	AET-2T	AET-3T	BTC	HBC IBC JBC
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圖示說明
Guide Line to Icons

切削性能 CUTTING PERFORMANCE

優
Excellent

良
Good

尚可
Acceptable

禁止
No

鎢鋼種類 CARBIDE

超微粒。
Micro grain.

極超微粒。
Super micro grain.

顆粒大小 GRAIN SIZE

粉末顆粒是0.4 μm
Grain size is 0.4 μm.

粉末顆粒是0.6 μm
Grain size is 0.6 μm.

螺旋角 HELIX ANGLE

螺旋角度25°、40°、45°、55°
Helix Angle is 25°,40°,45°,55°.

圓隅角 CORNER R

圓隅角。
Corner Radius.

刃數 FLUTE

鍍層 COATING

適用於銅加工，有良好表面光潔度及刀具壽命。
Good at copper machining. With benefits of surface finishing and long tool life.

齒形 ROUGHING

大粗齒
Big Roughing.

縮頸 SHRINK NECK

適用於深溝加工
Best for long neck machine.

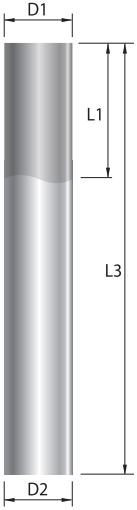
彩虹立銑刀
End Mills

AEW

精銑 Finishing
中銑 Semi-finishing
粗銑 Roughing

乾式切削 Dry Machining
油霧切削 MQL (Mist)
水溶性切削 Emulsion Machining
油性切削 Oil Machining

MG | 0.6 μm | Roughing | 45° | 3 Flutes



公差表 TOLERANCE

直徑 D1	直徑公差值 D1 Tolerance
6.0	0 -0.025
8.0	0 -0.025
10.0	0 -0.03
12.0	0 -0.035
16.0	0 -0.04
20.0	0 -0.04

柄徑 D2	柄徑公差值 D2 Tolerance
Ø6	0 -0.008
Ø8	0 -0.009
Ø10	0 -0.009
Ø12	0 -0.011
Ø16	0 -0.011
Ø20	0 -0.013

unit : mm

產品規格 SPECIFICATIONS

型號 Type No.	D1 直徑 Diameter	L1 刃長 Flute Length	L3 全長 O.A.L.	D2 柄徑 Shank Dia.
AEW0603	6.0	16	50	6
AEW0803	8.0	20	60	8
AEW0803L	8.0	25	80	8
AEW1003	10.0	22	75	10
AEW1003L	10.0	30	80	10
AEW1203	12.0	26	75	12
AEW1203L	12.0	35	100	12
AEW1603	16.0	40	100	16
AEW1603L	16.0	50	120	16
AEW2003	20.0	45	100	20
AEW2003L	20.0	55	120	20

unit : mm

★ AEW的切削數據請查閱P.13~16 Please find the milling condition on P.13~16

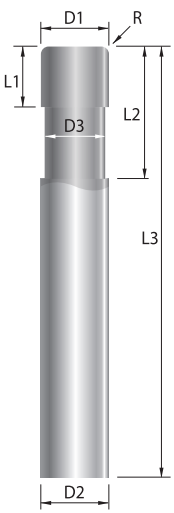
彩虹圓鼻角立銑刀
End Mills
Corner Radius

AEWR

精銑 Finishing
中銑 Semi-finishing
粗銑 Roughing

乾式切削 Dry Machining
油霧切削 MQL (Mist)
水溶性切削 Emulsion Machining
油性切削 Oil Machining

MG | 0.6 μm | Roughing | 45° | R | 3 Flutes



公差表 TOLERANCE

直徑 D1	R徑公差值 R Tolerance	直徑公差值 D1 Tolerance
6.0	$^{+0.02}_{0}$	$^{0}_{-0.02}$
8.0	$^{+0.02}_{0}$	$^{0}_{-0.02}$
10.0	$^{+0.02}_{0}$	$^{0}_{-0.02}$
12.0	$^{+0.02}_{0}$	$^{0}_{-0.02}$
16.0	$^{+0.02}_{0}$	$^{0}_{-0.03}$
20.0	$^{+0.02}_{0}$	$^{0}_{-0.03}$

柄徑 D2	柄徑公差值 D2 Tolerance
Ø6	$^{0}_{-0.008}$
Ø8	$^{0}_{-0.009}$
Ø10	$^{0}_{-0.009}$
Ø12	$^{0}_{-0.011}$
Ø16	$^{0}_{-0.011}$
Ø20	$^{0}_{-0.013}$

unit : mm

產品規格 SPECIFICATIONS

型號 Type No.	D1 直徑 Diameter	D3 頸徑 Neck Dia.	R R角 Corner R	L1 刃長 Flute Length	L2 有效長 Effective Length	L3 全長 O.A.L.	D2 柄徑 Shank Dia.
AEWR0605	6.0	5.8	0.5	8	18	50	6
AEWR0805	8.0	7.7	0.5	10	24	60	8
AEWR1005	10.0	9.6	0.5	12	30	75	10
AEWR1205	12.0	11.5	0.5	15	36	75	12
AEWR1610	16.0	15.5	1.0	24	40	120	16
AEWR2010	20.0	19.0	1.0	30	50	120	20

unit : mm

★ AEWR的切削數據請查閱P.17~18 Please find the milling condition on P.17~18

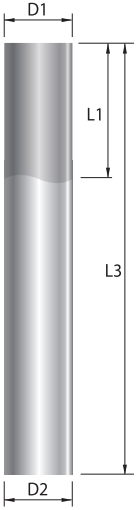
高效能 鋁用立銑刀 End Mills

AES

精銑 Finishing
中銑 Semi-finishing
粗銑 Roughing

乾式切削 Dry Machining
油霧切削 MQL (Mist)
水溶性切削 Emulsion Machining
油性切削 Oil Machining

Super MG | 0.4 μm | 40° | 3 Flutes



公差表 TOLERANCE

直徑 D1	直徑公差值 D1 Tolerance
2.0	$^{0}_{-0.02}$
3.0	$^{0}_{-0.02}$
4.0	$^{0}_{-0.02}$
5.0	$^{0}_{-0.02}$
6.0	$^{0}_{-0.02}$
8.0	$^{0}_{-0.02}$
10.0	$^{0}_{-0.02}$
12.0	$^{0}_{-0.02}$
16.0	$^{0}_{-0.03}$
20.0	$^{0}_{-0.03}$

柄徑 D2	柄徑公差值 D2 Tolerance
Ø6	$^{0}_{-0.008}$
Ø8	$^{0}_{-0.009}$
Ø10	$^{0}_{-0.009}$
Ø12	$^{0}_{-0.011}$
Ø16	$^{0}_{-0.011}$
Ø20	$^{0}_{-0.013}$

unit : mm

產品規格 SPECIFICATIONS

型號 Type No.	D1 直徑 Diameter	L1 刃長 Flute Length	L3 全長 O.A.L.	D2 柄徑 Shank Dia.
AES0203S	2.0	6	50	4
AES0203	2.0	6	50	6
AES0303S	3.0	8	50	4
AES0303	3.0	8	50	6
AES0403S	4.0	11	50	4
AES0403	4.0	11	50	6
AES0503	5.0	13	50	6
AES0603	6.0	16	50	6
AES0603L	6.0	32	75	6
AES0803	8.0	20	60	8
AES0803L	8.0	45	100	8
AES1003	10.0	25	75	10
AES1003L	10.0	50	100	10
AES1203	12.0	30	75	12
AES1203L	12.0	55	100	12
AES1603	16.0	40	100	16
AES1603L	16.0	50	120	16
AES2003	20.0	45	100	20
AES2003L	20.0	60	120	20

unit : mm

★ AES的切削數據請查閱P.19~24 Please find the milling condition on P.19~24

新產品 NEW PRODUCT

無現貨，需下單後塗層
Coating after order.

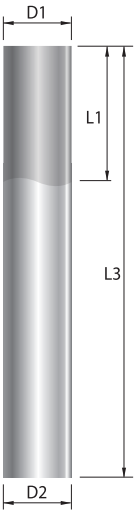
高效能 鋁用立銑刀 End Mills

AES+

- 精銑 Finishing
- 中銑 Semi-finishing
- 粗銑 Roughing

- 乾式切削 Dry Machining
- 油霧切削 MQL (Mist)
- 水溶性切削 Emulsion Machining
- 油性切削 Oil Machining

Super MG | 0.4 μm | 40° | 3 Flutes | DLC



公差表 TOLERANCE

直徑 D1	直徑公差值 D1 Tolerance
2.0	$^{0}_{-0.02}$
3.0	$^{0}_{-0.02}$
4.0	$^{0}_{-0.02}$
5.0	$^{0}_{-0.02}$
6.0	$^{0}_{-0.02}$
8.0	$^{0}_{-0.02}$
10.0	$^{0}_{-0.02}$
12.0	$^{0}_{-0.02}$
16.0	$^{0}_{-0.03}$
20.0	$^{0}_{-0.03}$

柄徑 D2	柄徑公差值 D2 Tolerance
Ø6	$^{0}_{-0.008}$
Ø8	$^{0}_{-0.009}$
Ø10	$^{0}_{-0.009}$
Ø12	$^{0}_{-0.011}$
Ø16	$^{0}_{-0.011}$
Ø20	$^{0}_{-0.013}$

unit : mm

產品規格 SPECIFICATIONS

型號 Type No.	D1 直徑 Diameter	L1 刃長 Flute Length	L3 全長 O.A.L.	D2 柄徑 Shank Dia.
AES0203S+	2.0	6	50	4
AES0203+	2.0	6	50	6
AES0303S+	3.0	8	50	4
AES0303+	3.0	8	50	6
AES0403S+	4.0	11	50	4
AES0403+	4.0	11	50	6
AES0503+	5.0	13	50	6
AES0603+	6.0	16	50	6
AES0603L+	6.0	32	75	6
AES0803+	8.0	20	60	8
AES0803L+	8.0	45	100	8
AES1003+	10.0	25	75	10
AES1003L+	10.0	50	100	10
AES1203+	12.0	30	75	12
AES1203L+	12.0	55	100	12
AES1603+	16.0	40	100	16
AES1603L+	16.0	50	120	16
AES2003+	20.0	45	100	20
AES2003L+	20.0	60	120	20

unit : mm

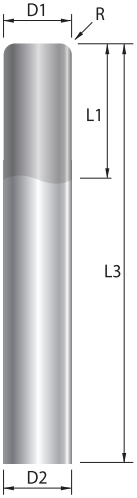
鋁用圓鼻角立銑刀
End Mills
Corner Radius

AER

精銑 Finishing
中銑 Semi-finishing
粗銑 Roughing

乾式切削 Dry Machining
油霧切削 MQL (Mist)
水溶性切削 Emulsion Machining
油性切削 Oil Machining

MG | 0.6 μm | 45° | R | 3 Flutes



公差表 TOLERANCE

直徑 D1	R徑公差值 R Tolerance	直徑公差值 D1 Tolerance
2.0	+0.02 0	0 -0.02
3.0	+0.02 0	0 -0.02
4.0	+0.02 0	0 -0.02
6.0	+0.02 0	0 -0.02
8.0	+0.02 0	0 -0.02
10.0	+0.02 0	0 -0.02

柄徑 D2	柄徑公差值 D2 Tolerance
Ø6	0 -0.008
Ø8	0 -0.009
Ø10	0 -0.009

unit : mm

產品規格 SPECIFICATIONS

型號 Type No.	D1 直徑 Diameter	R R角 Corner R	L1 刃長 Flute Length	L3 全長 O.A.L.	D2 柄徑 Shank Dia.
AER0202	2.0	0.2	6	50	6
AER0302	3.0	0.2	10	50	6
AER0402	4.0	0.2	12	50	6
AER0603	6.0	0.3	18	50	6
AER0805	8.0	0.5	20	60	8
AER1005	10.0	0.5	30	75	10

unit : mm

★ AER的切削數據請查閱P.25~26 Please find the milling condition on P.25~26

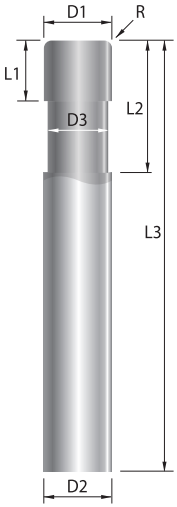
高效能鋁用 圓鼻角立銑刀
End Mills
Corner Radius

AESR

精銑 Finishing
中銑 Semi-finishing
粗銑 Roughing

乾式切削 Dry Machining
油霧切削 MQL (Mist)
水溶性切削 Emulsion Machining
油性切削 Oil Machining

Super MG | 0.4 μm | 40° | R | 3 Flutes



公差表 TOLERANCE

直徑 D1	R徑公差值 R Tolerance	直徑公差值 D1 Tolerance
3.0	$^{+0.02}_{0}$	$^{0}_{-0.02}$
4.0	$^{+0.02}_{0}$	$^{0}_{-0.02}$
6.0	$^{+0.02}_{0}$	$^{0}_{-0.02}$
8.0	$^{+0.02}_{0}$	$^{0}_{-0.02}$
10.0	$^{+0.02}_{0}$	$^{0}_{-0.02}$
12.0	$^{+0.02}_{0}$	$^{0}_{-0.02}$
16.0	$^{+0.02}_{0}$	$^{0}_{-0.03}$
20.0	$^{+0.02}_{0}$	$^{0}_{-0.03}$

柄徑 D2	柄徑公差值 D2 Tolerance
Ø6	$^{0}_{-0.008}$
Ø8	$^{0}_{-0.009}$
Ø10	$^{0}_{-0.009}$
Ø12	$^{0}_{-0.011}$
Ø16	$^{0}_{-0.011}$
Ø20	$^{0}_{-0.013}$

unit : mm

產品規格 SPECIFICATIONS

型號 Type No.	D1 直徑 Diameter	D3 頸徑 Neck Dia.	R R角 Corner R	L1 刃長 Flute Length	L2 有效長 Effective Length	L3 全長 O.A.L.	D2 柄徑 Shank Dia.
AESR0305	3.0	2.9	0.5	4.5	9	50	6
AESR0405	4.0	3.9	0.5	6.0	12	50	6
AESR0605	6.0	5.8	0.5	9.0	18	60	6
AESR0610	6.0	5.8	1.0	9.0	18	60	6
AESR0805	8.0	7.7	0.5	12.0	24	60	8
AESR0810	8.0	7.7	1.0	12.0	24	60	8
AESR1005	10.0	9.6	0.5	15.0	30	75	10
AESR1010	10.0	9.6	1.0	15.0	30	75	10
AESR1205	12.0	11.5	0.5	18.0	36	75	12
AESR1210	12.0	11.5	1.0	18.0	36	75	12
AESR1605	16.0	15.5	0.5	24.0	40	120	16
AESR1610	16.0	15.5	1.0	24.0	40	120	16
AESR1630	16.0	15.5	3.0	24.0	40	120	16
AESR2005	20.0	19.0	0.5	30.0	50	120	20
AESR2010	20.0	19.0	1.0	30.0	50	120	20
AESR2030	20.0	19.0	3.0	30.0	50	120	20

unit : mm

★ AESR的切削數據請查閱P.27~29 Please find the milling condition on P.27~29

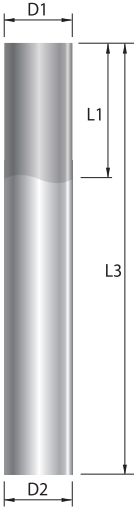
鋁用立銑刀
End Mills

AEA-2T

精銑 Finishing
中銑 Semi-finishing
粗銑 Roughing

乾式切削 Dry Machining
油霧切削 MQL (Mist)
水溶性切削 Emulsion Machining
油性切削 Oil Machining

MG | 0.6 μm | 55° | 2 Flutes



公差表 TOLERANCE

直徑 D1	直徑公差值 D1 Tolerance
0.5	$^{0}_{-0.02}$
1.0	$^{0}_{-0.02}$
1.5	$^{0}_{-0.02}$
2.0	$^{0}_{-0.02}$
3.0	$^{0}_{-0.02}$
4.0	$^{0}_{-0.02}$
5.0	$^{0}_{-0.02}$
6.0	$^{0}_{-0.02}$
8.0	$^{0}_{-0.02}$
10.0	$^{0}_{-0.02}$
12.0	$^{0}_{-0.02}$

柄徑 D2	柄徑公差值 D2 Tolerance
Ø4	$^{0}_{-0.008}$
Ø6	$^{0}_{-0.008}$
Ø8	$^{0}_{-0.009}$
Ø10	$^{0}_{-0.009}$
Ø12	$^{0}_{-0.011}$

unit : mm

產品規格 SPECIFICATIONS

型號 Type No.	D1 直徑 Diameter	L1 刃長 Flute Length	L3 全長 O.A.L.	D2 柄徑 Shank Dia.
AEA0052	0.5	1.5	50	4
AEA0102	1.0	3	50	4
AEA0152	1.5	4	50	4
AEA0202	2.0	6	50	4
AEA0302	3.0	8	50	4
AEA0402	4.0	12	50	4
AEA0502	5.0	16	50	6
AEA0602	6.0	18	50	6
AEA0802	8.0	22	60	8
AEA1002	10.0	28	75	10
AEA1202	12.0	30	75	12

unit : mm

★ AEA-2T的切削數據請查閱P.30~33 Please find the milling condition on P.30~33

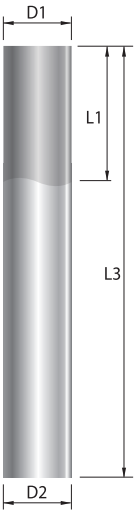
鋁用立銑刀
End Mills

AEA-3T

精銑 Finishing
中銑 Semi-finishing
粗銑 Roughing

乾式切削 Dry Machining
油霧切削 MQL (Mist)
水溶性切削 Emulsion Machining
油性切削 Oil Machining

MG | 0.6 μm | 45° | 3 Flutes



公差表 TOLERANCE

直徑 D1	直徑公差值 D1 Tolerance
2.0	0 -0.02
3.0	0 -0.02
4.0	0 -0.02
5.0	0 -0.02
6.0	0 -0.02
8.0	0 -0.02
10.0	0 -0.02
12.0	0 -0.02
16.0	0 -0.03

柄徑 D2	柄徑公差值 D2 Tolerance
Ø6	0 -0.008
Ø8	0 -0.009
Ø10	0 -0.009
Ø12	0 -0.011
Ø16	0 -0.011

unit : mm

產品規格 SPECIFICATIONS

型號 Type No.	D1 直徑 Diameter	L1 刃長 Flute Length	L3 全長 O.A.L.	D2 柄徑 Shank Dia.
AEA0203	2.0	6	50	6
AEA0303	3.0	10	50	6
AEA0403	4.0	12	50	6
AEA0503	5.0	16	50	6
AEA0603	6.0	18	50	6
AEA0803	8.0	20	60	8
AEA1003	10.0	25	75	10
AEA1203	12.0	30	75	12
AEA1603	16.0	40	100	16

unit : mm

★ AEA-3T的切削數據請查閱P.34~37 Please find the milling condition on P.34~37

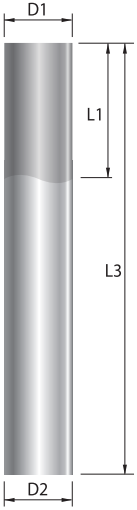
鏡面鋁用立銑刀
End Mills

AET-2T

精銑 Finishing
中銑 Semi-finishing
粗銑 Roughing

乾式切削 Dry Machining
油霧切削 MQL (Mist)
水溶性切削 Emulsion Machining
油性切削 Oil Machining

MG | 0.6 μm | 45° | 2 Flutes



公差表 TOLERANCE

直徑 D1	直徑公差值 D1 Tolerance
0.5	$^{0}_{-0.02}$
1.0	$^{0}_{-0.02}$
1.5	$^{0}_{-0.02}$
2.0	$^{0}_{-0.02}$
3.0	$^{0}_{-0.02}$
4.0	$^{0}_{-0.02}$
5.0	$^{0}_{-0.02}$
6.0	$^{0}_{-0.02}$
8.0	$^{0}_{-0.02}$
10.0	$^{0}_{-0.02}$
12.0	$^{0}_{-0.02}$

柄徑 D2	柄徑公差值 D2 Tolerance
Ø4	$^{0}_{-0.008}$
Ø6	$^{0}_{-0.008}$
Ø8	$^{0}_{-0.009}$
Ø10	$^{0}_{-0.009}$
Ø12	$^{0}_{-0.011}$

unit : mm

產品規格 SPECIFICATIONS

型號 Type No.	D1 直徑 Diameter	L1 刃長 Flute Length	L3 全長 O.A.L.	D2 柄徑 Shank Dia.
AET0052	0.5	1.5	50	4
AET0102	1.0	3	50	6
AET0152	1.5	4	50	6
AET0202	2.0	6	50	6
AET0302	3.0	8	50	6
AET0402	4.0	11	50	6
AET0502	5.0	13	50	6
AET0602	6.0	16	50	6
AET0802	8.0	19	60	8
AET1002	10.0	25	75	10
AET1202	12.0	26	75	12

unit : mm

★ AET-2T的切削數據請查閱P.38~39 Please find the milling condition on P.38~39

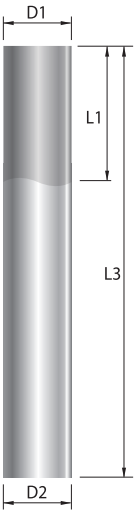
鏡面鋁用立銑刀
End Mills

AET-3T

精銑 Finishing
中銑 Semi-finishing
粗銑 Roughing

乾式切削 Dry Machining
油霧切削 MQL (Mist)
水溶性切削 Emulsion Machining
油性切削 Oil Machining

MG | 0.6 μm | 45° | 3 Flutes



公差表 TOLERANCE

直徑 D1	直徑公差值 D1 Tolerance
2.0	$^{0}_{-0.02}$
3.0	$^{0}_{-0.02}$
4.0	$^{0}_{-0.02}$
5.0	$^{0}_{-0.02}$
6.0	$^{0}_{-0.02}$
8.0	$^{0}_{-0.02}$
10.0	$^{0}_{-0.02}$
12.0	$^{0}_{-0.02}$
16.0	$^{0}_{-0.02}$

柄徑 D2	柄徑公差值 D2 Tolerance
Ø6	$^{0}_{-0.008}$
Ø8	$^{0}_{-0.009}$
Ø10	$^{0}_{-0.009}$
Ø12	$^{0}_{-0.011}$
Ø16	$^{0}_{-0.011}$

unit : mm

產品規格 SPECIFICATIONS

型號 Type No.	D1 直徑 Diameter	L1 刃長 Flute Length	L3 全長 O.A.L.	D2 柄徑 Shank Dia.
AET0203	2.0	6	50	6
AET0303	3.0	10	50	6
AET0403	4.0	12	50	6
AET0503	5.0	16	60	6
AET0603	6.0	18	60	6
AET0803	8.0	20	60	8
AET1003	10.0	25	75	10
AET1203	12.0	30	75	12
AET1603	16.0	40	100	16

unit : mm

★ AET-2T的切削數據請查閱P.40~41 Please find the milling condition on P.40~41

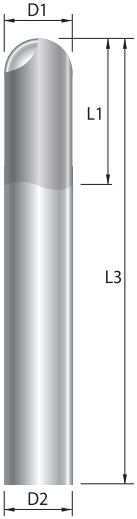
鋁用圓頭立銑刀
Ball Nose End Mills

BTC

精銑 Finishing
中銑 Semi-finishing
粗銑 Roughing

乾式切削 Dry Machining
油霧切削 MQL (Mist)
水溶性切削 Emulsion Machining
油性切削 Oil Machining

MG | 0.6 μm | 25° | 2 Flutes



公差表 TOLERANCE

直徑 D1	球頭公差值 R Tolerance
R0.5	±0.01
R0.75	±0.01
R1	±0.01
R1.5	±0.01
R2	±0.01
R2.5	±0.01
R3	±0.01
R4	±0.01
R5	±0.015
R6	±0.015

柄徑 D2	柄徑公差值 D2 Tolerance
Ø3	$^{0}_{-0.006}$
Ø4	$^{0}_{-0.008}$
Ø6	$^{0}_{-0.008}$
Ø8	$^{0}_{-0.009}$
Ø10	$^{0}_{-0.009}$
Ø12	$^{0}_{-0.011}$

unit : mm

產品規格 SPECIFICATIONS

型號 Type No.	D1 直徑 Diameter	L1 刃長 Flute Length	L3 全長 O.A.L.	D2 柄徑 Shank Dia.
BTC0102	R0.5	2	50	4
BTC0152	R0.75	3	50	4
BTC0202	R1	4	50	4
BTC0302	R1.5	6	50	3
BTC0402	R2	8	50	4
BTC0602	R3	12	50	6
BTC0802	R4	16	60	8
BTC1002	R5	20	75	10
BTC1202	R6	24	75	12

unit : mm

★ BTC的切削數據請查閱P.42~43 Please find the milling condition on P.42~43

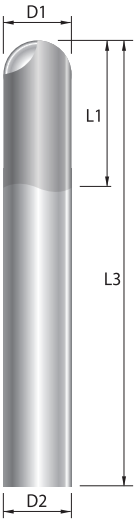
鋁用圓頭立銑刀
Ball Nose End Mills

HBC IBC JBC

精銑 Finishing
中銑 Semi-finishing
粗銑 Roughing

乾式切削 Dry Machining
油霧切削 MQL (Mist)
水溶性切削 Emulsion Machining
油性切削 Oil Machining

MG | 0.6 μm | 25° | 2 Flutes



公差表 TOLERANCE

直徑 D1	球頭公差值 R Tolerance
R2	±0.01
R2.5	±0.01
R3	±0.01
R4	±0.01
R5	±0.015
R6	±0.015

柄徑 D2	柄徑公差值 D2 Tolerance
Ø6	0 -0.008
Ø8	0 -0.009
Ø10	0 -0.009
Ø12	0 -0.011

unit : mm

產品規格 SPECIFICATIONS

型號 Type No.	D1 直徑 Diameter	L1 刃長 Flute Length	L3 全長 O.A.L.	D2 柄徑 Shank Dia.
HBC0402	R2	8	75	6
HBC0502	R2.5	10	75	6
HBC0602	R3	12	75	6
IBC0402	R2	8	100	6
IBC0602	R3	12	100	6
IBC0802	R4	16	100	8
IBC1002	R5	20	100	10
IBC1202	R6	24	100	12
JBC0602	R3	12	150	6
JBC0802	R4	16	150	8
JBC1002	R5	20	150	10
JBC1202	R6	24	150	12

unit : mm

★ HBC IBC JBC的切削數據請查閱P.44 Please find the milling condition on P.44

切削條件表 MILLING CONDITIONS

AEW

被切削材 Work Material	鋁合金 *Aluminum Alloy* : **5052 / 6061 / 7075**	建議機器轉速RPM=10000 (min^{-1}) 以下 Be used under the machine of RPM=10000 (min^{-1})
冷卻方式 Coolant Type	濕式切削 Wet coolant	

型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
AEW0603	20	185	9500~10000	4500~5000	0~1	4~6	溝銑 SLOTTING
AEW0603	20	185	9500~10000	3000~3500	2~3	4~6	溝銑 SLOTTING
AEW0603	20	185	9500~10000	2000~2500	4~6	4~6	溝銑 SLOTTING
AEW0603	20	185	9500~10000	6500~7000	6	0~1	側銑 SIDE MILLING
AEW0603	20	185	9500~10000	4500~5000	6	2~3	側銑 SIDE MILLING
AEW0603	20	185	9500~10000	2000~2500	6	4~6	側銑 SIDE MILLING
AEW0603	20	185	9500~10000	5000~5500	12	0~1	側銑 SIDE MILLING
AEW0603	20	185	9500~10000	2000~2500	12	2~3	側銑 SIDE MILLING
AEW0603	20	185	9500~10000	900~13000	12	4~5	側銑 SIDE MILLING
AEW0803	23	220	8500~9000	6000~6500	0~1.5	6~8	溝銑 SLOTTING
AEW0803	23	220	8500~9000	4000~4500	2~4	6~8	溝銑 SLOTTING
AEW0803	23	220	8500~9000	3000~3500	5~8	6~8	溝銑 SLOTTING
AEW0803	23	220	8500~9000	6000~6500	8	0~2	側銑 SIDE MILLING
AEW0803	23	220	8500~9000	4500~5000	8	3~5	側銑 SIDE MILLING
AEW0803	23	220	8500~9000	3000~3500	8	6~8	側銑 SIDE MILLING
AEW0803	23	220	8500~9000	4000~4500	16	0~2	側銑 SIDE MILLING
AEW0803	23	220	8500~9000	2500~3000	16	3~5	側銑 SIDE MILLING
AEW0803	23	220	8500~9000	1500~2000	16	6~8	側銑 SIDE MILLING
AEW0803L	40	195	7500~8000	4000~4500	8	0~2	側銑 SIDE MILLING
AEW0803L	40	195	7500~8000	2300~2800	8	3~5	側銑 SIDE MILLING
AEW0803L	40	195	7500~8000	1000~1500	8	6~8	側銑 SIDE MILLING
AEW0803L	40	195	7500~8000	3500~4000	16	0~2	側銑 SIDE MILLING
AEW0803L	40	195	7500~8000	1800~2300	16	3~5	側銑 SIDE MILLING
AEW0803L	40	180	7000~7500	1800~2300	22	0~2	側銑 SIDE MILLING
AEW0803L	40	180	7000~7500	1000~1400	22	3~5	側銑 SIDE MILLING
AEW1003	26	250	7800~8300	5000~5500	0~2	8~10	溝銑 SLOTTING
AEW1003	26	250	7800~8300	4000~4500	3~5	8~10	溝銑 SLOTTING
AEW1003	26	250	7800~8300	3000~3500	6~10	8~10	溝銑 SLOTTING
AEW1003	26	250	7800~8300	5500~6000	10	0~2	側銑 SIDE MILLING
AEW1003	26	250	7800~8300	4000~4500	10	3~5	側銑 SIDE MILLING
AEW1003	26	250	7800~8300	3000~3500	10	6~10	側銑 SIDE MILLING
AEW1003	26	250	7800~8300	4000~4500	20	0~2	側銑 SIDE MILLING
AEW1003	26	250	7800~8300	3000~3500	20	3~5	側銑 SIDE MILLING
AEW1003	26	250	7800~8300	2500~3000	20	6~10	側銑 SIDE MILLING
AEW1003L	45	140	4300~4800	2000~2500	0~2	8~10	溝銑 SLOTTING
AEW1003L	45	155	4700~5200	1800~2300	3~5	8~10	溝銑 SLOTTING
AEW1003L	45	155	4700~5200	1000~1500	6~10	8~10	溝銑 SLOTTING
AEW1003L	45	230	7000~7500	4000~4500	10	0~2	側銑 SIDE MILLING
AEW1003L	45	190	5800~6300	2700~3200	10	3~5	側銑 SIDE MILLING
AEW1003L	45	190	5800~6300	1300~1800	10	6~10	側銑 SIDE MILLING

型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
AEW1003L	45	165	5000~5500	2000~2500	20	0~2	側銑 SIDE MILLING
AEW1003L	45	165	5000~5500	800~1300	20	3~5	側銑 SIDE MILLING
AEW1003L	45	165	5000~5500	600~1000	20	6~10	側銑 SIDE MILLING
AEW1003L	45	155	4700~5300	700~1200	28	0~2	側銑 SIDE MILLING
AEW1003L	45	155	4700~5300	500~800	28	3~5	側銑 SIDE MILLING
AEW1203	30	290	7500~8000	4500~5000	0~2	10~12	溝銑 SLOTTING
AEW1203	30	290	7500~8000	3000~3500	3~6	10~12	溝銑 SLOTTING
AEW1203	30	290	7500~8000	2500~3000	7~12	10~12	溝銑 SLOTTING
AEW1203	30	290	7500~8000	3500~4000	12	0~2	側銑 SIDE MILLING
AEW1203	30	290	7500~8000	3000~3500	12	3~6	側銑 SIDE MILLING
AEW1203	30	290	7500~8000	3000~3500	12	7~12	側銑 SIDE MILLING
AEW1203	30	290	7500~8000	4500~5000	24	0~2	側銑 SIDE MILLING
AEW1203	30	290	7500~8000	4000~4500	24	3~6	側銑 SIDE MILLING
AEW1203	30	290	7500~8000	3000~3500	24	7~12	側銑 SIDE MILLING
AEW1203L	55	180	4500~5000	2000~2500	12	0~2	側銑 SIDE MILLING
AEW1203L	55	180	4500~5000	1800~2300	12	3~6	側銑 SIDE MILLING
AEW1203L	55	180	4500~5000	1500~2000	12	7~12	側銑 SIDE MILLING
AEW1203L	55	180	4500~5000	2000~2500	24	0~2	側銑 SIDE MILLING
AEW1203L	55	180	4500~5000	1500~2000	24	3~6	側銑 SIDE MILLING
AEW1203L	55	180	4500~5000	1500~2000	34	0~2	側銑 SIDE MILLING
AEW1203L	55	180	4500~5000	1000~1500	34	3~6	側銑 SIDE MILLING
AEW1603	55	340	6500~7000	2500~3000	3~4	14~16	溝銑 SLOTTING
AEW1603	55	340	6500~7000	1700~2200	6~8	14~16	溝銑 SLOTTING
AEW1603	55	340	6500~7000	1500~2000	10~12	14~16	溝銑 SLOTTING
AEW1603	55	340	6500~7000	4000~4500	16	0~2	側銑 SIDE MILLING
AEW1603	55	340	6500~7000	2700~3200	16	6~8	側銑 SIDE MILLING
AEW1603	55	340	6500~7000	2200~2700	16	10~12	側銑 SIDE MILLING
AEW1603	55	315	6000~6500	2000~2500	32	0~2	側銑 SIDE MILLING
AEW1603	55	315	6000~6500	1800~2300	32	6~8	側銑 SIDE MILLING
AEW1603	55	315	6000~6500	1500~2000	32	10~12	側銑 SIDE MILLING
AEW1603	55	315	6000~6500	2000~2500	48	0~2	側銑 SIDE MILLING
AEW1603	55	315	6000~6500	1000~1500	48	6~8	側銑 SIDE MILLING
AEW1603	55	315	6000~6500	700~1100	48	10~12	側銑 SIDE MILLING
AEW2003	60	340	5200~5700	2200~2700	3~4	18~20	溝銑 SLOTTING
AEW2003	60	340	5200~5700	1400~1900	6~8	18~20	溝銑 SLOTTING
AEW2003	60	340	5200~5700	1100~1500	10~12	18~20	溝銑 SLOTTING
AEW2003	60	340	5200~5700	3000~3500	20	0~2	側銑 SIDE MILLING
AEW2003	60	340	5200~5700	2000~2500	20	6~8	側銑 SIDE MILLING
AEW2003	60	340	5200~5700	1500~2000	20	10~12	側銑 SIDE MILLING
AEW2003	60	315	4800~5300	1700~2200	40	0~2	側銑 SIDE MILLING
AEW2003	60	315	4800~5300	1800~2300	40	6~8	側銑 SIDE MILLING
AEW2003	60	315	4800~5200	1000~1400	40	10~12	側銑 SIDE MILLING

切削條件表 MILLING CONDITIONS

AEW

被切削材 Work Material	鋁合金 *Aluminum Alloy* : **5052 / 6061 / 7075**	建議機器轉速RPM=18000 (min^{-1}) 以下 Be used under the machine of RPM=18000 (min^{-1})
冷卻方式 Coolant Type	濕式切削 Wet coolant	

型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
AEW0603	20	330	17000~18000	6500~7000	0~1	4~6	溝銑 SLOTTING
AEW0603	20	330	17000~18000	5000~5500	2~3	4~6	溝銑 SLOTTING
AEW0603	20	330	17000~18000	4500~5000	4~6	4~6	溝銑 SLOTTING
AEW0603	20	330	17000~18000	8500~9000	6	0~1	側銑 SIDE MILLING
AEW0603	20	330	17000~18000	6000~6500	6	2~3	側銑 SIDE MILLING
AEW0603	20	330	17000~18000	3000~3500	6	4~6	側銑 SIDE MILLING
AEW0603	20	330	17000~18000	7000~7500	12	0~1	側銑 SIDE MILLING
AEW0603	20	330	17000~18000	3000~3500	12	2~3	側銑 SIDE MILLING
AEW0603	20	330	17000~18000	2000~2500	12	4~5	側銑 SIDE MILLING
AEW0803	23	390	15000~16000	7500~8500	0~1.5	6~8	溝銑 SLOTTING
AEW0803	23	390	15000~16000	4500~5000	2~4	6~8	溝銑 SLOTTING
AEW0803	23	390	15000~16000	5500~6500	5~8	6~8	溝銑 SLOTTING
AEW0803	23	390	15000~16000	9000~10000	8	0~2	側銑 SIDE MILLING
AEW0803	23	390	15000~16000	6500~7500	8	3~5	側銑 SIDE MILLING
AEW0803	23	390	15000~16000	5000~5500	8	6~8	側銑 SIDE MILLING
AEW0803	23	390	15000~16000	7500~8500	16	0~2	側銑 SIDE MILLING
AEW0803	23	390	15000~16000	5500~6000	16	3~5	側銑 SIDE MILLING
AEW0803	23	390	15000~16000	4500~5000	16	6~8	側銑 SIDE MILLING
AEW0803L	40	195	7500~8000	4000~4500	8	0~2	側銑 SIDE MILLING
AEW0803L	40	195	7500~8000	2300~2800	8	3~5	側銑 SIDE MILLING
AEW0803L	40	195	7500~8000	1000~1500	8	6~8	側銑 SIDE MILLING
AEW0803L	40	195	7500~8000	3500~4000	16	0~2	側銑 SIDE MILLING
AEW0803L	40	195	7500~8000	1800~2300	16	3~5	側銑 SIDE MILLING
AEW0803L	40	180	7000~7500	1800~2300	22	0~2	側銑 SIDE MILLING
AEW0803L	40	180	7000~7500	1000~1400	22	3~5	側銑 SIDE MILLING
AEW1003	26	390	12000~13000	7000~7500	0~2	8~10	溝銑 SLOTTING
AEW1003	26	390	12000~13000	6500~7000	3~5	8~10	溝銑 SLOTTING
AEW1003	26	390	12000~13000	6000~6500	6~10	8~10	溝銑 SLOTTING
AEW1003	26	485	15000~16000	9000~9500	0~2	8~10	側銑 SIDE MILLING
AEW1003	26	390	12000~13000	7500~8500	10	0~2	側銑 SIDE MILLING
AEW1003	26	390	12000~13000	6000~6500	10	3~5	側銑 SIDE MILLING
AEW1003	26	390	12000~13000	5500~6000	10	6~10	側銑 SIDE MILLING
AEW1003	26	390	12000~13000	5000~5500	20	0~2	側銑 SIDE MILLING
AEW1003	26	390	12000~13000	4000~4500	20	3~5	側銑 SIDE MILLING
AEW1003	26	390	12000~13000	3000~3500	20	6~10	側銑 SIDE MILLING
AEW1003	26	485	15000~16000	7500~8500	10	0~2	側銑 SIDE MILLING
AEW1003	26	485	15000~16000	8500~9000	10	3~5	側銑 SIDE MILLING
AEW1003	26	485	15000~16000	5000~5500	10	6~10	側銑 SIDE MILLING
AEW1003	26	485	15000~16000	5000~5500	20	0~2	側銑 SIDE MILLING
AEW1003	26	485	15000~16000	5000~5500	20	3~5	側銑 SIDE MILLING
AEW1003	26	485	15000~16000	4000~4500	20	6~10	側銑 SIDE MILLING
AEW1003L	45	140	4300~4800	2000~2500	0~2	8~10	溝銑 SLOTTING
AEW1003L	45	155	4700~5200	1800~2300	3~5	8~10	溝銑 SLOTTING

型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
AEW1003L	45	155	4700~5200	1000~1500	6~10	8~10	溝銑 SLOTTING
AEW1003L	45	230	7000~7500	4000~4500	10	0~2	側銑 SIDE MILLING
AEW1003L	45	190	5800~6300	2700~3200	10	3~5	側銑 SIDE MILLING
AEW1003L	45	190	5800~6300	1300~1800	10	6~10	側銑 SIDE MILLING
AEW1003L	45	165	5000~5500	2000~2500	20	0~2	側銑 SIDE MILLING
AEW1003L	45	165	5000~5500	800~1300	20	3~5	側銑 SIDE MILLING
AEW1003L	45	165	5000~5500	600~1000	20	6~10	側銑 SIDE MILLING
AEW1003L	45	155	4700~5300	700~1200	28	0~2	側銑 SIDE MILLING
AEW1003L	45	155	4700~5300	500~800	28	3~5	側銑 SIDE MILLING
AEW1203	30	395	10000~11000	7000~7500	0~2	10~12	溝銑 SLOTTING
AEW1203	30	395	10000~11000	5500~6000	3~6	10~12	溝銑 SLOTTING
AEW1203	30	395	10000~11000	5500~6000	7~12	10~12	溝銑 SLOTTING
AEW1203	30	395	10000~11000	8000~8500	12	0~2	側銑 SIDE MILLING
AEW1203	30	395	10000~11000	4500~5000	12	3~6	側銑 SIDE MILLING
AEW1203	30	395	10000~11000	4500~5000	12	7~12	側銑 SIDE MILLING
AEW1203	30	395	10000~11000	7000~7500	24	0~2	側銑 SIDE MILLING
AEW1203	30	395	10000~11000	4500~5000	24	3~6	側銑 SIDE MILLING
AEW1203	30	395	10000~11000	4500~5000	24	7~12	側銑 SIDE MILLING
AEW1203L	55	180	4500~5000	2000~2500	12	0~2	側銑 SIDE MILLING
AEW1203L	55	180	4500~5000	1800~2300	12	3~6	側銑 SIDE MILLING
AEW1203L	55	180	4500~5000	1500~2000	12	7~12	側銑 SIDE MILLING
AEW1203L	55	180	4500~5000	2000~2500	24	0~2	側銑 SIDE MILLING
AEW1203L	55	180	4500~5000	1500~2000	24	3~6	側銑 SIDE MILLING
AEW1203L	55	180	4500~5000	1500~2000	34	0~2	側銑 SIDE MILLING
AEW1203L	55	180	4500~5000	1000~1500	34	3~6	側銑 SIDE MILLING
AEW1603	55	340	6500~7000	2500~3000	3~4	14~16	溝銑 SLOTTING
AEW1603	55	340	6500~7000	1700~2200	6~8	14~16	溝銑 SLOTTING
AEW1603	55	340	6500~7000	1500~2000	10~12	14~16	溝銑 SLOTTING
AEW1603	55	340	6500~7000	4000~4500	16	0~2	側銑 SIDE MILLING
AEW1603	55	340	6500~7000	2700~3200	16	6~8	側銑 SIDE MILLING
AEW1603	55	340	6500~7000	2200~2700	16	10~12	側銑 SIDE MILLING
AEW1603	55	315	6000~6500	2000~2500	32	0~2	側銑 SIDE MILLING
AEW1603	55	315	6000~6500	1800~2300	32	6~8	側銑 SIDE MILLING
AEW1603	55	315	6000~6500	1500~2000	32	10~12	側銑 SIDE MILLING
AEW1603	55	315	6000~6500	2000~2500	48	0~2	側銑 SIDE MILLING
AEW1603	55	315	6000~6500	1000~1500	48	6~8	側銑 SIDE MILLING
AEW1603	55	315	6000~6500	700~1100	48	10~12	側銑 SIDE MILLING
AEW2003	60	340	5200~5700	2200~2700	3~4	18~20	溝銑 SLOTTING
AEW2003	60	340	5200~5700	1400~1900	6~8	18~20	溝銑 SLOTTING
AEW2003	60	340	5200~5700	1100~1500	10~12	18~20	溝銑 SLOTTING
AEW2003	60	340	5200~5700	3000~3500	20	0~2	側銑 SIDE MILLING
AEW2003	60	340	5200~5700	2000~2500	20	6~8	側銑 SIDE MILLING
AEW2003	60	340	5200~5700	1500~2000	20	10~12	側銑 SIDE MILLING
AEW2003	60	315	4800~5300	1700~2200	40	0~2	側銑 SIDE MILLING
AEW2003	60	315	4800~5300	1800~2300	40	6~8	側銑 SIDE MILLING
AEW2003	60	315	4800~5200	1000~1400	40	10~12	側銑 SIDE MILLING

切削條件表 MILLING CONDITIONS

AEWR

被切削材 Work Material	鋁合金 *Aluminum Alloy* : **5052 / 6061 / 7075**	建議機器轉速RPM=10000 (min^{-1}) 以下 Be used under the machine of RPM=10000 (min^{-1})
冷卻方式 Coolant Type	濕式切削 Wet coolant	

型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
AEWR0605	20	185	9500~10000	3500~4000	0~1	4~6	溝銑 SLOTTING
AEWR0605	20	185	9500~10000	2000~2500	2~3	4~6	溝銑 SLOTTING
AEWR0605	20	185	9500~10000	1000~1500	4~6	4~6	溝銑 SLOTTING
AEWR0605	20	185	9500~10000	5000~5500	6	0~1	側銑 SIDE MILLING
AEWR0605	20	185	9500~10000	3000~3500	6	2~3	側銑 SIDE MILLING
AEWR0605	20	185	9500~10000	1000~1500	6	4~6	側銑 SIDE MILLING
AEWR0805	27	220	8500~9000	5000~5500	0~1.5	6~8	溝銑 SLOTTING
AEWR0805	27	220	8500~9000	3000~3500	2~4	6~8	溝銑 SLOTTING
AEWR0805	27	220	8500~9000	2000~2500	5~8	6~8	溝銑 SLOTTING
AEWR0805	27	220	8500~9000	5000~5500	8	0~2	側銑 SIDE MILLING
AEWR0805	27	220	8500~9000	3000~3500	8	3~5	側銑 SIDE MILLING
AEWR0805	27	220	8500~9000	1800~2300	8	6~8	側銑 SIDE MILLING
AEWR1005	33	250	7800~8300	4000~4500	0~2	8~10	溝銑 SLOTTING
AEWR1005	33	250	7800~8300	3000~3500	3~5	8~10	溝銑 SLOTTING
AEWR1005	33	250	7800~8300	2000~2500	6~10	8~10	溝銑 SLOTTING
AEWR1005	33	250	7800~8300	4000~4500	10	0~2	側銑 SIDE MILLING
AEWR1005	33	250	7800~8300	3000~3500	10	3~5	側銑 SIDE MILLING
AEWR1005	33	250	7800~8300	1800~2300	10	6~10	側銑 SIDE MILLING
AEWR1205	37	290	7500~8000	4000~4500	0~2	10~12	溝銑 SLOTTING
AEWR1205	37	290	7500~8000	2500~3000	3~6	10~12	溝銑 SLOTTING
AEWR1205	37	290	7500~8000	2000~2500	7~12	10~12	溝銑 SLOTTING
AEWR1205	37	290	7500~8000	3000~3500	12	0~2	側銑 SIDE MILLING
AEWR1205	37	290	7500~8000	2500~3000	12	3~6	側銑 SIDE MILLING
AEWR1205	37	290	7500~8000	2000~2500	12	7~12	側銑 SIDE MILLING
AEWR1610	55	340	6500~7000	2000~2500	3~4	14~16	溝銑 SLOTTING
AEWR1610	55	340	6500~7000	1200~1700	6~8	14~16	溝銑 SLOTTING
AEWR1610	55	340	6500~7000	1100~1600	9~10	14~16	溝銑 SLOTTING
AEWR1610	55	340	6500~7000	3200~3700	16	0~2	側銑 SIDE MILLING
AEWR1610	55	340	6500~7000	2000~2500	16	6~8	側銑 SIDE MILLING
AEWR1610	55	340	6500~7000	1400~1900	16	9~10	側銑 SIDE MILLING
AEWR2010	60	315	4800~5300	1700~2200	3~4	18~20	溝銑 SLOTTING
AEWR2010	60	315	4800~5300	1000~1400	6~8	18~20	溝銑 SLOTTING
AEWR2010	60	315	4800~5300	900~1200	9~10	18~20	溝銑 SLOTTING
AEWR2010	60	315	4800~5300	2500~3000	20	0~2	側銑 SIDE MILLING
AEWR2010	60	315	4800~5300	1600~2000	20	6~8	側銑 SIDE MILLING
AEWR2010	60	315	4800~5300	1100~1500	20	9~10	側銑 SIDE MILLING

AEWR

切削條件表 MILLING CONDITIONS

被切削材 Work Material	鋁合金 *Aluminum Alloy* : **5052 / 6061 / 7075**	建議機器轉速RPM=18000 (min^{-1}) 以下 Be used under the machine of RPM=18000 (min^{-1})
冷卻方式 Coolant Type	濕式切削 Wet coolant	

型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
AEWR0605	20	330	17000~18000	5500~6000	0~1	4~6	溝銑 SLOTTING
AEWR0605	20	330	17000~18000	4000~4500	2~3	4~6	溝銑 SLOTTING
AEWR0605	20	330	17000~18000	3500~4000	4~6	4~6	溝銑 SLOTTING
AEWR0605	20	330	17000~18000	7000~7500	6	0~1	側銑 SIDE MILLING
AEWR0605	20	330	17000~18000	5000~5500	6	2~3	側銑 SIDE MILLING
AEWR0605	20	330	17000~18000	2000~2500	6	4~6	側銑 SIDE MILLING
AEWR0805	27	390	15000~16000	6500~7000	0~1.5	6~8	溝銑 SLOTTING
AEWR0805	27	390	15000~16000	3500~4000	2~4	6~8	溝銑 SLOTTING
AEWR0805	27	340	13000~14000	2500~3000	5~8	6~8	溝銑 SLOTTING
AEWR0805	27	390	15000~16000	7000~7500	8	0~2	側銑 SIDE MILLING
AEWR0805	27	390	15000~16000	5000~5500	8	3~5	側銑 SIDE MILLING
AEWR0805	27	390	15000~16000	4000~4500	8	6~8	側銑 SIDE MILLING
AEWR1005	33	390	12000~13000	6500~7000	0~2	8~10	溝銑 SLOTTING
AEWR1005	33	390	12000~13000	3500~4000	3~5	8~10	溝銑 SLOTTING
AEWR1005	33	390	12000~13000	2500~3000	6~10	8~10	溝銑 SLOTTING
AEWR1005	33	390	12000~13000	7000~7500	10	0~2	側銑 SIDE MILLING
AEWR1005	33	390	12000~13000	5000~5500	10	3~5	側銑 SIDE MILLING
AEWR1005	33	390	12000~13000	4000~4500	10	6~10	側銑 SIDE MILLING
AEWR1205	37	395	10000~11000	6000~6500	0~2	10~12	溝銑 SLOTTING
AEWR1205	37	395	10000~11000	4500~5000	3~6	10~12	溝銑 SLOTTING
AEWR1205	37	395	10000~11000	4500~5000	7~12	10~12	溝銑 SLOTTING
AEWR1205	37	395	10000~11000	7000~7500	12	0~2	側銑 SIDE MILLING
AEWR1205	37	395	10000~11000	3500~4000	12	3~6	側銑 SIDE MILLING
AEWR1205	37	395	10000~11000	3500~4000	12	7~12	側銑 SIDE MILLING
AEWR1610	55	340	6500~7000	2000~2500	3~4	14~16	溝銑 SLOTTING
AEWR1610	55	340	6500~7000	1200~1700	6~8	14~16	溝銑 SLOTTING
AEWR1610	55	340	6500~7000	1100~1600	9~10	14~16	溝銑 SLOTTING
AEWR1610	55	340	6500~7000	3200~3700	16	0~2	側銑 SIDE MILLING
AEWR1610	55	340	6500~7000	2000~2500	16	6~8	側銑 SIDE MILLING
AEWR1610	55	340	6500~7000	1400~1900	16	9~10	側銑 SIDE MILLING
AEWR2010	60	315	4800~5300	1700~2200	3~4	18~20	溝銑 SLOTTING
AEWR2010	60	315	4800~5300	1000~1400	6~8	18~20	溝銑 SLOTTING
AEWR2010	60	315	4800~5300	900~1200	9~10	18~20	溝銑 SLOTTING
AEWR2010	60	315	4800~5300	2500~3000	20	0~2	側銑 SIDE MILLING
AEWR2010	60	315	4800~5300	1600~2000	20	6~8	側銑 SIDE MILLING
AEWR2010	60	315	4800~5300	1100~1500	20	9~10	側銑 SIDE MILLING

切削條件表 MILLING CONDITIONS

AES

被切削材 Work Material	鋁合金 *Aluminum Alloy* : **5052 / 6061 / 7075**	建議機器轉速RPM=10000 (min^{-1}) 以下 Be used under the machine of RPM=10000 (min^{-1})
冷卻方式 Coolant Type	濕式切削 Wet coolant	

型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
AES0203S	14	60	9500~10000	2000~2400	0~0.2	0.5~2	溝銑 SLOTTING
AES0203S	14	60	9500~10000	1400~1800	0.3~0.6	0.5~2	溝銑 SLOTTING
AES0203S	14	60	9500~10000	1400~1800	0.05~0.08	0.5~2	溝銑 SLOTTING
AES0203S	14	60	9500~10000	2000~2400	4	0~0.2	側銑 SIDE MILLING
AES0203S	14	60	9500~10000	1400~1800	4	0.3~0.6	側銑 SIDE MILLING
AES0203S	14	60	9500~10000	1200~1600	4	0.05~0.08	側銑 SIDE MILLING
AES0203	14	60	9500~10000	1800~2200	0.05~0.08	0.5~2	溝銑 SLOTTING
AES0203	14	60	9500~10000	2600~3000	0~0.2	0.5~2	溝銑 SLOTTING
AES0203	14	60	9500~10000	1800~2200	0.3~0.6	0.5~2	溝銑 SLOTTING
AES0203	14	60	9500~10000	1000~1300	0.7~1	0.5~2	溝銑 SLOTTING
AES0203	14	60	9500~10000	1200~1600	4	0.05~0.08	側銑 SIDE MILLING
AES0203	14	60	9500~10000	2800~3200	4	0~0.2	側銑 SIDE MILLING
AES0203	14	60	9500~10000	1800~2200	4	0.3~0.6	側銑 SIDE MILLING
AES0203	14	60	9500~10000	1000~1400	4	0.7~1	側銑 SIDE MILLING
AES0303S	16	90	9500~10000	2500~3000	0~0.4	1~3	溝銑 SLOTTING
AES0303S	16	90	9500~10000	1800~2300	0.5~0.8	1~3	溝銑 SLOTTING
AES0303S	16	90	9500~10000	1400~1800	0.05~0.1	1~3	溝銑 SLOTTING
AES0303S	16	90	9500~10000	2500~3000	6	0~0.4	側銑 SIDE MILLING
AES0303S	16	90	9500~10000	1800~2300	6	0.5~0.8	側銑 SIDE MILLING
AES0303S	16	90	9500~10000	1400~1800	6	0.05~0.1	側銑 SIDE MILLING
AES0303	16	90	9500~10000	1500~2000	0.05~0.1	1~3	溝銑 SLOTTING
AES0303	16	90	9500~10000	3000~3500	0~0.4	1~3	溝銑 SLOTTING
AES0303	16	90	9500~10000	2200~2700	0.5~0.8	1~3	溝銑 SLOTTING
AES0303	16	90	9500~10000	1200~1600	0.9~1.2	1~3	溝銑 SLOTTING
AES0303	16	90	9500~10000	1400~1800	6	0.05~0.1	側銑 SIDE MILLING
AES0303	16	90	9500~10000	3000~3500	6	0~0.4	側銑 SIDE MILLING
AES0303	16	90	9500~10000	2200~2700	6	0.5~0.8	側銑 SIDE MILLING
AES0303	16	90	9500~10000	1200~1600	6	0.9~1.2	側銑 SIDE MILLING
AES0403S	16	119	9500~10000	2800~3300	0~0.6	2~4	溝銑 SLOTTING
AES0403S	16	119	9500~10000	2000~2400	0.7~1.2	2~4	溝銑 SLOTTING
AES0403S	16	119	9500~10000	1400~1800	0.05~0.12	2~4	溝銑 SLOTTING
AES0403S	16	119	9500~10000	2800~3300	8	0~0.6	側銑 SIDE MILLING
AES0403S	16	119	9500~10000	2000~2400	8	0.7~1.2	側銑 SIDE MILLING
AES0403S	16	119	9500~10000	1400~1800	8	0.05~0.12	側銑 SIDE MILLING
AES0403	16	120	9500~10000	1500~2000	0.05~0.12	2~4	溝銑 SLOTTING
AES0403	16	120	9500~10000	4000~4500	0~0.6	2~4	溝銑 SLOTTING
AES0403	16	120	9500~10000	2500~3000	0.7~1.2	2~4	溝銑 SLOTTING
AES0403	16	120	9500~10000	1500~2000	1.3~2	2~4	溝銑 SLOTTING
AES0403	16	120	9500~10000	1400~1800	8	0.05~0.12	側銑 SIDE MILLING
AES0403	16	120	9500~10000	4000~4500	8	0~0.6	側銑 SIDE MILLING

型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
AES0403	16	120	9500~10000	2500~3000	8	0.7~1.2	側銑 SIDE MILLING
AES0403	16	120	9500~10000	1500~2000	8	1.3~2	側銑 SIDE MILLING
AES0503	16	150	9500~10000	1800~2200	0.05~0.15	3~5	溝銑 SLOTTING
AES0503	16	150	9500~10000	4500~5000	0~0.7	3~5	溝銑 SLOTTING
AES0503	16	150	9500~10000	2500~3000	0.8~1.5	3~5	溝銑 SLOTTING
AES0503	16	150	9500~10000	1500~2000	1.6~3.5	3~5	溝銑 SLOTTING
AES0503	16	150	9500~10000	1600~2000	10	0.05~0.15	側銑 SIDE MILLING
AES0503	16	150	9500~10000	4500~5000	10	0~0.7	側銑 SIDE MILLING
AES0503	16	150	9500~10000	3000~3500	10	0.8~1.5	側銑 SIDE MILLING
AES0503	16	150	9500~10000	1500~2000	10	1.6~3.5	側銑 SIDE MILLING
AES0603	20	170	9000~9500	1800~2200	0.05~0.15	4~6	溝銑 SLOTTING
AES0603	20	170	9000~9500	5000~5500	0~1	4~6	溝銑 SLOTTING
AES0603	20	170	9000~9500	3800~4300	2~3	4~6	溝銑 SLOTTING
AES0603	20	170	9000~9500	3000~3500	3.5~6	4~6	溝銑 SLOTTING
AES0603	20	170	9000~9500	1800~2200	12	0.05~0.15	側銑 SIDE MILLING
AES0603	20	170	9000~9500	5000~5500	12	0~1	側銑 SIDE MILLING
AES0603	20	170	9000~9500	3800~4300	12	2~3	側銑 SIDE MILLING
AES0603	20	170	9000~9500	2400~2800	12	3.5~6	側銑 SIDE MILLING
AES0603L	40	130	6700~7200	500~800	30	0.05~0.15	側銑 SIDE MILLING
AES0603L	40	130	6700~7200	1000~1400	30	0.4~0.6	側銑 SIDE MILLING
AES0603L	40	130	6700~7200	700~1100	30	0.7~1	側銑 SIDE MILLING
AES0803	25	215	8500~9000	1800~2300	0.05~0.15	6~8	溝銑 SLOTTING
AES0803	25	215	8500~9000	5000~5500	0~1.5	6~8	溝銑 SLOTTING
AES0803	25	215	8500~9000	3500~4000	2~4	6~8	溝銑 SLOTTING
AES0803	25	215	8500~9000	2500~3000	5~8	6~8	溝銑 SLOTTING
AES0803	25	215	8500~9000	1800~2300	16	0.05~0.15	側銑 SIDE MILLING
AES0803	25	215	8500~9000	5000~5500	16	0~2	側銑 SIDE MILLING
AES0803	25	215	8500~9000	4000~4500	16	2.5~4	側銑 SIDE MILLING
AES0803	25	215	8500~9000	2500~3000	16	5~8	側銑 SIDE MILLING
AES0803L	55	150	5700~6200	500~800	40	0.05~0.15	側銑 SIDE MILLING
AES0803L	55	145	5500~6000	1000~1400	40	1	側銑 SIDE MILLING
AES0803L	55	145	5500~6000	700~1100	40	1.5~2	側銑 SIDE MILLING
AES1003	30	245	7800~8200	2000~2400	0.05~0.15	8~10	溝銑 SLOTTING
AES1003	30	245	7800~8200	5500~6000	0~2	8~10	溝銑 SLOTTING
AES1003	30	245	7800~8200	3000~3500	3~5	8~10	溝銑 SLOTTING
AES1003	30	245	7800~8200	2000~2500	6~10	8~10	溝銑 SLOTTING
AES1003	30	245	7800~8200	1400~1800	20	0.05~0.15	側銑 SIDE MILLING
AES1003	30	245	7800~8200	5500~6000	20	0~2	側銑 SIDE MILLING
AES1003	30	245	7800~8200	2800~3300	20	3~5	側銑 SIDE MILLING
AES1003	30	245	7800~8200	1200~1600	20	6~10	側銑 SIDE MILLING
AES1003L	60	140	4200~4700	500~800	50	0.05~0.15	側銑 SIDE MILLING
AES1003L	60	165	5000~5500	800~1200	50	1	側銑 SIDE MILLING
AES1003L	60	165	5000~5500	500~800	50	2	側銑 SIDE MILLING

型號 Type No.	刀具伸長量 Extension Length (mm)	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
AES1203	35	295	7800~8200	2000~2400	0.05~0.15	10~12	溝銑 SLOTTING
AES1203	35	295	7800~8200	6000~6500	0~2	10~12	溝銑 SLOTTING
AES1203	35	295	7800~8200	3500~4000	3~6	10~12	溝銑 SLOTTING
AES1203	35	295	7800~8200	2800~3300	7~12	10~12	溝銑 SLOTTING
AES1203	35	295	7800~8200	2000~2400	24	0.05~0.15	側銑 SIDE MILLING
AES1203	35	295	7800~8200	5500~6000	24	0~2	側銑 SIDE MILLING
AES1203	35	295	7800~8200	3500~4000	24	3~6	側銑 SIDE MILLING
AES1203	35	295	7800~8200	2800~3300	24	7~12	側銑 SIDE MILLING
AES1203L	60	170	4200~4700	500~800	50	0.05~0.15	側銑 SIDE MILLING
AES1203L	60	130	3200~3700	800~1200	50	1	側銑 SIDE MILLING
AES1203L	60	130	3200~3700	700~1000	50	2	側銑 SIDE MILLING
AES1603	55	325	6200~6700	1400~1800	0.05~0.2	14~16	溝銑 SLOTTING
AES1603	55	325	6200~6700	3500~4000	0~2	14~16	溝銑 SLOTTING
AES1603	55	325	6200~6700	2500~3000	3~6	14~16	溝銑 SLOTTING
AES1603	55	325	6200~6700	1700~2200	7~12	14~16	溝銑 SLOTTING
AES1603	55	325	6200~6700	4000~4500	16	0~2	側銑 SIDE MILLING
AES1603	55	325	6200~6700	2500~3000	16	3~6	側銑 SIDE MILLING
AES1603	55	325	6200~6700	2000~2500	16	8~10	側銑 SIDE MILLING
AES1603	55	325	5800~6300	800~1200	32	0.05~0.2	側銑 SIDE MILLING
AES1603	55	325	6200~6700	2000~2500	32	0~2	側銑 SIDE MILLING
AES1603	55	325	6200~6700	1400~1800	32	3~6	側銑 SIDE MILLING
AES1603	55	325	6200~6700	900~1300	32	8~10	側銑 SIDE MILLING
AES1603L	75	165	3000~3500	500~800	50	0.05~0.15	側銑 SIDE MILLING
AES1603L	75	165	3000~3500	800~1200	50	1	側銑 SIDE MILLING
AES1603L	75	165	3000~3500	700~1000	50	2	側銑 SIDE MILLING
AES2003	65	315	5000~5400	1200~1600	0.05~0.2	18~20	溝銑 SLOTTING
AES2003	65	315	5000~5400	4000~4500	0~2	18~20	溝銑 SLOTTING
AES2003	65	315	5000~5400	2800~3300	3~6	18~20	溝銑 SLOTTING
AES2003	65	315	5000~5400	2000~2500	7~12	18~20	溝銑 SLOTTING
AES2003	65	315	5000~5400	1200~1600	40	0.05~0.2	側銑 SIDE MILLING
AES2003	65	315	5000~5400	4000~4500	40	0~2	側銑 SIDE MILLING
AES2003	65	315	5000~5400	2800~3300	40	3~6	側銑 SIDE MILLING
AES2003	65	315	5000~5400	2000~2500	40	7~12	側銑 SIDE MILLING
AES2003L	80	190	2800~3300	400~700	55	0.05~0.2	側銑 SIDE MILLING
AES2003L	80	190	2800~3300	700~1000	55	1	側銑 SIDE MILLING
AES2003L	80	190	2800~3300	600~800	55	2	側銑 SIDE MILLING

AES

切削條件表 MILLING CONDITIONS

被切削材 Work Material	鋁合金 *Aluminum Alloy* : **5052 / 6061 / 7075**	建議機器轉速RPM=20000 (min^{-1}) 以下 Be used under the machine of RPM=20000 (min^{-1})
冷卻方式 Coolant Type	濕式切削 Wet coolant	

型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
AES0203S	14	115	18000~20000	3500~4000	0~0.2	0.5~2	溝銑 SLOTTING
AES0203S	14	115	18000~20000	2500~3000	0.3~0.6	0.5~2	溝銑 SLOTTING
AES0203S	14	115	18000~20000	2000~2400	0.05~0.08	0.5~2	溝銑 SLOTTING
AES0203S	14	115	18000~20000	3500~4000	4	0~0.2	側銑 SIDE MILLING
AES0203S	14	115	18000~20000	2500~3000	4	0.3~0.6	側銑 SIDE MILLING
AES0203S	14	115	18000~20000	2000~2400	4	0.05~0.08	側銑 SIDE MILLING
AES0203	14	115	18000~20000	2400~2800	0.05~0.08	0.5~2	溝銑 SLOTTING
AES0203	14	115	18000~20000	4400~4800	0~0.2	0.5~2	溝銑 SLOTTING
AES0203	14	115	18000~20000	3400~3800	0.3~0.6	0.5~2	溝銑 SLOTTING
AES0203	14	115	18000~20000	2400~2800	0.7~1	0.5~2	溝銑 SLOTTING
AES0203	14	115	18000~20000	2400~2800	4	0.05~0.08	側銑 SIDE MILLING
AES0203	14	115	18000~20000	4000~4400	4	0~0.2	側銑 SIDE MILLING
AES0203	14	115	18000~20000	3000~3400	4	0.3~0.6	側銑 SIDE MILLING
AES0203	14	115	18000~20000	2000~2400	4	0.7~1	側銑 SIDE MILLING
AES0303S	16	160	17000~18000	3500~4000	0~0.4	1~3	溝銑 SLOTTING
AES0303S	16	160	17000~18000	2500~3000	0.5~0.8	1~3	溝銑 SLOTTING
AES0303S	16	160	17000~18000	2000~2400	0.05~0.1	1~3	溝銑 SLOTTING
AES0303S	16	160	17000~18000	3500~4000	6	0~0.4	側銑 SIDE MILLING
AES0303S	16	160	17000~18000	2500~3000	6	0.5~0.8	側銑 SIDE MILLING
AES0303S	16	160	17000~18000	2000~2400	6	0.05~0.1	側銑 SIDE MILLING
AES0303	16	160	17000~18000	2400~2800	0.05~0.1	1~3	溝銑 SLOTTING
AES0303	16	160	17000~18000	4400~4800	0~0.4	1~3	溝銑 SLOTTING
AES0303	16	160	17000~18000	3400~3800	0.5~0.8	1~3	溝銑 SLOTTING
AES0303	16	160	17000~18000	2400~2800	0.9~1.2	1~3	溝銑 SLOTTING
AES0303	16	160	17000~18000	2400~2800	6	0.05~0.1	側銑 SIDE MILLING
AES0303	16	160	17000~18000	4000~4400	6	0~0.4	側銑 SIDE MILLING
AES0303	16	160	17000~18000	3000~3400	6	0.5~0.8	側銑 SIDE MILLING
AES0303	16	160	17000~18000	2000~2400	6	0.9~1.2	側銑 SIDE MILLING
AES0403S	16	175	14000~15000	3800~4300	0~0.6	2~4	溝銑 SLOTTING
AES0403S	16	150	12000~13000	2400~2800	0.7~1.2	2~4	溝銑 SLOTTING
AES0403S	16	200	16000~17000	2000~2400	0.05~0.12	2~4	溝銑 SLOTTING
AES0403S	16	175	14000~15000	3800~4300	8	0~0.6	側銑 SIDE MILLING
AES0403S	16	150	12000~13000	2400~2800	8	0.7~1.2	側銑 SIDE MILLING
AES0403S	16	150	12000~13000	1600~2000	8	0.05~0.12	側銑 SIDE MILLING
AES0403	16	200	16000~17000	3000~3500	0.05~0.12	2~4	溝銑 SLOTTING
AES0403	16	175	14000~15000	4800~5300	0~0.6	2~4	溝銑 SLOTTING
AES0403	16	150	12000~13000	3200~3700	0.7~1.2	2~4	溝銑 SLOTTING
AES0403	16	150	12000~13000	2200~2700	1.3~2	2~4	溝銑 SLOTTING
AES0403	16	150	12000~13000	1600~2000	8	0.05~0.12	側銑 SIDE MILLING
AES0403	16	175	14000~15000	4800~5300	8	0~0.6	側銑 SIDE MILLING

型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
AES0403	16	150	12000~13000	3200~3700	8	0.7~1.2	側銑 SIDE MILLING
AES0403	16	150	12000~13000	2200~2700	8	1.3~2	側銑 SIDE MILLING
AES0503	16	235	15000~16000	3000~3500	0.05~0.15	3~5	溝銑 SLOTTING
AES0503	16	235	15000~16000	5500~6000	0~0.7	3~5	溝銑 SLOTTING
AES0503	16	190	12000~13000	3500~4000	0.8~1.5	3~5	溝銑 SLOTTING
AES0503	16	190	12000~13000	2500~3000	1.6~3.5	3~5	溝銑 SLOTTING
AES0503	16	205	13000~14000	2200~2600	10	0.05~0.15	側銑 SIDE MILLING
AES0503	16	205	13000~14000	5500~6000	10	0~0.7	側銑 SIDE MILLING
AES0503	16	190	12000~13000	3500~4000	10	0.8~1.5	側銑 SIDE MILLING
AES0503	16	190	12000~13000	2500~3000	10	1.6~3.5	側銑 SIDE MILLING
AES0603	20	305	16000~17000	3000~3500	0.05~0.15	4~6	溝銑 SLOTTING
AES0603	20	305	16000~17000	6500~7500	0~1	4~6	溝銑 SLOTTING
AES0603	20	285	15000~16000	5000~5500	2~3	4~6	溝銑 SLOTTING
AES0603	20	285	15000~16000	3800~4300	3.5~6	4~6	溝銑 SLOTTING
AES0603	20	305	16000~17000	2800~3200	12	0.05~0.15	側銑 SIDE MILLING
AES0603	20	305	16000~17000	6500~7500	12	0~1	側銑 SIDE MILLING
AES0603	20	285	15000~16000	4500~5000	12	2~3	側銑 SIDE MILLING
AES0603	20	285	15000~16000	3000~3500	12	3.5~6	側銑 SIDE MILLING
AES0803	25	355	14000~15000	2600~3000	0.05~0.15	6~8	溝銑 SLOTTING
AES0803	25	355	14000~15000	6000~6500	0~1.5	6~8	溝銑 SLOTTING
AES0803	25	355	14000~15000	4500~5000	2~4	6~8	溝銑 SLOTTING
AES0803	25	355	14000~15000	3000~3500	5~8	6~8	溝銑 SLOTTING
AES0803	25	305	12000~13000	2400~2800	16	0.05~0.15	側銑 SIDE MILLING
AES0803	25	330	13000~14000	6500~7500	16	0~2	側銑 SIDE MILLING
AES0803	25	330	13000~14000	5000~5500	16	2.5~4	側銑 SIDE MILLING
AES0803	25	330	13000~14000	3000~3500	16	5~8	側銑 SIDE MILLING
AES1003	30	380	12000~13000	3000~3500	0.05~0.15	8~10	溝銑 SLOTTING
AES1003	30	380	12000~13000	6500~7000	0~2	8~10	溝銑 SLOTTING
AES1003	30	315	10000~11000	3500~4000	3~5	8~10	溝銑 SLOTTING
AES1003	30	315	10000~11000	3000~3500	6~10	8~10	溝銑 SLOTTING
AES1003	30	380	12000~13000	2800~3200	20	0.05~0.15	側銑 SIDE MILLING
AES1003	30	380	12000~13000	7000~8000	20	0~2	側銑 SIDE MILLING
AES1003	30	315	10000~11000	3500~4000	20	3~5	側銑 SIDE MILLING
AES1003	30	315	10000~11000	2000~2500	20	6~10	側銑 SIDE MILLING
AES1203	35	295	7800~8200	2000~2400	0.05~0.15	10~12	溝銑 SLOTTING
AES1203	35	295	7800~8200	6000~6500	0~2	10~12	溝銑 SLOTTING
AES1203	35	295	7800~8200	3500~4000	3~6	10~12	溝銑 SLOTTING
AES1203	35	295	7800~8200	2800~3300	7~12	10~12	溝銑 SLOTTING
AES1203	35	295	7800~8200	2000~2400	24	0.05~0.15	側銑 SIDE MILLING
AES1203	35	295	7800~8200	5500~6000	24	0~2	側銑 SIDE MILLING
AES1203	35	295	7800~8200	3500~4000	24	3~6	側銑 SIDE MILLING
AES1203	35	295	7800~8200	2800~3300	24	7~12	側銑 SIDE MILLING

型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
AES1603	55	325	6400~6800	4800~5300	0~2	14~16	溝銑 SLOTTING
AES1603	55	325	6400~6800	3500~4000	3~6	14~16	溝銑 SLOTTING
AES1603	55	325	6400~6800	2800~3300	7~12	14~16	溝銑 SLOTTING
AES1603	55	325	6400~6800	1400~1800	0.05~0.2	14~16	溝銑 SLOTTING
AES1603	55	325	6400~6800	5000~5500	16	0~2	側銑 SIDE MILLING
AES1603	55	325	6400~6800	3500~4000	16	3~6	側銑 SIDE MILLING
AES1603	55	325	6400~6800	2800~3300	16	7~12	側銑 SIDE MILLING
AES1603	55	325	6400~6800	1400~1800	16	0.05~0.2	側銑 SIDE MILLING
AES2003	65	315	5000~5400	1200~1600	32	18~20	溝銑 SLOTTING
AES2003	65	315	5000~5400	4000~4500	0~2	18~20	溝銑 SLOTTING
AES2003	65	315	5000~5400	2800~3300	3~6	18~20	溝銑 SLOTTING
AES2003	65	315	5000~5400	2000~2500	7~12	18~20	溝銑 SLOTTING
AES2003	65	315	5000~5400	1200~1600	40	0.05~0.2	側銑 SIDE MILLING
AES2003	65	315	5000~5400	4000~4500	40	0~2	側銑 SIDE MILLING
AES2003	65	315	5000~5400	2800~3300	40	3~6	側銑 SIDE MILLING
AES2003	65	315	5000~5400	2000~2500	40	7~12	側銑 SIDE MILLING

切削條件表 MILLING CONDITIONS

AER

被切削材 Work Material	鋁合金 *Aluminum Alloy* : **5052 / 6061 / 7075**
冷卻方式 Coolant Type	濕式切削 Wet coolant

建議機器轉速RPM=10000 (min^{-1}) 以下
Be used under the machine of RPM=10000 (min^{-1})

型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
AER0202	9	65	9500~10000	1400~1800	0.05~0.08	1.5~2	溝銑 SLOTTING
AER0202	9	65	9500~10000	2200~2600	0~0.2	2	溝銑 SLOTTING
AER0202	9	65	9500~10000	1400~1800	0.2~0.6	2	溝銑 SLOTTING
AER0202	9	65	9500~10000	1100~1500	0.6~1	2	溝銑 SLOTTING
AER0202	9	65	9500~10000	1400~1800	4	0.05~0.08	側銑 SIDE MILLING
AER0202	9	65	9500~10000	2200~2600	2	0~0.2	側銑 SIDE MILLING
AER0202	9	65	9500~10000	1400~1800	2	0.2~0.6	側銑 SIDE MILLING
AER0202	9	65	9500~10000	1100~1500	2	0.6~1	側銑 SIDE MILLING
AER0302	13	90	9000~9500	1400~1600	0.05~0.1	2.5~3	溝銑 SLOTTING
AER0302	13	90	9000~9500	2000~2400	0~0.4	3	溝銑 SLOTTING
AER0302	13	90	9000~9500	1600~2000	0.4~0.8	3	溝銑 SLOTTING
AER0302	13	90	9000~9500	1200~1600	0.8~1.2	3	溝銑 SLOTTING
AER0302	13	90	9000~9500	1400~1600	6	0.05~0.1	側銑 SIDE MILLING
AER0302	13	90	9000~9500	2000~2400	3	0~0.4	側銑 SIDE MILLING
AER0302	13	90	9000~9500	1600~2000	3	0.4~0.8	側銑 SIDE MILLING
AER0302	13	90	9000~9500	1100~1500	3	0.8~1.2	側銑 SIDE MILLING
AER0402	15	110	8500~9000	1400~1800	0.05~0.12	3~4	溝銑 SLOTTING
AER0402	15	110	8500~9000	2400~2800	0~0.6	4	溝銑 SLOTTING
AER0402	15	110	8500~9000	1800~2200	0.6~1.2	4	溝銑 SLOTTING
AER0402	15	110	8500~9000	1200~1600	1.2~2	4	溝銑 SLOTTING
AER0402	15	110	8500~9000	1400~1800	8	0.05~0.12	側銑 SIDE MILLING
AER0402	15	110	8500~9000	2700~3200	4	0~0.6	側銑 SIDE MILLING
AER0402	15	110	8500~9000	2100~2500	4	0.6~1.2	側銑 SIDE MILLING
AER0402	15	110	8500~9000	1200~1600	4	1.2~2	側銑 SIDE MILLING
AER0603	21	150	7800~8300	1600~2000	0.05~0.15	5~6	溝銑 SLOTTING
AER0603	21	150	7800~8300	2800~3200	0~1	6	溝銑 SLOTTING
AER0603	21	150	7800~8300	1700~2200	1~3	6	溝銑 SLOTTING
AER0603	21	150	7800~8300	1200~1700	3~6	6	溝銑 SLOTTING
AER0603	21	150	7800~8300	1600~2000	12	0.05~0.15	側銑 SIDE MILLING
AER0603	21	150	7800~8300	2500~3000	6	0~1	側銑 SIDE MILLING
AER0603	21	150	7800~8300	1800~2300	6	1~3	側銑 SIDE MILLING
AER0603	21	150	7800~8300	1200~1700	6	3~6	側銑 SIDE MILLING
AER0805	25	200	7800~8300	1600~2000	0.05~0.15	6~8	溝銑 SLOTTING
AER0805	25	200	7800~8300	3500~4000	0~1.5	8	溝銑 SLOTTING
AER0805	25	200	7800~8300	3000~3500	1.5~4	8	溝銑 SLOTTING
AER0805	25	200	7800~8300	2400~2800	4~8	8	溝銑 SLOTTING
AER0805	25	200	7800~8300	1600~2000	16	0.05~0.15	側銑 SIDE MILLING
AER0805	25	200	7800~8300	3800~4300	8	0~2	側銑 SIDE MILLING
AER0805	25	200	7800~8300	2800~3300	8	2~4	側銑 SIDE MILLING
AER0805	25	200	7800~8300	2400~2800	8	4~8	側銑 SIDE MILLING
AER1005	33	250	7800~8300	1600~2000	0.05~0.15	8~10	溝銑 SLOTTING
AER1005	33	250	7800~8300	3500~4000	0~2	10	溝銑 SLOTTING
AER1005	33	250	7800~8300	3000~3500	2~5	10	溝銑 SLOTTING
AER1005	33	250	7800~8300	2000~2400	5~10	10	溝銑 SLOTTING
AER1005	33	250	7800~8300	1600~2000	20	0.05~0.15	側銑 SIDE MILLING
AER1005	33	250	7800~8300	3500~4000	10	0~2	側銑 SIDE MILLING
AER1005	33	250	7800~8300	3000~3500	10	2~5	側銑 SIDE MILLING
AER1005	33	250	7800~8300	2000~2400	10	5~10	側銑 SIDE MILLING

AER

切削條件表 MILLING CONDITIONS

被切削材 Work Material	鋁合金 *Aluminum Alloy* : **5052 / 6061 / 7075**	建議機器轉速RPM=20000 (min^{-1}) 以下 Be used under the machine of RPM=20000 (min^{-1})
冷卻方式 Coolant Type	濕式切削 Wet coolant	

型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
AER0202	9	115	18000~20000	1800~2200	0.05~0.08	1.5~2	溝銑 SLOTTING
AER0202	9	115	18000~20000	3000~3500	0~0.2	2	溝銑 SLOTTING
AER0202	9	115	18000~20000	1700~2000	0.2~0.6	2	溝銑 SLOTTING
AER0202	9	115	18000~20000	1300~1700	0.6~1	2	溝銑 SLOTTING
AER0202	9	115	18000~20000	1800~2200	4	0.05~0.08	側銑 SIDE MILLING
AER0202	9	115	18000~20000	3200~3700	2	0~0.2	側銑 SIDE MILLING
AER0202	9	115	18000~20000	1600~1900	2	0.2~0.6	側銑 SIDE MILLING
AER0202	9	115	18000~20000	1300~1700	2	0.6~1	側銑 SIDE MILLING
AER0302	13	160	17000~18000	1800~2200	0.05~0.1	2.5~3	溝銑 SLOTTING
AER0302	13	160	17000~18000	2600~3000	0~0.4	3	溝銑 SLOTTING
AER0302	13	160	17000~18000	2000~2400	0.4~0.8	3	溝銑 SLOTTING
AER0302	13	160	17000~18000	1200~1600	0.8~1.2	3	溝銑 SLOTTING
AER0302	13	160	17000~18000	1800~2200	6	0.05~0.1	側銑 SIDE MILLING
AER0302	13	160	17000~18000	2800~3200	3	0~0.4	側銑 SIDE MILLING
AER0302	13	160	17000~18000	2000~2400	3	0.4~0.8	側銑 SIDE MILLING
AER0302	13	160	17000~18000	1300~1700	3	0.8~1.2	側銑 SIDE MILLING
AER0402	15	175	14000~15000	2000~2400	0.05~0.12	3~4	溝銑 SLOTTING
AER0402	15	150	12000~13000	3000~3500	0~0.6	4	溝銑 SLOTTING
AER0402	15	150	12000~13000	2100~2500	0.6~1.2	4	溝銑 SLOTTING
AER0402	15	200	16000~17000	1500~1900	1.2~2	4	溝銑 SLOTTING
AER0402	15	175	14000~15000	2000~2400	8	0.05~0.12	側銑 SIDE MILLING
AER0402	15	150	12000~13000	3000~3500	4	0~0.6	側銑 SIDE MILLING
AER0402	15	150	12000~13000	2100~2500	4	0.6~1.2	側銑 SIDE MILLING
AER0402	15	150	12000~13000	1400~1800	4	1.2~2	側銑 SIDE MILLING
AER0603	21	270	14000~15000	2000~2400	0.05~0.15	5~6	溝銑 SLOTTING
AER0603	21	270	14000~15000	3500~4000	0~1	6	溝銑 SLOTTING
AER0603	21	270	14000~15000	2400~2800	1~3	6	溝銑 SLOTTING
AER0603	21	270	14000~15000	1600~2000	3~6	6	溝銑 SLOTTING
AER0603	21	270	14000~15000	2000~2400	12	0.05~0.15	側銑 SIDE MILLING
AER0603	21	270	14000~15000	3500~4000	6	0~1	側銑 SIDE MILLING
AER0603	21	270	14000~15000	2000~2500	6	1~3	側銑 SIDE MILLING
AER0603	21	270	14000~15000	1600~2000	6	3~6	側銑 SIDE MILLING
AER0805	25	315	12000~13000	2000~2400	0.05~0.15	6~8	溝銑 SLOTTING
AER0805	25	315	12000~13000	4500~5000	0~1.5	8	溝銑 SLOTTING
AER0805	25	315	12000~13000	3500~4000	1.5~4	8	溝銑 SLOTTING
AER0805	25	315	12000~13000	2400~2800	4~8	8	溝銑 SLOTTING
AER0805	25	315	12000~13000	2000~2400	16	0.05~0.15	側銑 SIDE MILLING
AER0805	25	315	12000~13000	4500~5000	8	0~2	側銑 SIDE MILLING
AER0805	25	315	12000~13000	3500~4000	8	2~4	側銑 SIDE MILLING
AER0805	25	315	12000~13000	2400~2800	8	4~8	側銑 SIDE MILLING
AER1005	33	330	10000~11000	2000~2400	0.05~0.15	8~10	溝銑 SLOTTING
AER1005	33	330	10000~11000	5000~5500	0~2	10	溝銑 SLOTTING
AER1005	33	330	10000~11000	3500~4000	2~5	10	溝銑 SLOTTING
AER1005	33	330	10000~11000	2000~2400	5~10	10	溝銑 SLOTTING
AER1005	33	330	10000~11000	2000~2400	20	0.05~0.15	側銑 SIDE MILLING
AER1005	33	330	10000~11000	5000~5500	10	0~2	側銑 SIDE MILLING
AER1005	33	330	10000~11000	3500~4000	10	2~5	側銑 SIDE MILLING
AER1005	33	330	10000~11000	2000~2400	10	5~10	側銑 SIDE MILLING

切削條件表 MILLING CONDITIONS

AESR

被切削材 Work Material	鋁合金 *Aluminum Alloy* : **5052 / 6061 / 7075**
冷卻方式 Coolant Type	濕式切削 Wet coolant

型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
AESR0305	16	90	9500~10000	2000~2500	0~0.4	1~3	溝銑 SLOTTING
AESR0305	16	90	9500~10000	1200~1600	0.5~0.8	1~3	溝銑 SLOTTING
AESR0305	16	90	9500~10000	600~800	0.9~1.2	1~3	溝銑 SLOTTING
AESR0305	16	90	9500~10000	1000~1400	0.05~0.1	1~3	溝銑 SLOTTING
AESR0305	16	90	9500~10000	2000~2500	3	0~0.4	側銑 SIDE MILLING
AESR0305	16	90	9500~10000	1500~2000	3	0.5~0.8	側銑 SIDE MILLING
AESR0305	16	90	9500~10000	1000~1200	3	0.9~1.2	側銑 SIDE MILLING
AESR0305	16	90	9500~10000	1000~1400	3	0.05~0.1	側銑 SIDE MILLING
AESR0405	16	120	9500~10000	3000~3500	0~0.6	2~4	溝銑 SLOTTING
AESR0405	16	120	9500~10000	1500~2000	0.7~1.2	2~4	溝銑 SLOTTING
AESR0405	16	120	9500~10000	1000~1500	1.3~2	2~4	溝銑 SLOTTING
AESR0405	16	120	9500~10000	1000~1400	0.05~0.12	2~4	溝銑 SLOTTING
AESR0405	16	120	9500~10000	3000~3500	4	0~0.6	側銑 SIDE MILLING
AESR0405	16	120	9500~10000	1500~2000	4	0.7~1.2	側銑 SIDE MILLING
AESR0405	16	120	9500~10000	1000~1500	4	1.3~2	側銑 SIDE MILLING
AESR0405	16	120	9500~10000	1000~1400	4	0.05~0.12	側銑 SIDE MILLING
AESR0605	20	175	9000~9500	3500~4000	0~1	4~6	溝銑 SLOTTING
AESR0605	20	175	9000~9500	2500~3000	2~3	4~6	溝銑 SLOTTING
AESR0605	20	175	9000~9500	1700~2200	3.5~6	4~6	溝銑 SLOTTING
AESR0605	20	175	9000~9500	1200~1600	0.05~0.15	4~6	溝銑 SLOTTING
AESR0605	20	175	9000~9500	3500~4000	6	0~1	側銑 SIDE MILLING
AESR0605	20	175	9000~9500	2500~3000	6	2~3	側銑 SIDE MILLING
AESR0605	20	175	9000~9500	1700~2200	6	3.5~6	側銑 SIDE MILLING
AESR0605	20	175	9000~9500	1200~1600	6	0.05~0.15	側銑 SIDE MILLING
AESR0610	20	175	9000~9500	3500~4000	0~1	4~6	溝銑 SLOTTING
AESR0610	20	175	9000~9500	2500~3000	2~3	4~6	溝銑 SLOTTING
AESR0610	20	175	9000~9500	1700~2200	3.5~6	4~6	溝銑 SLOTTING
AESR0610	20	175	9000~9500	1200~1600	0.05~0.15	4~6	溝銑 SLOTTING
AESR0610	20	175	9000~9500	3500~4000	6	0~1	側銑 SIDE MILLING
AESR0610	20	175	9000~9500	2500~3000	6	2~3	側銑 SIDE MILLING
AESR0610	20	175	9000~9500	1700~2200	6	3.5~6	側銑 SIDE MILLING
AESR0610	20	175	9000~9500	1200~1600	6	0.05~0.15	側銑 SIDE MILLING
AESR0805	25	290	11000~12000	5000~5500	0~1.5	6~8	溝銑 SLOTTING
AESR0805	25	220	8500~9000	3000~3500	2~4	6~8	溝銑 SLOTTING
AESR0805	25	220	8500~9000	2000~2500	5~8	6~8	溝銑 SLOTTING
AESR0805	25	220	8500~9000	1400~1800	0.05~0.15	6~8	溝銑 SLOTTING
AESR0805	25	290	11000~12000	5500~6000	8	0~2	側銑 SIDE MILLING
AESR0805	25	220	8500~9000	3500~4000	8	2.5~4	側銑 SIDE MILLING
AESR0805	25	220	8500~9000	2000~2500	8	5~8	側銑 SIDE MILLING
AESR0805	25	220	8500~9000	1600~2000	8	0.05~0.15	側銑 SIDE MILLING

型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
AESR0810	25	220	8500~9000	4000~4500	0~1.5	6~8	溝銑 SLOTTING
AESR0810	25	220	8500~9000	3000~3500	2~4	6~8	溝銑 SLOTTING
AESR0810	25	220	8500~9000	2000~2500	5~8	6~8	溝銑 SLOTTING
AESR0810	25	220	8500~9000	1400~1800	0.05~0.15	6~8	溝銑 SLOTTING
AESR0810	25	220	8500~9000	4500~5000	8	0~2	側銑 SIDE MILLING
AESR0810	25	220	8500~9000	3500~4000	8	2.5~4	側銑 SIDE MILLING
AESR0810	25	220	8500~9000	2000~2500	8	5~8	側銑 SIDE MILLING
AESR0810	25	220	8500~9000	1600~2000	8	0.05~0.15	側銑 SIDE MILLING
AESR1005	32	250	7800~8200	4500~5000	0~2	8~10	溝銑 SLOTTING
AESR1005	32	180	5500~6000	2000~2500	3~5	8~10	溝銑 SLOTTING
AESR1005	32	180	5500~6000	1000~1500	6~10	8~10	溝銑 SLOTTING
AESR1005	32	180	5500~6000	1200~1600	0.05~0.15	8~10	溝銑 SLOTTING
AESR1005	32	250	7800~8200	4500~5000	10	0~2	側銑 SIDE MILLING
AESR1005	32	180	5500~6000	2000~2400	10	3~5	側銑 SIDE MILLING
AESR1005	32	180	5500~6000	1000~1400	10	6~10	側銑 SIDE MILLING
AESR1005	32	250	7800~8200	1200~1600	10	0.05~0.15	側銑 SIDE MILLING
AESR1010	32	250	7800~8200	4500~5000	0~2	8~10	溝銑 SLOTTING
AESR1010	32	180	5500~6000	2000~2500	3~5	8~10	溝銑 SLOTTING
AESR1010	32	180	5500~6000	1000~1500	6~10	8~10	溝銑 SLOTTING
AESR1010	32	180	5500~6000	1200~1600	0.05~0.15	8~10	溝銑 SLOTTING
AESR1010	32	250	7800~8200	4500~5000	10	0~2	側銑 SIDE MILLING
AESR1010	32	180	5500~6000	2000~2400	10	3~5	側銑 SIDE MILLING
AESR1010	32	180	5500~6000	1000~1400	10	6~10	側銑 SIDE MILLING
AESR1010	32	250	7800~8200	1200~1600	10	0.05~0.15	側銑 SIDE MILLING
AESR1205	37	295	7800~8200	5000~5500	0~2	10~12	溝銑 SLOTTING
AESR1205	37	295	7800~8200	3000~3500	3~6	10~12	溝銑 SLOTTING
AESR1205	37	295	7800~8200	2300~2800	7~12	10~12	溝銑 SLOTTING
AESR1205	37	295	7800~8200	1500~2000	0.05~0.15	10~12	溝銑 SLOTTING
AESR1205	37	295	7800~8200	5000~5500	24	0~2	側銑 SIDE MILLING
AESR1205	37	295	7800~8200	3000~3500	24	3~6	側銑 SIDE MILLING
AESR1205	37	295	7800~8200	2300~2800	24	7~12	側銑 SIDE MILLING
AESR1205	37	295	7800~8200	1500~2000	24	0.05~0.15	側銑 SIDE MILLING
AESR1210	37	295	7800~8200	4500~5000	0~2	9~12	溝銑 SLOTTING
AESR1210	37	295	7800~8200	2700~3200	3~6	9~12	溝銑 SLOTTING
AESR1210	37	295	7800~8200	2000~2500	7~12	9~12	溝銑 SLOTTING
AESR1210	37	295	7800~8200	1500~2000	0.05~0.15	9~12	溝銑 SLOTTING
AESR1210	37	295	7800~8200	4500~5000	12	0~2	側銑 SIDE MILLING
AESR1210	37	295	7800~8200	2700~3200	12	3~6	側銑 SIDE MILLING
AESR1210	37	295	7800~8200	2000~2500	12	7~12	側銑 SIDE MILLING
AESR1210	37	295	7800~8200	1500~2000	12	0.05~0.15	側銑 SIDE MILLING
AESR1605	55	325	6200~6700	3000~3500	0~2	14~16	溝銑 SLOTTING
AESR1605	55	325	6200~6700	2000~2500	3~5	14~16	溝銑 SLOTTING
AESR1605	55	325	6200~6700	1400~1800	6~7	14~16	溝銑 SLOTTING
AESR1605	55	325	6200~6700	1000~1400	0.05~0.2	14~16	溝銑 SLOTTING

型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
AESR1605	55	325	6200~6700	3500~4000	16	0~2	側銑 SIDE MILLING
AESR1605	55	325	6200~6700	2000~2500	16	3~5	側銑 SIDE MILLING
AESR1605	55	325	6200~6700	1500~2000	16	6~7	側銑 SIDE MILLING
AESR1605	55	325	6200~6700	1000~1400	16	0.05~0.2	側銑 SIDE MILLING
AESR1610	55	325	6200~6700	2700~3200	0~2	13~16	溝銑 SLOTTING
AESR1610	55	325	6200~6700	1800~2300	3~5	13~16	溝銑 SLOTTING
AESR1610	55	325	6200~6700	1200~1600	6~7	13~16	溝銑 SLOTTING
AESR1610	55	325	6200~6700	1000~1400	0.05~0.2	13~16	溝銑 SLOTTING
AESR1610	55	325	6200~6700	3000~3500	16	0~2	側銑 SIDE MILLING
AESR1610	55	325	6200~6700	1800~2300	16	3~5	側銑 SIDE MILLING
AESR1610	55	325	6200~6700	1200~1600	16	6~7	側銑 SIDE MILLING
AESR1610	55	325	6200~6700	1000~1400	16	0.05~0.2	側銑 SIDE MILLING
AESR1630	55	325	6200~6700	2300~2800	0~2	9~16	溝銑 SLOTTING
AESR1630	55	325	6200~6700	1600~2000	3~5	9~16	溝銑 SLOTTING
AESR1630	55	325	6200~6700	1000~1400	6~7	9~16	溝銑 SLOTTING
AESR1630	55	325	6200~6700	1000~1400	0.05~0.2	9~16	溝銑 SLOTTING
AESR1630	55	325	6200~6700	2500~3000	16	0~2	側銑 SIDE MILLING
AESR1630	55	325	6200~6700	1600~2000	16	3~5	側銑 SIDE MILLING
AESR1630	55	325	6200~6700	1000~1400	16	6~7	側銑 SIDE MILLING
AESR1630	55	325	6200~6700	1000~1400	16	0.05~0.2	側銑 SIDE MILLING
AESR2005	65	315	5000~5400	2700~3200	0~2	18~20	溝銑 SLOTTING
AESR2005	65	315	5000~5400	1700~2200	3~5	18~20	溝銑 SLOTTING
AESR2005	65	315	5000~5400	1000~1400	6~7	18~20	溝銑 SLOTTING
AESR2005	65	315	5000~5400	1000~1400	0.05~0.2	18~20	溝銑 SLOTTING
AESR2005	65	315	5000~5400	2700~3200	20	0~2	側銑 SIDE MILLING
AESR2005	65	315	5000~5400	1700~2200	20	3~5	側銑 SIDE MILLING
AESR2005	65	315	5000~5400	1000~1400	20	6~7	側銑 SIDE MILLING
AESR2005	65	315	5000~5400	1000~1400	20	0.05~0.2	側銑 SIDE MILLING
AESR2010	65	315	5000~5400	2400~2900	0~2	16~20	溝銑 SLOTTING
AESR2010	65	315	5000~5400	1500~2000	3~5	16~20	溝銑 SLOTTING
AESR2010	65	315	5000~5400	900~1200	6~7	16~20	溝銑 SLOTTING
AESR2010	65	315	5000~5400	1000~1400	0.05~0.2	16~20	溝銑 SLOTTING
AESR2010	65	315	5000~5400	2400~2900	20	0~2	側銑 SIDE MILLING
AESR2010	65	315	5000~5400	1500~2000	20	3~5	側銑 SIDE MILLING
AESR2010	65	315	5000~5400	900~1200	20	6~7	側銑 SIDE MILLING
AESR2010	65	315	5000~5400	1000~1400	20	0.05~0.2	側銑 SIDE MILLING
AESR2030	65	315	5000~5400	2000~2500	0~2	13~20	溝銑 SLOTTING
AESR2030	65	315	5000~5400	1300~1700	3~5	13~20	溝銑 SLOTTING
AESR2030	65	315	5000~5400	800~1100	6~7	13~20	溝銑 SLOTTING
AESR2030	65	315	5000~5400	1000~1400	0.05~0.2	13~20	溝銑 SLOTTING
AESR2030	65	315	5000~5400	2000~2500	20	0~2	側銑 SIDE MILLING
AESR2030	65	315	5000~5400	1300~1700	20	3~5	側銑 SIDE MILLING
AESR2030	65	315	5000~5400	800~1100	20	6~7	側銑 SIDE MILLING
AESR2030	65	315	5000~5400	1000~1400	20	0.05~0.2	側銑 SIDE MILLING

AEA-2T

切削條件表 MILLING CONDITIONS

被切削材 Work Material	鋁合金 *Aluminum Alloy* : **5052 / 6061 / 7075**	建議機器轉速RPM=10000 (min^{-1}) 以下 Be used under the machine of RPM=10000 (min^{-1})
冷卻方式 Coolant Type	濕式切削 Wet coolant	

型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
AEA0052	9	15	9500~10000	1200~1600	0.02~0.04	0.4~0.5	溝銑 SLOTTING
AEA0052	9	15	9500~10000	1200~1600	0~0.04	0.5	溝銑 SLOTTING
AEA0052	9	15	9500~10000	500~800	0.04~0.07	0.5	溝銑 SLOTTING
AEA0052	9	15	9500~10000	200~400	0.07~0.1	0.5	溝銑 SLOTTING
AEA0052	9	15	9500~10000	1200~1600	1	0.03~0.05	側銑 SIDE MILLING
AEA0052	9	15	9500~10000	1200~1600	1	0~0.04	側銑 SIDE MILLING
AEA0052	9	15	9500~10000	500~800	1	0.04~0.07	側銑 SIDE MILLING
AEA0052	9	15	9500~10000	200~400	1	0.07~0.1	側銑 SIDE MILLING
AEA0102	9	30	9500~10000	1200~1600	0.03~0.06	0.8~1	溝銑 SLOTTING
AEA0102	9	30	9500~10000	1500~2000	0~0.1	1	溝銑 SLOTTING
AEA0102	9	30	9500~10000	900~1200	0.1~0.2	1	溝銑 SLOTTING
AEA0102	9	30	9500~10000	500~800	0.2~0.3	1	溝銑 SLOTTING
AEA0102	9	30	9500~10000	1100~1500	2	0.03~0.06	側銑 SIDE MILLING
AEA0102	9	30	9500~10000	1500~2000	2	0~0.1	側銑 SIDE MILLING
AEA0102	9	30	9500~10000	1000~1300	2	0.1~0.2	側銑 SIDE MILLING
AEA0102	9	30	9500~10000	600~900	2	0.2~0.3	側銑 SIDE MILLING
AEA0152	9	45	9000~9500	1200~1600	0.04~0.07	1.3~1.5	溝銑 SLOTTING
AEA0152	9	45	9000~9500	1500~2000	0~0.2	1.5	溝銑 SLOTTING
AEA0152	9	45	9000~9500	1000~1300	0.2~0.4	1.5	溝銑 SLOTTING
AEA0152	9	45	9000~9500	500~800	0.4~0.6	1.5	溝銑 SLOTTING
AEA0152	9	45	9000~9500	1200~1600	3	0.04~0.07	側銑 SIDE MILLING
AEA0152	9	45	9000~9500	1500~2000	2	0~0.2	側銑 SIDE MILLING
AEA0152	9	45	9000~9500	1000~1300	2	0.2~0.4	側銑 SIDE MILLING
AEA0152	9	45	9000~9500	600~900	2	0.4~0.6	側銑 SIDE MILLING
AEA0202	9	60	9000~9500	1200~1600	0.05~0.08	1.5~2	溝銑 SLOTTING
AEA0202	9	60	9000~9500	1600~2000	0~0.2	2	溝銑 SLOTTING
AEA0202	9	60	9000~9500	1100~1400	0.2~0.6	2	溝銑 SLOTTING
AEA0202	9	60	9000~9500	600~900	0.6~1	2	溝銑 SLOTTING
AEA0202	9	60	9000~9500	1300~1700	4	0.05~0.08	側銑 SIDE MILLING
AEA0202	9	60	9000~9500	1800~2200	2	0~0.2	側銑 SIDE MILLING
AEA0202	9	60	9000~9500	1100~1400	2	0.2~0.6	側銑 SIDE MILLING
AEA0202	9	60	9000~9500	600~900	2	0.6~1	側銑 SIDE MILLING
AEA0302	12	85	8500~9000	1200~1600	0.05~0.1	2.5~3	溝銑 SLOTTING
AEA0302	12	85	8500~9000	1600~2000	0~0.4	3	溝銑 SLOTTING
AEA0302	12	85	8500~9000	1200~1600	0.4~0.8	3	溝銑 SLOTTING
AEA0302	12	85	8500~9000	600~900	0.8~1.2	3	溝銑 SLOTTING
AEA0302	12	85	8500~9000	1200~1600	6	0.05~0.1	側銑 SIDE MILLING
AEA0302	12	85	8500~9000	1600~2000	3	0~0.4	側銑 SIDE MILLING
AEA0302	12	85	8500~9000	1200~1600	3	0.4~0.8	側銑 SIDE MILLING
AEA0302	12	85	8500~9000	700~1000	3	0.8~1.2	側銑 SIDE MILLING
AEA0402	15	110	8500~9000	1200~1600	0.05~0.12	3~4	溝銑 SLOTTING
AEA0402	15	110	8500~9000	1800~2200	0~0.6	4	溝銑 SLOTTING
AEA0402	15	110	8500~9000	1200~1600	0.6~1.2	4	溝銑 SLOTTING

型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
AEA0402	15	110	8500~9000	700~1000	1.2~2	4	溝銑 SLOTTING
AEA0402	15	110	8500~9000	1200~1600	8	0.05~0.12	側銑 SIDE MILLING
AEA0402	15	110	8500~9000	1800~2200	4	0~0.6	側銑 SIDE MILLING
AEA0402	15	110	8500~9000	1200~1600	4	0.6~1.2	側銑 SIDE MILLING
AEA0402	15	110	8500~9000	800~1100	4	1.2~2	側銑 SIDE MILLING
AEA0502	19	140	8500~9000	1400~1800	0.05~0.12	4~5	溝銑 SLOTTING
AEA0502	19	140	8500~9000	2700~3200	0~0.7	5	溝銑 SLOTTING
AEA0502	19	140	8500~9000	1400~1900	0.7~1.5	5	溝銑 SLOTTING
AEA0502	19	140	8500~9000	700~1100	1.5~3.5	5	溝銑 SLOTTING
AEA0502	19	140	8500~9000	1400~1800	10	0.05~0.12	側銑 SIDE MILLING
AEA0502	19	140	8500~9000	2500~3000	5	0~0.7	側銑 SIDE MILLING
AEA0502	19	140	8500~9000	1600~2000	5	0.7~1.5	側銑 SIDE MILLING
AEA0502	19	140	8500~9000	800~1200	5	1.5~3.5	側銑 SIDE MILLING
AEA0602	21	165	8500~9000	1600~2000	0.05~0.15	5~6	溝銑 SLOTTING
AEA0602	21	165	8500~9000	2500~3000	0~1	6	溝銑 SLOTTING
AEA0602	21	165	8500~9000	1400~1800	1~3	6	溝銑 SLOTTING
AEA0602	21	165	8500~9000	800~1200	3~6	6	溝銑 SLOTTING
AEA0602	21	165	8500~9000	1600~2000	12	0.05~0.15	側銑 SIDE MILLING
AEA0602	21	165	8500~9000	2400~2800	6	0~1	側銑 SIDE MILLING
AEA0602	21	165	8500~9000	1500~1900	6	1~3	側銑 SIDE MILLING
AEA0602	21	165	8500~9000	900~1300	6	3~6	側銑 SIDE MILLING
AEA0802	25	200	7800~8300	1400~1800	0.05~0.15	6~8	溝銑 SLOTTING
AEA0802	25	200	7800~8300	2500~3000	0~1.5	8	溝銑 SLOTTING
AEA0802	25	200	7800~8300	1600~2000	1.5~4	8	溝銑 SLOTTING
AEA0802	25	200	7800~8300	1500~2000	4~8	8	溝銑 SLOTTING
AEA0802	25	200	7800~8300	1400~1800	16	0.05~0.15	側銑 SIDE MILLING
AEA0802	25	200	7800~8300	2800~3200	8	0~2	側銑 SIDE MILLING
AEA0802	25	200	7800~8300	2000~2500	8	2~4	側銑 SIDE MILLING
AEA0802	25	200	7800~8300	1600~2000	8	4~8	側銑 SIDE MILLING
AEA1002	30	250	7800~8300	1400~1800	0.05~0.15	8~10	溝銑 SLOTTING
AEA1002	30	250	7800~8300	3000~3500	0~2	10	溝銑 SLOTTING
AEA1002	30	250	7800~8300	2000~2500	2~5	10	溝銑 SLOTTING
AEA1002	30	250	7800~8300	1400~1800	5~10	10	溝銑 SLOTTING
AEA1002	30	250	7800~8300	1400~1800	20	0.05~0.15	側銑 SIDE MILLING
AEA1002	30	250	7800~8300	3000~3500	10	0~2	側銑 SIDE MILLING
AEA1002	30	250	7800~8300	2200~2600	10	2~5	側銑 SIDE MILLING
AEA1002	30	250	7800~8300	1400~1800	10	5~10	側銑 SIDE MILLING
AEA1202	35	225	5800~6300	1600~2000	0.05~0.15	10~12	溝銑 SLOTTING
AEA1202	35	225	5800~6300	2000~2400	0~2	12	溝銑 SLOTTING
AEA1202	35	225	5800~6300	1500~2000	2~6	12	溝銑 SLOTTING
AEA1202	35	225	5800~6300	1000~1400	6~12	12	溝銑 SLOTTING
AEA1202	35	225	5800~6300	1600~2000	24	0.05~0.15	側銑 SIDE MILLING
AEA1202	35	225	5800~6300	2400~2800	12	0~2	側銑 SIDE MILLING
AEA1202	35	225	5800~6300	2000~2500	12	2~6	側銑 SIDE MILLING
AEA1202	35	225	5800~6300	1100~1500	12	6~12	側銑 SIDE MILLING

AEA-2T

切削條件表 MILLING CONDITIONS

被切削材 Work Material	鋁合金 *Aluminum Alloy* : **5052 / 6061 / 7075**	建議機器轉速RPM=24000 (min^{-1}) 以下 Be used under the machine of RPM=24000 (min^{-1})
冷卻方式 Coolant Type	濕式切削 Wet coolant	

型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
AEA0052	9	40	23000~24000	1600~2000	0.02~0.04	0.4~0.5	溝銑 SLOTTING
AEA0052	9	40	23000~24000	1600~2000	0~0.04	0.5	溝銑 SLOTTING
AEA0052	9	40	23000~24000	700~1000	0.04~0.07	0.5	溝銑 SLOTTING
AEA0052	9	40	23000~24000	300~500	0.07~0.1	0.5	溝銑 SLOTTING
AEA0052	9	40	23000~24000	1600~2000	1	0.03~0.05	側銑 SIDE MILLING
AEA0052	9	40	23000~24000	1600~2000	1	0~0.04	側銑 SIDE MILLING
AEA0052	9	40	23000~24000	700~1000	1	0.04~0.07	側銑 SIDE MILLING
AEA0052	9	40	23000~24000	300~500	1	0.07~0.1	側銑 SIDE MILLING
AEA0102	9	75	23000~24000	1800~2200	0.03~0.06	0.8~1	溝銑 SLOTTING
AEA0102	9	75	23000~24000	1800~2200	0~0.1	1	溝銑 SLOTTING
AEA0102	9	75	23000~24000	1200~1500	0.1~0.2	1	溝銑 SLOTTING
AEA0102	9	75	23000~24000	700~1000	0.2~0.3	1	溝銑 SLOTTING
AEA0102	9	75	23000~24000	1800~2200	2	0.03~0.06	側銑 SIDE MILLING
AEA0102	9	75	23000~24000	1800~2200	2	0~0.1	側銑 SIDE MILLING
AEA0102	9	75	23000~24000	1200~1500	2	0.1~0.2	側銑 SIDE MILLING
AEA0102	9	75	23000~24000	800~1100	2	0.2~0.3	側銑 SIDE MILLING
AEA0152	9	105	21000~22000	2000~2400	0.04~0.07	1.3~1.5	溝銑 SLOTTING
AEA0152	9	105	21000~22000	2400~2800	0~0.2	1.5	溝銑 SLOTTING
AEA0152	9	105	21000~22000	1600~1900	0.2~0.4	1.5	溝銑 SLOTTING
AEA0152	9	105	21000~22000	800~1100	0.4~0.6	1.5	溝銑 SLOTTING
AEA0152	9	105	21000~22000	2000~2400	3	0.04~0.07	側銑 SIDE MILLING
AEA0152	9	105	21000~22000	2400~2800	2	0~0.2	側銑 SIDE MILLING
AEA0152	9	105	21000~22000	1700~2000	2	0.2~0.4	側銑 SIDE MILLING
AEA0152	9	105	21000~22000	900~1200	2	0.4~0.6	側銑 SIDE MILLING
AEA0202	9	125	19000~20000	1800~2200	0.05~0.08	1.5~2	溝銑 SLOTTING
AEA0202	9	125	19000~20000	2700~3200	0~0.2	2	溝銑 SLOTTING
AEA0202	9	125	19000~20000	1400~1800	0.2~0.6	2	溝銑 SLOTTING
AEA0202	9	125	19000~20000	1000~1400	0.6~1	2	溝銑 SLOTTING
AEA0202	9	125	19000~20000	1800~2200	4	0.05~0.08	側銑 SIDE MILLING
AEA0202	9	125	19000~20000	2700~3200	2	0~0.2	側銑 SIDE MILLING
AEA0202	9	125	19000~20000	1400~1800	2	0.2~0.6	側銑 SIDE MILLING
AEA0202	9	125	19000~20000	1000~1400	2	0.6~1	側銑 SIDE MILLING
AEA0302	12	180	18000~19000	1800~2200	0.05~0.1	2.5~3	溝銑 SLOTTING
AEA0302	12	180	18000~19000	2400~2800	0~0.4	3	溝銑 SLOTTING
AEA0302	12	180	18000~19000	1800~2000	0.4~0.8	3	溝銑 SLOTTING
AEA0302	12	180	18000~19000	1000~1400	0.8~1.2	3	溝銑 SLOTTING
AEA0302	12	180	18000~19000	1800~2200	6	0.05~0.1	側銑 SIDE MILLING
AEA0302	12	180	18000~19000	3000~3400	3	0~0.4	側銑 SIDE MILLING
AEA0302	12	180	18000~19000	1600~2000	3	0.4~0.8	側銑 SIDE MILLING
AEA0302	12	180	18000~19000	1000~1400	3	0.8~1.2	側銑 SIDE MILLING
AEA0402	15	225	17000~18000	1800~2200	0.05~0.12	3~4	溝銑 SLOTTING
AEA0402	15	225	17000~18000	2500~3000	0~0.6	4	溝銑 SLOTTING
AEA0402	15	225	17000~18000	1800~2200	0.6~1.2	4	溝銑 SLOTTING

型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
AEA0402	15	225	17000~18000	1100~1500	1.2~2	4	溝銑 SLOTTING
AEA0402	15	225	17000~18000	1800~2200	8	0.05~0.12	側銑 SIDE MILLING
AEA0402	15	225	17000~18000	2500~3000	4	0~0.6	側銑 SIDE MILLING
AEA0402	15	225	17000~18000	1800~2200	4	0.6~1.2	側銑 SIDE MILLING
AEA0402	15	225	17000~18000	1200~1600	4	1.2~2	側銑 SIDE MILLING
AEA0502	19	250	15000~16000	1700~2100	0.05~0.12	4~5	溝銑 SLOTTING
AEA0502	19	250	15000~16000	3200~3600	0~0.7	5	溝銑 SLOTTING
AEA0502	19	250	15000~16000	2000~2500	0.7~1.5	5	溝銑 SLOTTING
AEA0502	19	250	15000~16000	1200~1600	1.5~3.5	5	溝銑 SLOTTING
AEA0502	19	250	15000~16000	1700~2100	10	0.05~0.12	側銑 SIDE MILLING
AEA0502	19	250	15000~16000	3200~3600	5	0~0.7	側銑 SIDE MILLING
AEA0502	19	250	15000~16000	2000~2400	5	0.7~1.5	側銑 SIDE MILLING
AEA0502	19	250	15000~16000	1200~1600	5	1.5~3.5	側銑 SIDE MILLING
AEA0602	21	250	12500~13500	1700~2100	0.05~0.15	5~6	溝銑 SLOTTING
AEA0602	21	225	11500~12500	3200~3600	0~1	6	溝銑 SLOTTING
AEA0602	21	225	11500~12500	1800~2200	1~3	6	溝銑 SLOTTING
AEA0602	21	225	11500~12500	1200~1600	3~6	6	溝銑 SLOTTING
AEA0602	21	250	12500~13500	1800~2200	12	0.05~0.15	側銑 SIDE MILLING
AEA0602	21	225	11500~12500	3200~3600	6	0~1	側銑 SIDE MILLING
AEA0602	21	225	11500~12500	1700~2100	6	1~3	側銑 SIDE MILLING
AEA0602	21	225	11500~12500	1300~1700	6	3~6	側銑 SIDE MILLING
AEA0802	25	300	11000~12000	1700~2100	0.05~0.15	6~8	溝銑 SLOTTING
AEA0802	25	300	11000~12000	3400~3800	0~1.5	8	溝銑 SLOTTING
AEA0802	25	300	11000~12000	2000~2500	1.5~4	8	溝銑 SLOTTING
AEA0802	25	300	11000~12000	2000~2400	4~8	8	溝銑 SLOTTING
AEA0802	25	300	11000~12000	1700~2100	16	0.05~0.15	側銑 SIDE MILLING
AEA0802	25	300	11000~12000	3800~4200	8	0~2	側銑 SIDE MILLING
AEA0802	25	300	11000~12000	2500~3000	8	2~4	側銑 SIDE MILLING
AEA0802	25	300	11000~12000	2000~2400	8	4~8	側銑 SIDE MILLING
AEA1002	30	300	9000~9500	1600~2000	0.05~0.15	8~10	溝銑 SLOTTING
AEA1002	30	300	9000~9500	3500~4000	0~2	10	溝銑 SLOTTING
AEA1002	30	300	9000~9500	2500~3000	2~5	10	溝銑 SLOTTING
AEA1002	30	300	9000~9500	1600~2000	5~10	10	溝銑 SLOTTING
AEA1002	30	300	9000~9500	1600~2000	20	0.05~0.15	側銑 SIDE MILLING
AEA1002	30	300	9000~9500	3800~4200	10	0~2	側銑 SIDE MILLING
AEA1002	30	300	9000~9500	2700~3200	10	2~5	側銑 SIDE MILLING
AEA1002	30	300	9000~9500	1700~2100	10	5~10	側銑 SIDE MILLING
AEA1202	35	300	7800~8300	1600~2000	0.05~0.15	10~12	溝銑 SLOTTING
AEA1202	35	300	7800~8300	2800~3200	0~2	12	溝銑 SLOTTING
AEA1202	35	300	7800~8300	2000~2500	2~6	12	溝銑 SLOTTING
AEA1202	35	300	7800~8300	1600~2000	6~12	12	溝銑 SLOTTING
AEA1202	35	300	7800~8300	1600~2000	24	0.05~0.15	側銑 SIDE MILLING
AEA1202	35	300	7800~8300	3200~3600	12	0~2	側銑 SIDE MILLING
AEA1202	35	300	7800~8300	2500~3000	12	2~6	側銑 SIDE MILLING
AEA1202	35	300	7800~8300	1600~2000	12	6~12	側銑 SIDE MILLING

切削條件表 MILLING CONDITIONS

AEA-3T

被切削材 Work Material	鋁合金 *Aluminum Alloy* : **5052 / 6061 / 7075**	建議機器轉速RPM=10000 (min^{-1}) 以下 Be used under the machine of RPM=10000 (min^{-1})
冷卻方式 Coolant Type	濕式切削 Wet coolant	

型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
AEA0203	9	65	9500~10000	1300~1700	0.05~0.08	1.5~2	溝銑 SLOTTING
AEA0203	9	65	9500~10000	1800~2200	0~0.2	2	溝銑 SLOTTING
AEA0203	9	65	9500~10000	1400~1800	0.2~0.6	2	溝銑 SLOTTING
AEA0203	9	65	9500~10000	900~1300	0.6~1	2	溝銑 SLOTTING
AEA0203	9	65	9500~10000	1300~1700	4	0.05~0.08	側銑 SIDE MILLING
AEA0203	9	65	9500~10000	2000~2400	2	0~0.2	側銑 SIDE MILLING
AEA0203	9	65	9500~10000	1400~1800	2	0.2~0.6	側銑 SIDE MILLING
AEA0203	9	65	9500~10000	1000~1400	2	0.6~1	側銑 SIDE MILLING
AEA0303	12	90	9000~9500	1400~1800	0.05~0.1	2.5~3	溝銑 SLOTTING
AEA0303	12	90	9000~9500	1800~2200	0~0.4	3	溝銑 SLOTTING
AEA0303	12	90	9000~9500	1500~1900	0.4~0.8	3	溝銑 SLOTTING
AEA0303	12	90	9000~9500	1000~1400	0.8~1.2	3	溝銑 SLOTTING
AEA0303	12	90	9000~9500	1400~1800	6	0.05~0.1	側銑 SIDE MILLING
AEA0303	12	90	9000~9500	1800~2200	3	0~0.4	側銑 SIDE MILLING
AEA0303	12	90	9000~9500	1500~1900	3	0.4~0.8	側銑 SIDE MILLING
AEA0303	12	90	9000~9500	1000~1400	3	0.8~1.2	側銑 SIDE MILLING
AEA0403	15	110	8500~9000	1400~1800	0.05~0.12	3~4	溝銑 SLOTTING
AEA0403	15	110	8500~9000	2200~2600	0~0.6	4	溝銑 SLOTTING
AEA0403	15	110	8500~9000	1800~2200	0.6~1.2	4	溝銑 SLOTTING
AEA0403	15	110	8500~9000	1000~1400	1.2~2	4	溝銑 SLOTTING
AEA0403	15	110	8500~9000	1400~1800	8	0.05~0.12	側銑 SIDE MILLING
AEA0403	15	110	8500~9000	2200~2600	4	0~0.6	側銑 SIDE MILLING
AEA0403	15	110	8500~9000	1800~2200	4	0.6~1.2	側銑 SIDE MILLING
AEA0403	15	110	8500~9000	1000~1400	4	1.2~2	側銑 SIDE MILLING
AEA0503	19	125	7800~8300	1600~2000	0.05~0.12	4~5	溝銑 SLOTTING
AEA0503	19	125	7800~8300	3500~4000	0~0.7	5	溝銑 SLOTTING
AEA0503	19	125	7800~8300	2000~2500	0.7~1.5	5	溝銑 SLOTTING
AEA0503	19	125	7800~8300	1200~1700	1.5~3.5	5	溝銑 SLOTTING
AEA0503	19	125	7800~8300	1600~2000	10	0.05~0.12	側銑 SIDE MILLING
AEA0503	19	125	7800~8300	3500~4000	5	0~0.7	側銑 SIDE MILLING
AEA0503	19	125	7800~8300	2000~2500	5	0.7~1.5	側銑 SIDE MILLING
AEA0503	19	125	7800~8300	1200~1700	5	1.5~3.5	側銑 SIDE MILLING
AEA0603	21	150	7800~8300	1800~2200	0.05~0.15	5~6	溝銑 SLOTTING
AEA0603	21	150	7800~8300	3200~3600	0~1	6	溝銑 SLOTTING
AEA0603	21	150	7800~8300	1700~2200	1~3	6	溝銑 SLOTTING
AEA0603	21	150	7800~8300	1200~1700	3~6	6	溝銑 SLOTTING
AEA0603	21	150	7800~8300	1800~2200	12	0.05~0.15	側銑 SIDE MILLING
AEA0603	21	150	7800~8300	2800~3200	6	0~1	側銑 SIDE MILLING
AEA0603	21	150	7800~8300	1800~2300	6	1~3	側銑 SIDE MILLING
AEA0603	21	150	7800~8300	1200~1700	6	3~6	側銑 SIDE MILLING

型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
AEA0803	25	200	7800~8300	1800~2200	0.05~0.15	6~8	溝銑 SLOTTING
AEA0803	25	200	7800~8300	4500~5000	0~1.5	8	溝銑 SLOTTING
AEA0803	25	200	7800~8300	3000~3500	1.5~4	8	溝銑 SLOTTING
AEA0803	25	200	7800~8300	2400~2800	4~8	8	溝銑 SLOTTING
AEA0803	25	200	7800~8300	1800~2200	16	0.05~0.15	側銑 SIDE MILLING
AEA0803	25	200	7800~8300	4500~5000	8	0~2	側銑 SIDE MILLING
AEA0803	25	200	7800~8300	3000~3500	8	2~4	側銑 SIDE MILLING
AEA0803	25	200	7800~8300	2400~2800	8	4~8	側銑 SIDE MILLING
AEA1003	30	250	7800~8300	1800~2200	0.05~0.15	8~10	溝銑 SLOTTING
AEA1003	30	250	7800~8300	4500~5000	0~2	10	溝銑 SLOTTING
AEA1003	30	250	7800~8300	3500~4000	2~5	10	溝銑 SLOTTING
AEA1003	30	250	7800~8300	2000~2400	5~10	10	溝銑 SLOTTING
AEA1003	30	250	7800~8300	1800~2200	20	0.05~0.15	側銑 SIDE MILLING
AEA1003	30	250	7800~8300	4500~5000	10	0~2	側銑 SIDE MILLING
AEA1003	30	250	7800~8300	3500~4000	10	2~5	側銑 SIDE MILLING
AEA1003	30	250	7800~8300	2000~2400	10	5~10	側銑 SIDE MILLING
AEA1203	35	300	7800~8300	2000~2400	0.05~0.15	10~12	溝銑 SLOTTING
AEA1203	35	300	7800~8300	4500~5000	0~2	12	溝銑 SLOTTING
AEA1203	35	300	7800~8300	3000~3500	2~6	12	溝銑 SLOTTING
AEA1203	35	300	7800~8300	2000~2400	6~12	12	溝銑 SLOTTING
AEA1203	35	300	7800~8300	2000~2400	24	0.05~0.15	側銑 SIDE MILLING
AEA1203	35	300	7800~8300	4500~5000	12	0~2	側銑 SIDE MILLING
AEA1203	35	300	7800~8300	3500~4000	12	2~6	側銑 SIDE MILLING
AEA1203	35	300	7800~8300	2000~2400	12	6~12	側銑 SIDE MILLING
AEA1603	50	300	6000~6500	1700~2100	0.05~0.2	14~16	溝銑 SLOTTING
AEA1603	50	300	6000~6500	3500~4000	0~2	16	溝銑 SLOTTING
AEA1603	50	300	6000~6500	2600~3200	2~6	16	溝銑 SLOTTING
AEA1603	50	300	6000~6500	2000~2400	6~12	16	溝銑 SLOTTING
AEA1603	50	300	6000~6500	1700~2100	32	0.05~0.2	側銑 SIDE MILLING
AEA1603	50	300	6000~6500	3500~4000	16	0~2	側銑 SIDE MILLING
AEA1603	50	300	6000~6500	2600~3200	16	2~6	側銑 SIDE MILLING
AEA1603	50	300	6000~6500	2000~2400	16	6~12	側銑 SIDE MILLING

AEA-3T

切削條件表 MILLING CONDITIONS

被切削材 Work Material	鋁合金 *Aluminum Alloy* : **5052 / 6061 / 7075**	建議機器轉速RPM=24000 (min^{-1}) 以下 Be used under the machine of RPM=24000 (min^{-1})
冷卻方式 Coolant Type	濕式切削 Wet coolant	

型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
AEA0203	9	150	23000~24000	2000~2400	0.05~0.08	1.5~2	溝銑 SLOTTING
AEA0203	9	150	23000~24000	3000~3500	0~0.2	2	溝銑 SLOTTING
AEA0203	9	150	23000~24000	1700~2000	0.2~0.6	2	溝銑 SLOTTING
AEA0203	9	150	23000~24000	1300~1700	0.6~1	2	溝銑 SLOTTING
AEA0203	9	150	23000~24000	2000~2400	4	0.05~0.08	側銑 SIDE MILLING
AEA0203	9	150	23000~24000	3200~3700	2	0~0.2	側銑 SIDE MILLING
AEA0203	9	150	23000~24000	1600~1900	2	0.2~0.6	側銑 SIDE MILLING
AEA0203	9	150	23000~24000	1300~1700	2	0.6~1	側銑 SIDE MILLING
AEA0303	12	210	21000~22000	2000~2400	0.05~0.1	2.5~3	溝銑 SLOTTING
AEA0303	12	210	21000~22000	2600~3000	0~0.4	3	溝銑 SLOTTING
AEA0303	12	210	21000~22000	2000~2400	0.4~0.8	3	溝銑 SLOTTING
AEA0303	12	210	21000~22000	1200~1600	0.8~1.2	3	溝銑 SLOTTING
AEA0303	12	210	21000~22000	2000~2400	6	0.05~0.1	側銑 SIDE MILLING
AEA0303	12	210	21000~22000	3400~3900	3	0~0.4	側銑 SIDE MILLING
AEA0303	12	210	21000~22000	1800~2100	3	0.4~0.8	側銑 SIDE MILLING
AEA0303	12	210	21000~22000	1300~1700	3	0.8~1.2	側銑 SIDE MILLING
AEA0403	15	250	19000~20000	2000~2400	0.05~0.12	3~4	溝銑 SLOTTING
AEA0403	15	250	19000~20000	3000~3500	0~0.6	4	溝銑 SLOTTING
AEA0403	15	250	19000~20000	2100~2500	0.6~1.2	4	溝銑 SLOTTING
AEA0403	15	250	19000~20000	1400~1800	1.2~2	4	溝銑 SLOTTING
AEA0403	15	250	19000~20000	2000~2400	8	0.05~0.12	側銑 SIDE MILLING
AEA0403	15	250	19000~20000	3000~3500	4	0~0.6	側銑 SIDE MILLING
AEA0403	15	250	19000~20000	2100~2500	4	0.6~1.2	側銑 SIDE MILLING
AEA0403	15	250	19000~20000	1400~1800	4	1.2~2	側銑 SIDE MILLING
AEA0503	19	260	16000~17000	2000~2400	0.05~0.12	4~5	溝銑 SLOTTING
AEA0503	19	260	16000~17000	4000~4500	0~0.7	5	溝銑 SLOTTING
AEA0503	19	260	16000~17000	2400~2800	0.7~1.5	5	溝銑 SLOTTING
AEA0503	19	260	16000~17000	1400~1800	1.5~3.5	5	溝銑 SLOTTING
AEA0503	19	260	16000~17000	2000~2400	10	0.05~0.12	側銑 SIDE MILLING
AEA0503	19	260	16000~17000	4200~4800	5	0~0.7	側銑 SIDE MILLING
AEA0503	19	260	16000~17000	2400~2800	5	0.7~1.5	側銑 SIDE MILLING
AEA0503	19	260	16000~17000	1400~1800	5	1.5~3.5	側銑 SIDE MILLING
AEA0603	21	270	14000~15000	2000~2400	0.05~0.15	5~6	溝銑 SLOTTING
AEA0603	21	270	14000~15000	4000~4500	0~1	6	溝銑 SLOTTING
AEA0603	21	270	14000~15000	2500~3000	1~3	6	溝銑 SLOTTING
AEA0603	21	270	14000~15000	1600~2000	3~6	6	溝銑 SLOTTING
AEA0603	21	270	14000~15000	2000~2400	12	0.05~0.15	側銑 SIDE MILLING
AEA0603	21	270	14000~15000	3500~4000	6	0~1	側銑 SIDE MILLING
AEA0603	21	270	14000~15000	2000~2500	6	1~3	側銑 SIDE MILLING
AEA0603	21	270	14000~15000	1600~2000	6	3~6	側銑 SIDE MILLING

型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
AEA0803	25	315	12000~13000	2000~2400	0.05~0.15	6~8	溝銑 SLOTTING
AEA0803	25	315	12000~13000	5000~5500	0~1.5	8	溝銑 SLOTTING
AEA0803	25	315	12000~13000	3500~4000	1.5~4	8	溝銑 SLOTTING
AEA0803	25	315	12000~13000	2400~2800	4~8	8	溝銑 SLOTTING
AEA0803	25	315	12000~13000	2000~2400	16	0.05~0.15	側銑 SIDE MILLING
AEA0803	25	315	12000~13000	5000~5500	8	0~2	側銑 SIDE MILLING
AEA0803	25	315	12000~13000	3500~4000	8	2~4	側銑 SIDE MILLING
AEA0803	25	315	12000~13000	2400~2800	8	4~8	側銑 SIDE MILLING
AEA1003	30	330	10000~11000	2000~2400	0.05~0.15	8~10	溝銑 SLOTTING
AEA1003	30	330	10000~11000	5000~5500	0~2	10	溝銑 SLOTTING
AEA1003	30	330	10000~11000	3500~4000	2~5	10	溝銑 SLOTTING
AEA1003	30	330	10000~11000	2000~2400	5~10	10	溝銑 SLOTTING
AEA1003	30	330	10000~11000	2000~2400	20	0.05~0.15	側銑 SIDE MILLING
AEA1003	30	330	10000~11000	5000~5500	10	0~2	側銑 SIDE MILLING
AEA1003	30	330	10000~11000	3500~4000	10	2~5	側銑 SIDE MILLING
AEA1003	30	330	10000~11000	2000~2400	10	5~10	側銑 SIDE MILLING
AEA1203	35	300	7800~8300	2000~2400	0.05~0.15	10~12	溝銑 SLOTTING
AEA1203	35	300	7800~8300	4500~5000	0~2	12	溝銑 SLOTTING
AEA1203	35	300	7800~8300	3000~3500	2~6	12	溝銑 SLOTTING
AEA1203	35	300	7800~8300	2000~2400	6~12	12	溝銑 SLOTTING
AEA1203	35	300	7800~8300	2000~2400	24	0.05~0.15	側銑 SIDE MILLING
AEA1203	35	300	7800~8300	4500~5000	12	0~2	側銑 SIDE MILLING
AEA1203	35	300	7800~8300	3500~4000	12	2~6	側銑 SIDE MILLING
AEA1203	35	300	7800~8300	2000~2400	12	6~12	側銑 SIDE MILLING
AEA1603	50	300	6000~6500	1700~2100	0.05~0.2	14~16	溝銑 SLOTTING
AEA1603	50	300	6000~6500	3500~4000	0~2	16	溝銑 SLOTTING
AEA1603	50	300	6000~6500	2600~3200	2~6	16	溝銑 SLOTTING
AEA1603	50	300	6000~6500	2000~2400	6~12	16	溝銑 SLOTTING
AEA1603	50	300	6000~6500	1700~2100	32	0.05~0.2	側銑 SIDE MILLING
AEA1603	50	300	6000~6500	3500~4000	16	0~2	側銑 SIDE MILLING
AEA1603	50	300	6000~6500	2600~3200	16	2~6	側銑 SIDE MILLING
AEA1603	50	300	6000~6500	2000~2400	16	6~12	側銑 SIDE MILLING

AET-2T

切削條件表 MILLING CONDITIONS

被切削材 Work Material	鋁合金 *Aluminum Alloy* : **5052 / 6061 / 7075**	建議機器轉速RPM=10000 (min^{-1}) 以下 Be used under the machine of RPM=10000 (min^{-1})
冷卻方式 Coolant Type	濕式切削 Wet coolant	

型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
AET0052	13	15	9500~10000	500~700	0.04~0.06	0.1~0.5	溝銑 SLOTTING
AET0052	13	15	9500~10000	300~500	1	0.04~0.06	側銑 SIDE MILLING
AET0102	13	30	9500~10000	800~1000	0.05~0.08	0.5~1	溝銑 SLOTTING
AET0102	13	30	9500~10000	600~800	2	0.05~0.08	側銑 SIDE MILLING
AET0152	13	45	9500~10000	1000~1200	0.05~0.08	0.5~1.5	溝銑 SLOTTING
AET0152	13	45	9500~10000	800~1000	3	0.05~0.08	側銑 SIDE MILLING
AET0202	14	60	9500~10000	1800~2200	0~0.2	0.5~2	溝銑 SLOTTING
AET0202	14	60	9500~10000	1000~1200	0.05~0.08	0.5~2	溝銑 SLOTTING
AET0202	14	60	9500~10000	2000~2400	4	0~0.2	側銑 SIDE MILLING
AET0202	14	60	9500~10000	800~1000	4	0.05~0.08	側銑 SIDE MILLING
AET0302	14	90	9500~10000	2200~2600	0~0.4	1~3	溝銑 SLOTTING
AET0302	14	90	9500~10000	1000~1400	0.05~0.1	1~3	溝銑 SLOTTING
AET0302	14	90	9500~10000	2600~3000	6	0~0.4	側銑 SIDE MILLING
AET0302	14	90	9500~10000	800~1200	6	0.05~0.1	側銑 SIDE MILLING
AET0402	16	120	9500~10000	2800~3200	0~0.6	2~4	溝銑 SLOTTING
AET0402	16	120	9500~10000	1200~1600	0.05~0.12	2~4	溝銑 SLOTTING
AET0402	16	120	9500~10000	3000~3400	8	0~0.6	側銑 SIDE MILLING
AET0402	16	120	9500~10000	1000~1400	8	0.05~0.12	側銑 SIDE MILLING
AET0502	18	150	9500~10000	3400~3800	0~0.7	3~5	溝銑 SLOTTING
AET0502	18	150	9500~10000	1400~1800	0.05~0.15	3~5	溝銑 SLOTTING
AET0502	18	150	9500~10000	3400~3800	10	0~0.7	側銑 SIDE MILLING
AET0502	18	150	9500~10000	1000~1400	10	0.05~0.15	側銑 SIDE MILLING
AET0602	20	170	9000~9500	3400~3800	0~1	4~6	溝銑 SLOTTING
AET0602	20	170	9000~9500	1400~1800	0.05~0.15	4~6	溝銑 SLOTTING
AET0602	20	170	9000~9500	3400~3800	12	0~1	側銑 SIDE MILLING
AET0602	20	170	9000~9500	1000~1400	12	0.05~0.15	側銑 SIDE MILLING
AET0802	26	215	8500~9000	3400~3800	0~1.5	6~8	溝銑 SLOTTING
AET0802	26	215	8500~9000	1600~2000	0.05~0.15	6~8	溝銑 SLOTTING
AET0802	26	215	8500~9000	3600~4000	16	0~2	側銑 SIDE MILLING
AET0802	26	215	8500~9000	1400~1800	16	0.05~0.15	側銑 SIDE MILLING
AET1002	30	245	7800~8200	4000~4500	0~2	8~10	溝銑 SLOTTING
AET1002	30	245	7800~8200	1400~1800	0.05~0.15	8~10	溝銑 SLOTTING
AET1002	30	245	7800~8200	4000~4500	20	0~2	側銑 SIDE MILLING
AET1002	30	245	7800~8200	1400~1800	20	0.05~0.15	側銑 SIDE MILLING
AET1202	36	295	7800~8200	4000~4500	0~2	10~12	溝銑 SLOTTING
AET1202	36	295	7800~8200	1200~1600	0.05~0.15	10~12	溝銑 SLOTTING
AET1202	36	295	7800~8200	3200~3600	24	0~2	側銑 SIDE MILLING
AET1202	36	295	7800~8200	1200~1600	24	0.05~0.15	側銑 SIDE MILLING

切削條件表 MILLING CONDITIONS

AET-2T

被切削材 Work Material	鋁合金 *Aluminum Alloy* : **5052 / 6061 / 7075**
冷卻方式 Coolant Type	濕式切削 Wet coolant

建議機器轉速RPM=20000 (min^{-1}) 以下
Be used under the machine of RPM=20000 (min^{-1})

型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
AET0052	13	30	18000~20000	600~800	0.04~0.06	0.1~0.5	溝銑 SLOTTING
AET0052	13	30	18000~20000	400~600	1	0.04~0.06	側銑 SIDE MILLING
AET0102	13	60	18000~20000	1200~1400	0.05~0.08	0.5~1	溝銑 SLOTTING
AET0102	13	60	18000~20000	1000~1200	2	0.05~0.08	側銑 SIDE MILLING
AET0152	13	85	18000~20000	1400~1600	0.05~0.08	0.5~1.5	溝銑 SLOTTING
AET0152	13	85	18000~20000	1200~1400	3	0.05~0.08	側銑 SIDE MILLING
AET0202	14	110	17000~18000	2200~2600	0~0.2	0.5~2	溝銑 SLOTTING
AET0202	14	110	17000~18000	1400~1600	0.05~0.08	0.5~2	溝銑 SLOTTING
AET0202	14	110	17000~18000	2600~3000	4	0~0.2	側銑 SIDE MILLING
AET0202	14	110	17000~18000	1400~1600	4	0.05~0.08	側銑 SIDE MILLING
AET0302	14	160	17000~18000	2600~3000	0~0.4	1~3	溝銑 SLOTTING
AET0302	14	160	17000~18000	1800~2200	0.05~0.1	1~3	溝銑 SLOTTING
AET0302	14	160	17000~18000	3000~3400	6	0~0.4	側銑 SIDE MILLING
AET0302	14	160	17000~18000	1600~2000	6	0.05~0.1	側銑 SIDE MILLING
AET0402	16	200	16000~17000	3400~3800	0~0.6	2~4	溝銑 SLOTTING
AET0402	16	200	16000~17000	2000~2400	0.05~0.12	2~4	溝銑 SLOTTING
AET0402	16	200	16000~17000	3400~3800	8	0~0.6	側銑 SIDE MILLING
AET0402	16	200	16000~17000	1600~2000	8	0.05~0.12	側銑 SIDE MILLING
AET0502	18	235	15000~16000	4400~4800	0~0.7	3~5	溝銑 SLOTTING
AET0502	18	235	15000~16000	2400~2800	0.05~0.15	3~5	溝銑 SLOTTING
AET0502	18	235	15000~16000	4400~4800	10	0~0.7	側銑 SIDE MILLING
AET0502	18	235	15000~16000	1600~2000	10	0.05~0.15	側銑 SIDE MILLING
AET0602	20	285	15000~16000	4400~4800	0~1	4~6	溝銑 SLOTTING
AET0602	20	285	15000~16000	2400~2800	0.05~0.15	4~6	溝銑 SLOTTING
AET0602	20	285	15000~16000	4400~4800	12	0~1	側銑 SIDE MILLING
AET0602	20	285	15000~16000	1600~2000	12	0.05~0.15	側銑 SIDE MILLING
AET0802	26	355	14000~15000	4500~5000	0~1.5	6~8	溝銑 SLOTTING
AET0802	26	355	14000~15000	2200~2600	0.05~0.15	6~8	溝銑 SLOTTING
AET0802	26	355	14000~15000	5000~5500	16	0~2	側銑 SIDE MILLING
AET0802	26	355	14000~15000	2000~2400	16	0.05~0.15	側銑 SIDE MILLING
AET1002	30	380	12000~13000	5500~6000	0~2	8~10	溝銑 SLOTTING
AET1002	30	380	12000~13000	2000~2400	0.05~0.15	8~10	溝銑 SLOTTING
AET1002	30	380	12000~13000	6000~6500	20	0~2	側銑 SIDE MILLING
AET1002	30	380	12000~13000	1800~2200	20	0.05~0.15	側銑 SIDE MILLING
AET1202	36	295	7800~8200	4000~4500	0~2	10~12	溝銑 SLOTTING
AET1202	36	295	7800~8200	1200~1600	0.05~0.15	10~12	溝銑 SLOTTING
AET1202	36	295	7800~8200	3200~3600	24	0~2	側銑 SIDE MILLING
AET1202	36	295	7800~8200	1200~1600	24	0.05~0.15	側銑 SIDE MILLING

AET-3T

切削條件表 MILLING CONDITIONS

被切削材 Work Material	鋁合金 *Aluminum Alloy* : **5052 / 6061 / 7075**	建議機器轉速RPM=10000 (min^{-1}) 以下 Be used under the machine of RPM=10000 (min^{-1})
冷卻方式 Coolant Type	濕式切削 Wet coolant	

型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
AET0203	14	60	9500~10000	2200~2600	0~0.2	0.5~2	溝銑 SLOTTING
AET0203	14	60	9500~10000	1200~1600	0.05~0.08	0.5~2	溝銑 SLOTTING
AET0203	14	60	9500~10000	2400~2800	4	0~0.2	側銑 SIDE MILLING
AET0203	14	60	9500~10000	1200~1600	4	0.05~0.08	側銑 SIDE MILLING
AET0303	16	90	9500~10000	2800~3200	0~0.4	1~3	溝銑 SLOTTING
AET0303	16	90	9500~10000	1600~2000	0.05~0.1	1~3	溝銑 SLOTTING
AET0303	16	90	9500~10000	3000~3400	6	0~0.4	側銑 SIDE MILLING
AET0303	16	90	9500~10000	1400~1800	6	0.05~0.1	側銑 SIDE MILLING
AET0403	18	115	9000~9500	3400~3800	0~0.6	2~4	溝銑 SLOTTING
AET0403	18	115	9000~9500	1600~2000	0.05~0.12	2~4	溝銑 SLOTTING
AET0403	18	115	9000~9500	3400~3800	8	0~0.6	側銑 SIDE MILLING
AET0403	18	115	9000~9500	1400~1800	8	0.05~0.12	側銑 SIDE MILLING
AET0503	20	125	7800~8300	3800~4200	0~0.7	3~5	溝銑 SLOTTING
AET0503	20	125	7800~8300	1600~2000	0.05~0.15	3~5	溝銑 SLOTTING
AET0503	20	125	7800~8300	3800~4200	10	0~0.7	側銑 SIDE MILLING
AET0503	20	125	7800~8300	1200~1600	10	0.05~0.15	側銑 SIDE MILLING
AET0603	22	150	7800~8200	4200~4600	0~0.9	4~6	溝銑 SLOTTING
AET0603	22	150	7800~8200	1600~2000	0.05~0.15	4~6	溝銑 SLOTTING
AET0603	22	150	7800~8200	4200~4600	12	0~0.9	側銑 SIDE MILLING
AET0603	22	150	7800~8200	1600~2000	12	0.05~0.15	側銑 SIDE MILLING
AET0803	26	175	7000~7500	3000~3400	0~1.5	6~8	溝銑 SLOTTING
AET0803	26	215	8500~9000	1800~2200	0.05~0.15	6~8	溝銑 SLOTTING
AET0803	26	215	8500~9000	1600~2000	16	0~1	側銑 SIDE MILLING
AET0803	26	215	8500~9000	1600~2000	16	0.05~0.15	側銑 SIDE MILLING
AET1003	30	245	7800~8200	4500~5000	0~2	8~10	溝銑 SLOTTING
AET1003	30	245	7800~8200	1600~2000	0.05~0.15	8~10	溝銑 SLOTTING
AET1003	30	245	7800~8200	4000~4500	20	0~2	側銑 SIDE MILLING
AET1003	30	245	7800~8200	1600~2000	20	0.05~0.15	側銑 SIDE MILLING
AET1203	36	295	7800~8200	5000~5500	0~2	10~12	溝銑 SLOTTING
AET1203	36	295	7800~8200	1600~2000	0.05~0.15	10~12	溝銑 SLOTTING
AET1203	36	295	7800~8200	4500~5000	24	0~2	側銑 SIDE MILLING
AET1203	36	295	7800~8200	1600~2000	24	2	側銑 SIDE MILLING
AET1603	55	325	6400~6800	4400~4800	0~2	14~16	溝銑 SLOTTING
AET1603	55	325	6400~6800	1400~1800	0.05~0.2	14~16	溝銑 SLOTTING
AET1603	55	325	6400~6800	4600~5000	32	0~2	側銑 SIDE MILLING
AET1603	55	325	6400~6800	1400~1800	32	0.05~0.2	側銑 SIDE MILLING

切削條件表 MILLING CONDITIONS

AET-3T

被切削材 Work Material	鋁合金 *Aluminum Alloy* : **5052 / 6061 / 7075**	建議機器轉速RPM=20000 (min^{-1}) 以下 Be used under the machine of RPM=20000 (min^{-1})
冷卻方式 Coolant Type	濕式切削 Wet coolant	

型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
AET0203	14	115	18000~20000	3400~3800	0~0.2	0.5~2	溝銑 SLOTTING
AET0203	14	115	18000~20000	1800~2200	0.05~0.08	0.5~2	溝銑 SLOTTING
AET0203	14	115	18000~20000	3400~3800	4	0~0.2	側銑 SIDE MILLING
AET0203	14	115	18000~20000	1800~2200	4	0.05~0.08	側銑 SIDE MILLING
AET0303	16	160	17000~18000	3800~4200	0~0.4	1~3	溝銑 SLOTTING
AET0303	16	160	17000~18000	2400~2800	0.05~0.1	1~3	溝銑 SLOTTING
AET0303	16	160	17000~18000	3800~4200	6	0~0.4	側銑 SIDE MILLING
AET0303	16	160	17000~18000	2000~2400	6	0.05~0.1	側銑 SIDE MILLING
AET0403	18	165	13000~14000	4200~4600	0~0.6	2~4	溝銑 SLOTTING
AET0403	18	165	13000~14000	2400~2800	0.05~0.12	2~4	溝銑 SLOTTING
AET0403	18	165	13000~14000	4200~4600	8	0~0.6	側銑 SIDE MILLING
AET0403	18	165	13000~14000	2000~2400	8	0.05~0.12	側銑 SIDE MILLING
AET0503	20	175	11000~12000	5000~5400	0~0.7	3~5	溝銑 SLOTTING
AET0503	20	175	11000~12000	2600~3000	0.05~0.15	3~5	溝銑 SLOTTING
AET0503	20	175	11000~12000	5000~5400	10	0~0.7	側銑 SIDE MILLING
AET0503	20	175	11000~12000	1800~2200	10	0.05~0.15	側銑 SIDE MILLING
AET0603	22	255	13000~14000	6000~6500	0~0.9	4~6	溝銑 SLOTTING
AET0603	22	255	13000~14000	2400~2800	0.05~0.15	4~6	溝銑 SLOTTING
AET0603	22	255	13000~14000	6500~7500	12	0~0.9	側銑 SIDE MILLING
AET0603	22	255	13000~14000	2200~2600	12	0.05~0.15	側銑 SIDE MILLING
AET0803	26	280	11000~12000	4000~4500	0~1	6~8	溝銑 SLOTTING
AET0803	26	355	14000~15000	2400~2800	0.05~0.15	6~8	溝銑 SLOTTING
AET0803	26	355	14000~15000	2800~3200	16	0~1	側銑 SIDE MILLING
AET0803	26	355	14000~15000	2200~2600	16	0.05~0.15	側銑 SIDE MILLING
AET1003	30	360	11000~12000	5500~6000	0~2	8~10	溝銑 SLOTTING
AET1003	30	360	11000~12000	2400~2800	0.05~0.15	8~10	溝銑 SLOTTING
AET1003	30	360	11000~12000	5500~6000	20	0~2	側銑 SIDE MILLING
AET1003	30	360	11000~12000	2200~2600	20	0.05~0.15	側銑 SIDE MILLING
AET1203	36	295	7800~8200	5000~5500	0~2	10~12	溝銑 SLOTTING
AET1203	36	295	7800~8200	1600~2000	0.05~0.15	10~12	溝銑 SLOTTING
AET1203	36	295	7800~8200	4500~5000	24	0~2	側銑 SIDE MILLING
AET1203	36	295	7800~8200	1600~2000	24	2	側銑 SIDE MILLING
AET1603	55	325	6400~6800	4400~4800	0~2	14~16	溝銑 SLOTTING
AET1603	55	325	6400~6800	1400~1800	0.05~0.2	14~16	溝銑 SLOTTING
AET1603	55	325	6400~6800	4600~5000	32	0~2	側銑 SIDE MILLING
AET1603	55	325	6400~6800	1400~1800	32	0.05~0.2	側銑 SIDE MILLING

BTC

切削條件表 MILLING CONDITIONS

被切削材 Work Material	鋁合金 *Aluminum Alloy* : **5052 / 6061 / 7075**	建議機器轉速RPM=10000 (min^{-1}) 以下 Be used under the machine of RPM=10000 (min^{-1})
冷卻方式 Coolant Type	濕式切削 Wet coolant	

型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
BTC0102	10	30	9500~10000	400~600	0.15~0.18	0.3~0.36	3D銑 3D MILLING
BTC0102	10	30	9500~10000	800~1200	0.08~0.11	0.15~0.18	3D銑 3D MILLING
BTC0102	10	30	9500~10000	1400~1800	0.03~0.05	0.05~0.08	3D銑 3D MILLING
BTC0152	12	45	9500~10000	400~600	0.15~0.18	0.3~0.36	3D銑 3D MILLING
BTC0152	12	45	9500~10000	1000~1400	0.08~0.11	0.15~0.18	3D銑 3D MILLING
BTC0152	12	45	9500~10000	1800~2200	0.03~0.05	0.05~0.08	3D銑 3D MILLING
BTC0202	12	60	9000~9500	600~1000	0.2~0.25	0.45~0.5	3D銑 3D MILLING
BTC0202	12	60	9000~9500	1200~1600	0.1~0.13	0.2~0.25	3D銑 3D MILLING
BTC0202	12	60	9000~9500	2200~2600	0.04~0.06	0.06~0.1	3D銑 3D MILLING
BTC0302	14	85	9000~9500	800~1200	0.25~0.3	0.5~0.6	3D銑 3D MILLING
BTC0302	14	85	9000~9500	1500~1900	0.12~0.15	0.23~0.28	3D銑 3D MILLING
BTC0302	14	85	9000~9500	2400~2800	0.05~0.07	0.8~0.12	3D銑 3D MILLING
BTC0402	14	115	9000~9500	1000~1400	0.3~0.35	0.7~08	3D銑 3D MILLING
BTC0402	14	115	9000~9500	2000~2400	0.15~0.18	0.3~0.4	3D銑 3D MILLING
BTC0402	14	115	9000~9500	2600~3000	0.06~0.08	0.1~0.13	3D銑 3D MILLING
BTC0602	20	160	8500~9000	1200~1600	0.5~0.6	1~1.5	3D銑 3D MILLING
BTC0602	20	160	8500~9000	2400~2800	0.2~0.25	0.4~0.5	3D銑 3D MILLING
BTC0602	20	170	9000~9500	3000~3400	0.08~0.1	0.12~0.15	3D銑 3D MILLING
BTC0802	25	200	8000~8500	1400~1800	0.7~1	2~2.5	3D銑 3D MILLING
BTC0802	25	200	8000~8500	2600~3000	0.25~0.3	0.5~0.6	3D銑 3D MILLING
BTC0802	25	230	9000~9500	3200~3600	0.08~0.13	0.15~0.2	3D銑 3D MILLING
BTC1002	35	255	8000~8500	1600~2000	0.8~1.3	2~2.5	3D銑 3D MILLING
BTC1002	35	255	8000~8500	3400~3800	0.3~0.35	0.7~0.8	3D銑 3D MILLING
BTC1002	35	285	9000~9500	3000~3400	0.1~0.15	0.18~0.23	3D銑 3D MILLING
BTC1202	40	290	7700~8200	1600~2000	1~1.5	2.5~3.5	3D銑 3D MILLING
BTC1202	40	290	7700~8200	2800~3200	0.4~0.45	0.8~1	3D銑 3D MILLING
BTC1202	40	290	7700~8200	3800~4200	0.13~0.16	0.2~0.25	3D銑 3D MILLING

切削條件表 MILLING CONDITIONS

BTC

被切削材 Work Material	鋁合金 *Aluminum Alloy* : **5052 / 6061 / 7075**	建議機器轉速RPM=24000 (min^{-1}) 以下 Be used under the machine of RPM=24000 (min^{-1})
冷卻方式 Coolant Type	濕式切削 Wet coolant	

型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
BTC0102	10	75	23000~24000	600~800	0.15~0.18	0.3~0.36	3D銑 3D MILLING
BTC0102	10	75	23000~24000	1000~1400	0.08~0.11	0.15~0.18	3D銑 3D MILLING
BTC0102	10	75	23000~24000	1800~2200	0.03~0.05	0.05~0.08	3D銑 3D MILLING
BTC0152	12	105	22000~23000	600~800	0.15~0.18	0.3~0.36	3D銑 3D MILLING
BTC0152	12	105	22000~23000	1400~1800	0.08~0.11	0.15~0.18	3D銑 3D MILLING
BTC0152	12	105	22000~23000	2200~2600	0.03~0.05	0.05~0.08	3D銑 3D MILLING
BTC0202	12	125	20000~22000	800~1200	0.2~0.25	0.45~0.5	3D銑 3D MILLING
BTC0202	12	125	20000~22000	1600~2000	0.1~0.13	0.2~0.25	3D銑 3D MILLING
BTC0202	12	125	20000~22000	2600~3000	0.04~0.06	0.06~0.1	3D銑 3D MILLING
BTC0302	14	160	17000~19000	1100~1500	0.25~0.3	0.5~0.6	3D銑 3D MILLING
BTC0302	14	160	17000~19000	1800~2200	0.12~0.15	0.23~0.28	3D銑 3D MILLING
BTC0302	14	160	17000~19000	2800~3200	0.05~0.07	0.8~0.12	3D銑 3D MILLING
BTC0402	14	200	16000~17000	1400~1800	0.3~0.35	0.7~0.8	3D銑 3D MILLING
BTC0402	14	200	16000~17000	2600~3000	0.15~0.18	0.3~0.4	3D銑 3D MILLING
BTC0402	14	200	16000~17000	3000~3400	0.06~0.08	0.1~0.13	3D銑 3D MILLING
BTC0602	20	285	15000~16000	1600~2000	0.5~0.6	1~1.5	3D銑 3D MILLING
BTC0602	20	285	15000~16000	2800~3200	0.2~0.25	0.4~0.5	3D銑 3D MILLING
BTC0602	20	285	15000~16000	3400~3800	0.08~0.1	0.12~0.15	3D銑 3D MILLING
BTC0802	25	330	13000~14000	2000~2400	0.7~1	2~2.5	3D銑 3D MILLING
BTC0802	25	330	13000~14000	3600~4000	0.25~0.3	0.5~0.6	3D銑 3D MILLING
BTC0802	25	330	13000~14000	4200~4600	0.08~0.13	0.15~0.2	3D銑 3D MILLING
BTC1002	35	315	10000~11000	2000~2400	0.8~1.3	2~2.5	3D銑 3D MILLING
BTC1002	35	380	12000~13000	4000~4400	0.3~0.35	0.7~0.8	3D銑 3D MILLING
BTC1002	35	380	12000~13000	3800~4200	0.1~0.15	0.18~0.23	3D銑 3D MILLING
BTC1202	40	415	11000~12000	2400~2800	1~1.5	2.5~3.5	3D銑 3D MILLING
BTC1202	40	415	11000~12000	3800~4200	0.4~0.45	0.8~1	3D銑 3D MILLING
BTC1202	40	415	11000~12000	4200~4600	0.13~0.16	0.2~0.25	3D銑 3D MILLING

切削條件表 MILLING CONDITIONS HBC . IBC . JBC

被切削材 Work Material	鋁合金 *Aluminum Alloy* : **5052 / 6061 / 7075**
冷卻方式 Coolant Type	濕式切削 Wet coolant

型號 Type No.	刀具伸長量 Extension Length (mm)	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 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
HBC0402	35	100	8000~8500	1200~1600	0.09~0.18	0.18~0.3	3D銑 3D MILLING
HBC0402	35	115	9000~9500	1800~2200	0.06~0.08	0.1~0.15	3D銑 3D MILLING
HBC0502	35	120	7300~7800	1400~1800	0.15~0.22	0.38~0.48	3D銑 3D MILLING
HBC0502	35	130	8000~8500	2000~2400	0.05~0.1	0.1~0.15	3D銑 3D MILLING
HBC0602	35	130	6700~7200	1400~1800	0.15~0.25	0.3~0.5	3D銑 3D MILLING
HBC0602	35	150	7700~8200	2000~2400	0.05~0.1	0.12~0.16	3D銑 3D MILLING
IBC0402	50	85	6700~7200	1000~1400	0.09~0.18	0.18~0.3	3D銑 3D MILLING
IBC0402	50	100	8000~8500	1600~2000	0.06~0.08	0.1~0.15	3D銑 3D MILLING
IBC0602	50	120	6000~6500	1200~1600	0.15~0.25	0.3~0.5	3D銑 3D MILLING
IBC0602	50	140	7200~7600	1800~2200	0.05~0.1	0.12~0.16	3D銑 3D MILLING
IBC0802	50	200	8000~8500	2000~2400	0.25~0.3	0.5~0.6	3D銑 3D MILLING
IBC0802	50	230	9000~9500	3200~3600	0.08~0.13	0.15~0.2	3D銑 3D MILLING
IBC1002	60	255	8000~8500	3600~4000	0.3~0.35	0.7~0.8	3D銑 3D MILLING
IBC1002	60	285	9000~9500	3000~3400	0.1~0.15	0.18~0.23	3D銑 3D MILLING
IBC1202	60	290	7700~8200	3000~3400	0.35~0.4	0.8~1	3D銑 3D MILLING
IBC1202	60	290	7700~8200	3000~3400	0.13~0.16	0.2~0.25	3D銑 3D MILLING
JBC0602	80	120	4700~5200	1600~2000	0.1~0.2	0.2~0.4	3D銑 3D MILLING
JBC0602	80	180	9000~9500	2000~2400	0.05~0.1	0.12~0.16	3D銑 3D MILLING
JBC0802	80	120	4700~5200	2000~2400	0.25~0.3	0.5~0.6	3D銑 3D MILLING
JBC0802	80	230	9000~9500	3000~3400	0.08~0.13	0.15~0.2	3D銑 3D MILLING
JBC1002	100	125	4000~4400	1200~1600	0.1~0.15	0.18~0.23	3D銑 3D MILLING
JBC1002	100	285	9000~9500	3000~3400	0.1~0.15	0.18~0.23	3D銑 3D MILLING
JBC1202	100	85	2000~2400	800~1000	0.35~0.4	0.8~1	3D銑 3D MILLING
JBC1202	100	150	3700~4200	1800~2200	0.13~0.16	0.2~0.25	3D銑 3D MILLING

德信發企業有限公司

DHF Precision Tool Co., Ltd.

營運總部

台灣台中市南屯區大墩六街425號
No.425, Da Dun 6th St., Nantun District, Taichung 40867,Taiwan
TEL : 886-4-23815088　　FAX : 886-4-23814488
http://www.endmill.com.tw
E-mail : dhf@endmill.com.tw

分公司

Italy / Pordenone
DHF Italia Srl　http://www.dhfitalia.it

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DHF Polska Sp z o.o.

China / Shanghai
上海徐匯區徐匯苑大廈
TEL / 021-64564958　　FAX / 021-64564968

China / GuangDong
東莞市虎門鎮索菲特東方時代廣場
TEL / 0769-85115970　FAX / 0769-85240930

Distributor

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