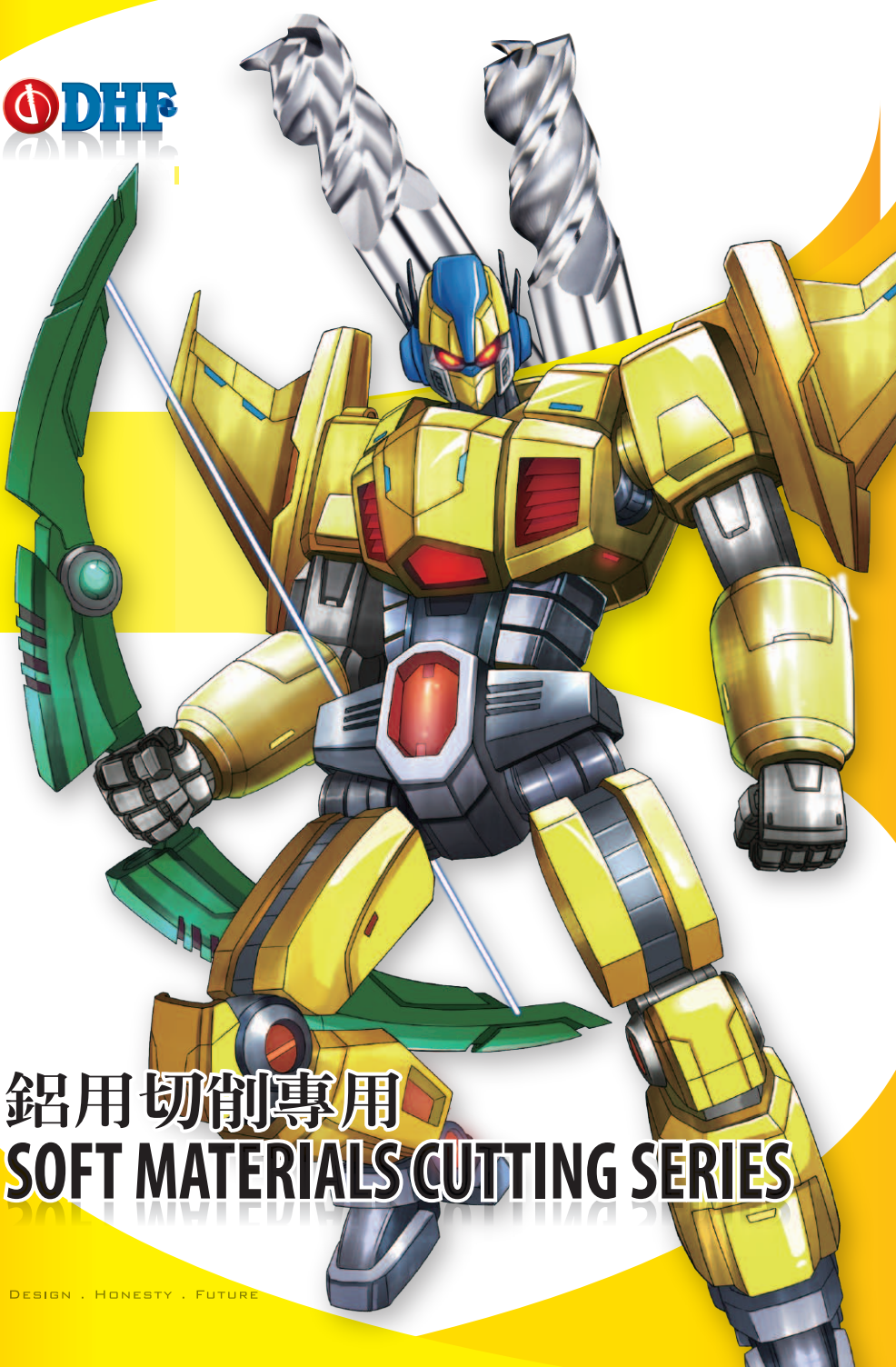


A large, yellow and blue robot character is the central focus. It has a humanoid form with a blue head, yellow body, and large, segmented arms and legs. It is holding a large green sword in its right hand and a large green shield in its left hand. The robot is standing on a yellow and white background with a stylized sunburst effect behind it.

鋁用切削専用 SOFT MATERIALS CUTTING SERIES

DESIGN . HONESTY . FUTURE

版權聲明

THE STATEMENT OF COPYRIGHT

1. 本手冊中所提列之切削資料均由**DHF**應用技術中心測試提供，版權所有、翻印必究。
 2. 所有測試結果均使用本公司生產之刀具所得，對他廠牌產品不負參考價值與責任。
 3. 本手冊中僅提列若干刀具之切削條件表，如需更完整的資訊，請與**DHF**應用技術中心連絡。
-
1. As mentioned above in this manual, the cutting data is tested and provided by the **DHF Technical Applications Center**. All Rights Reserved.
 2. All test results are provided by **DHF** high quality control of productions.
There is no responsibility and value of reference for other brand products.
 3. Only certain tables for our cutting tools are recited. For any further complete information, please contact **DHF Technical Applications Center**.

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。

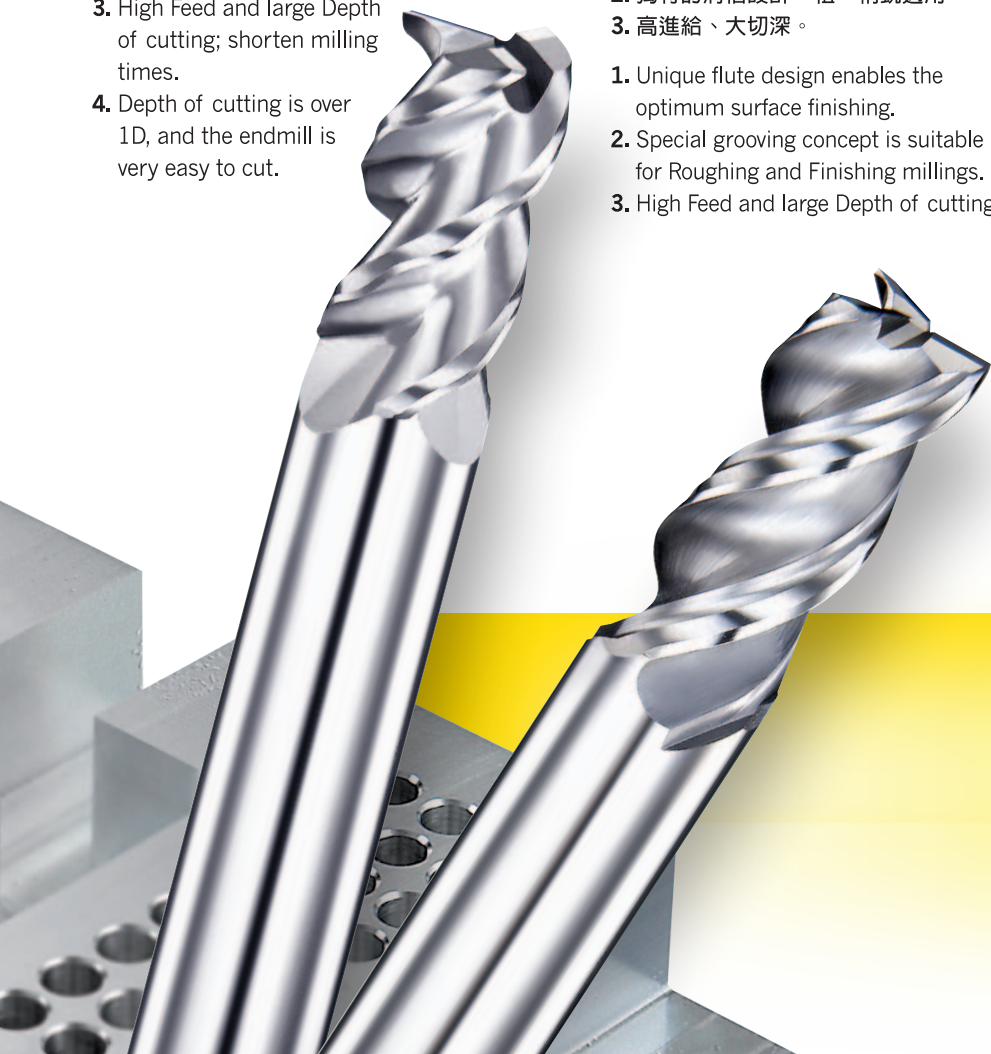
1. Low vibration and high stability.
2. Special design features smooth chip removal and low stickiness.
3. High Feed and large Depth of cutting; shorten milling times.
4. Depth of cutting is over 1D, and the endmill is very easy to cut.

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



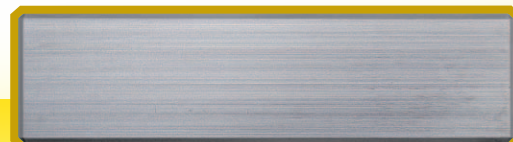
AET-3T



AEA-3T



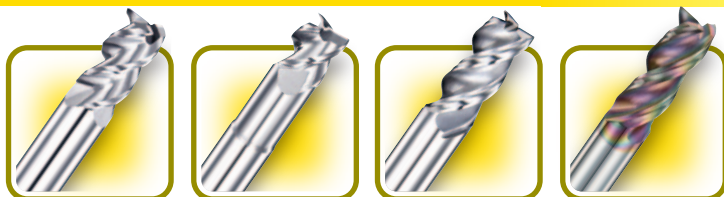
AET-2T



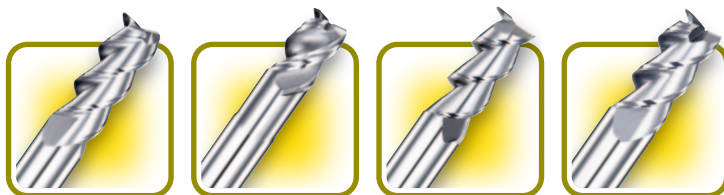
AEA-2T



目錄 INDEX



品名 Product	AEW	AEW R	AES	AES⁺
說明 Explanation	P.1	P.2	P.3	P.4
切削條件 Milling Conditions	P.13~16	P.17~18	P.19~24	



品名 Product	AER	AESR	AEA-2T	AEA-3T
說明 Explanation	P.5	P.6	P.7	P.8
切削條件 Milling Conditions	P.25~26	P.27~29	P.30~33	P.34~37



品名 Product	AET-2T	AET-3T	BTC	HBC IBC JBC
說明 Explanation	P.9	P.10	P.11	P.12
切削條件 Milling Conditions	P.38~39	P.40~41	P.42~43	P.44

圖示說明

Guide Line to Icons

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 $0.4\ \mu\text{m}$
Grain size is $0.4\ \mu\text{m}$.



粉末顆粒是 $0.6\ \mu\text{m}$
Grain size is $0.6\ \mu\text{m}$.

螺旋角 **HELIX ANGLE**



螺旋角度 25° 、 40° 、 45° 、 55°
Helix Angle is $25^\circ, 40^\circ, 45^\circ, 55^\circ$.

圓隅角 **CORNER R**



圓隅角。
Corner Radius.

切削性能 **CUTTING PERFORMANCE**



優
Excellent



良
Good



尚可
Acceptable



禁止
No

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.

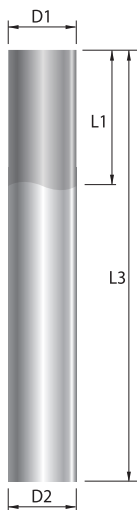
縮頸 **SHRINK NECK**



適用於深溝加工
Best for long neck machine.

彩虹立銑刀 End Mills

AEW



公差表 TOLERANCE

直徑 D1	直徑公差值 D1 Tolerance
6.0	$\frac{0}{-0.025}$
8.0	$\frac{0}{-0.025}$
10.0	$\frac{0}{-0.03}$
12.0	$\frac{0}{-0.035}$
16.0	$\frac{0}{-0.04}$
20.0	$\frac{0}{-0.04}$
柄徑 D2	柄徑公差值 D2 Tolerance
Ø6	$\frac{0}{-0.008}$
Ø8	$\frac{0}{-0.009}$
Ø10	$\frac{0}{-0.009}$
Ø12	$\frac{0}{-0.011}$
Ø16	$\frac{0}{-0.011}$
Ø20	$\frac{0}{-0.013}$

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

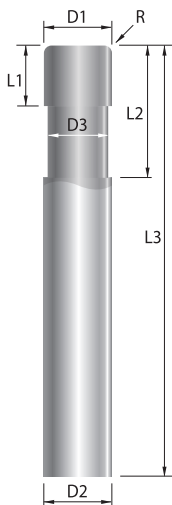
★ AEW的切削數據請查閱P.13~16 Please find the milling condition on P.13~16

彩虹圓鼻角立銑刀

End Mills

Corner Radius

AEWR



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

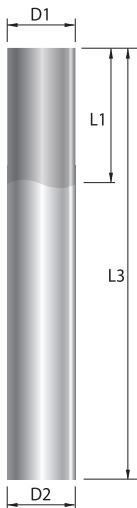
型號 Type No.	D1 直徑 Diameter	D3 頸徑 Neck Dia.	R 角 Corner R	L1 刃長 Flute Length	L2 有效長 Effective Length	L3 全長 O.A.L.	D2 柄徑 Shank Dia.
AEWR0605	6.0	5.8	0.5	8	18	50	6
AEWR0805	8.0	7.7	0.5	10	24	60	8
AEWR1005	10.0	9.6	0.5	12	30	75	10
AEWR1205	12.0	11.5	0.5	15	36	75	12
AEWR1610	16.0	15.5	1.0	24	40	120	16
AEWR2010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



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

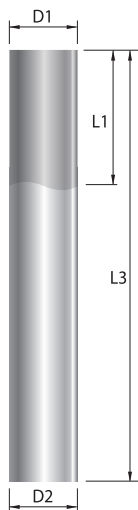
★ AES的切削數據請查閱P.19~24 Please find the milling condition on P.19~24

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+



公差表 TOLERANCE

直徑 D1	直徑公差值 D1 Tolerance
2.0	$\frac{0}{-0.02}$
3.0	$\frac{0}{-0.02}$
4.0	$\frac{0}{-0.02}$
5.0	$\frac{0}{-0.02}$
6.0	$\frac{0}{-0.02}$
8.0	$\frac{0}{-0.02}$
10.0	$\frac{0}{-0.02}$
12.0	$\frac{0}{-0.02}$
16.0	$\frac{0}{-0.03}$
20.0	$\frac{0}{-0.03}$
柄徑 D2	柄徑公差值 D2 Tolerance
Ø6	$\frac{0}{-0.008}$
Ø8	$\frac{0}{-0.009}$
Ø10	$\frac{0}{-0.009}$
Ø12	$\frac{0}{-0.011}$
Ø16	$\frac{0}{-0.011}$
Ø20	$\frac{0}{-0.013}$

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

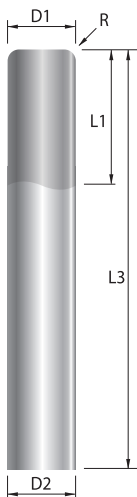
鋁用圓鼻角立銑刀 End Mills

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



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

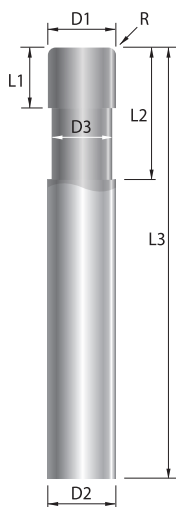
unit : mm

★ 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



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 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 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

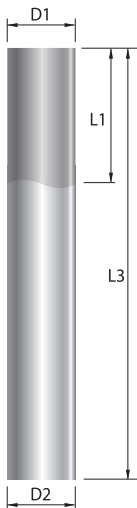
★ AESR的切削數據請查閱P.27~29 Please find the milling condition on P.27~29

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



公差表 TOLERANCE

直徑 D1	直徑公差值 D1 Tolerance
0.5	$\frac{0}{-0.02}$
1.0	$\frac{0}{-0.02}$
1.5	$\frac{0}{-0.02}$
2.0	$\frac{0}{-0.02}$
3.0	$\frac{0}{-0.02}$
4.0	$\frac{0}{-0.02}$
5.0	$\frac{0}{-0.02}$
6.0	$\frac{0}{-0.02}$
8.0	$\frac{0}{-0.02}$
10.0	$\frac{0}{-0.02}$
12.0	$\frac{0}{-0.02}$
柄徑 D2	柄徑公差值 D2 Tolerance
Ø4	$\frac{0}{-0.008}$
Ø6	$\frac{0}{-0.008}$
Ø8	$\frac{0}{-0.009}$
Ø10	$\frac{0}{-0.009}$
Ø12	$\frac{0}{-0.011}$

unit : mm

產品規格 SPECIFICATIONS

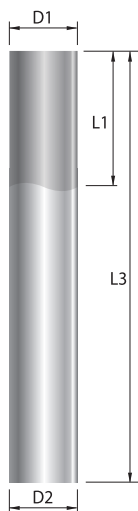
型號 Type No.	D1 直徑 Diameter	L1 刃長 Flute Length	L3 全長 O.A.L.	D2 柄徑 Shank Dia.
AEA0052	0.5	1.5	50	4
AEA0102	1.0	3	50	4
AEA0152	1.5	4	50	4
AEA0202	2.0	6	50	4
AEA0302	3.0	8	50	4
AEA0402	4.0	12	50	4
AEA0502	5.0	16	50	6
AEA0602	6.0	18	50	6
AEA0802	8.0	22	60	8
AEA1002	10.0	28	75	10
AEA1202	12.0	30	75	12

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

公差表 TOLERANCE

直徑 D1	直徑公差值 D1 Tolerance
2.0	$\frac{0}{-0.02}$
3.0	$\frac{0}{-0.02}$
4.0	$\frac{0}{-0.02}$
5.0	$\frac{0}{-0.02}$
6.0	$\frac{0}{-0.02}$
8.0	$\frac{0}{-0.02}$
10.0	$\frac{0}{-0.02}$
12.0	$\frac{0}{-0.02}$
16.0	$\frac{0}{-0.03}$
柄徑 D2	柄徑公差值 D2 Tolerance
Ø6	$\frac{0}{-0.008}$
Ø8	$\frac{0}{-0.009}$
Ø10	$\frac{0}{-0.009}$
Ø12	$\frac{0}{-0.011}$
Ø16	$\frac{0}{-0.011}$

unit : mm

產品規格 SPECIFICATIONS

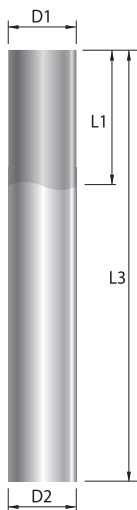
型號 Type No.	D1 直徑 Diameter	L1 刃長 Flute Length	L3 全長 O.A.L.	D2 柄徑 Shank Dia.
AEA0203	2.0	6	50	6
AEA0303	3.0	10	50	6
AEA0403	4.0	12	50	6
AEA0503	5.0	16	50	6
AEA0603	6.0	18	50	6
AEA0803	8.0	20	60	8
AEA1003	10.0	25	75	10
AEA1203	12.0	30	75	12
AEA1603	16.0	40	100	16

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



公差表 TOLERANCE

直徑 D1	直徑公差值 D1 Tolerance
0.5	$\frac{0}{-0.02}$
1.0	$\frac{0}{-0.02}$
1.5	$\frac{0}{-0.02}$
2.0	$\frac{0}{-0.02}$
3.0	$\frac{0}{-0.02}$
4.0	$\frac{0}{-0.02}$
5.0	$\frac{0}{-0.02}$
6.0	$\frac{0}{-0.02}$
8.0	$\frac{0}{-0.02}$
10.0	$\frac{0}{-0.02}$
12.0	$\frac{0}{-0.02}$
柄徑 D2	柄徑公差值 D2 Tolerance
Ø4	$\frac{0}{-0.008}$
Ø6	$\frac{0}{-0.008}$
Ø8	$\frac{0}{-0.009}$
Ø10	$\frac{0}{-0.009}$
Ø12	$\frac{0}{-0.011}$

unit : mm

產品規格 SPECIFICATIONS

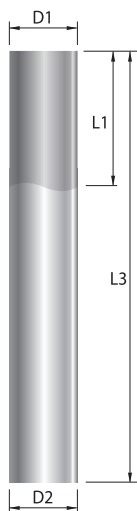
型號 Type No.	D1 直徑 Diameter	L1 刃長 Flute Length	L3 全長 O.A.L.	D2 柄徑 Shank Dia.
AET0052	0.5	1.5	50	4
AET0102	1.0	3	50	6
AET0152	1.5	4	50	6
AET0202	2.0	6	50	6
AET0302	3.0	8	50	6
AET0402	4.0	11	50	6
AET0502	5.0	13	50	6
AET0602	6.0	16	50	6
AET0802	8.0	19	60	8
AET1002	10.0	25	75	10
AET1202	12.0	26	75	12

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

公差表 TOLERANCE

直徑 D1	直徑公差值 D1 Tolerance
2.0	$\frac{0}{-0.02}$
3.0	$\frac{0}{-0.02}$
4.0	$\frac{0}{-0.02}$
5.0	$\frac{0}{-0.02}$
6.0	$\frac{0}{-0.02}$
8.0	$\frac{0}{-0.02}$
10.0	$\frac{0}{-0.02}$
12.0	$\frac{0}{-0.02}$
16.0	$\frac{0}{-0.02}$
柄徑 D2	柄徑公差值 D2 Tolerance
Ø6	$\frac{0}{-0.008}$
Ø8	$\frac{0}{-0.009}$
Ø10	$\frac{0}{-0.009}$
Ø12	$\frac{0}{-0.011}$
Ø16	$\frac{0}{-0.011}$

unit : mm

產品規格 SPECIFICATIONS

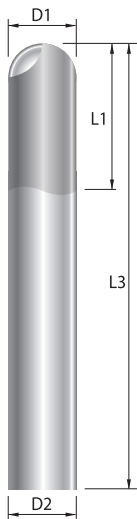
型號 Type No.	D1 直徑 Diameter	L1 刃長 Flute Length	L3 全長 O.A.L.	D2 柄徑 Shank Dia.
AET0203	2.0	6	50	6
AET0303	3.0	10	50	6
AET0403	4.0	12	50	6
AET0503	5.0	16	60	6
AET0603	6.0	18	60	6
AET0803	8.0	20	60	8
AET1003	10.0	25	75	10
AET1203	12.0	30	75	12
AET1603	16.0	40	100	16

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



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

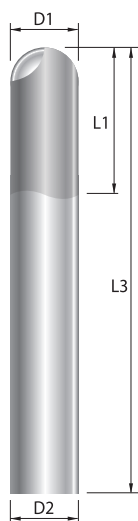
★ BTC的切削數據請查閱P.42~43 Please find the milling condition on P.42~43

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



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	$\begin{smallmatrix} 0 \\ -0.008 \end{smallmatrix}$
Ø8	$\begin{smallmatrix} 0 \\ -0.009 \end{smallmatrix}$
Ø10	$\begin{smallmatrix} 0 \\ -0.009 \end{smallmatrix}$
Ø12	$\begin{smallmatrix} 0 \\ -0.011 \end{smallmatrix}$

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

	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 (Aa) Depth of Cut	加工寬度 (Ap) 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 (Aa) Depth of Cut	加工寬度 (Ap) 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 (Aa) Depth of Cut	加工寬度 (Ap) 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 (Aa) Depth of Cut	加工寬度 (Ap) 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 (Ap) Depth of Cut	加工寬度 (Aw) 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	

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=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 (Aa) Depth of Cut	加工寬度 (Ap) 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		

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=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 (Aa) Depth of Cut	加工寬度 (Ap) 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 (Aa) Depth of Cut	加工寬度 (Ap) 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	6200~6700	2000~2500	0.05~0.15	10~12	溝銑 SLOTTING
AES1203	35	295	5800~6300	800~1200	0~2	10~12	溝銑 SLOTTING
AES1203	35	295	6200~6700	2000~2500	3~6	10~12	溝銑 SLOTTING
AES1203	35	295	6200~6700	1400~1800	7~12	10~12	溝銑 SLOTTING
AES1203	35	295	6200~6700	900~1300	24	0.05~0.15	側銑 SIDE MILLING
AES1203	35	295	5000~5400	1200~1600	24	0~2	側銑 SIDE MILLING
AES1203	35	295	5000~5400	4000~4500	24	3~6	側銑 SIDE MILLING
AES1203	35	295	5000~5400	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	5000~5400	2000~2500	0.05~0.2	14~16	溝銑 SLOTTING
AES1603	55	325	7800~8200	2000~2400	0~2	14~16	溝銑 SLOTTING
AES1603	55	325	7800~8200	6000~6500	3~6	14~16	溝銑 SLOTTING
AES1603	55	325	7800~8200	3500~4000	7~12	14~16	溝銑 SLOTTING
AES1603	55	325	7800~8200	2800~3300	16	0~2	側銑 SIDE MILLING
AES1603	55	325	7800~8200	2000~2400	16	3~6	側銑 SIDE MILLING
AES1603	55	325	7800~8200	5500~6000	16	8~10	側銑 SIDE MILLING
AES1603	55	325	7800~8200	3500~4000	32	0.05~0.2	側銑 SIDE MILLING
AES1603	55	325	7800~8200	2800~3300	32	0~2	側銑 SIDE MILLING
AES1603	55	325	4200~4700	500~800	32	3~6	側銑 SIDE MILLING
AES1603	55	325	3200~3700	800~1200	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	3200~3700	700~1000	0.05~0.2	18~20	溝銑 SLOTTING
AES2003	65	315	3200~3700	500~800	0~2	18~20	溝銑 SLOTTING
AES2003	65	315	6200~6700	1400~1800	3~6	18~20	溝銑 SLOTTING
AES2003	65	315	6200~6700	3500~4000	7~12	18~20	溝銑 SLOTTING
AES2003	65	315	6200~6700	2500~3000	40	0.05~0.2	側銑 SIDE MILLING
AES2003	65	315	6200~6700	1700~2200	40	0~2	側銑 SIDE MILLING
AES2003	65	315	6200~6700	4000~4500	40	3~6	側銑 SIDE MILLING
AES2003	65	315	6200~6700	2500~3000	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 (Aa) Depth of Cut	加工寬度 (Ap) 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 (Aa) Depth of Cut	加工寬度 (Ap) 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 (Aa) Depth of Cut	加工寬度 (Ap) 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

	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 Depth of Cut	加工寬度 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	

切削條件表 MILLING CONDITIONS

AER

	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 (Aa) Depth of Cut	加工寬度 (Ap) 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 Depth of Cut	加工寬度 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 (Aa) Depth of Cut	加工寬度 (Ap) 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 (Aa) Depth of Cut	加工寬度 (Ap) 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 (Aa) Depth of Cut	加工寬度 (Ap) 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 (Aa) Depth of Cut	加工寬度 (Ap) 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 (Aa) Depth of Cut	加工寬度 (Ap) 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 (Aa) Depth of Cut	加工寬度 (Ap) 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

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=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 (Aa) Depth of Cut	加工寬度 (Ap) 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 (Aa) Depth of Cut	加工寬度 (Ap) 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 (Aa) Depth of Cut	加工寬度 (Ap) 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 (Aa) Depth of Cut	加工寬度 (Ap) 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 (Aa) Depth of Cut	加工寬度 (Ap) 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			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 (Aa) Depth of Cut	加工寬度 (Ap) 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 (Aa) Depth of Cut	加工寬度 (Ap) 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 (Ap) Depth of Cut	加工寬度 (Aw) 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 (Aa) Depth of Cut	加工寬度 (Ap) 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	0.7~0.8	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

	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 (Aa) Depth of Cut	加工寬度 (Ap) 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 (Aa) Depth of Cut	加工寬度 (Ap) 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	



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